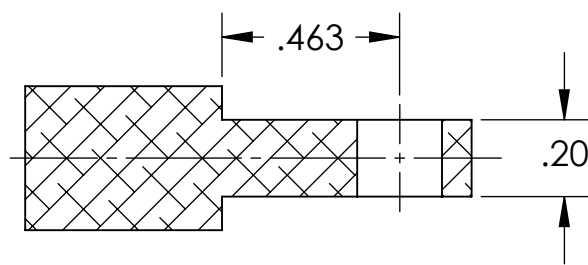NOTES CONTINUED:

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

8. 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.

9. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

10. DELETED.

REV.	DATE	DCN #	DRAWING TREE #
v1	9 MAY 2011	E1000360-v2	-
v2	14 SEP 2011	E1000360-V3	-

TABLE OF LENGTH

	D1100866-01	D1100866-02
X	11.750	10.25
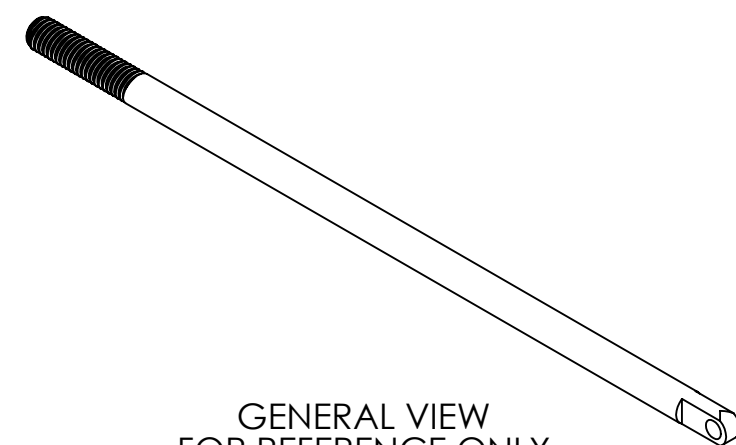
GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

.463

.20

SECTION A-A
SCALE 2 : 1
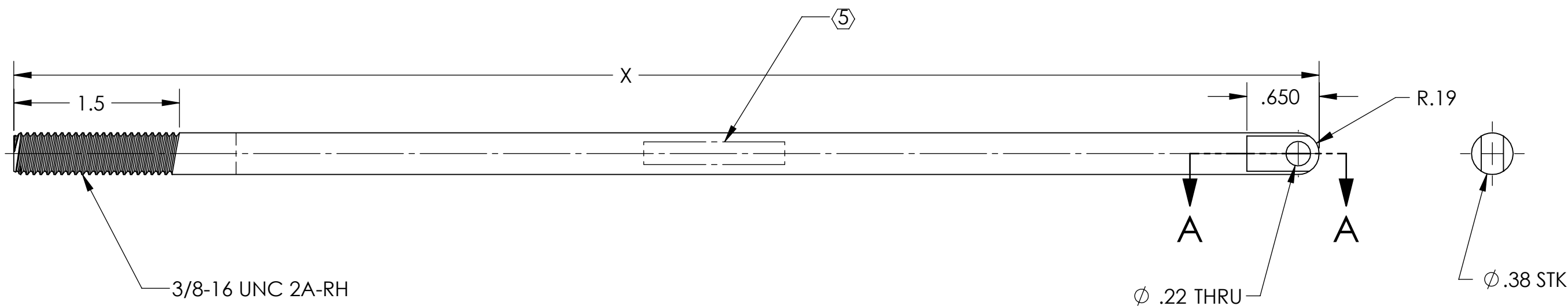
⑤

X

1.5

.650

R.19

3/8-16 UNC 2A-RH

A ← → A

Ø .22 THRU

Ø .38 STK

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .02
.XXX ± .005

ANGULAR ± 1.0°

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.

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS

MATERIAL: 304 SSTL
FINISH: 32 μinch
NEXT ASSY: D1100865

PART NAME: MANIFOLD CRYO PUMP BAFFLE, ROD

DESIGNER	H. KELMAN	9 MAY 2011	
DRAFTER	TQ. NGUYEN	9 MAY 2011	
CHECKER	M. SMITH		
APPROVAL	D. COYNE		

SIZE: B
DWG. NO.: D1100866
REV.: v2

SCALE: 1:1   PROJECTION: SHEET 1 OF 1