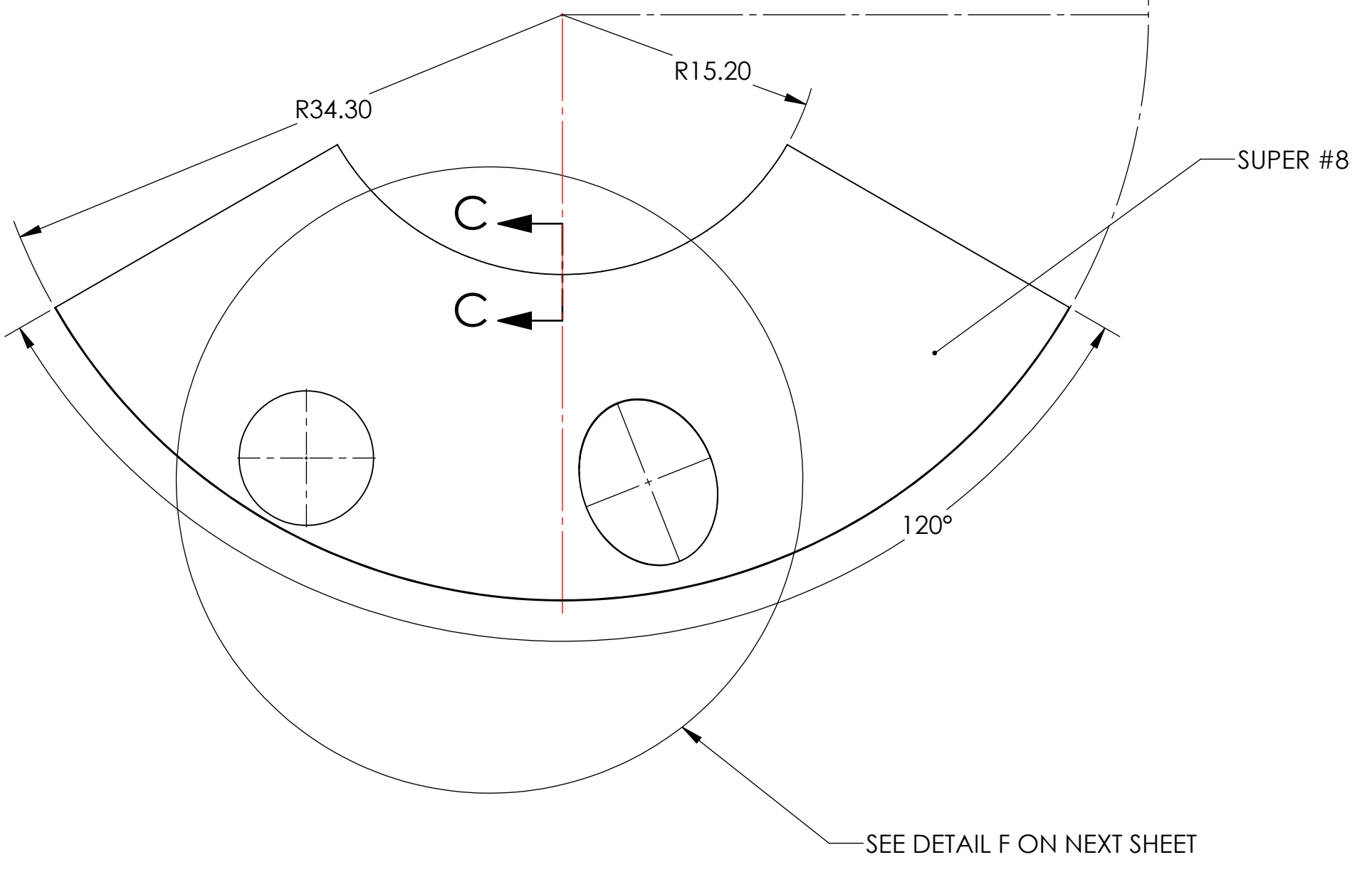
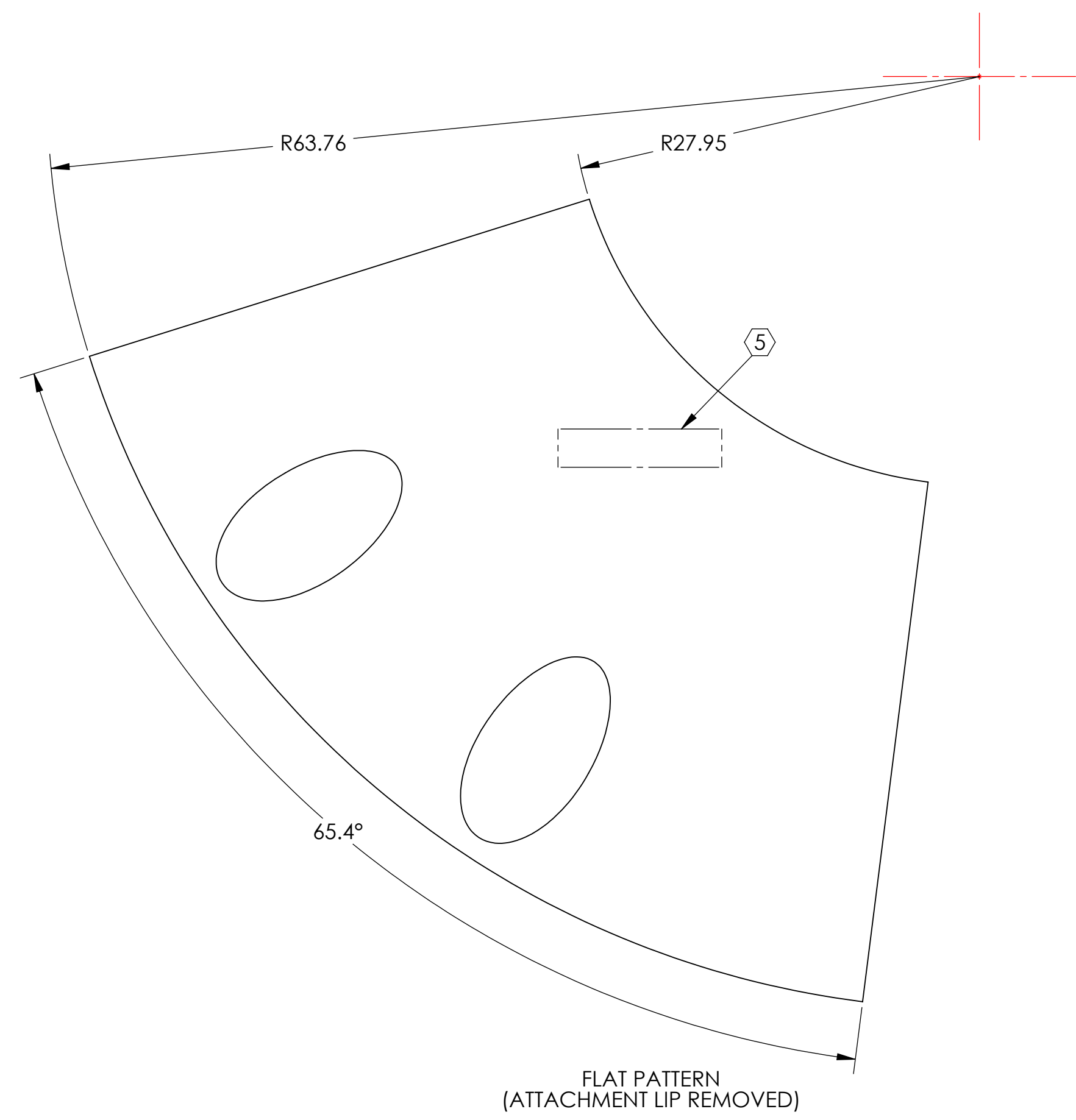
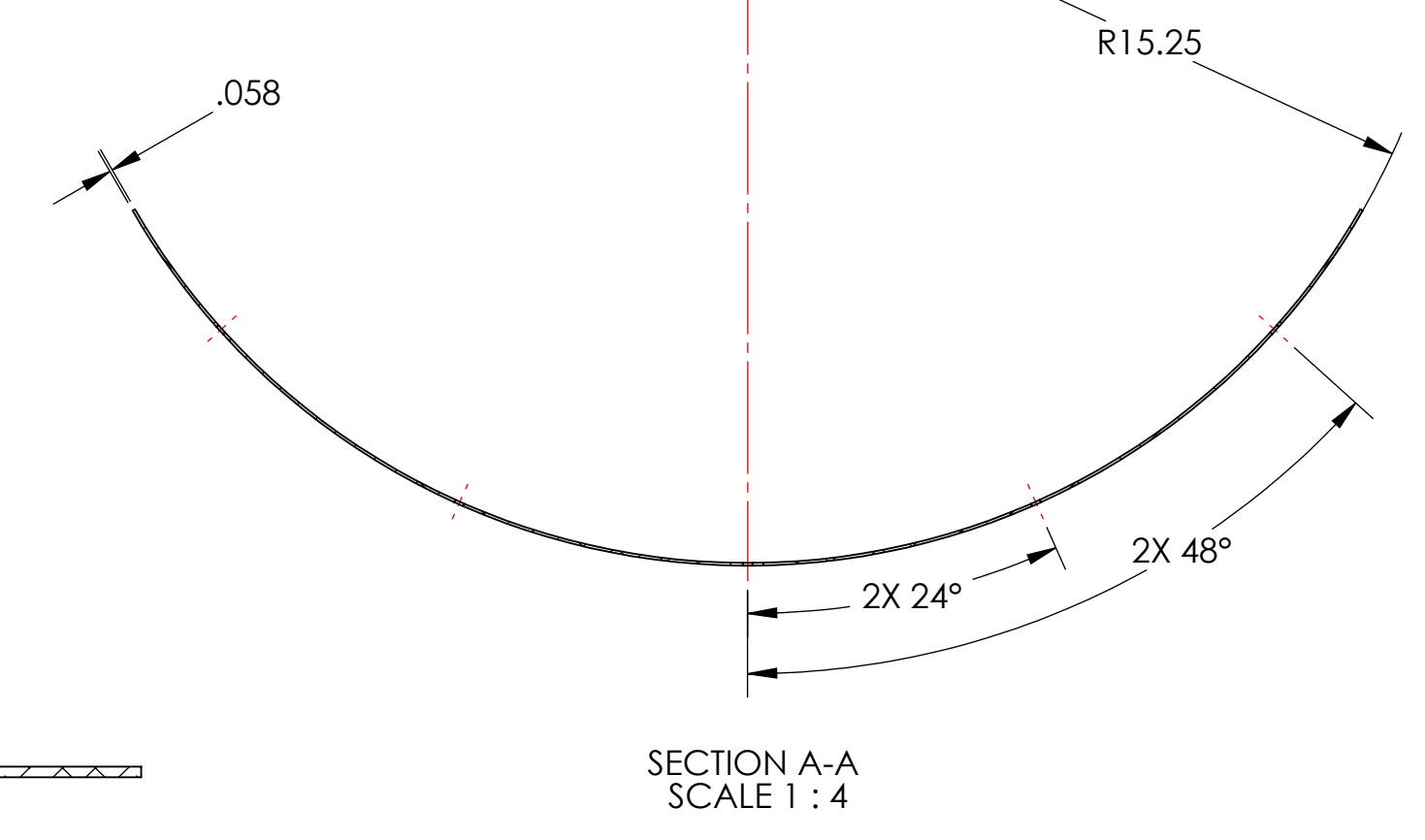
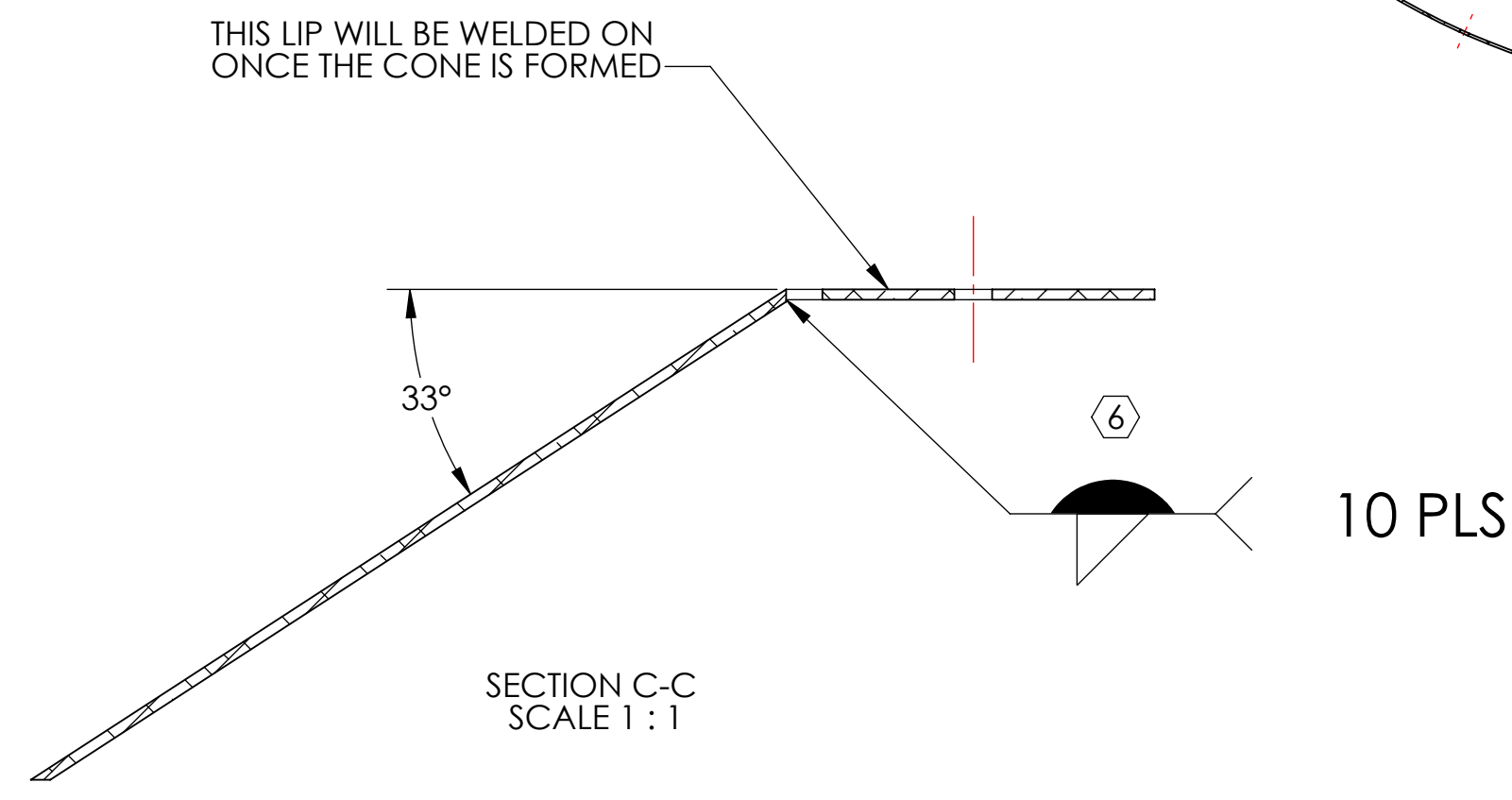
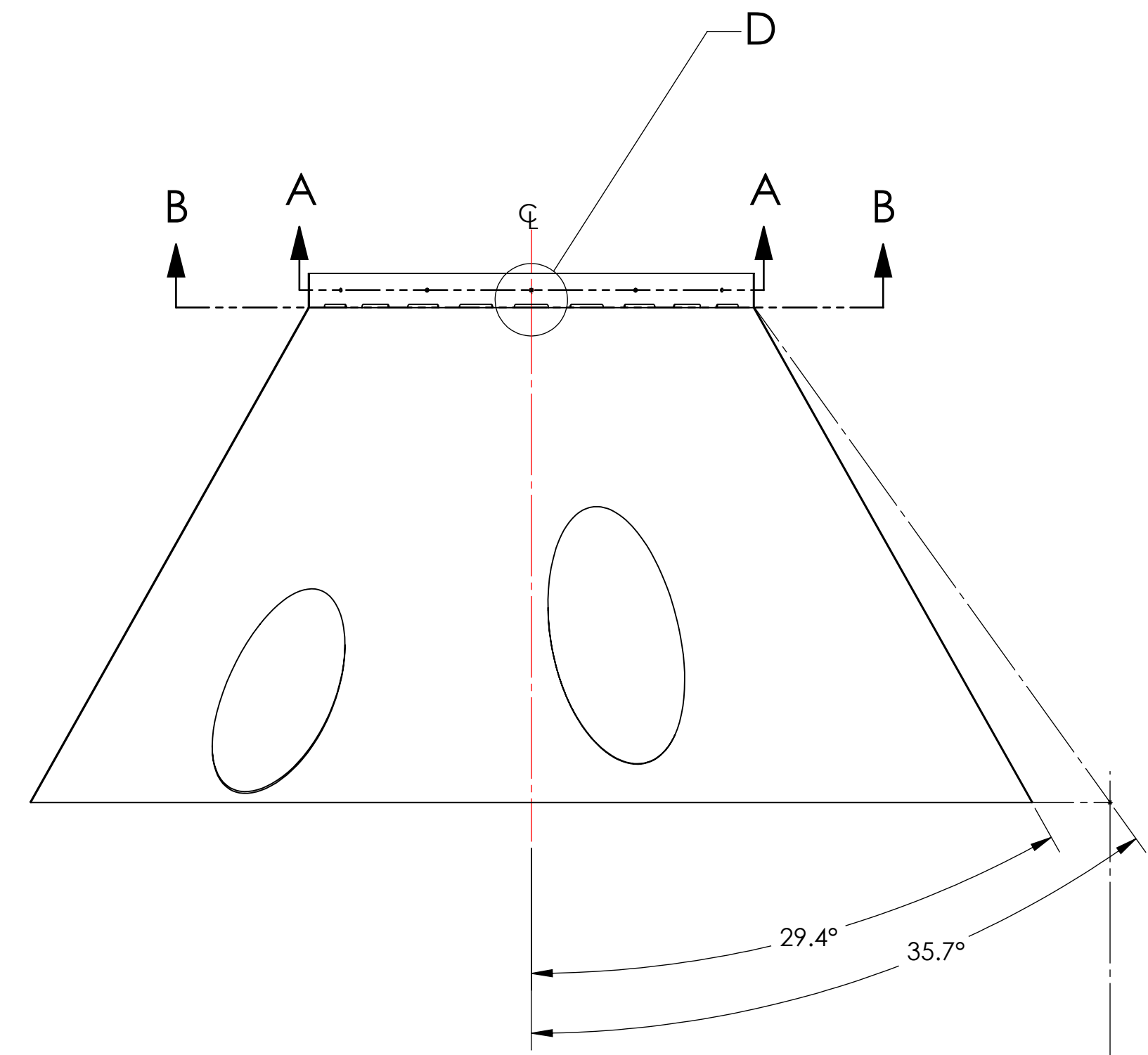
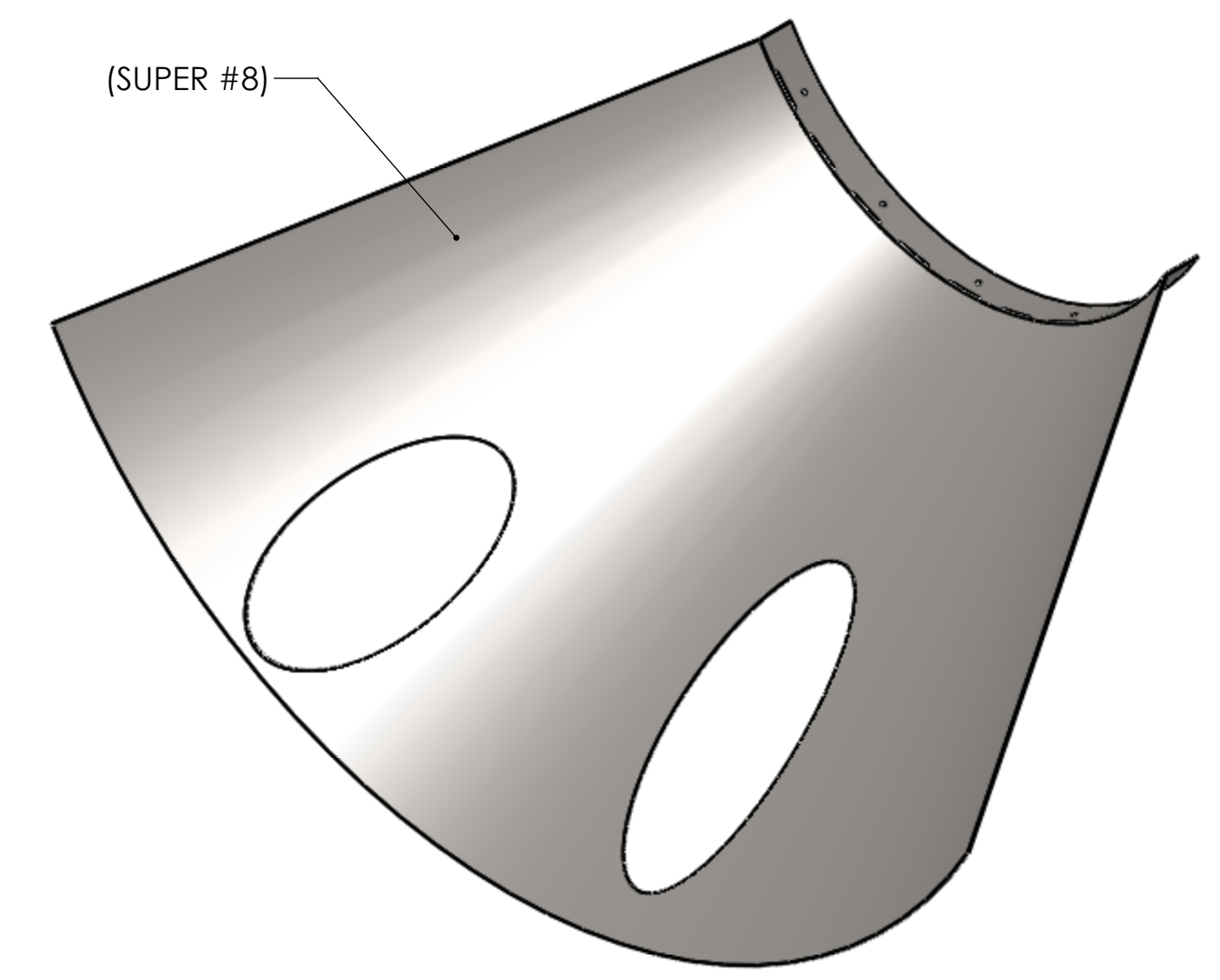
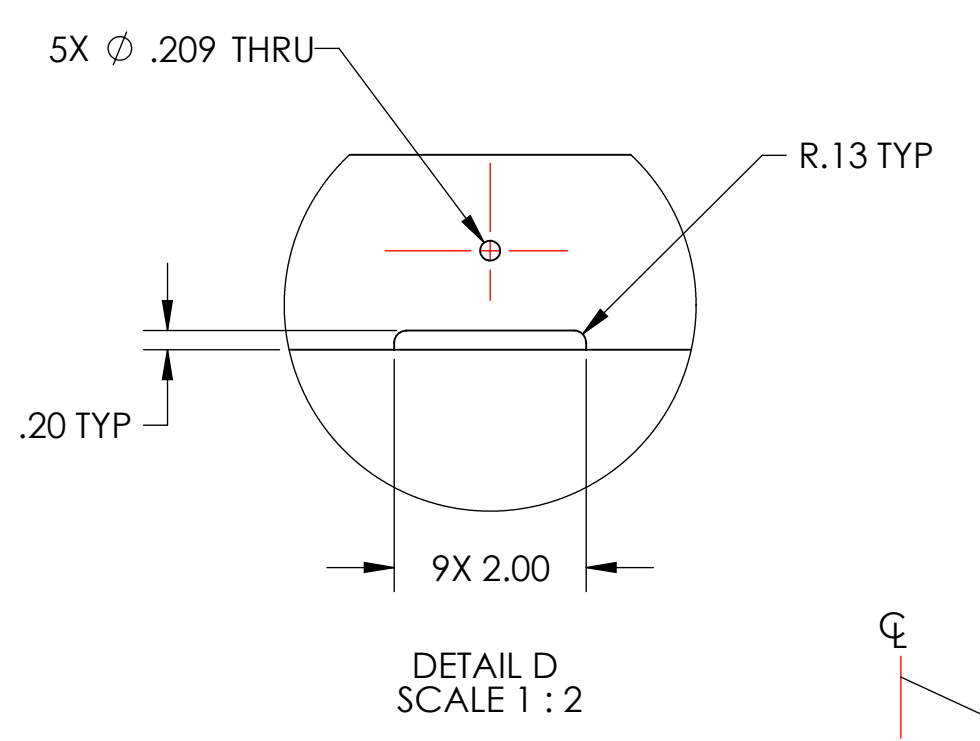
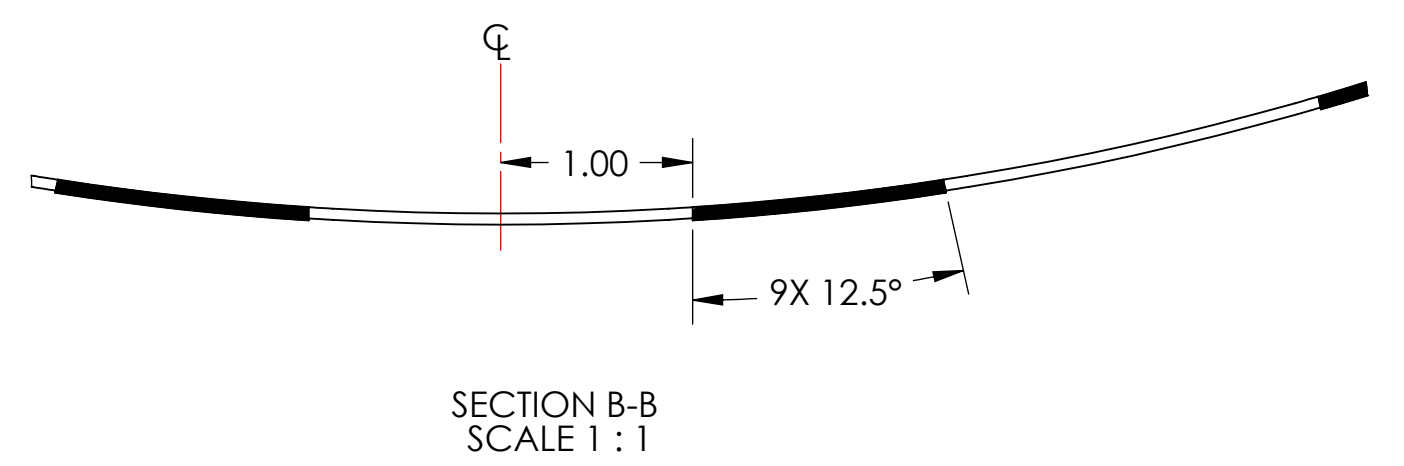


- NOTES CONTINUED:
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	28 JUL 2011	E1000360-v1	-
v2	20 OCT 2011	E1000360-v3	-
-	-	-	-



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 D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES	
TOLERANCES:	.XX ± .06
	.XXX ± .010
ANGULAR ± 0.5°	

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	FINISH
18 GAUGE 304 SSSL	⑩ SUPER #8

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1003186

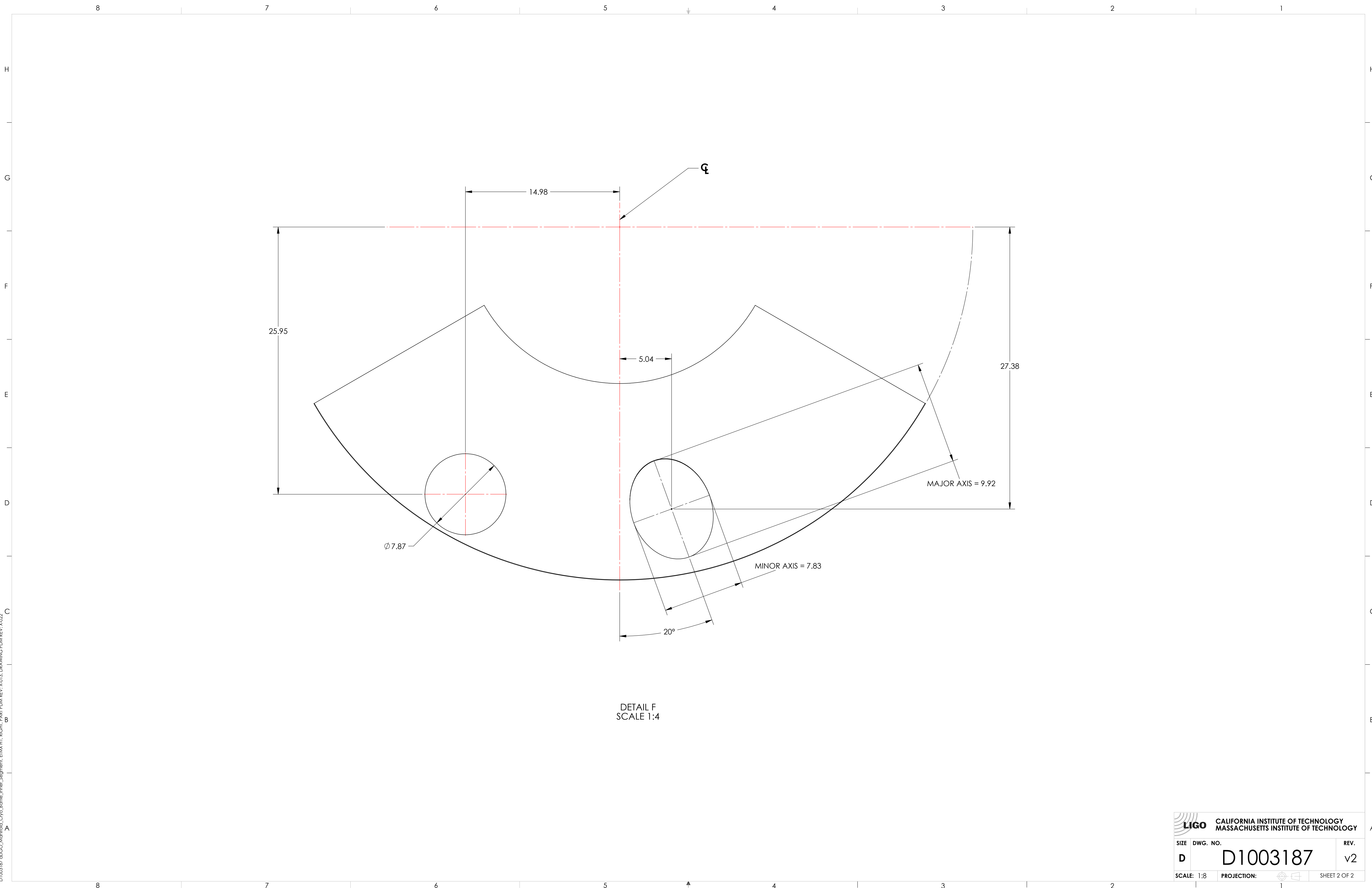
PART NAME: MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, RIGHT

DESIGNER	DATE	SIZE	DWG. NO.	REV.
TQ. NGUYEN	6 DEC 2010	D	D1003187	v2
DRAFTER	TQ. NGUYEN			
CHECKER	M. SMITH			
APPROVAL	D. COYNE			

SCALE: 1:8 PROJECTION:

SHEET 1 OF 2

D:\003187\alugo_Monfield_Cryo_Baffle_Inner_Segment1_ETMX_H1_RIGHT_PART.PDM REV: X-013.DRAWING PDM REV: X-022



DETAIL F
SCALE 1:4

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1003187	v2
SCALE: 1:8	PROJECTION:	SHEET 2 OF 2

D:\003187\duco_monfield_cyoa_baffle_inner_segment1_01x111_RIGHT.PART.PDM.REV.X:013.DRAWING.PDM.REV.X:022