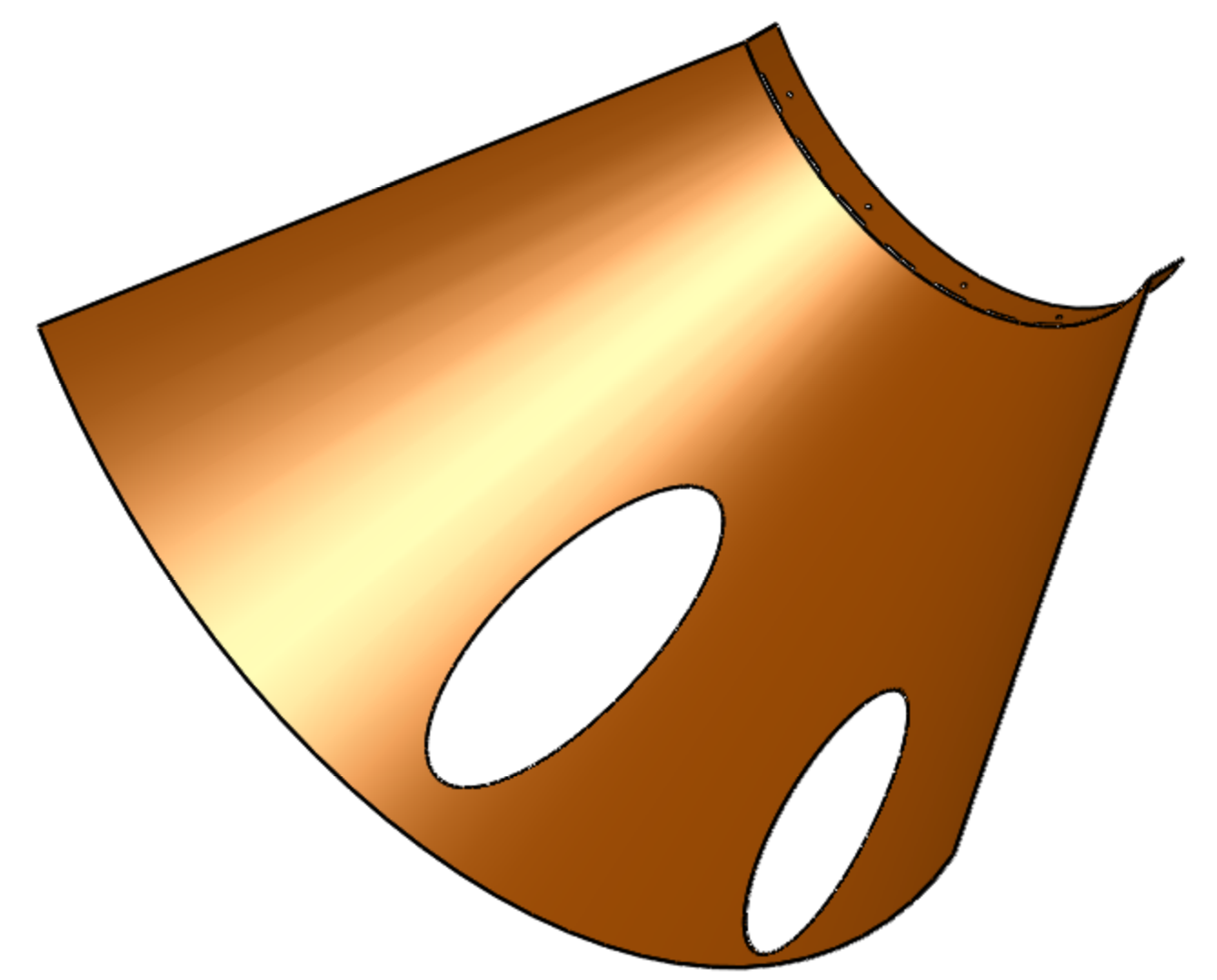
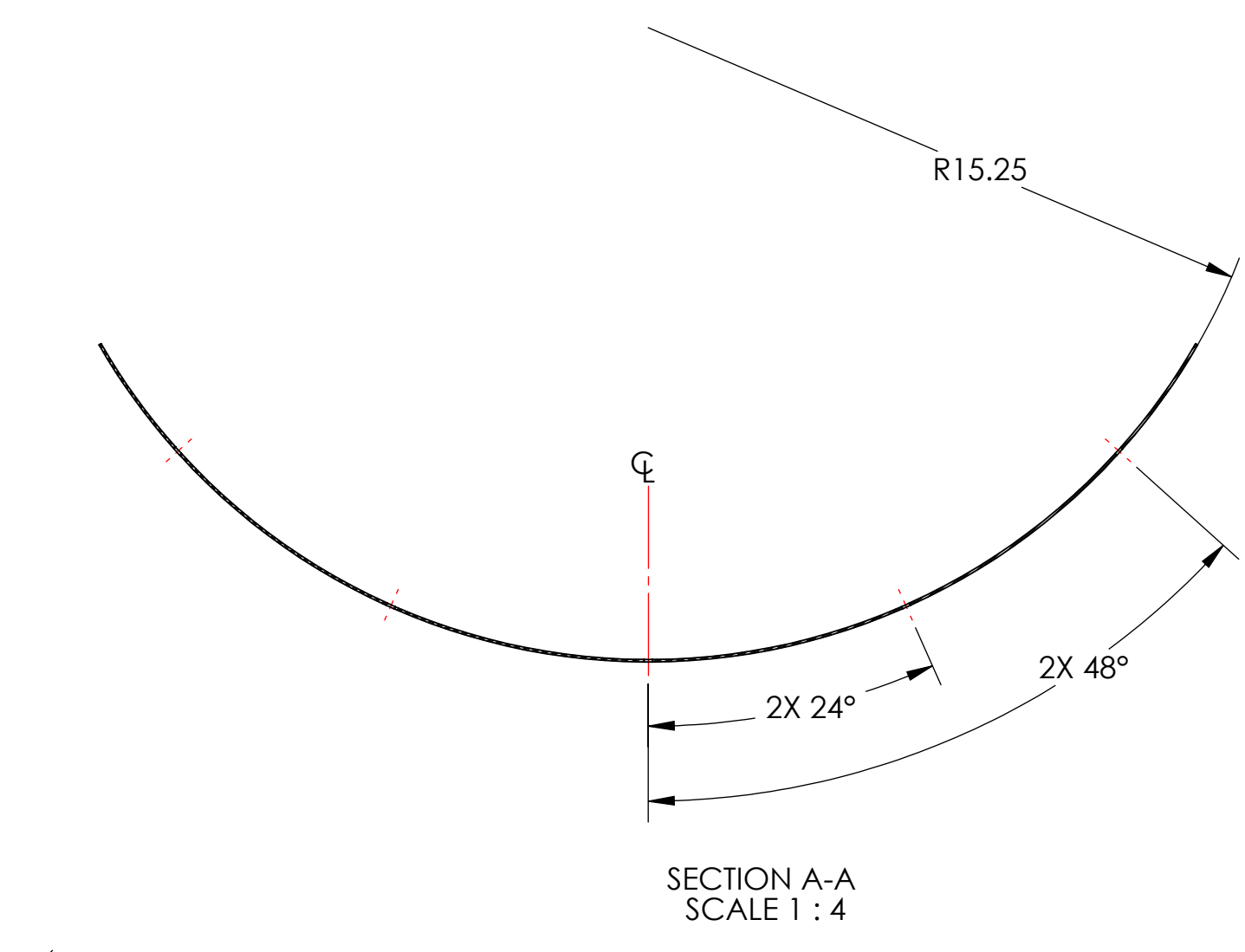
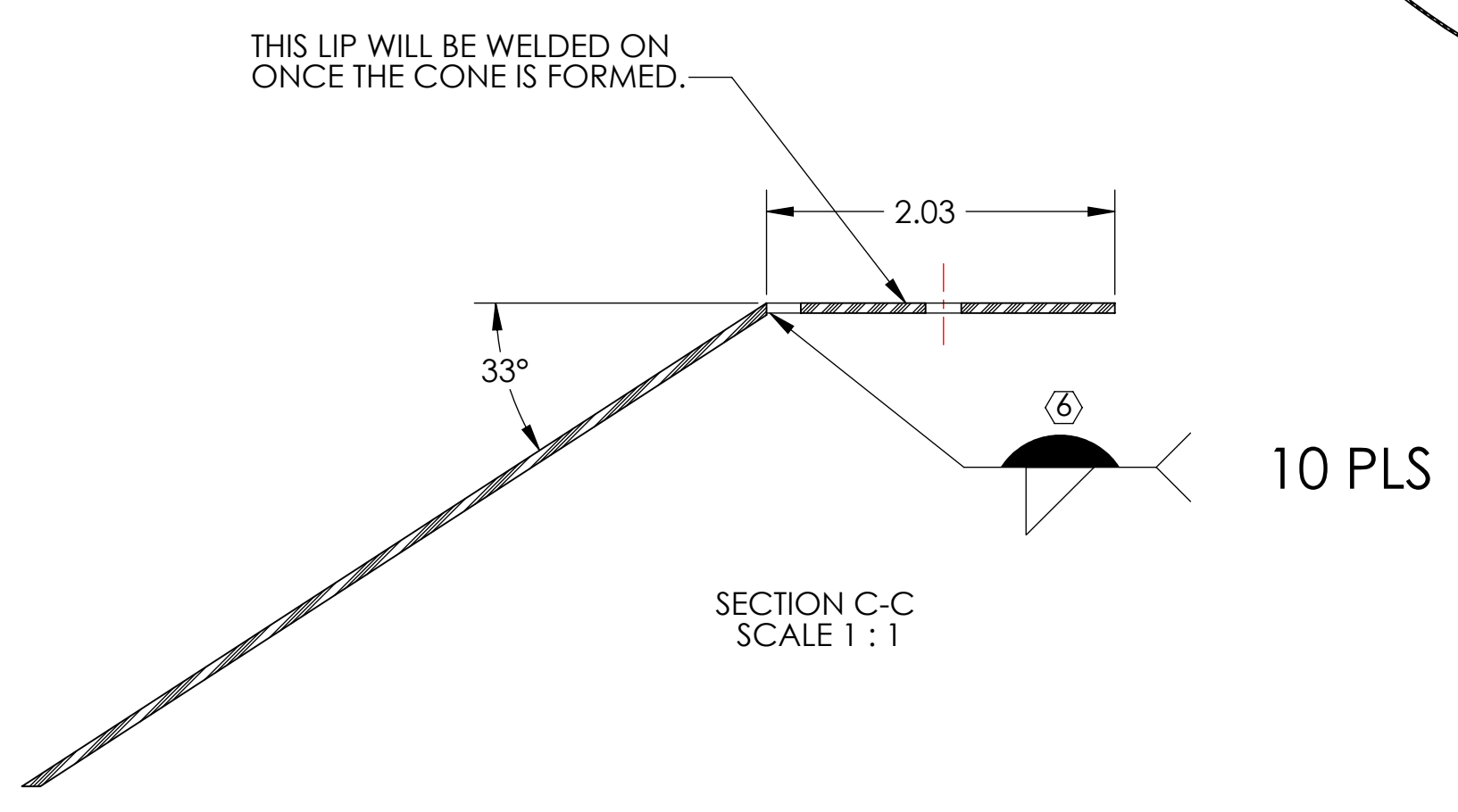
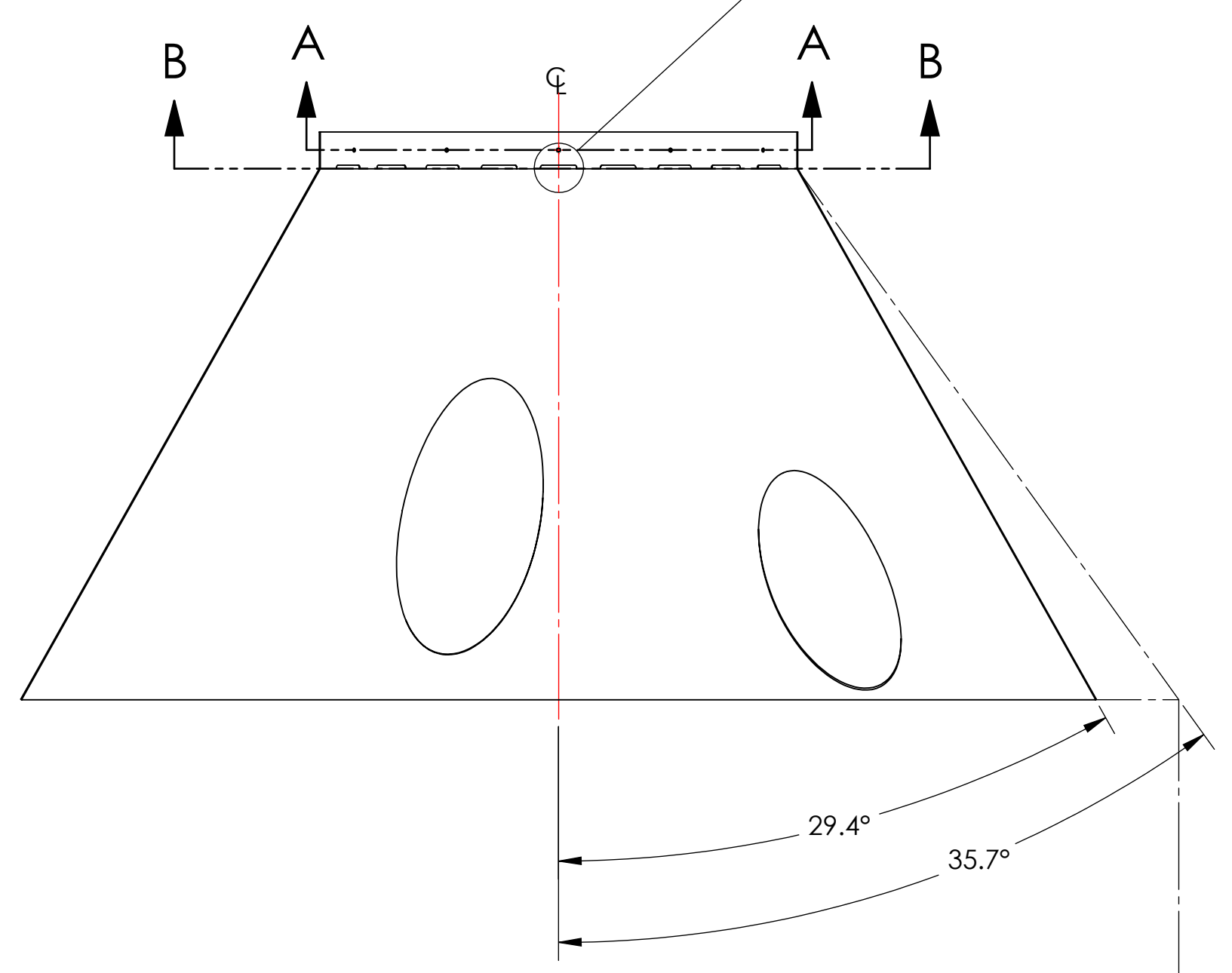
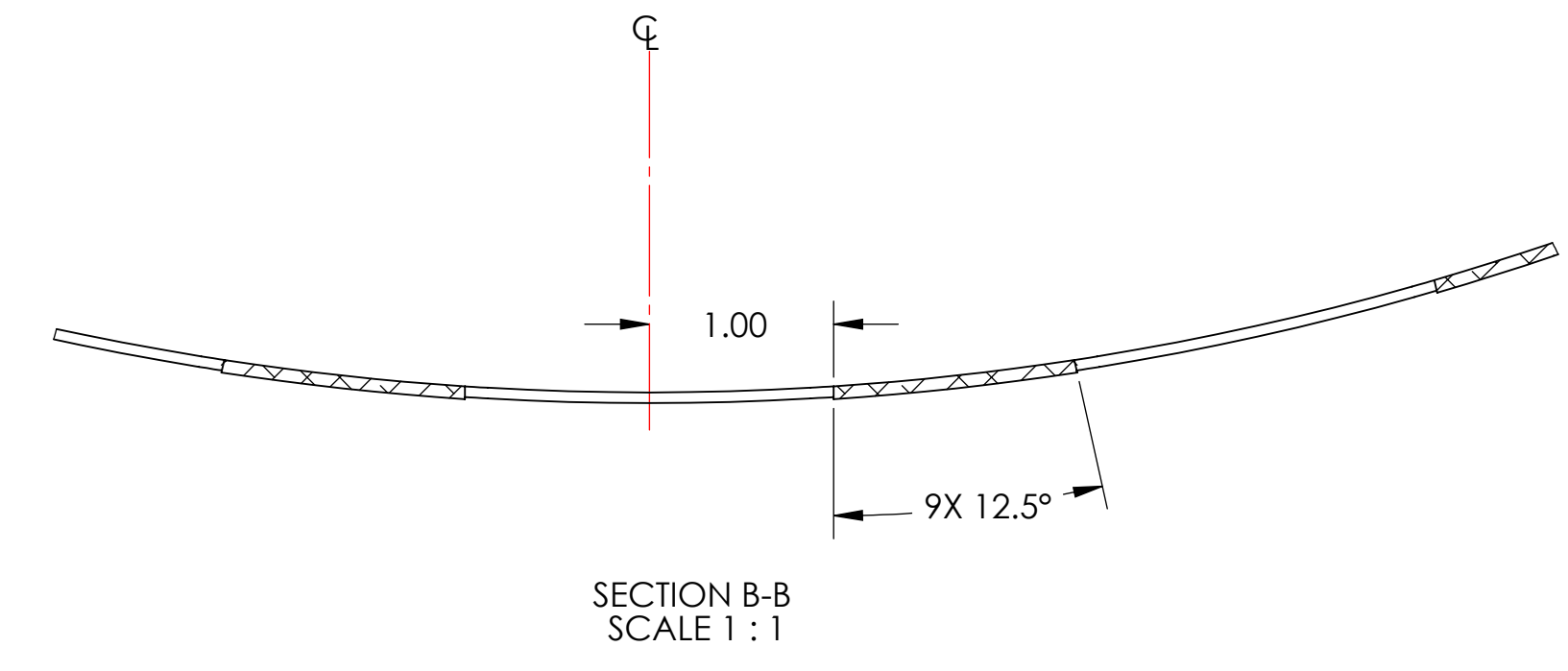
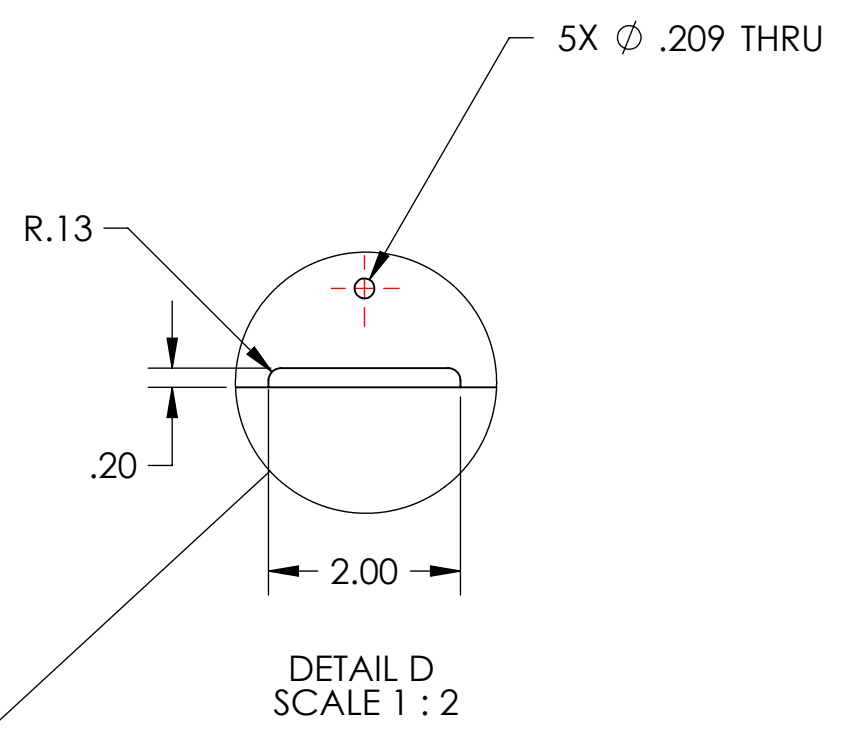


REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

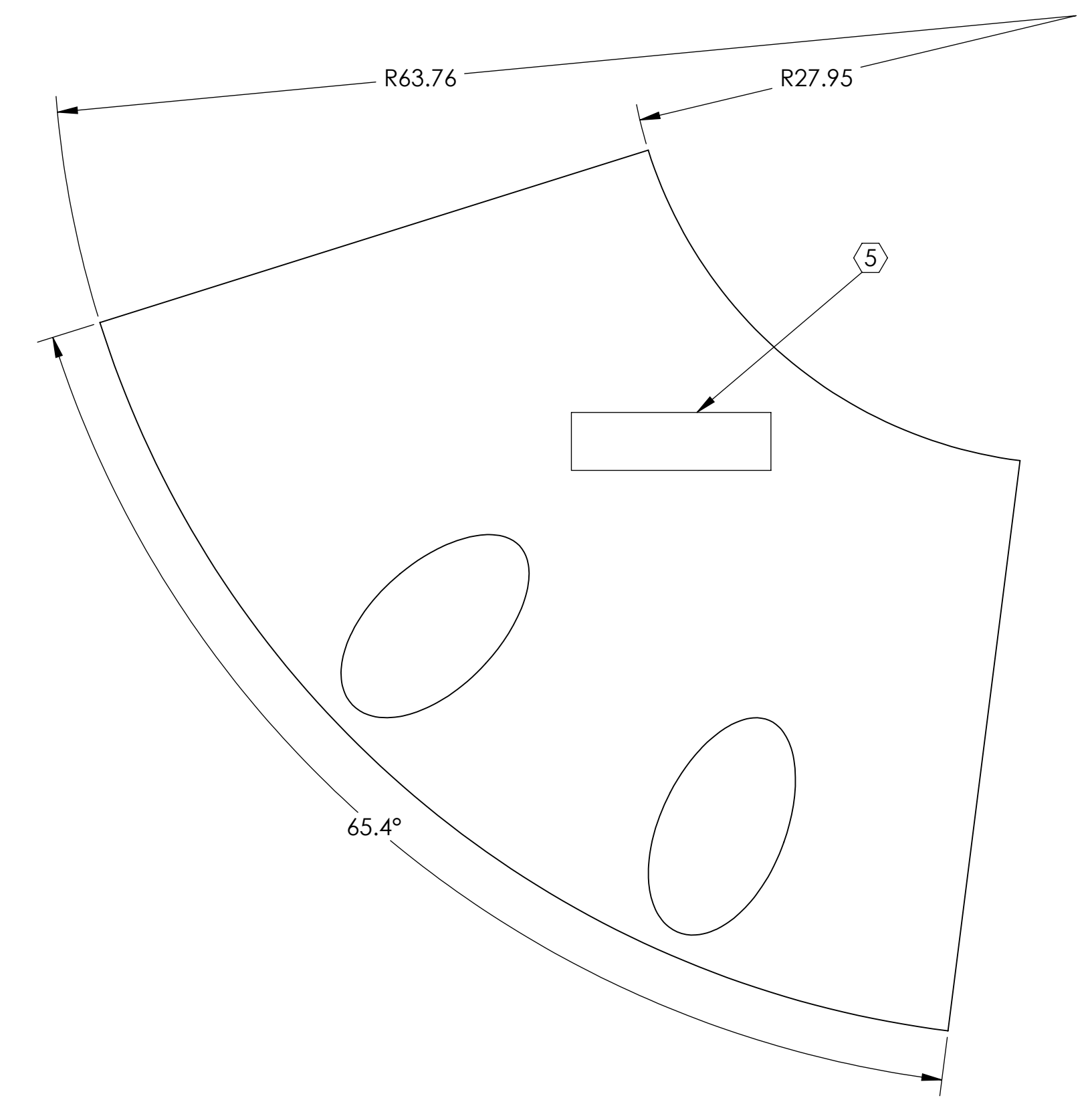
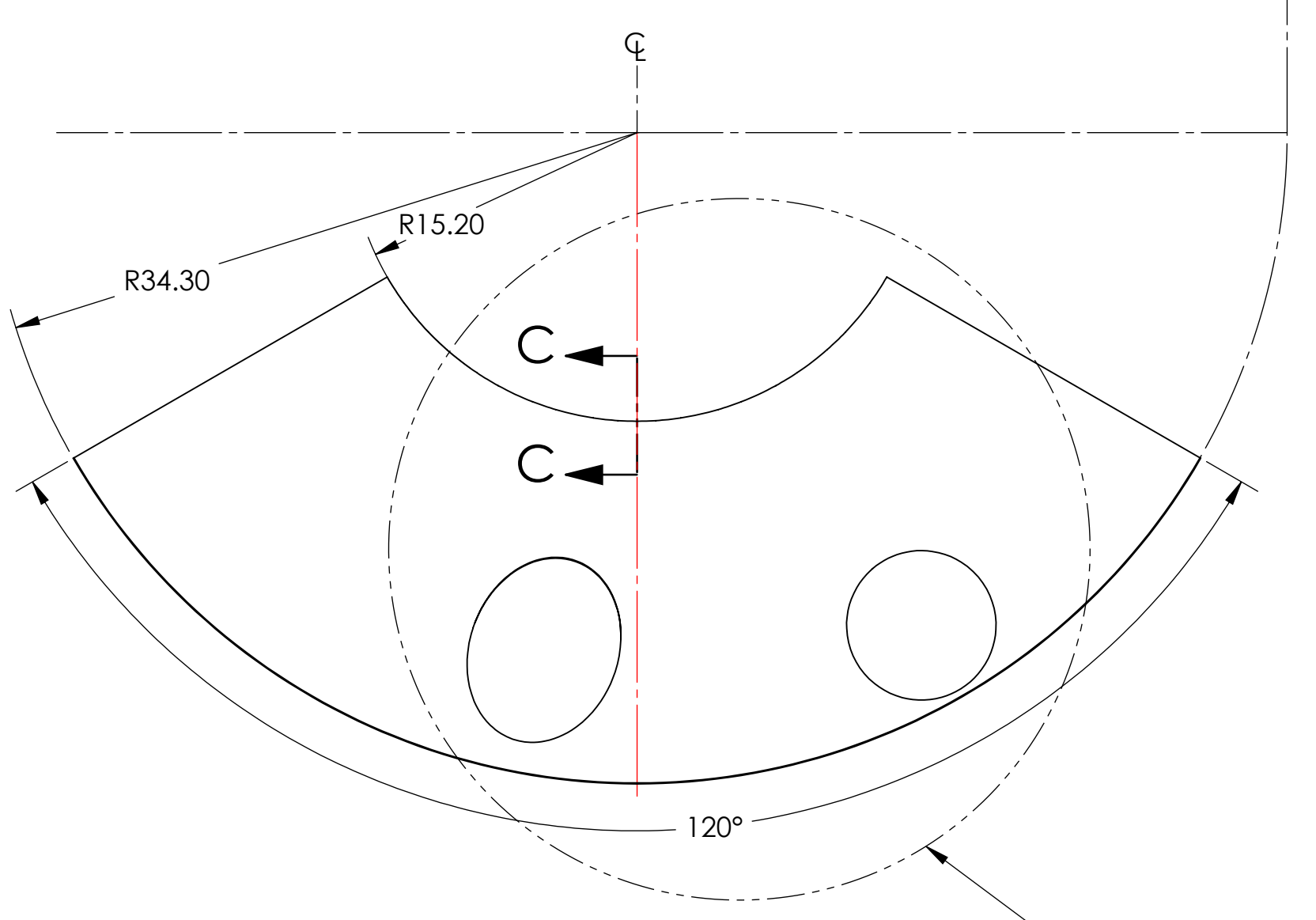
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR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



FLAT PATTERN (ATTACHMENT LIP REMOVED)

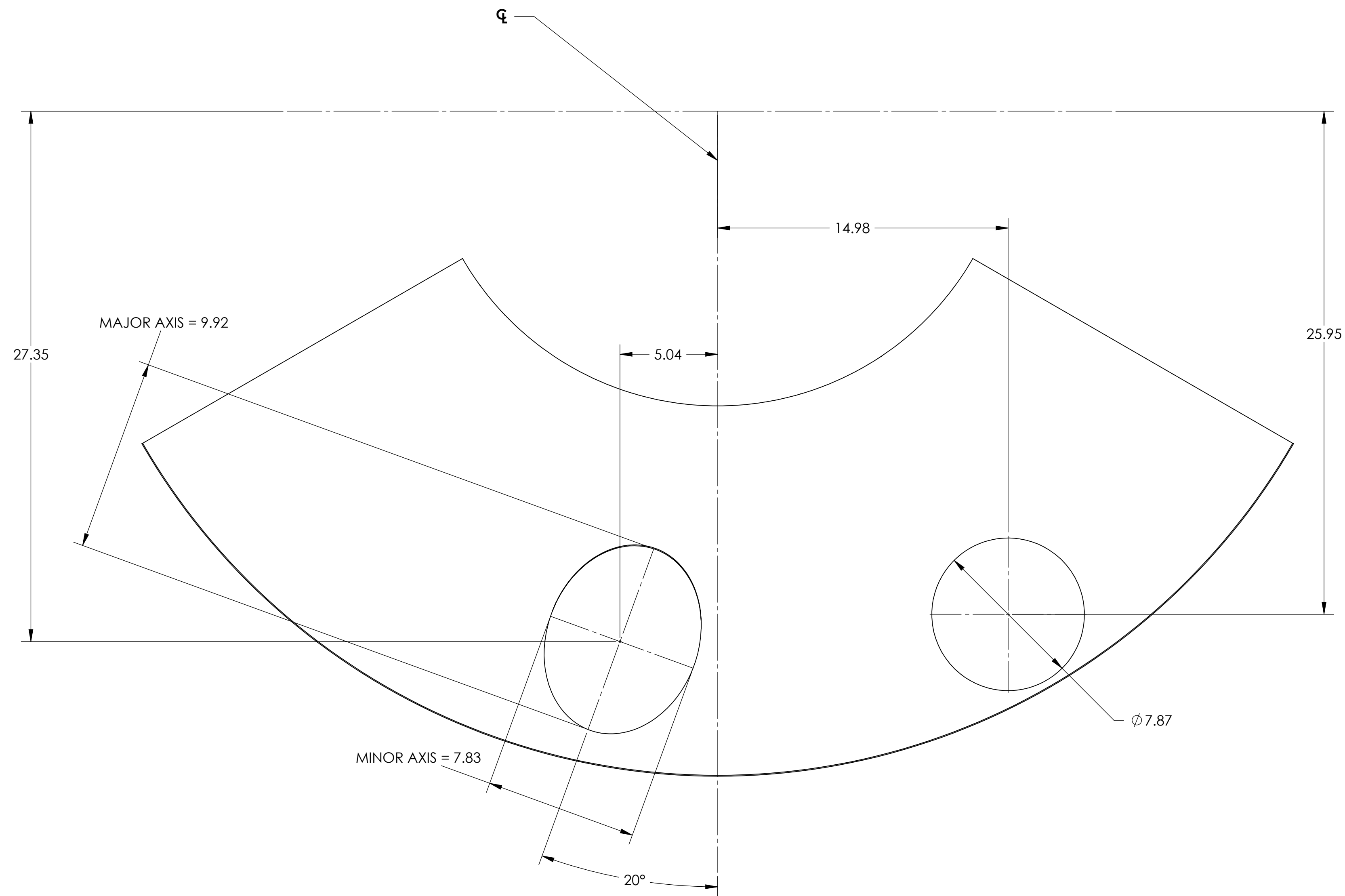
THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

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

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS
NEXT ASSY: D1003233	

PART NAME: MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMY H1, LEFT			
DESIGNER: TQ. NGUYEN	DATE: 16 DEC 2010	SIZE: D	DWG. NO.: D1003234
DRAFTER: TQ. NGUYEN	DATE: 17 AUG 2010	REV.: v1	
CHECKER: M. SMITH			
APPROVAL: D. COYNE		SCALE: 1:8	PROJECTION:
		SHEET 1 OF 2	

D:\003234_d\UGO_Monolith_Cryo_Baffle_Inner_Segment_ETMY_H1_LEFT_PART.PDM.REV-K.007.DRAWING.PDM.REV-K.004



DETAIL E
SCALE 1 : 4

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	v1
D	D1003234	
SCALE: 1:8	PROJECTION:	SHEET 2 OF 2

D:\003234.dwg - M001.dwg - LIGO - Monitor - Cyl - Baffle - Jms - Jms - Segment - E1M1 (1) - LEFT - PART PDM REV - X-007 - DRAWING PDM REV - X-004