

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (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 DO NOT APPLY MARK ON SUPER #8 SIDE

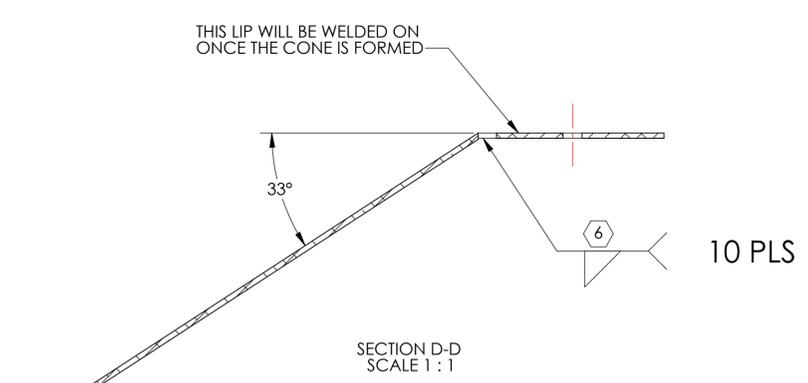
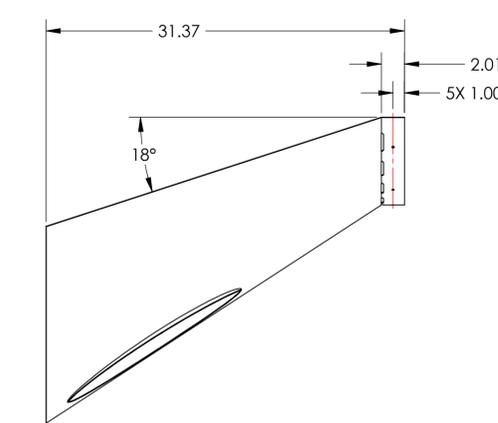
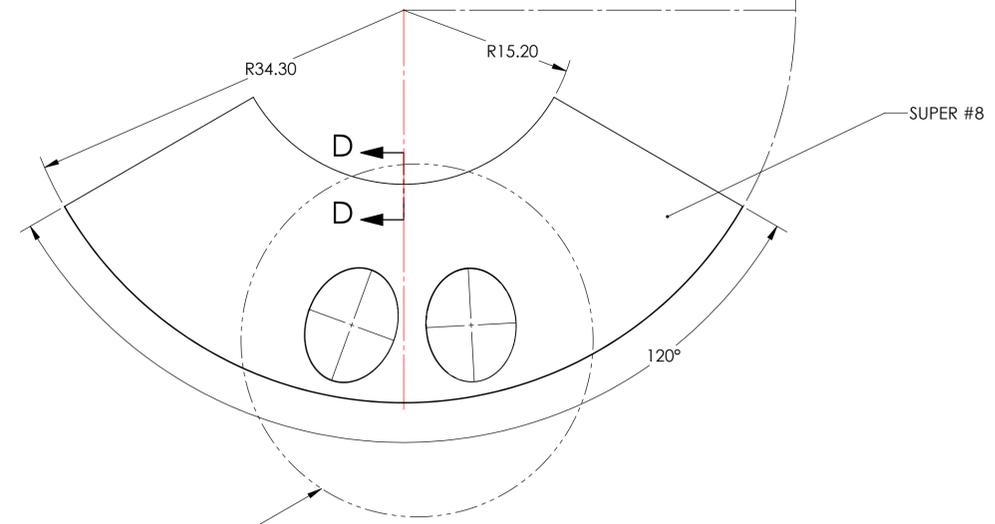
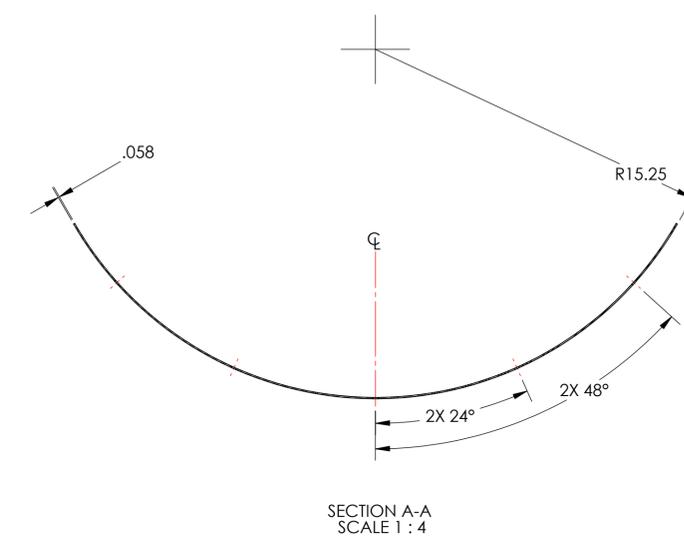
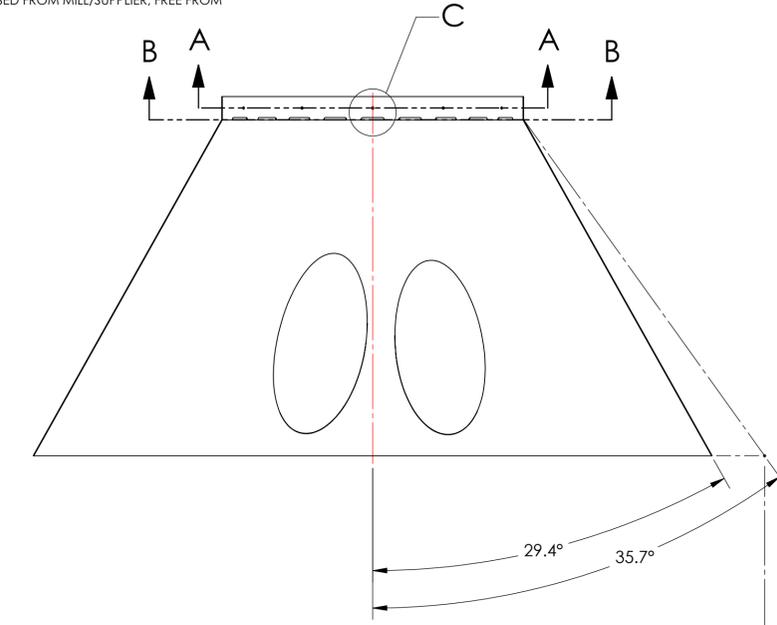
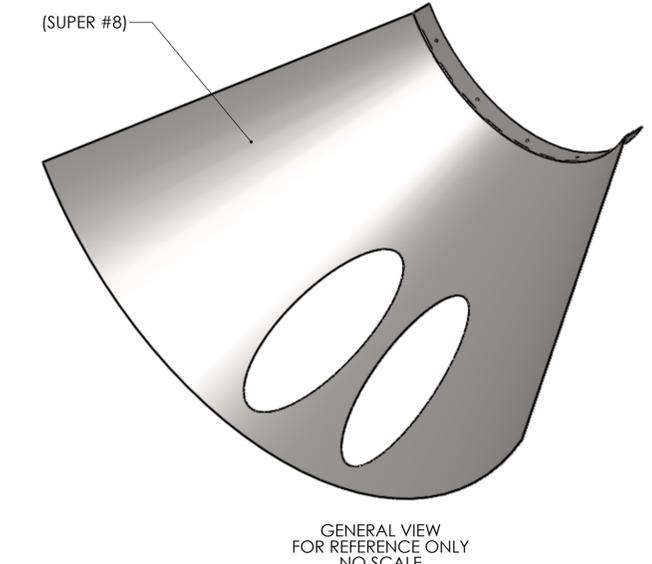
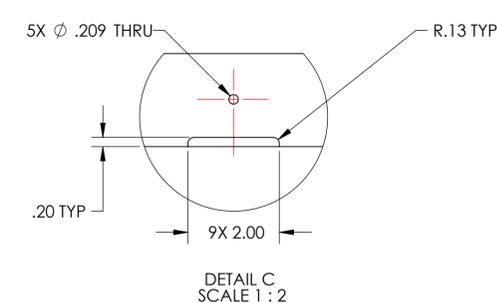
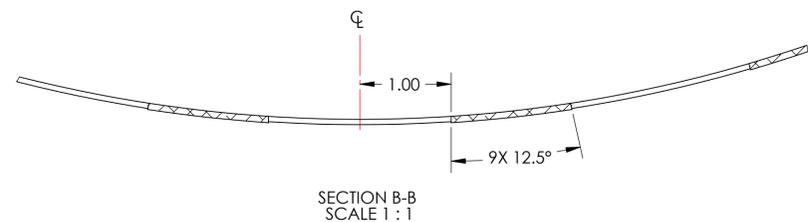
6. CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

7. DELETED

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

10. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.



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.

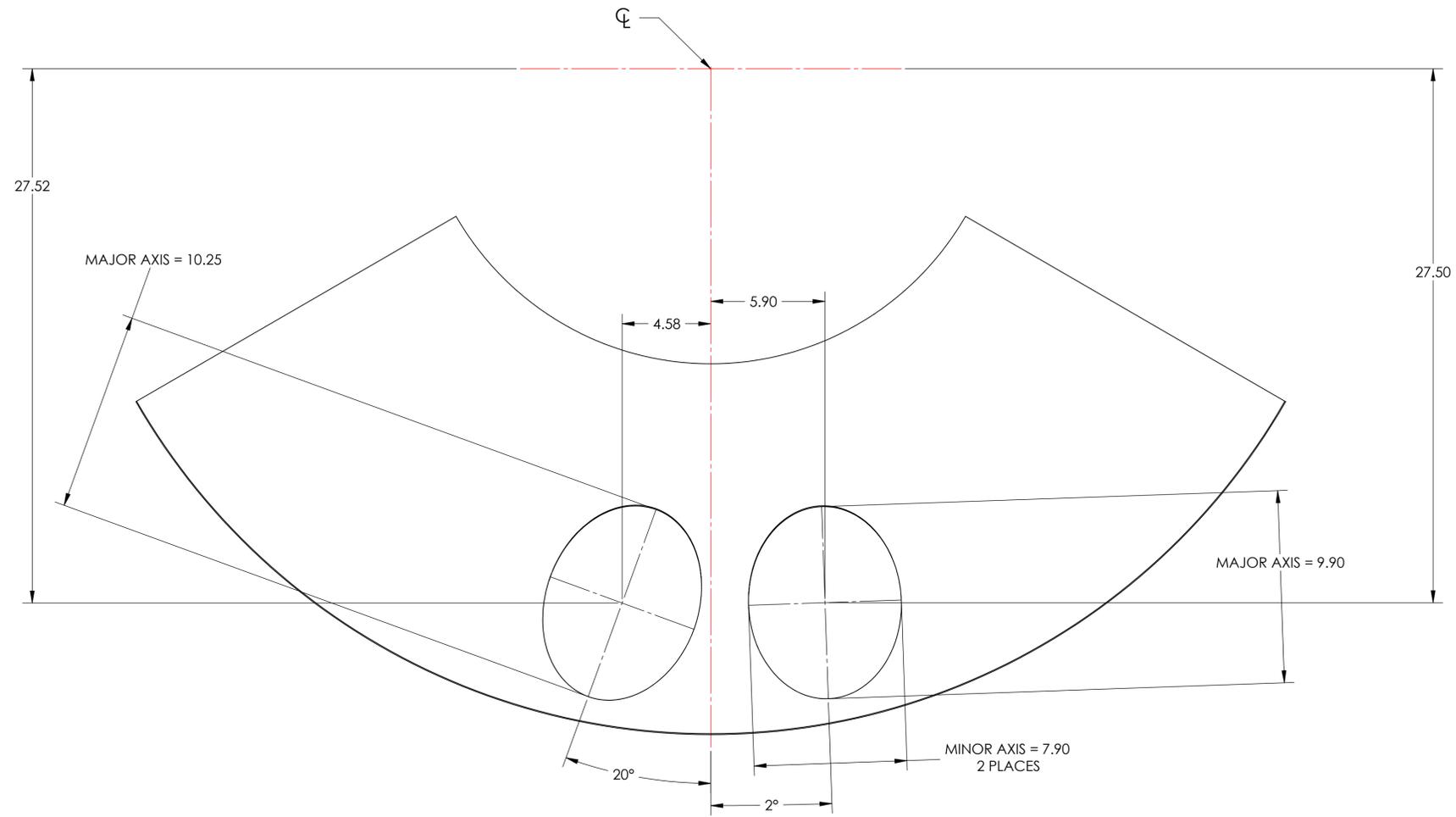
DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .06 .XXX ± .010		ANGULAR ± 0.1°	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
1. INTERPRET DRAWING PER ASME Y14.5-1994.					
2. REMOVE ALL SHARP EDGES, .005-.015 ON ALL EDGES AND HOLES.					
3. DO NOT SCALE FROM DRAWING.					
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.					
MATERIAL	18 GAUGE 304 SSSL	FINISH	10 SUPER #8		

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1003184

PART NAME		MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMX H1 BOTTOM			
DESIGNER	TQ. NGUYEN	6 DEC 2010	SIZE	DWG. NO.	REV.
DRAFTER	TQ. NGUYEN	6 DEC 2010	D	D1003185	v2
CHECKER	M. SMITH		SCALE: 1:8	PROJECTION:	SHEET 1 OF 2
APPROVAL	D. COYNE				



DETAIL F
SCALE 1:4

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1003185	v2
SCALE: 1:8	PROJECTION:	SHEET 2 OF 2

D:\003185\aligo_MonField_Cryo_Baffle_Inner_Segment1_ETMX-H1_Bottom_PART_PDM\REV-X-036_DRAWING_PDM\REV-X-036