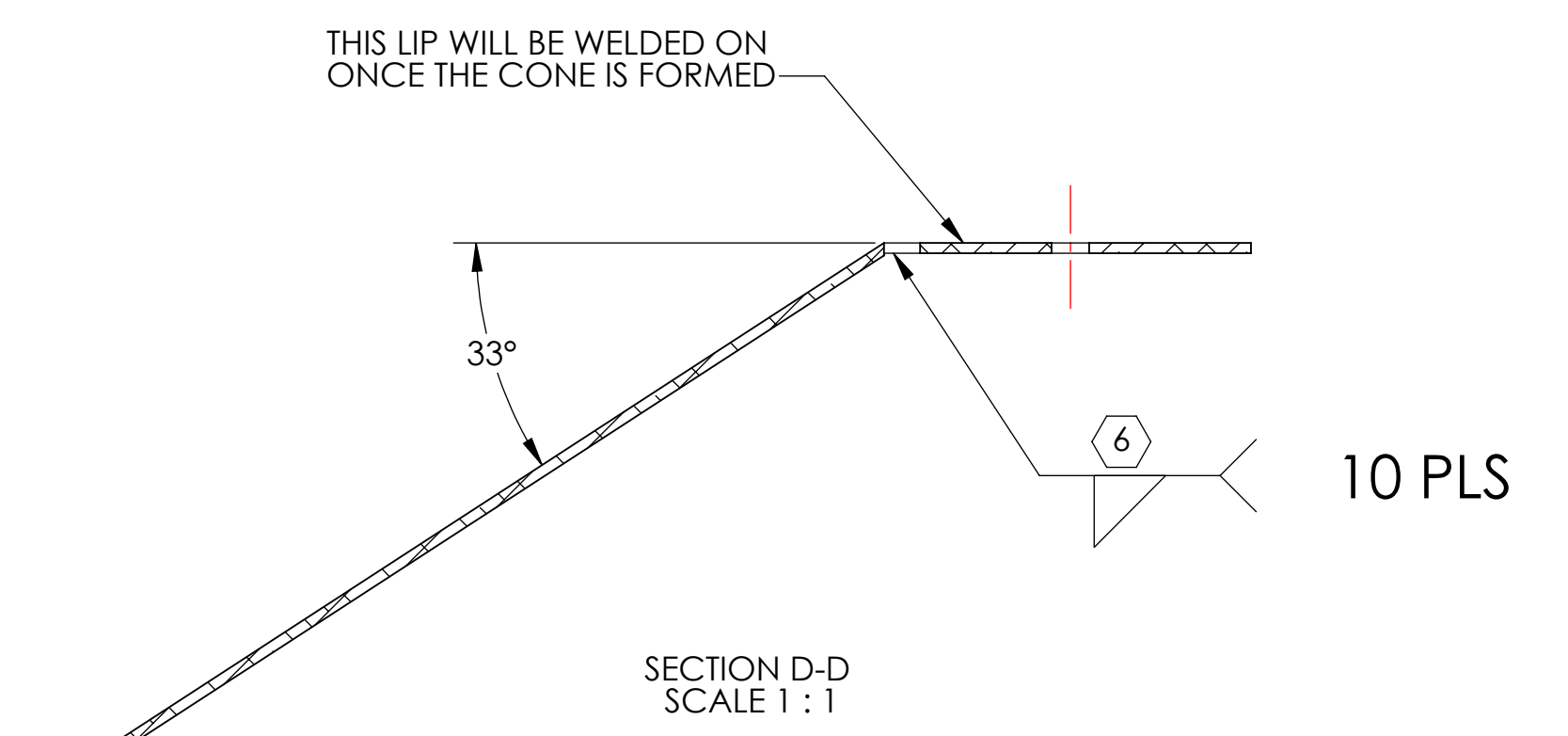
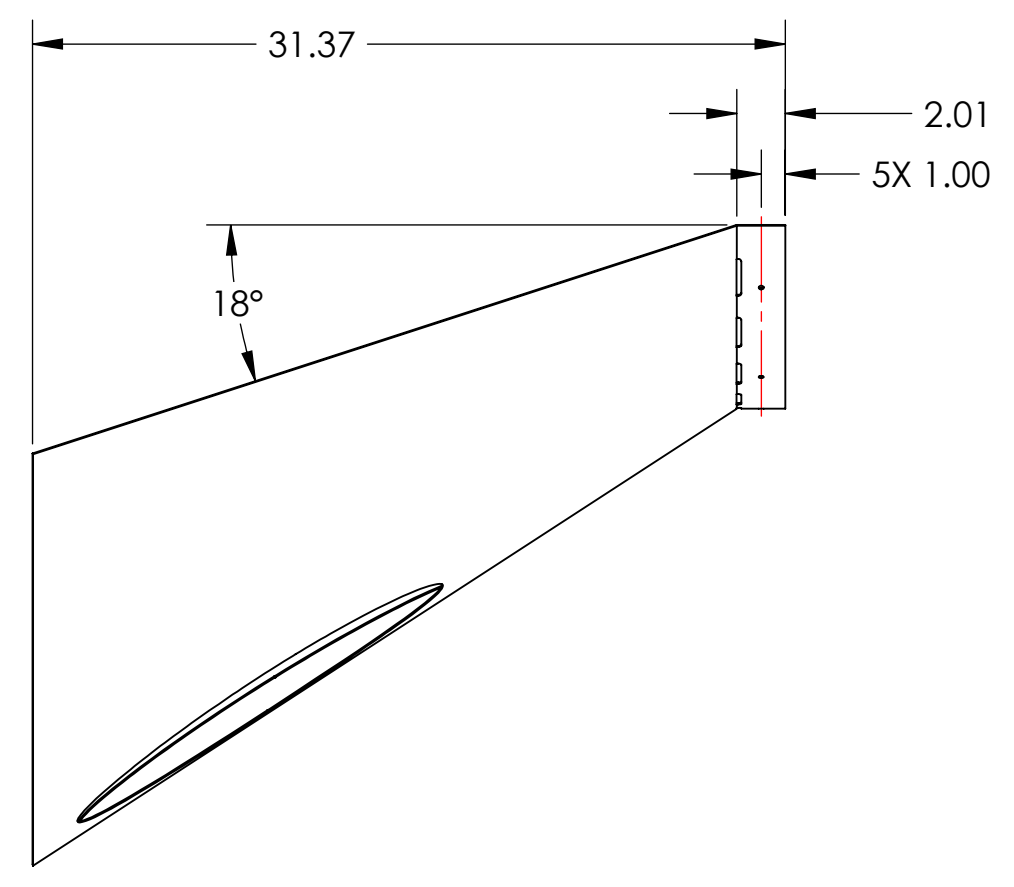
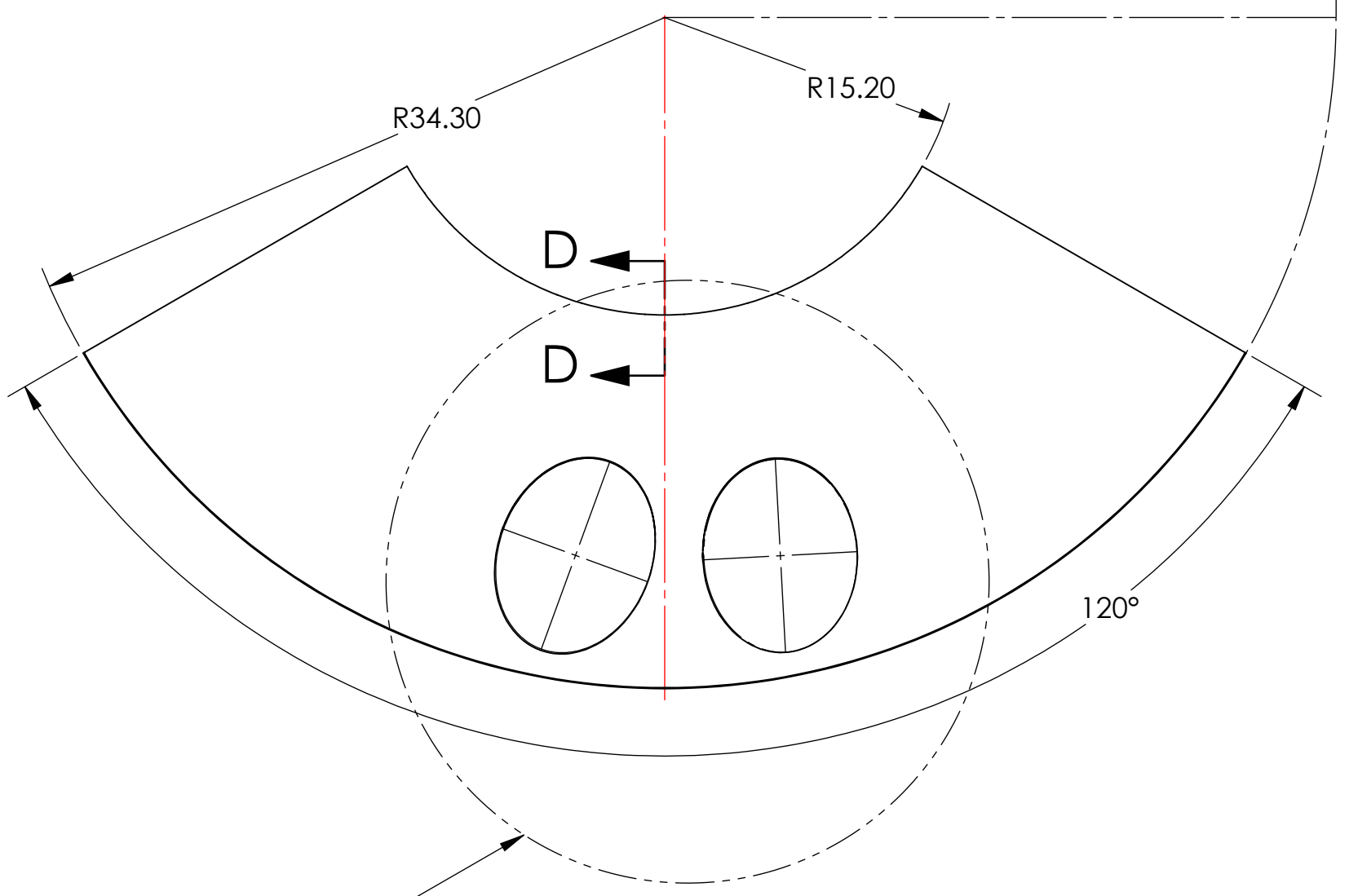
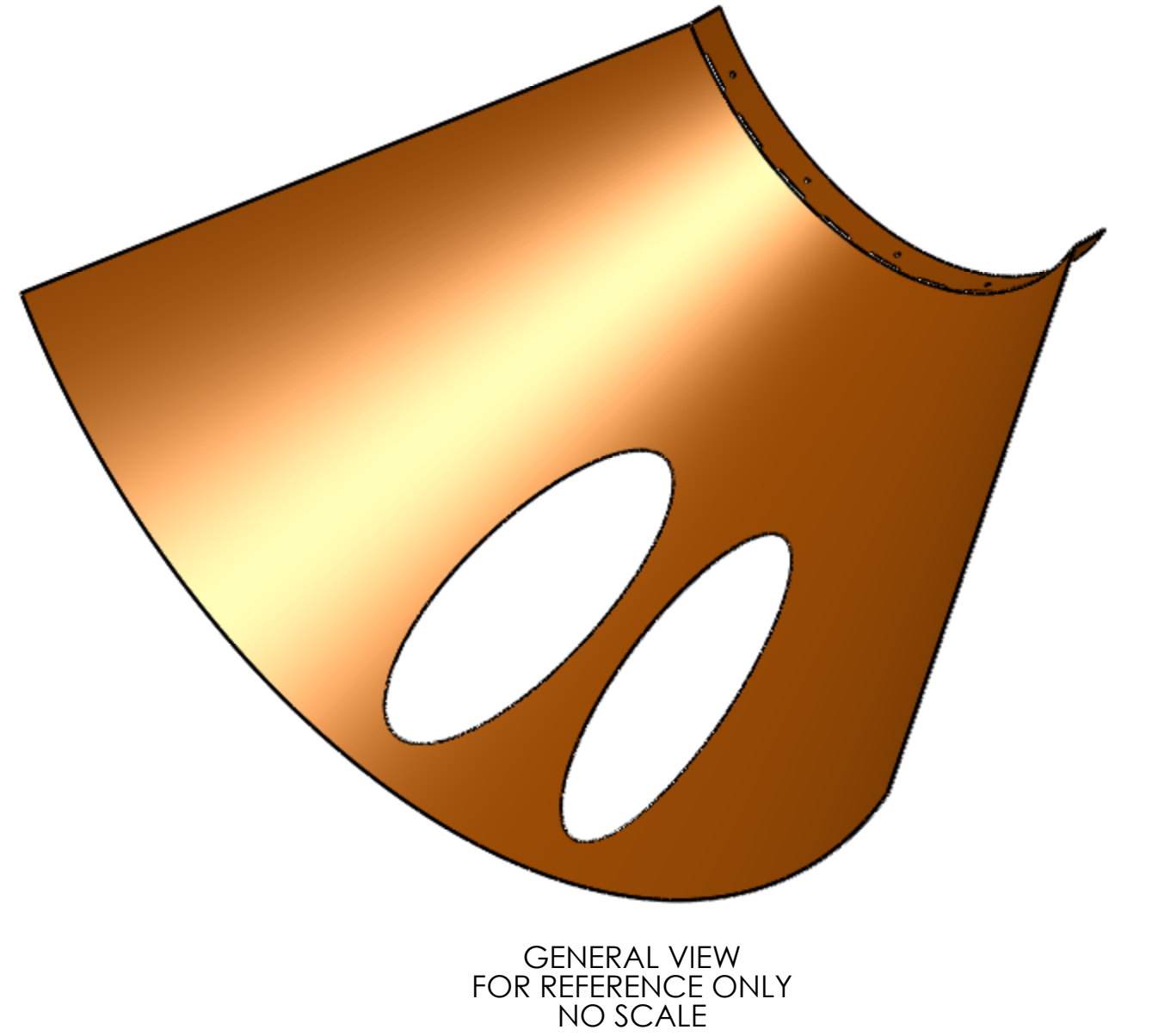
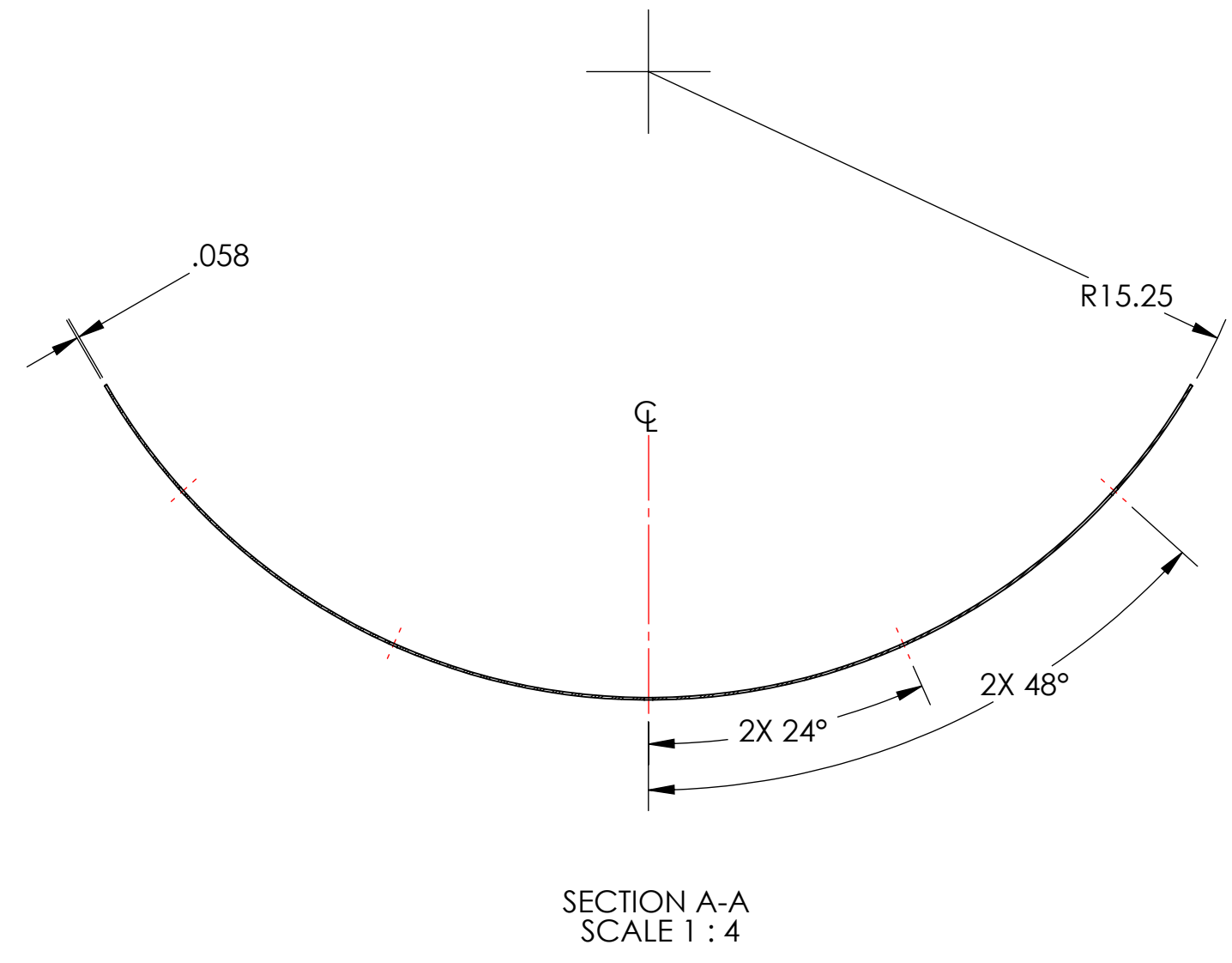
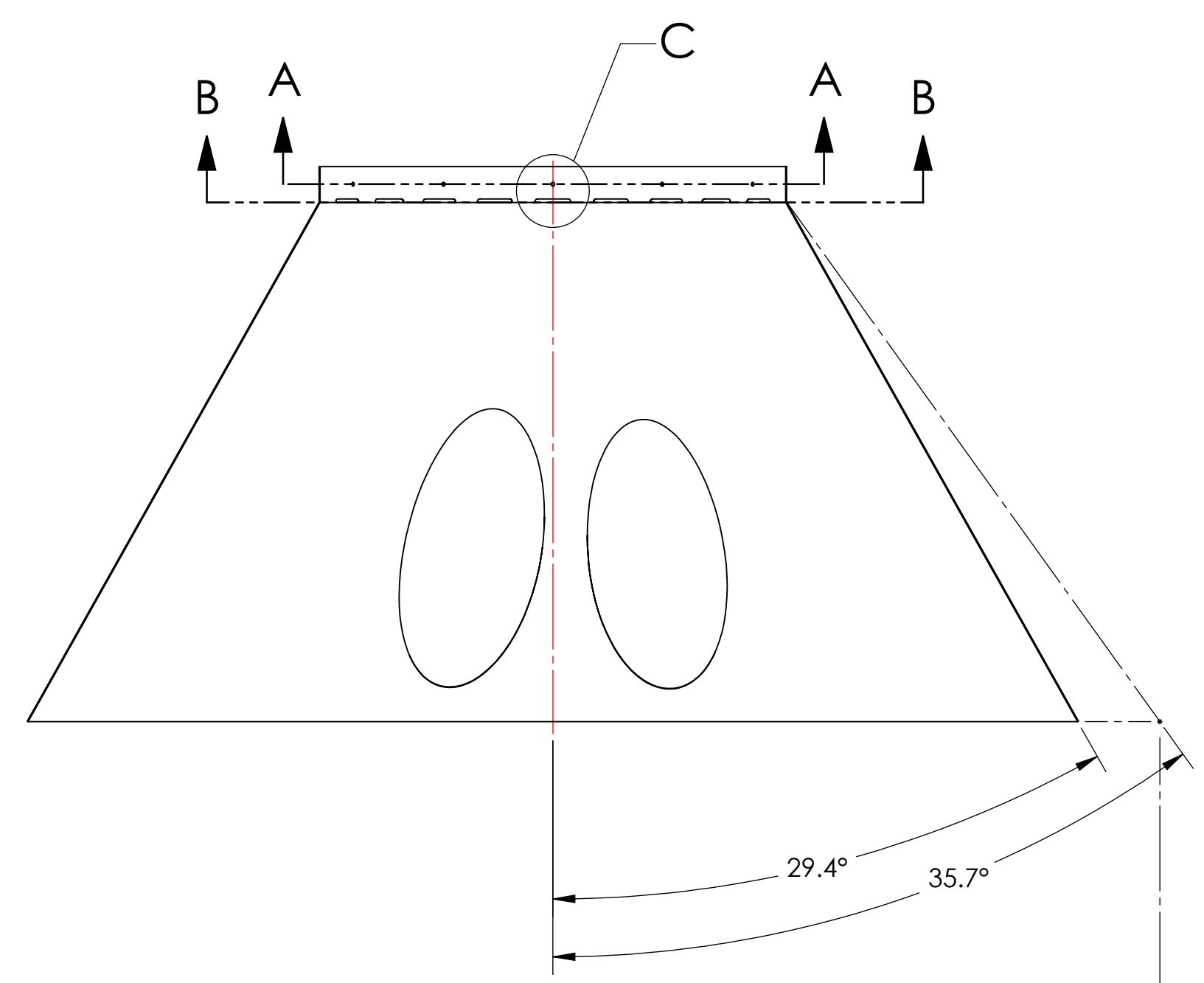
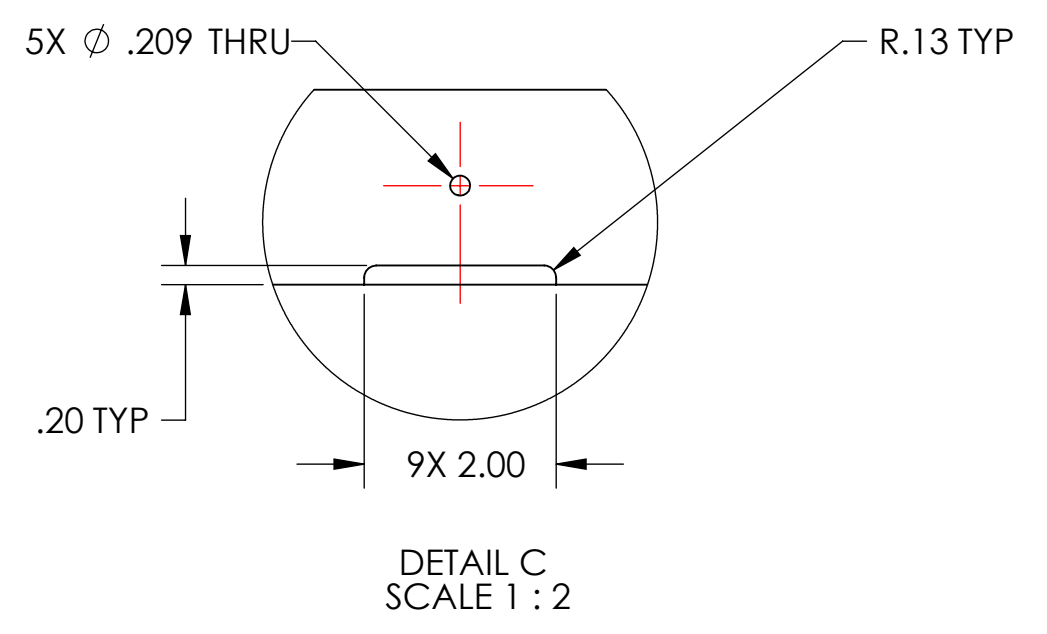
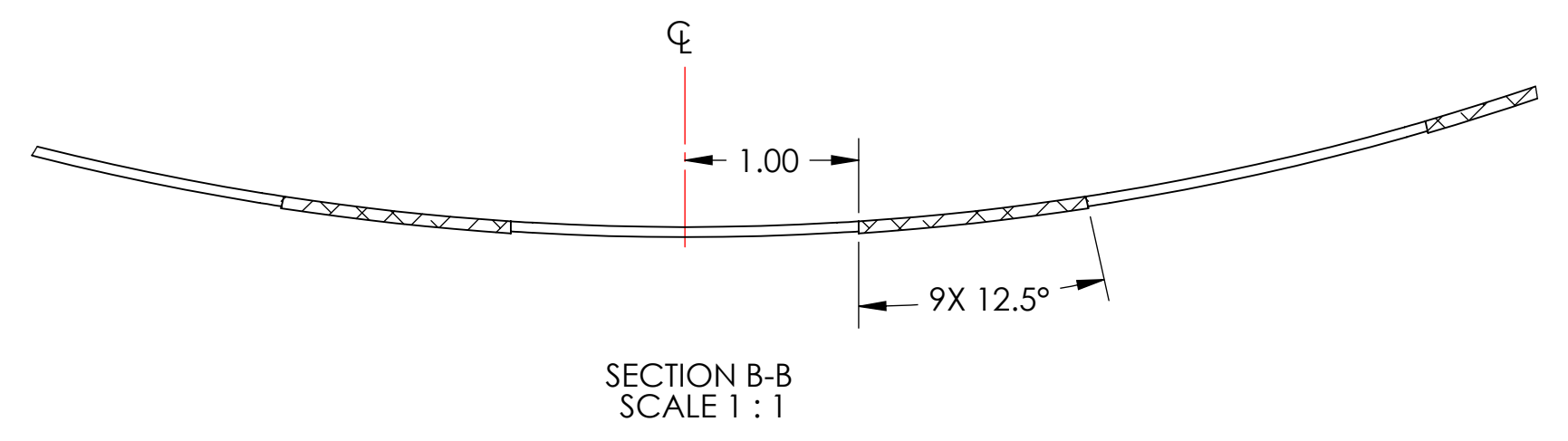


NOTES CONTINUED:  
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT.  
 ⑦ MATERIAL AS RECEIVED MACHINE FINISH



SEE DETAIL F ON SHEET 2

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902655 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .06 .XXX ± .010		ANGULAR ± 0.1°	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
1. INTERPRET DRAWING PER ASME Y14.5-1994.					
2. REMOVE ALL SHARP EDGES, R.02 MIN.					
3. DO NOT SCALE FROM DRAWING.					
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.					
MATERIAL	18GA A424 TYPE 1 STEEL		FINISH	⑦	

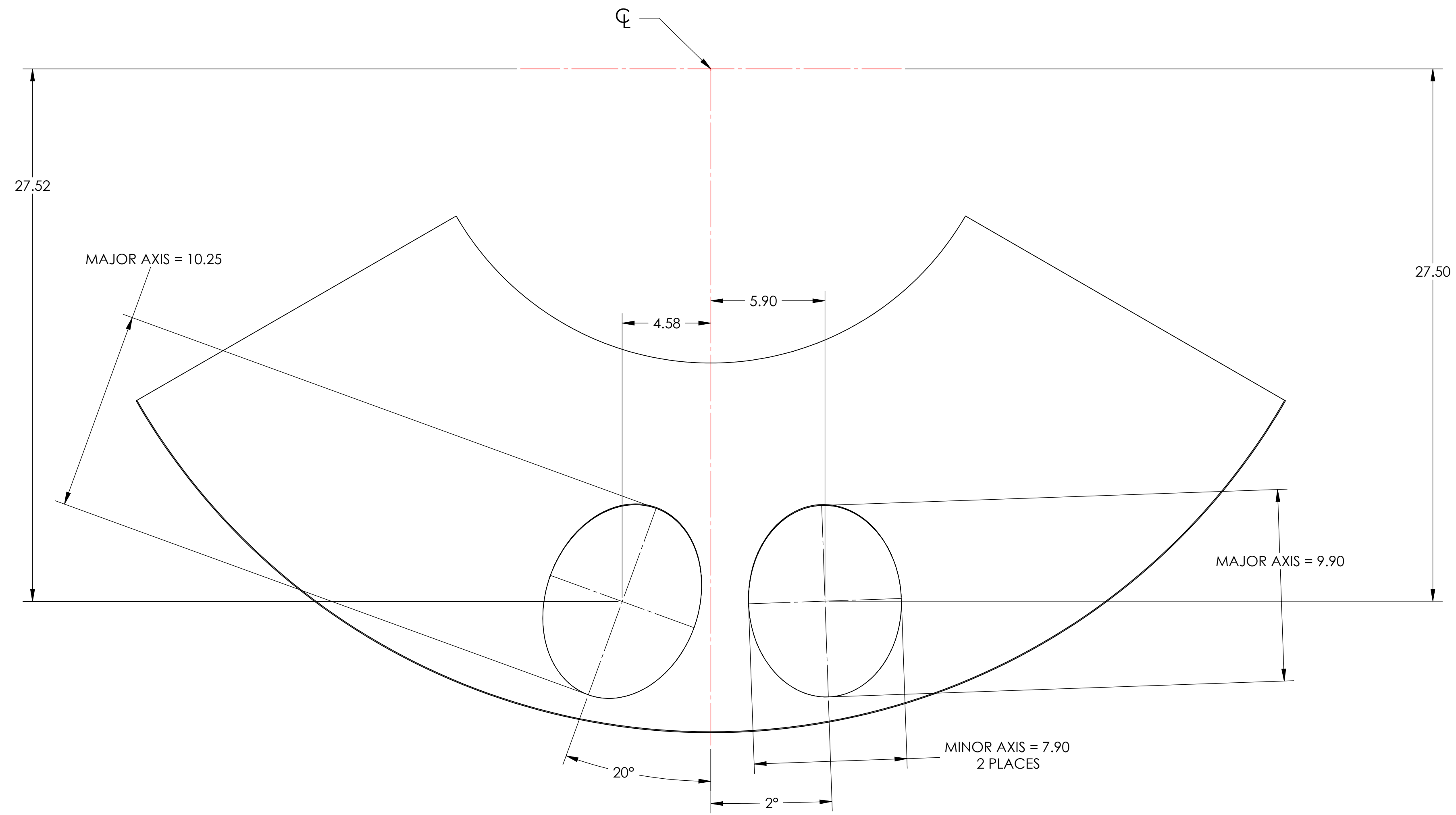
**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**


NEXT ASSY: **D1003184**

PART NAME		<b>MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMX H1 BOTTOM</b>			
DESIGNER	TQ. NGUYEN	6 DEC 2010	SIZE	DWG. NO.	
DRAFTER	TQ. NGUYEN	6 DEC 2010	<b>D</b>	<b>D1003185</b>	
CHECKER	M. SMITH			REV.	<b>v1</b>
APPROVAL	D. COYNE		SCALE: 1:8	PROJECTION:	SHEET 1 OF 2

D:\003185\alUGO\_Manifold\_Cryo\_Baffle\_Inner\_Segment1\_ETMX\_H1\_Bottom\_PART\_PDM\_REV\_X-034\_DRAWING\_PDM\_REV\_X-029



DETAIL F  
SCALE 1:4

 <b>CALIFORNIA INSTITUTE OF TECHNOLOGY</b> <b>MASSACHUSETTS INSTITUTE OF TECHNOLOGY</b>		
SIZE	DWG. NO.	REV.
D	D1003185	v1
SCALE: 1:8	PROJECTION:	SHEET 2 OF 2

D:\003185\aligo\_MonField\_Cryo\_Baffle\_Inner\_Segment1\_ETMX-H1\_Bottom\_PART\_PDM\REV-X\034\_DRAWING\_PDM\REV-X\029