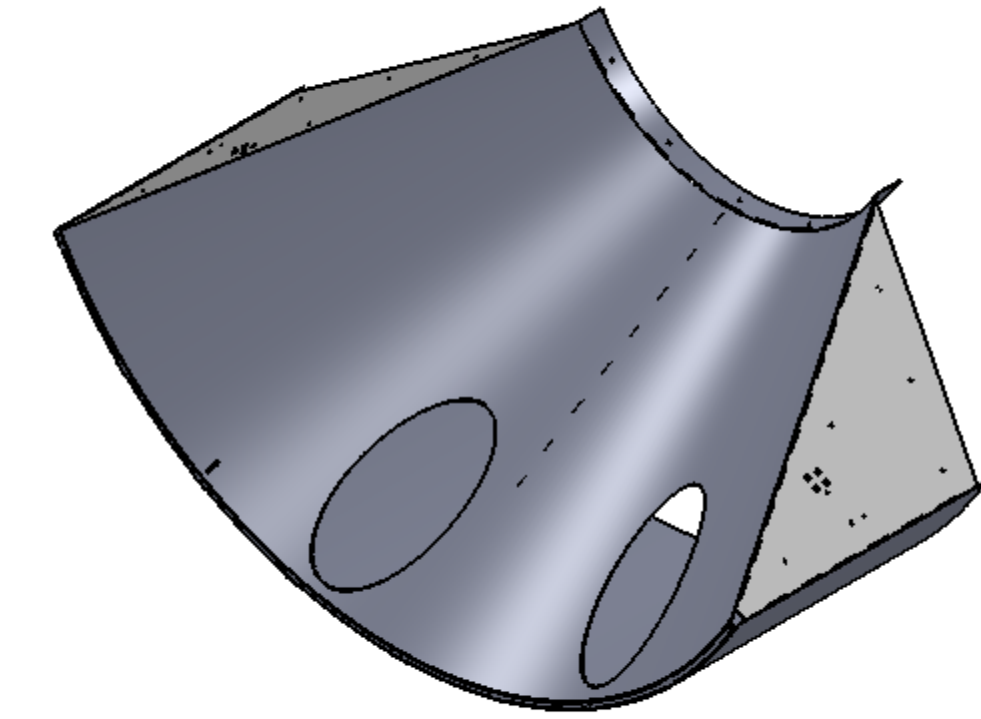
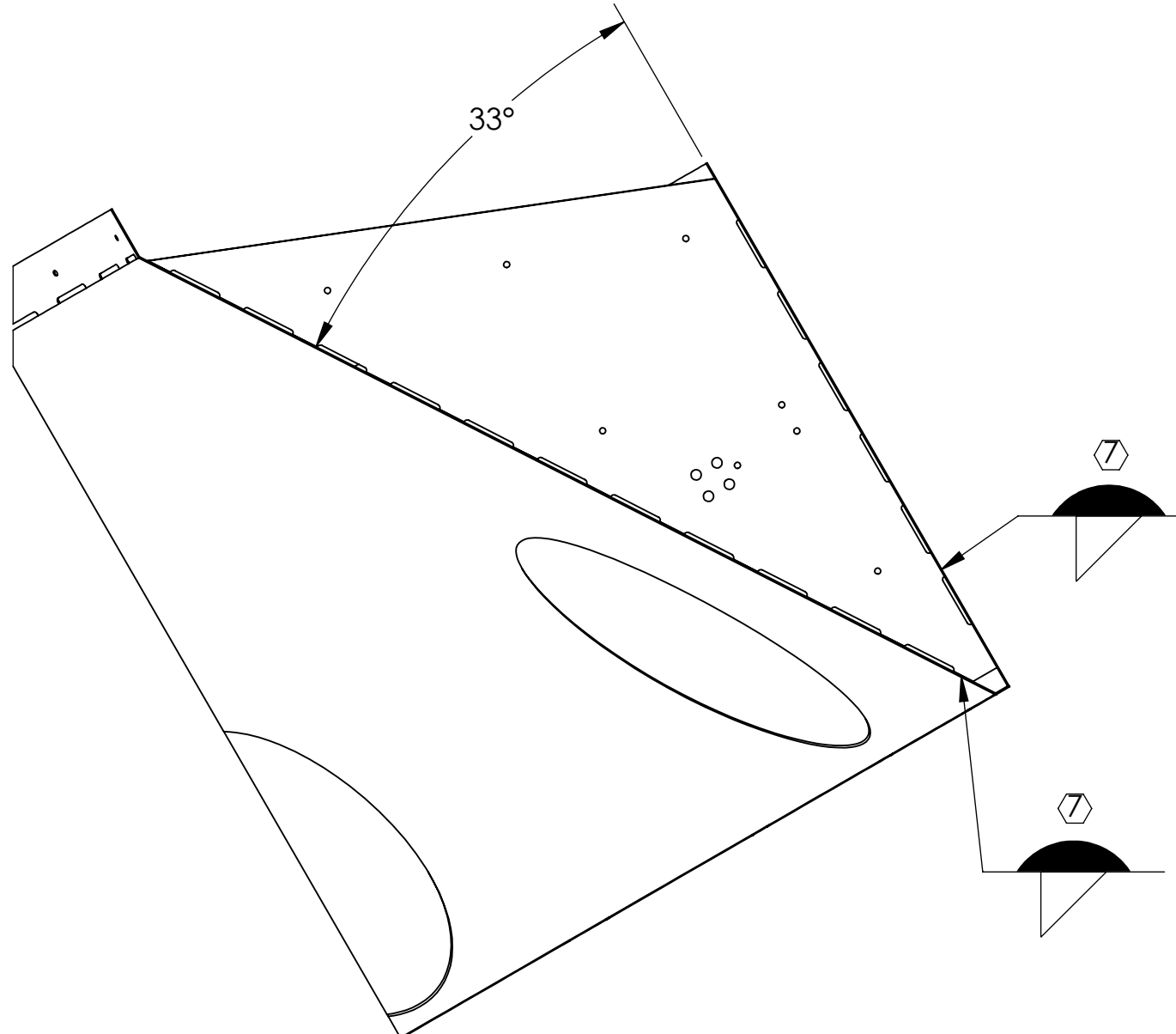
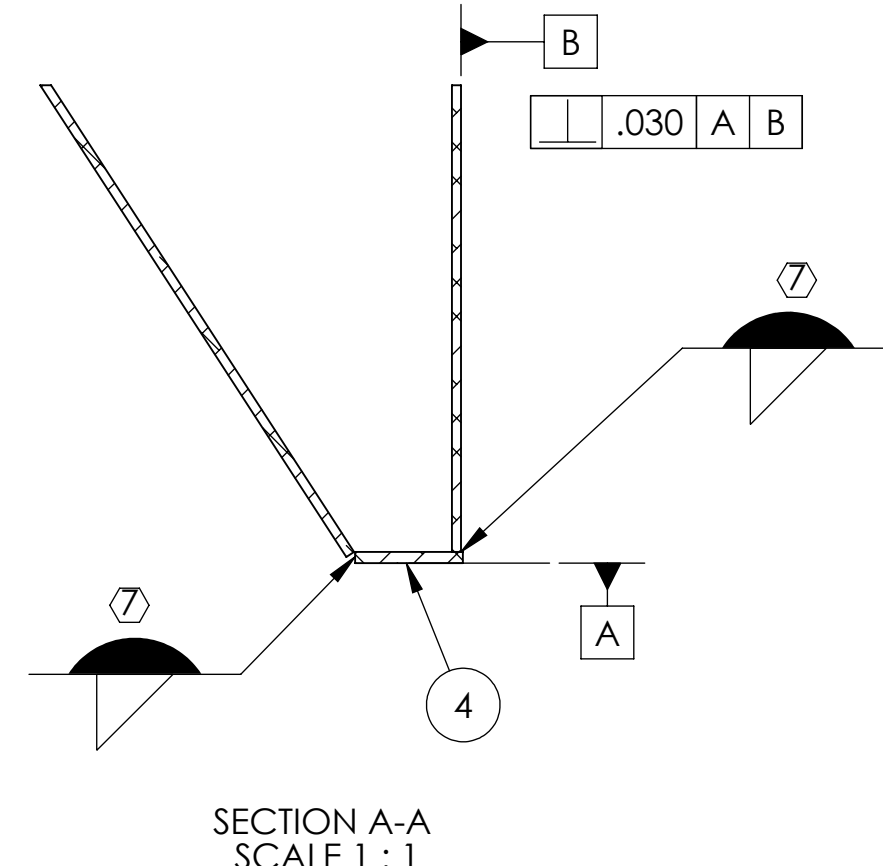
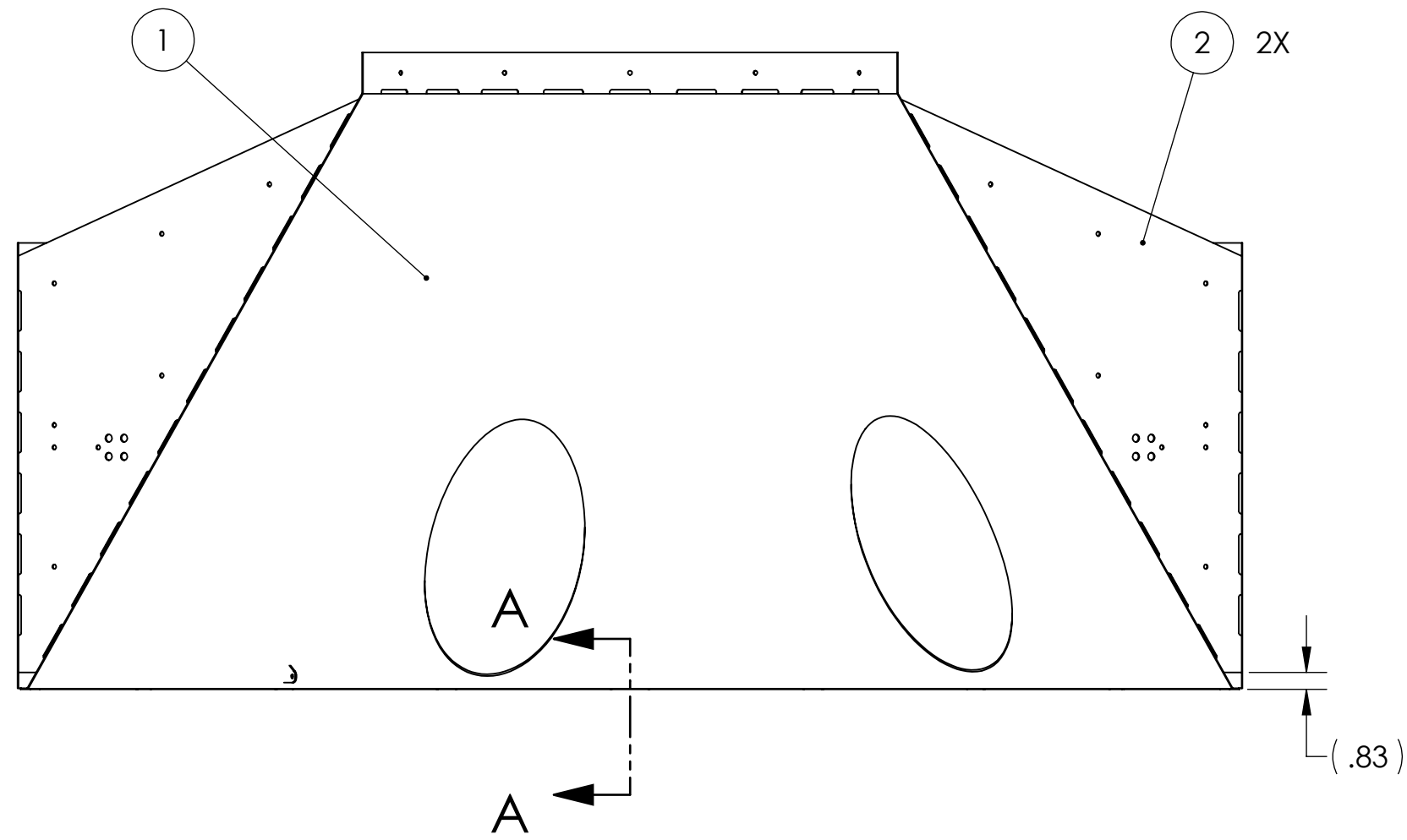
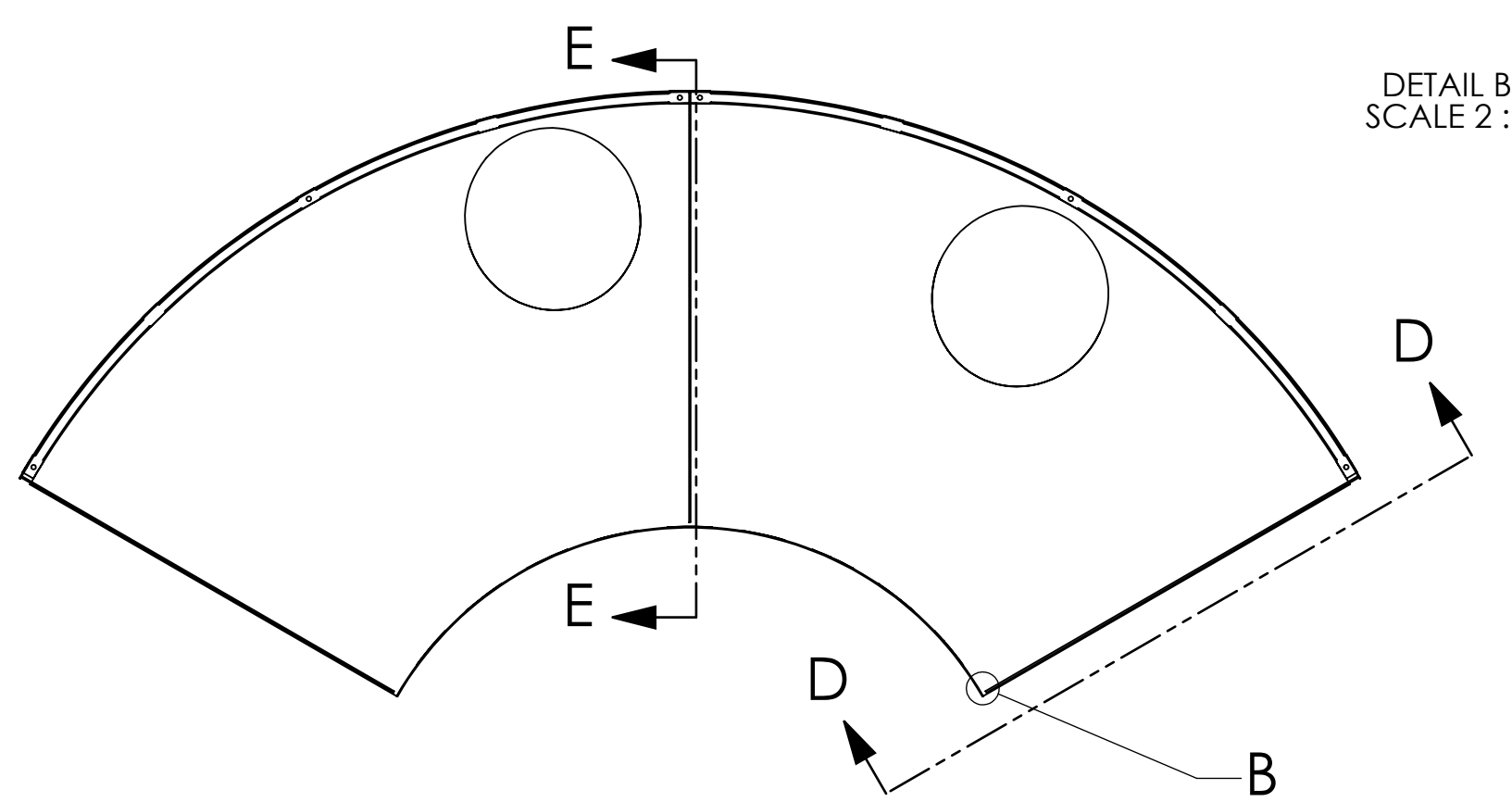
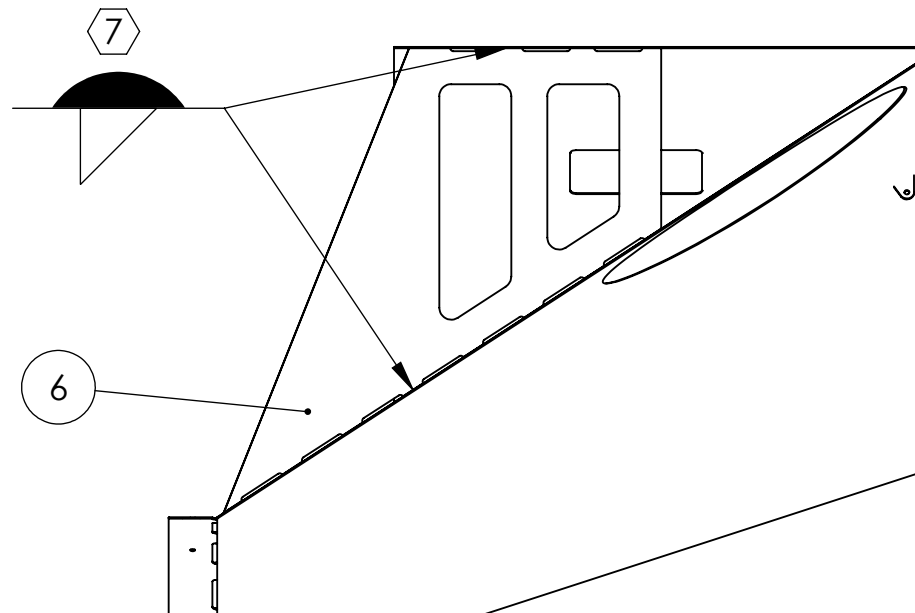
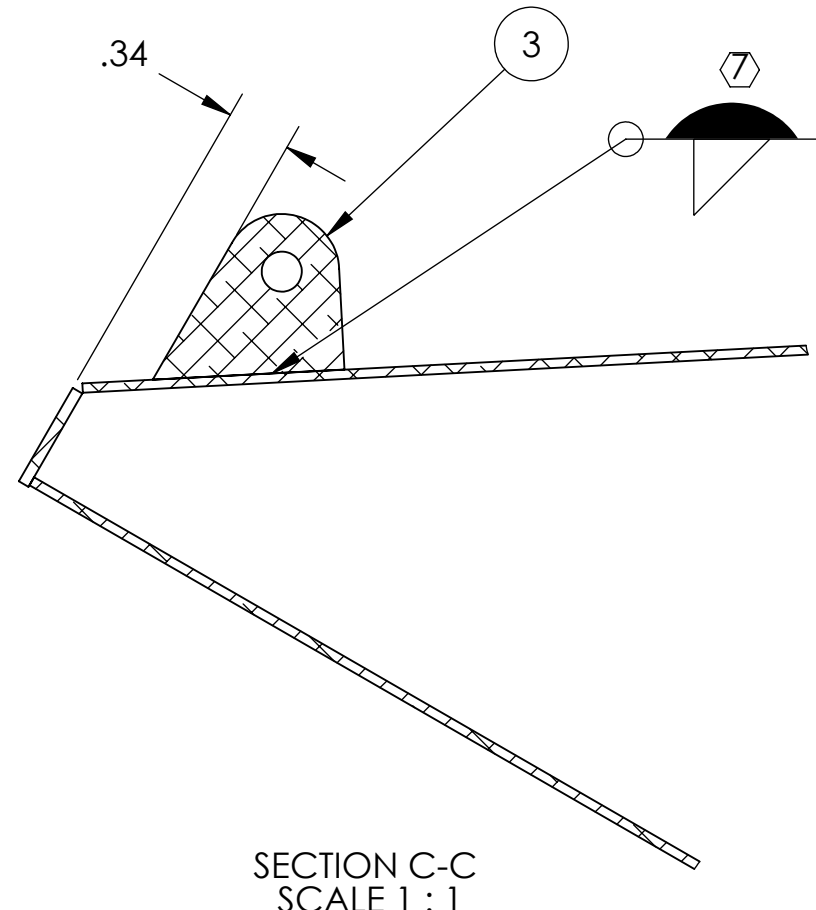
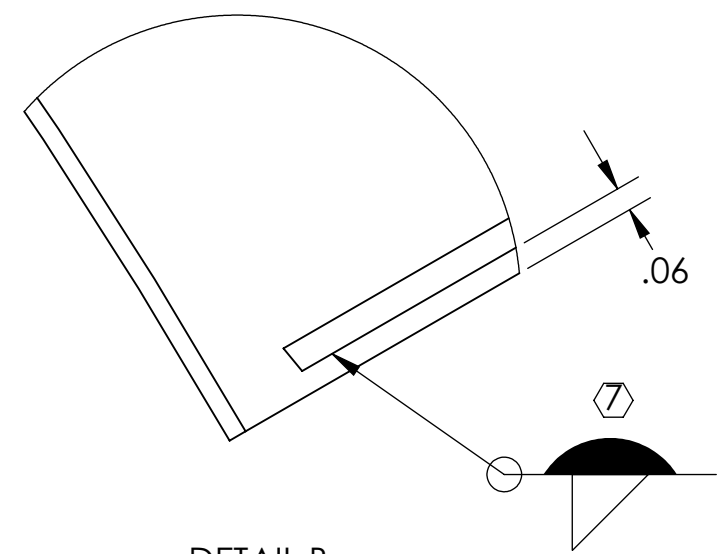


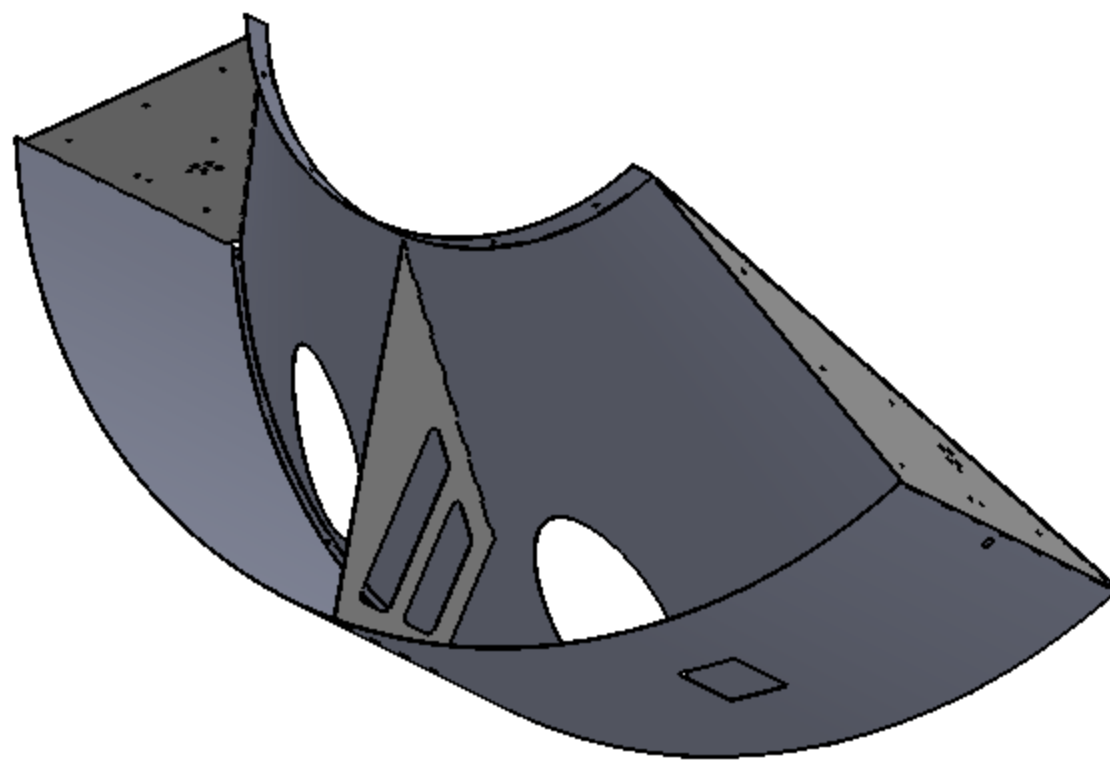
NOTES CONTINUED:  
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND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

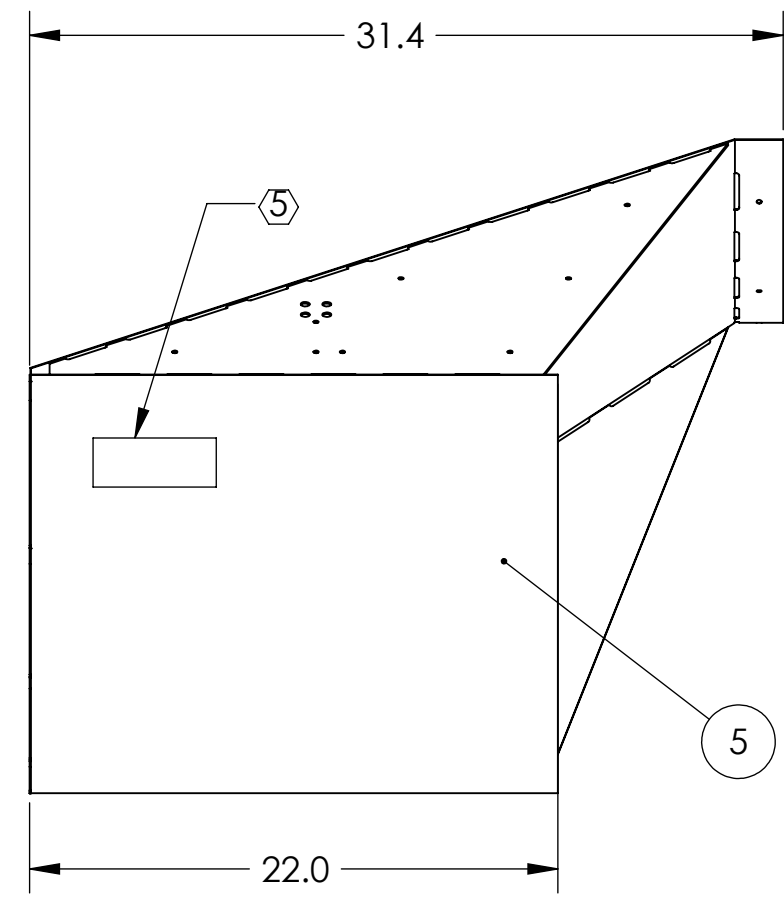
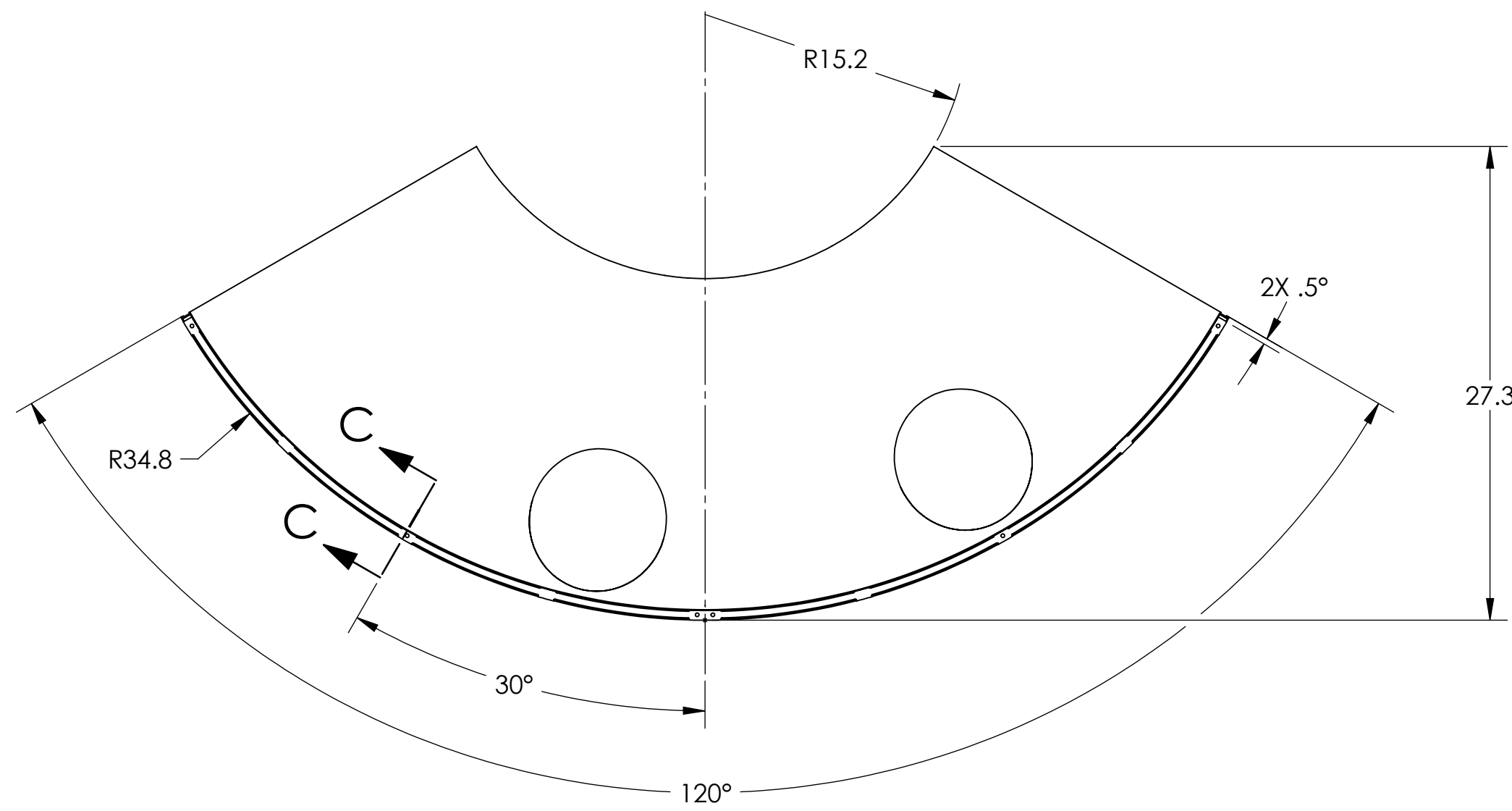
⑦ FILLET WELDS WHERE ITEMS MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.



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	D1000558	RADIAL SEGMENT, LEFT	18 GAUGE 304 SSSL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
3	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	2		2
1	D0902622	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITM XY, LEFT	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 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.

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, LEFT

DESIGNER H. KELMAN 20 MAY 2010 SIZE DWG. NO. D0902656 REV. v3  
 DRAFTER TQ. NGUYEN 07 SEP 2010  
 CHECKER M. SMITH  
 APPROVAL D. COYNE

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000090
v2	9 MAY 2011	E1000360-V2	-
v3	6 OCT 2011	E1000360-V3	-

D0902656.dwg; Manifold\_Cryo\_Baffle\_Segment\_Weldment; ITM XY, LEFT; PART PDM REV: X:664; DRAWING PDM REV: X:022