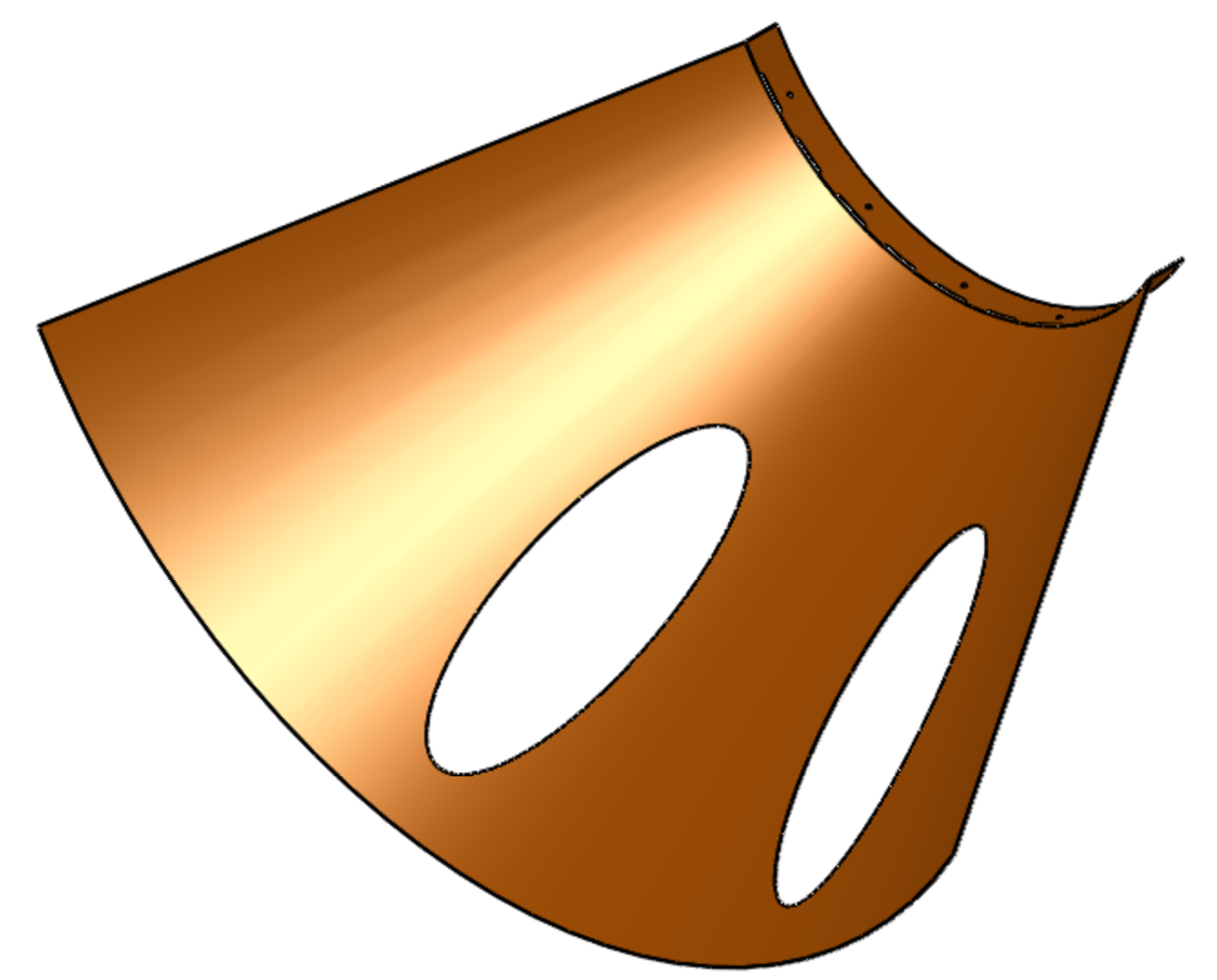
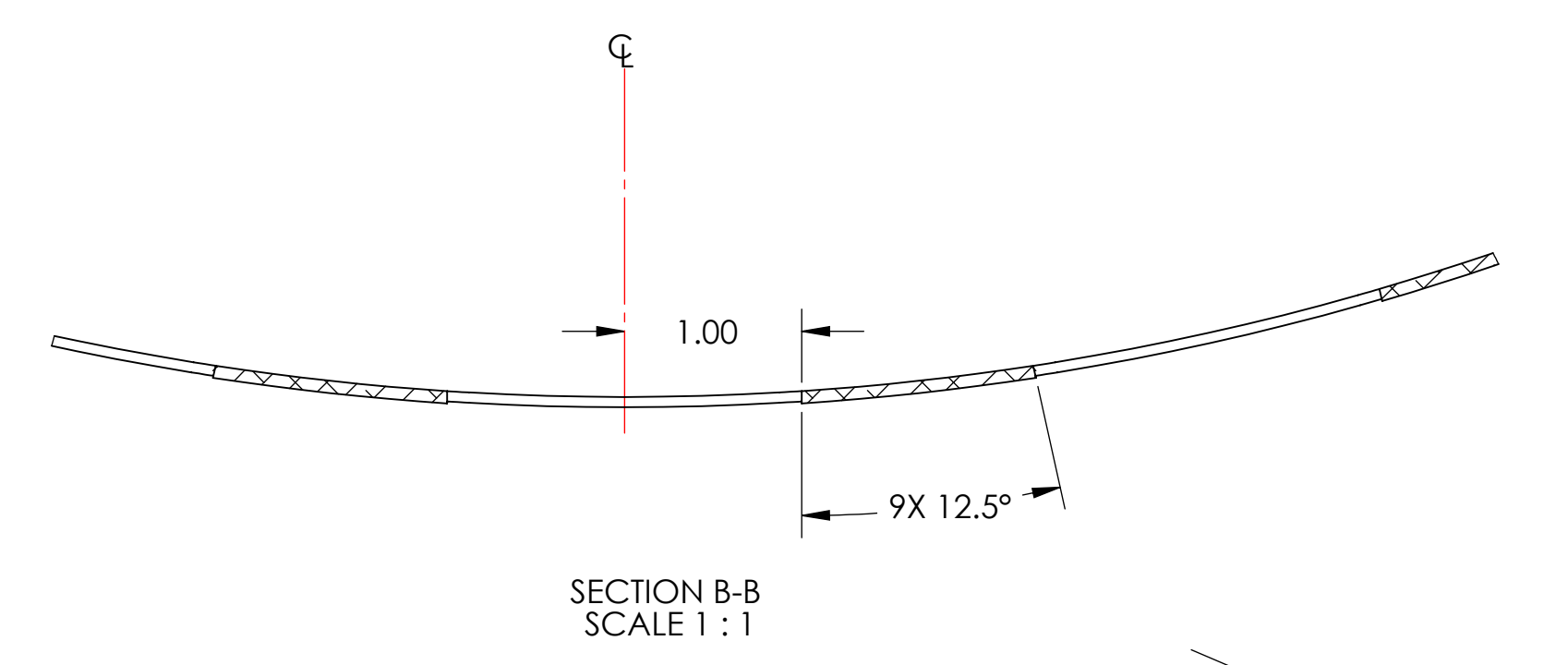
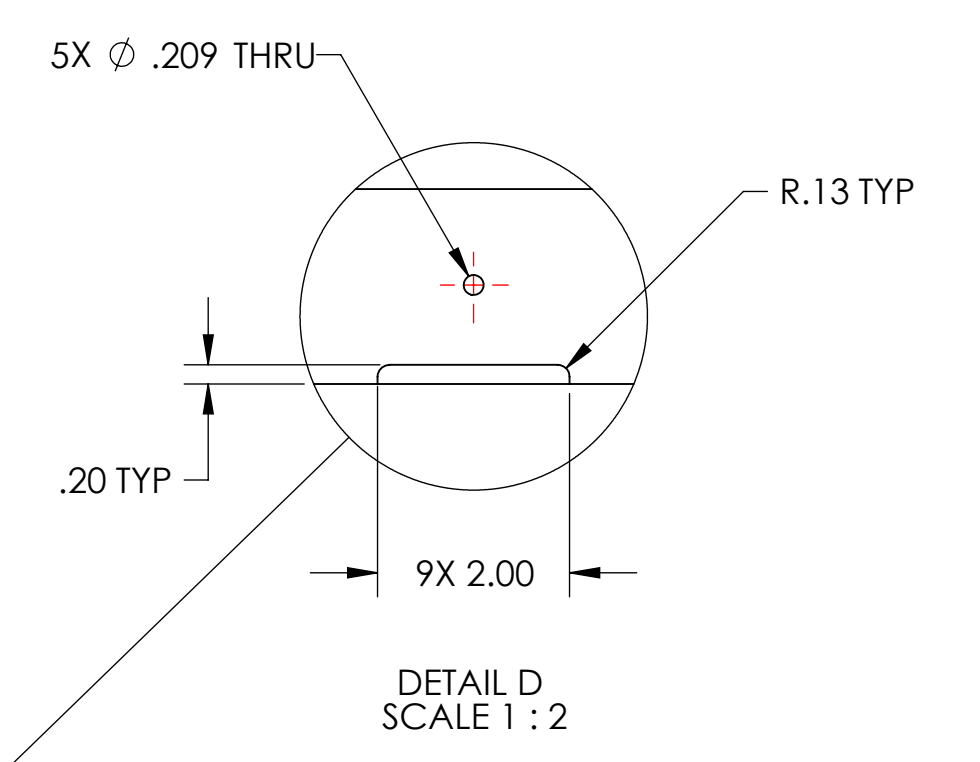


REV.	DATE	DCN #	DRAWING TREE #
v1	28 JUL 2010	E1000360-v2	-
-	-	-	-
-	-	-	-

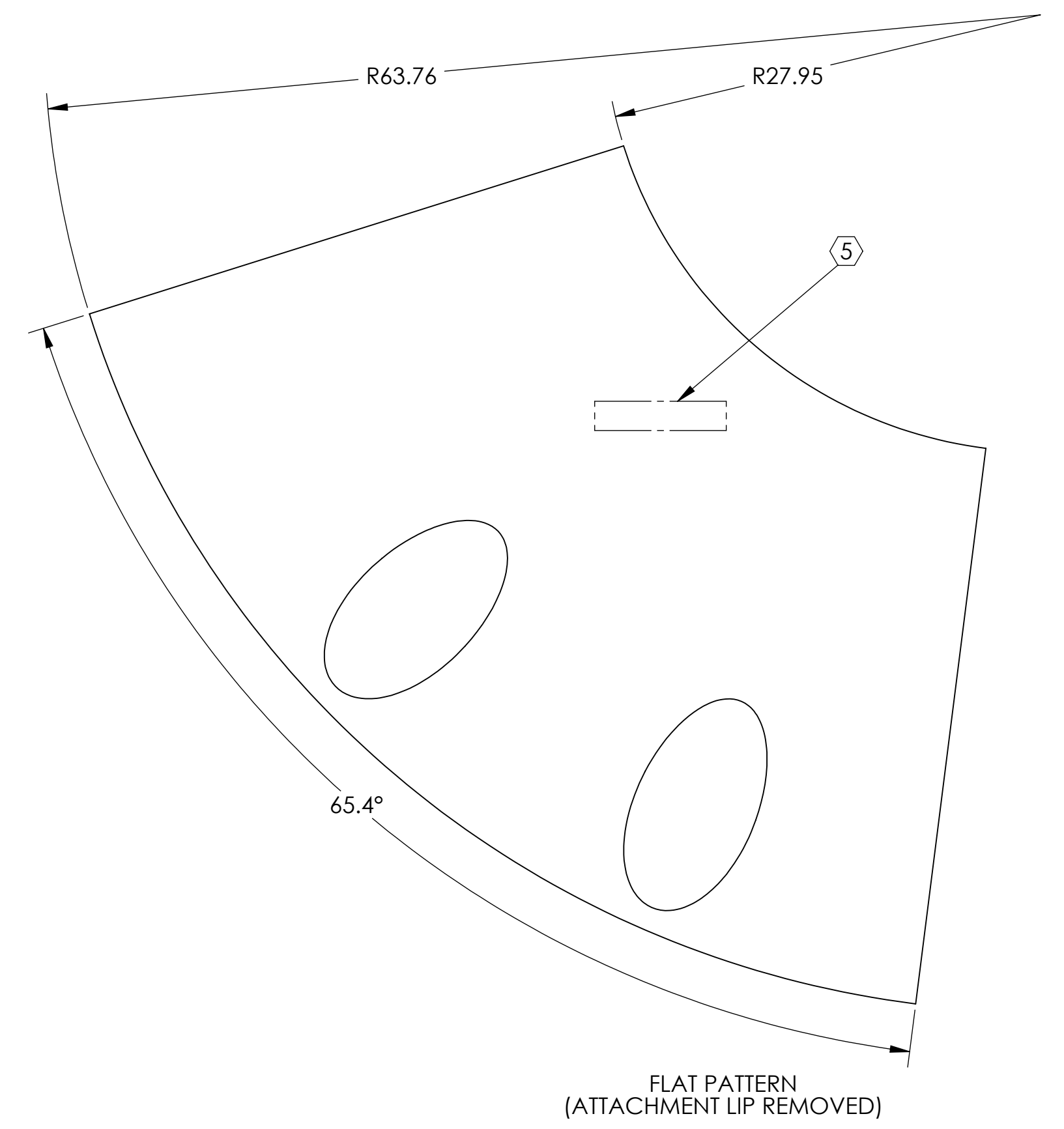
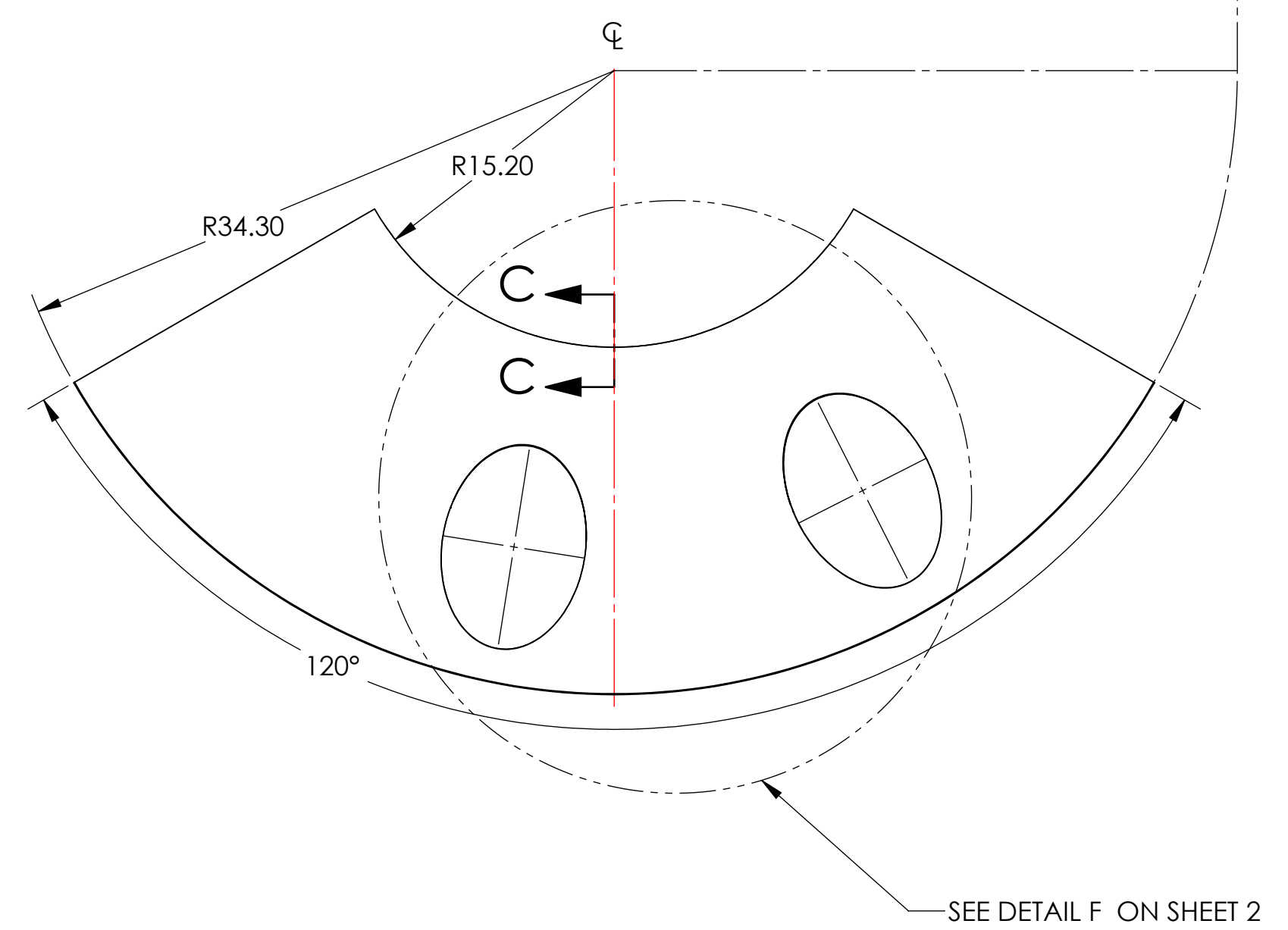
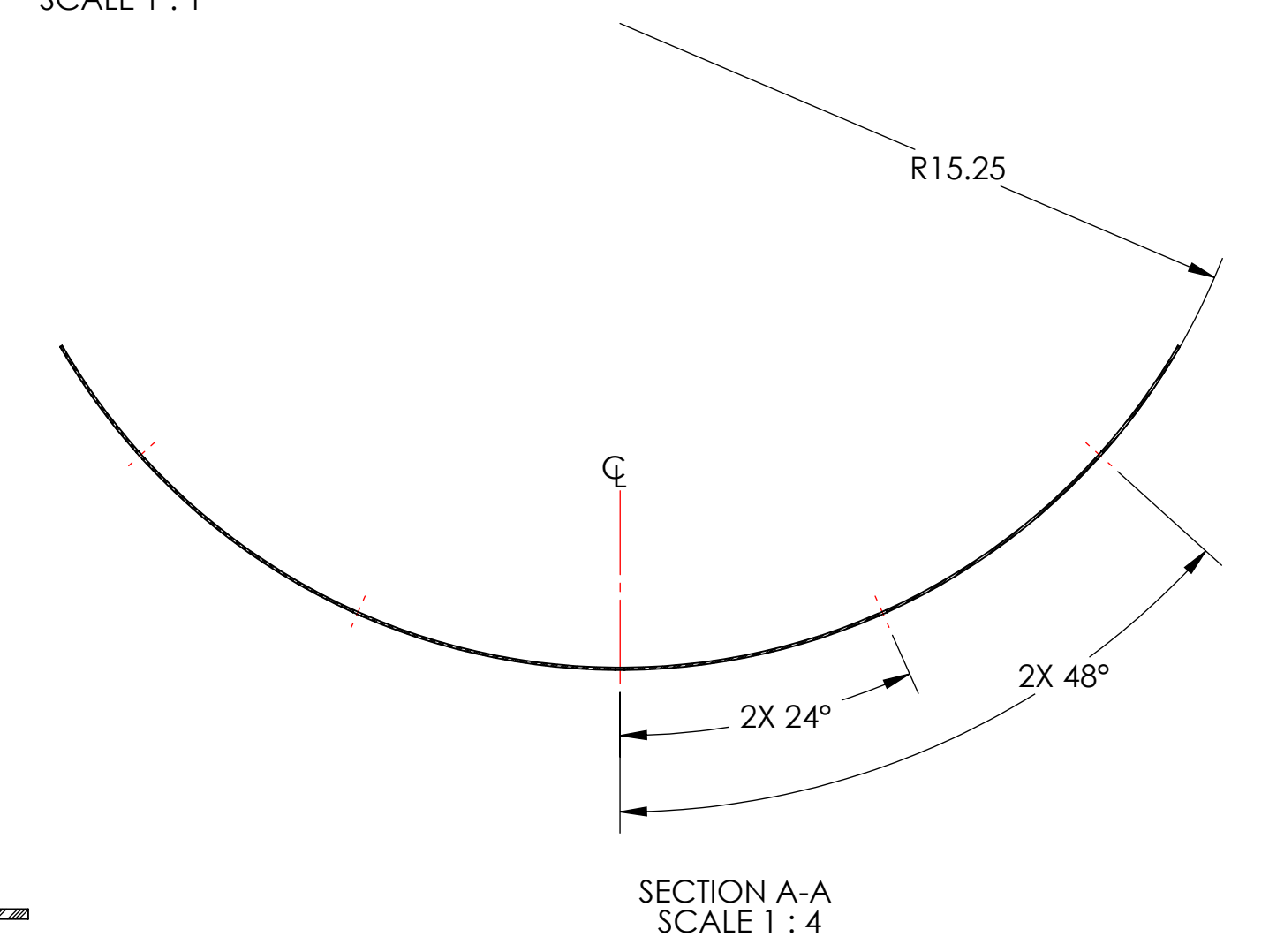
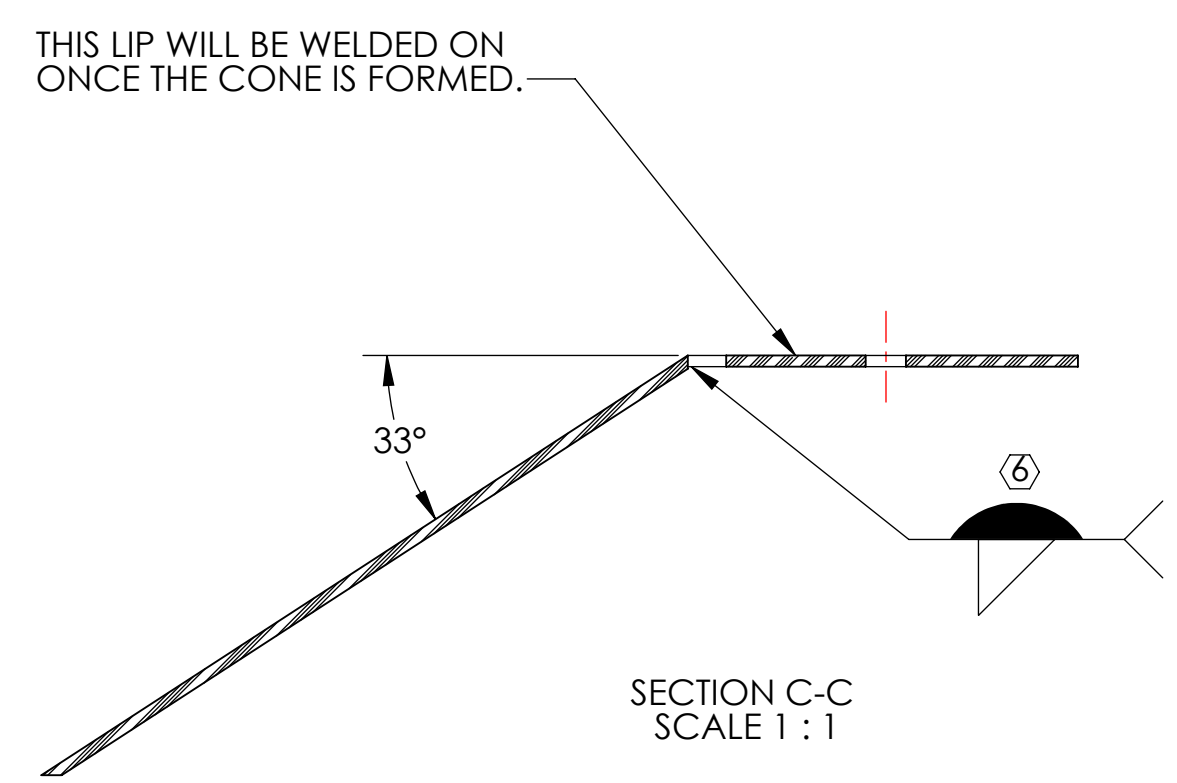
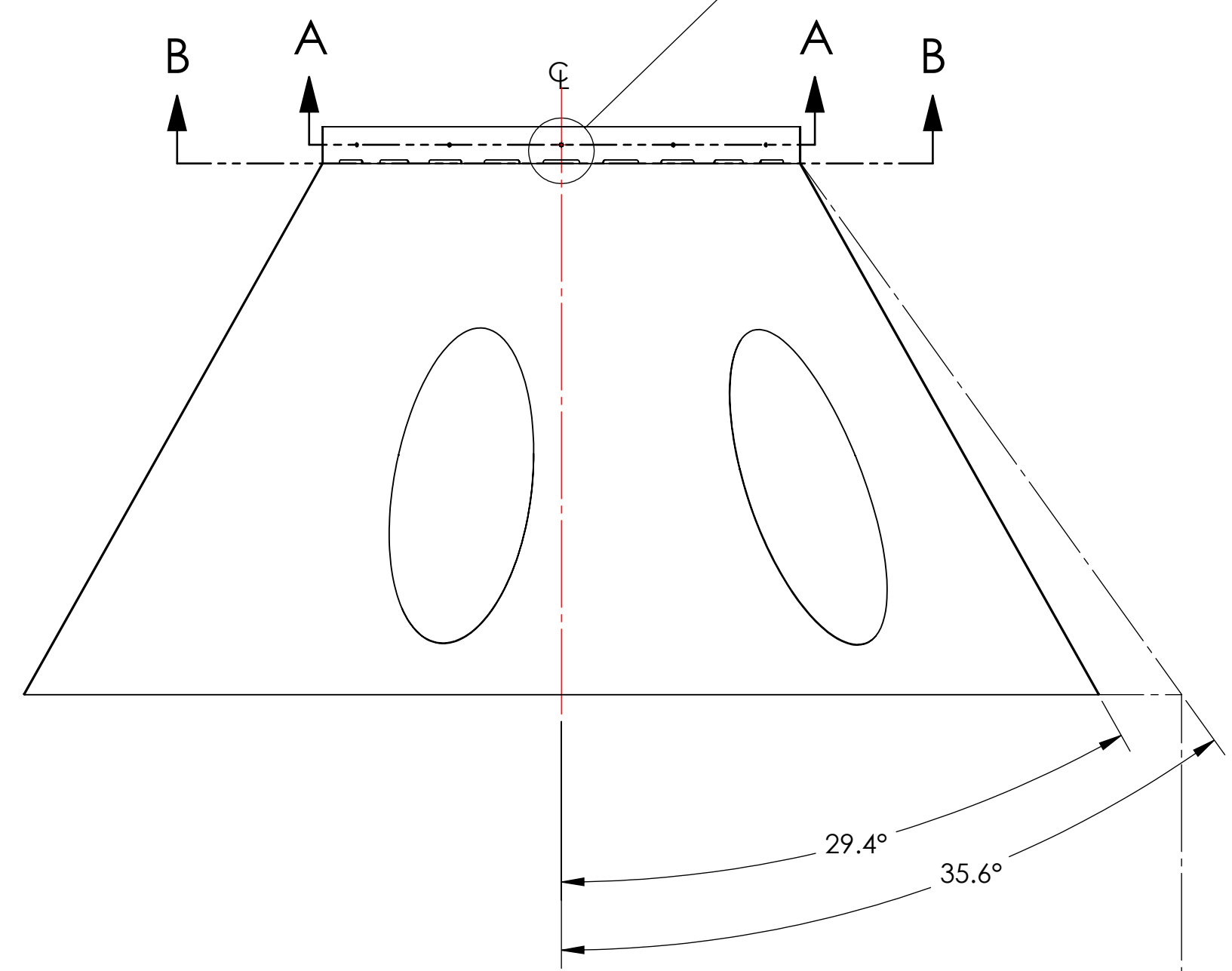
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR 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. WELD MUST BE PER SPECIFICATION E900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



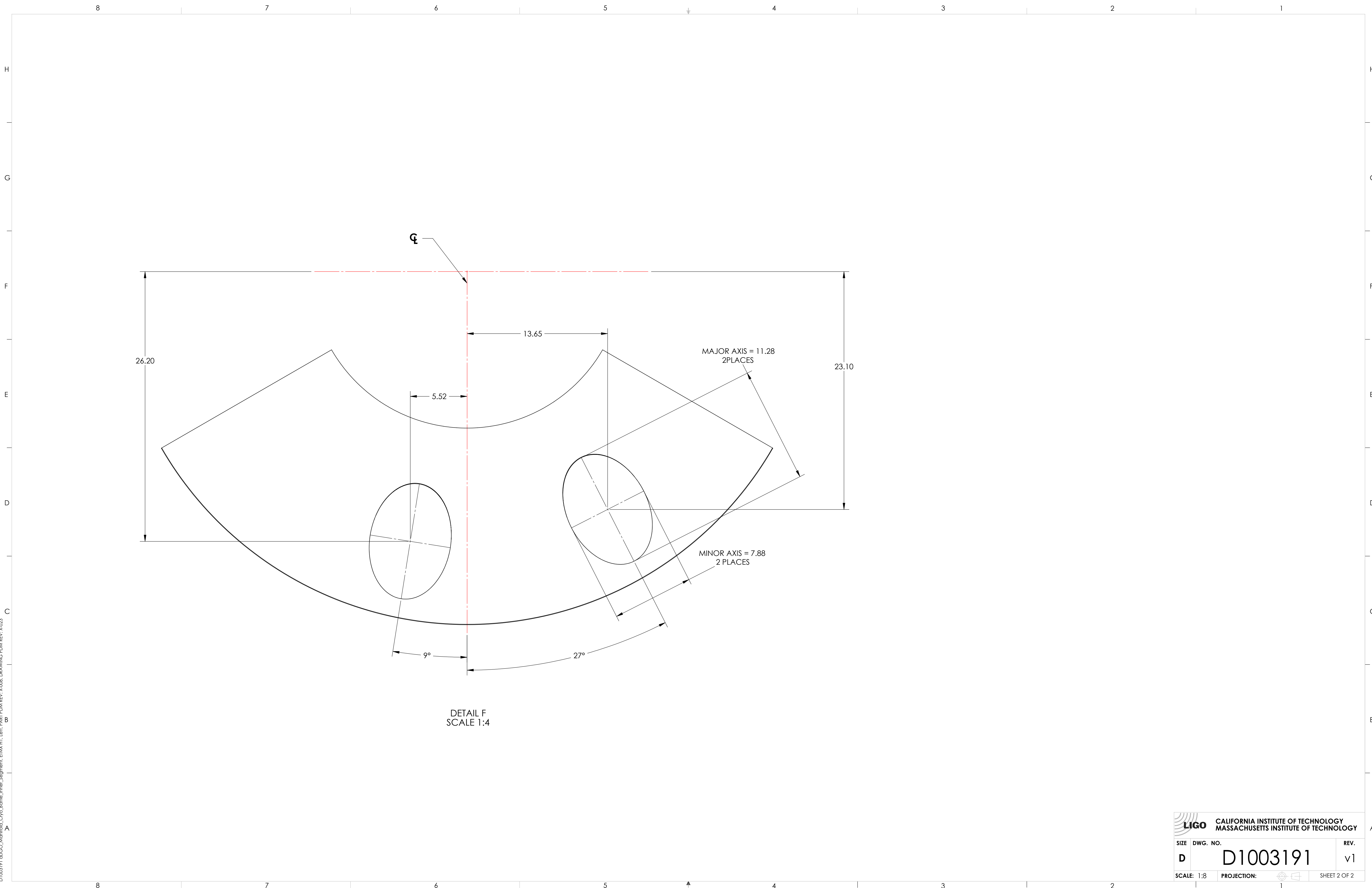
THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .06 .XXX ± .010	
ANGULAR ± 0.5°	
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	FINISH
18GA A424 TYPE 1 STEEL	⑦


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D1003188

PART NAME				MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, LEFT			
DESIGNER	TQ. NGUYEN	6 DEC 2010	SIZE	D	DWG. NO.	D1003191	REV.
DRAFTER	TQ. NGUYEN	7 DEC 2010					v1
CHECKER	M. SMITH						
APPROVAL	D. COYNE		SCALE: 1:8	PROJECTION:			SHEET 1 OF 2

D:\003191\dlUGO_Manifold_Cryo_Baffle_Inner_Segment1_ETMX_H1_Left_Plate_PDM_PDM_REV_X-008_DRAWING_PDM_REV_X-023



DETAIL F
SCALE 1:4

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	v1
D	D1003191	
SCALE: 1:8	PROJECTION:	SHEET 2 OF 2

D:\003191\dl\GO_MonField_Cryo_Baffle_Inner_Segment1_ETMX-H1_L1.dwg PDM REV. X:008 DRAWING PDM REV. X:023