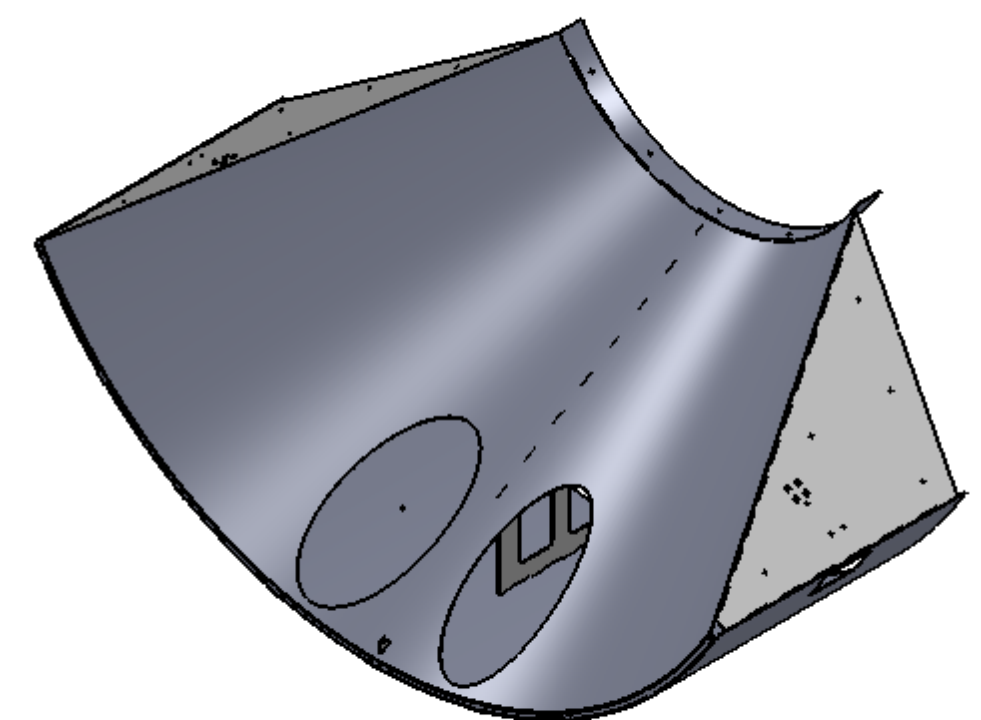
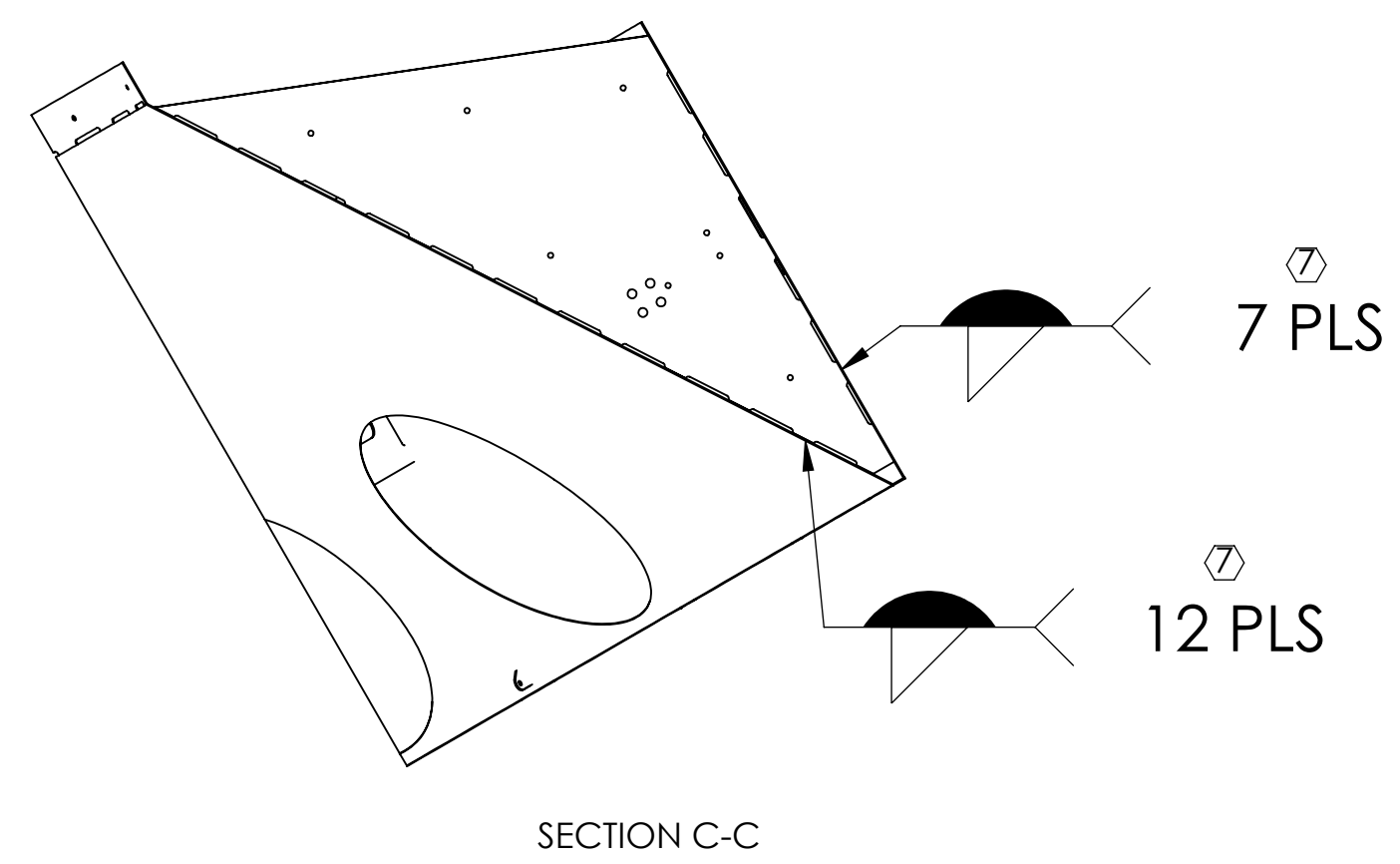
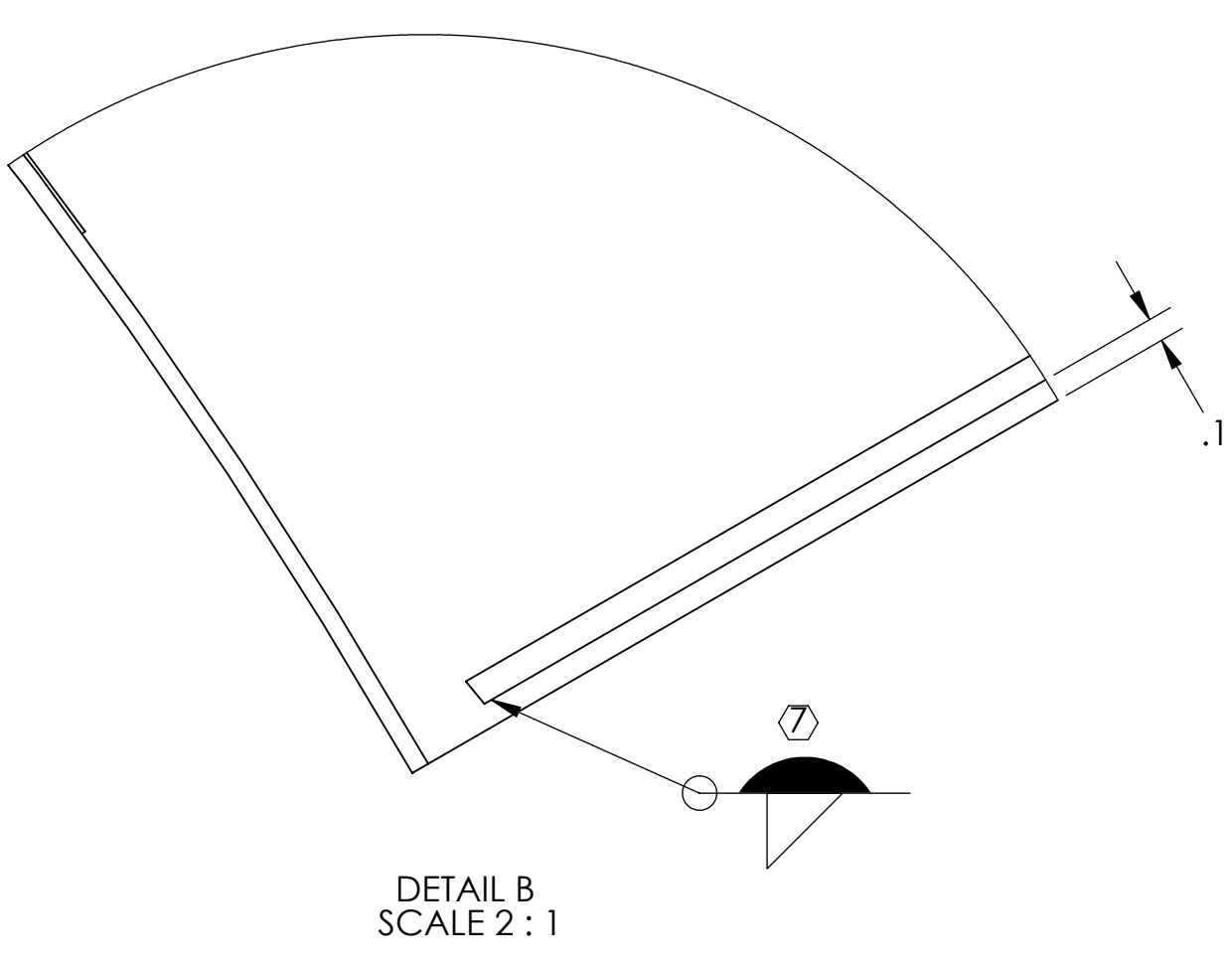
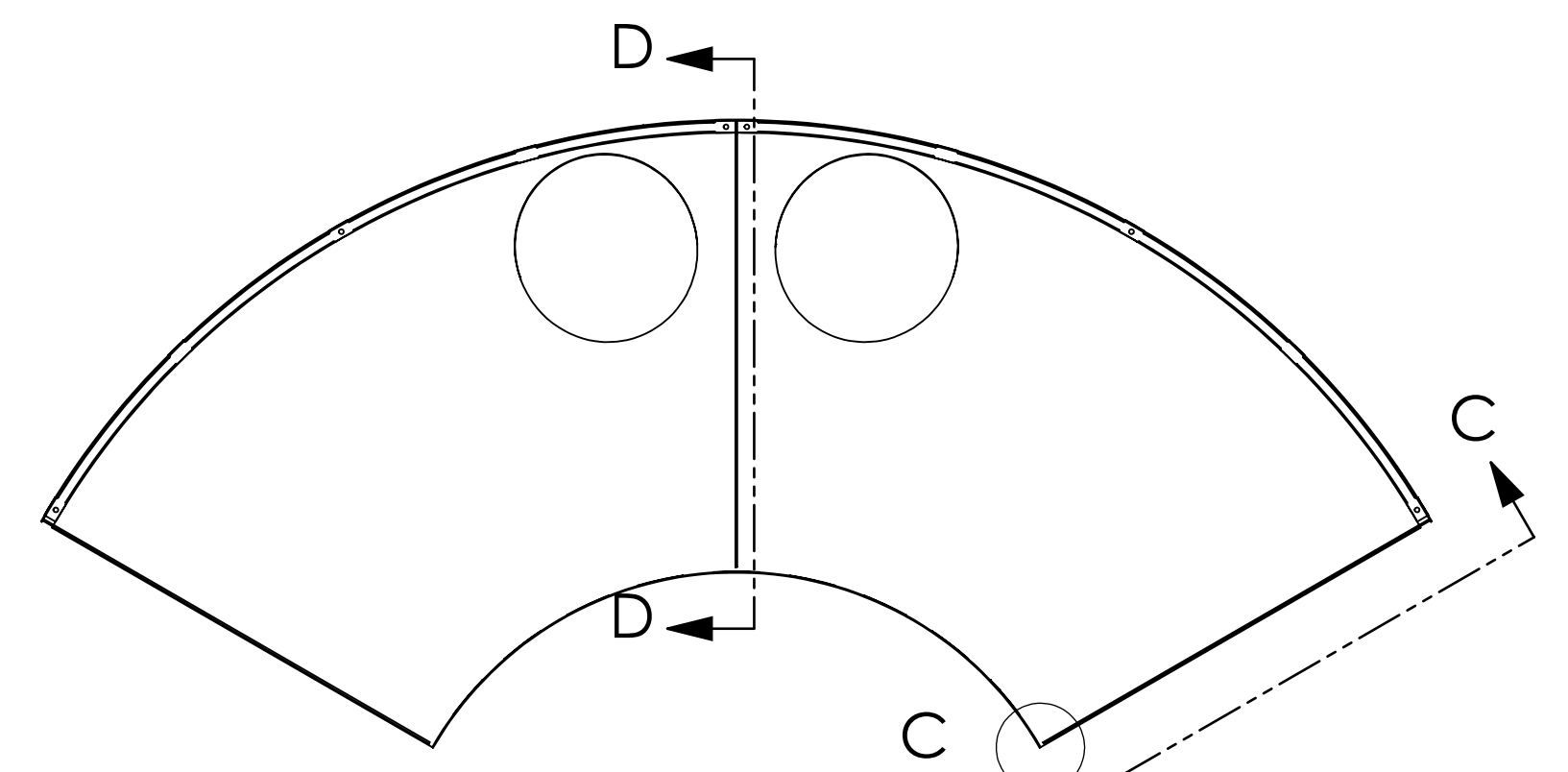


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND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

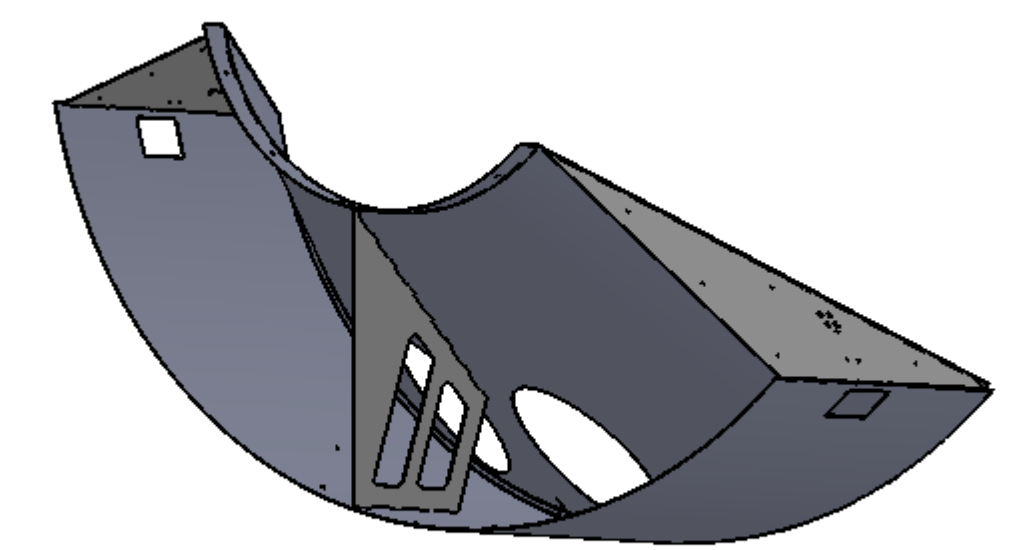
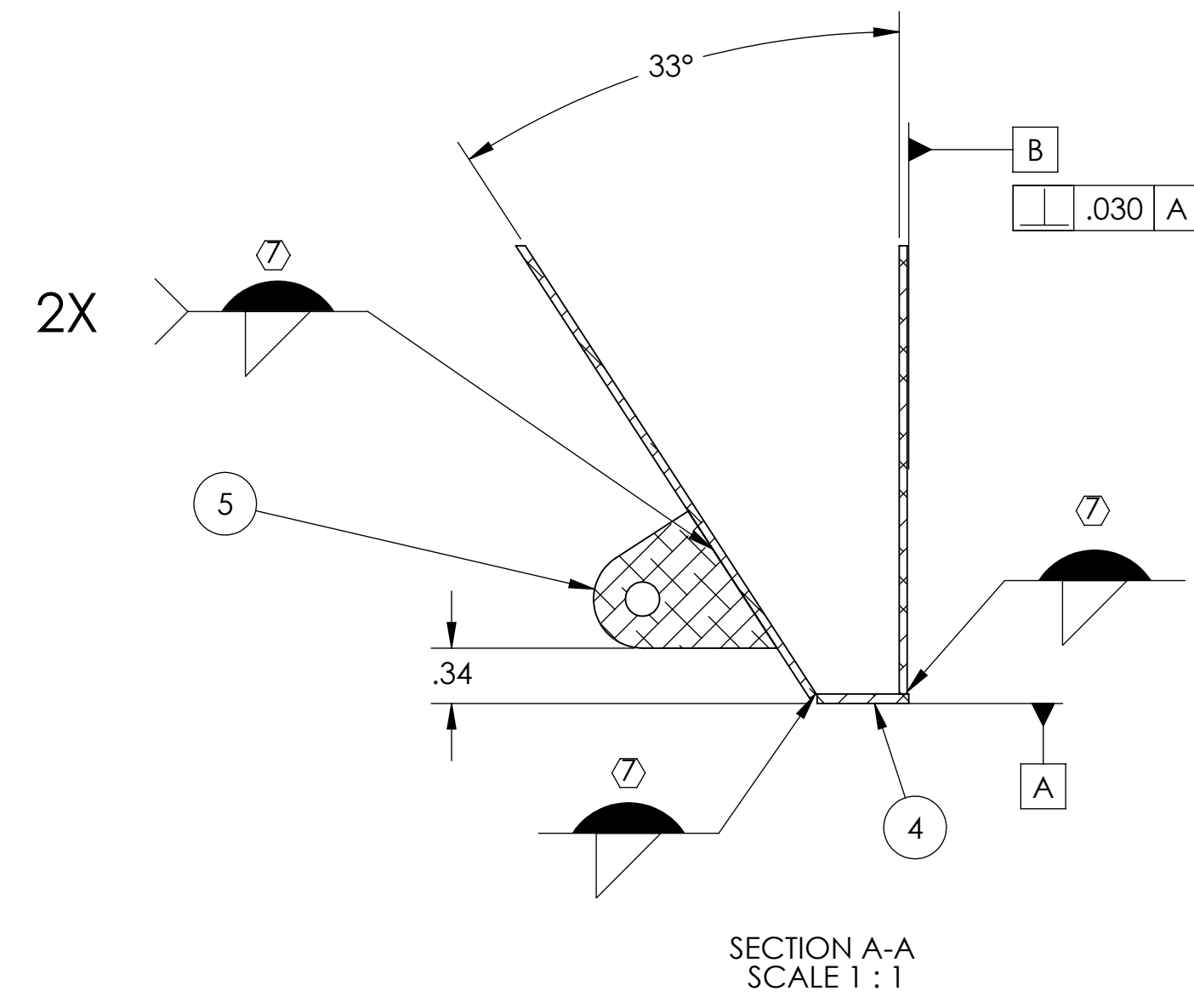
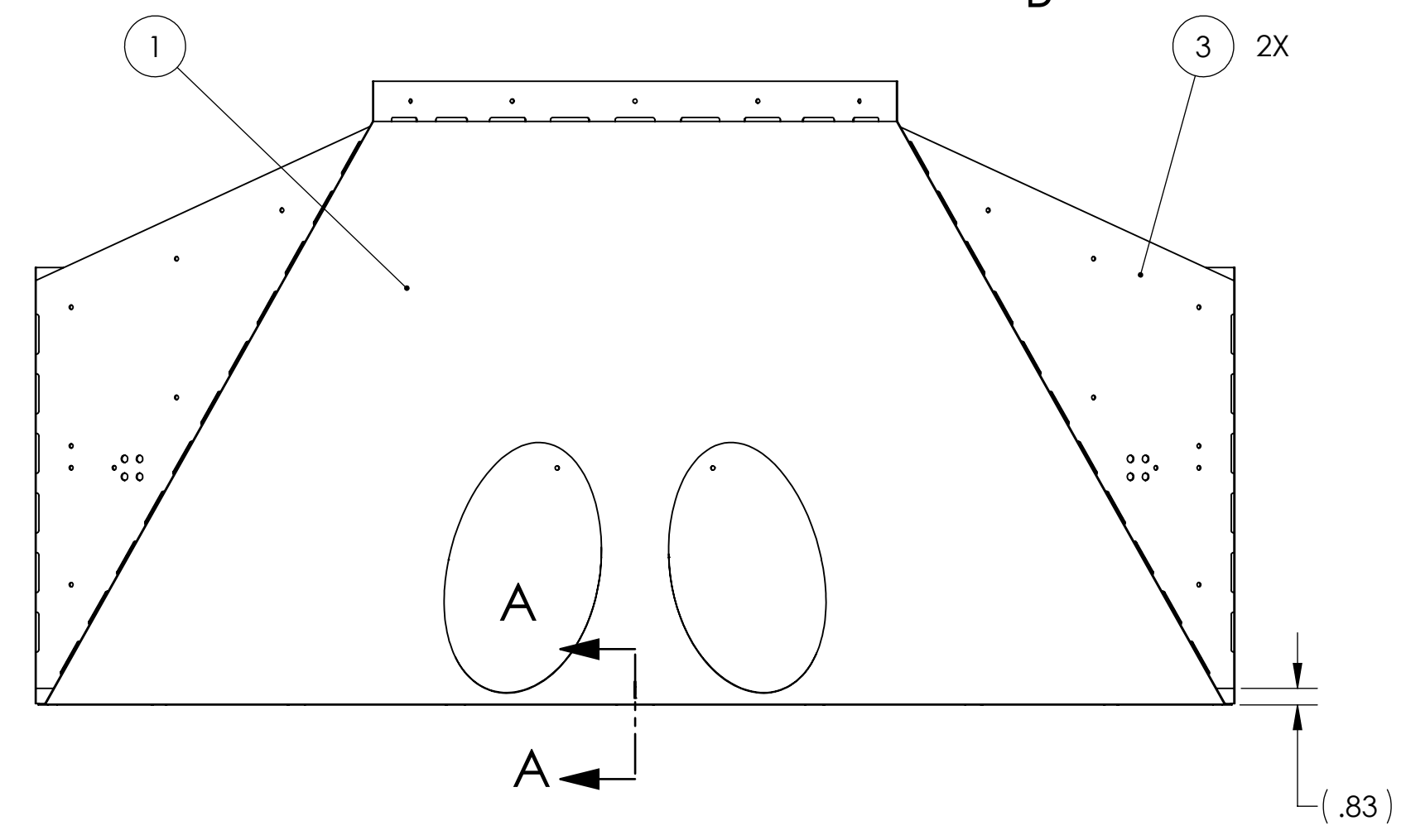
6. ASSEMBLY TO BE OXIDIZED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1100842.

7. FILLET WELDS WHERE ITEMS MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

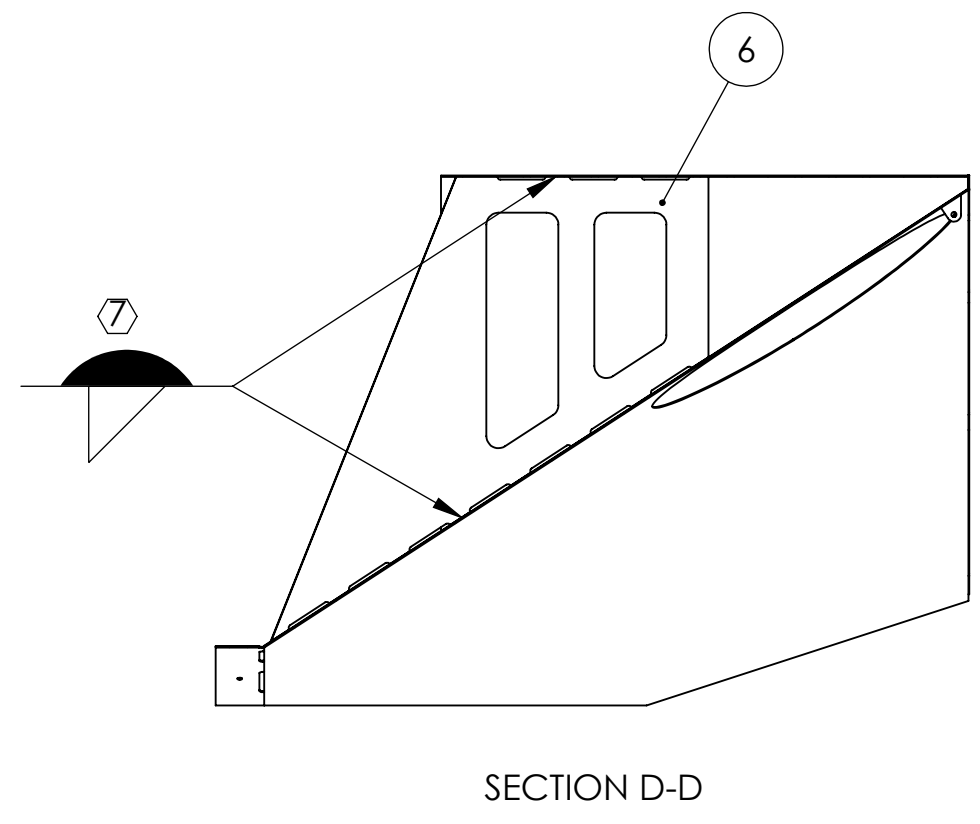
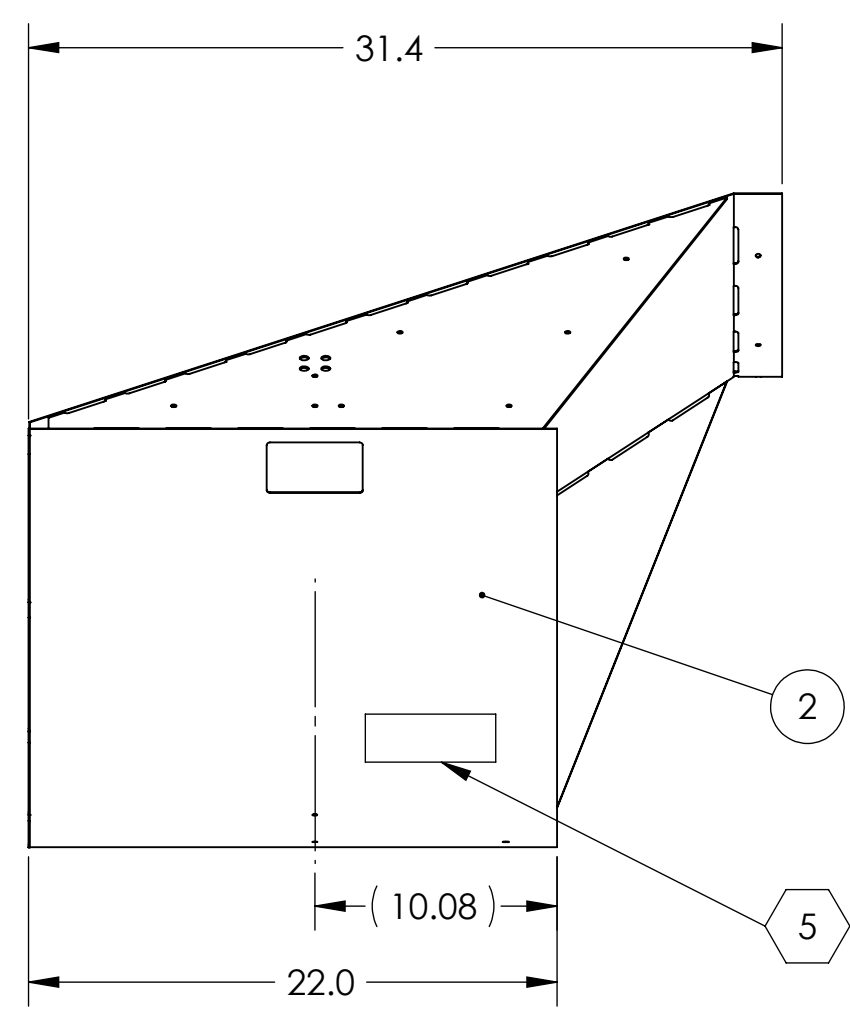
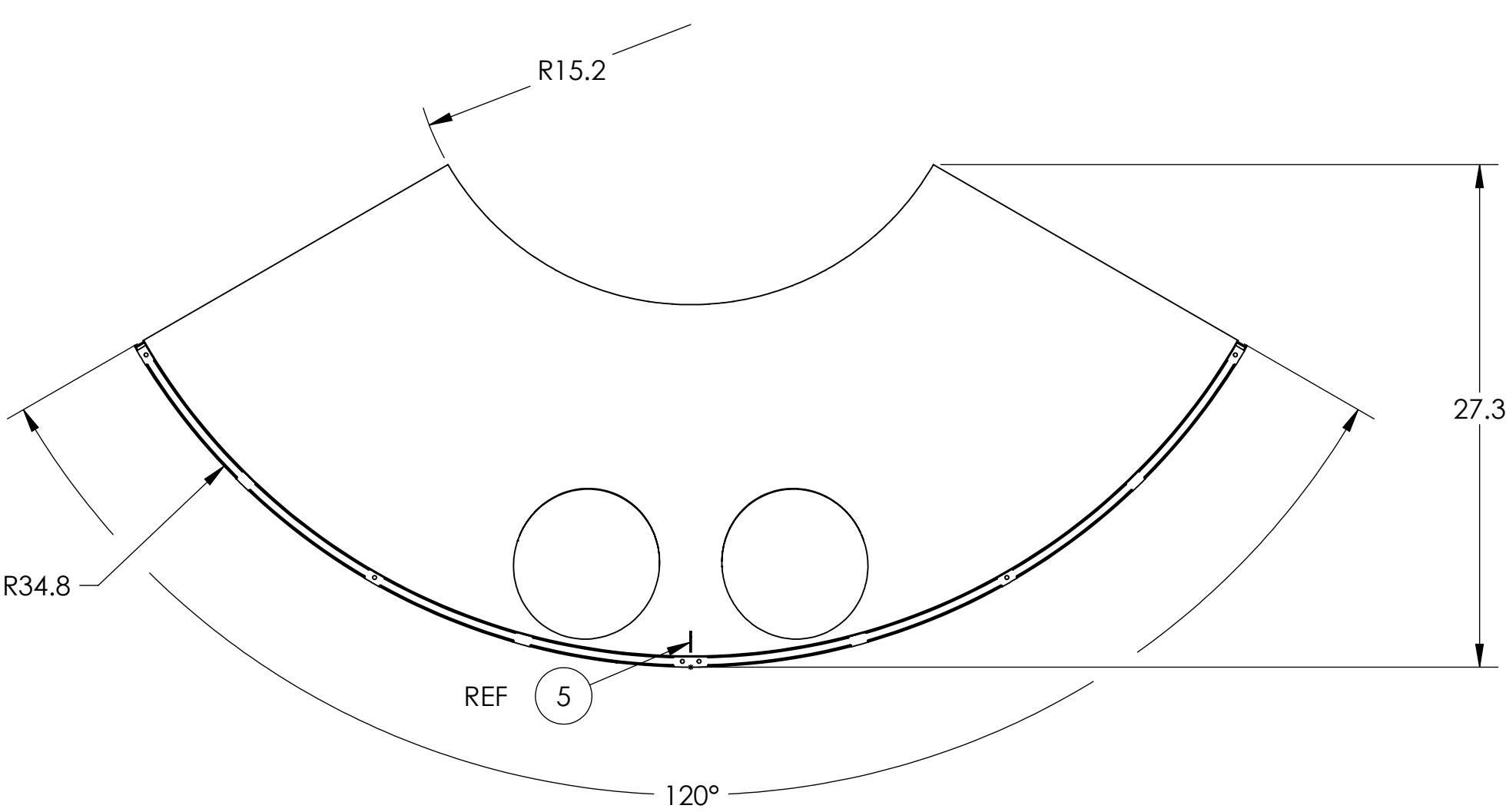
REV.	DATE	DCN #	DRAWING TREE #
v1	17 MAR 2010	E1000360	E1000085
v2	9 MAY 2011	E1000360-v2	-
v3	6 OCT 2011	E1000360-v3	-



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSSL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18 GAUGE 304 SSSL	1		1
1	D0902623	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITM XY, BOTTOM	18 GAUGE 304 SSSL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015 FOR 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.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .X ± .1
 .XX ± .06
 .XXX ± .010
 ANGULAR ± 1.0°

MATERIAL N/A FINISH N/A

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS NEXT ASSY: D1101398

PART NAME: MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITM XY, BOTTOM

DESIGNER: H. KELMAN 17 MAR 2010 SIZE: DWG. NO. D0902655 REV. v3
 DRAFTER: TQ. NGUYEN 03 SEP 2010
 CHECKER: M. SMITH
 APPROVAL: D. COYNE

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

D0902655 at LIGO_Monfield_Cryo_Baffle_Segment_Subassembly_Weldment_ITM_XY_BOTTOM.PART PDM REV: X-090 DRAWING PDM REV: X-034