

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. 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-ED900364.

7. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

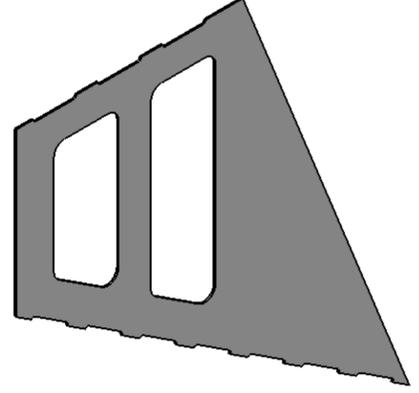
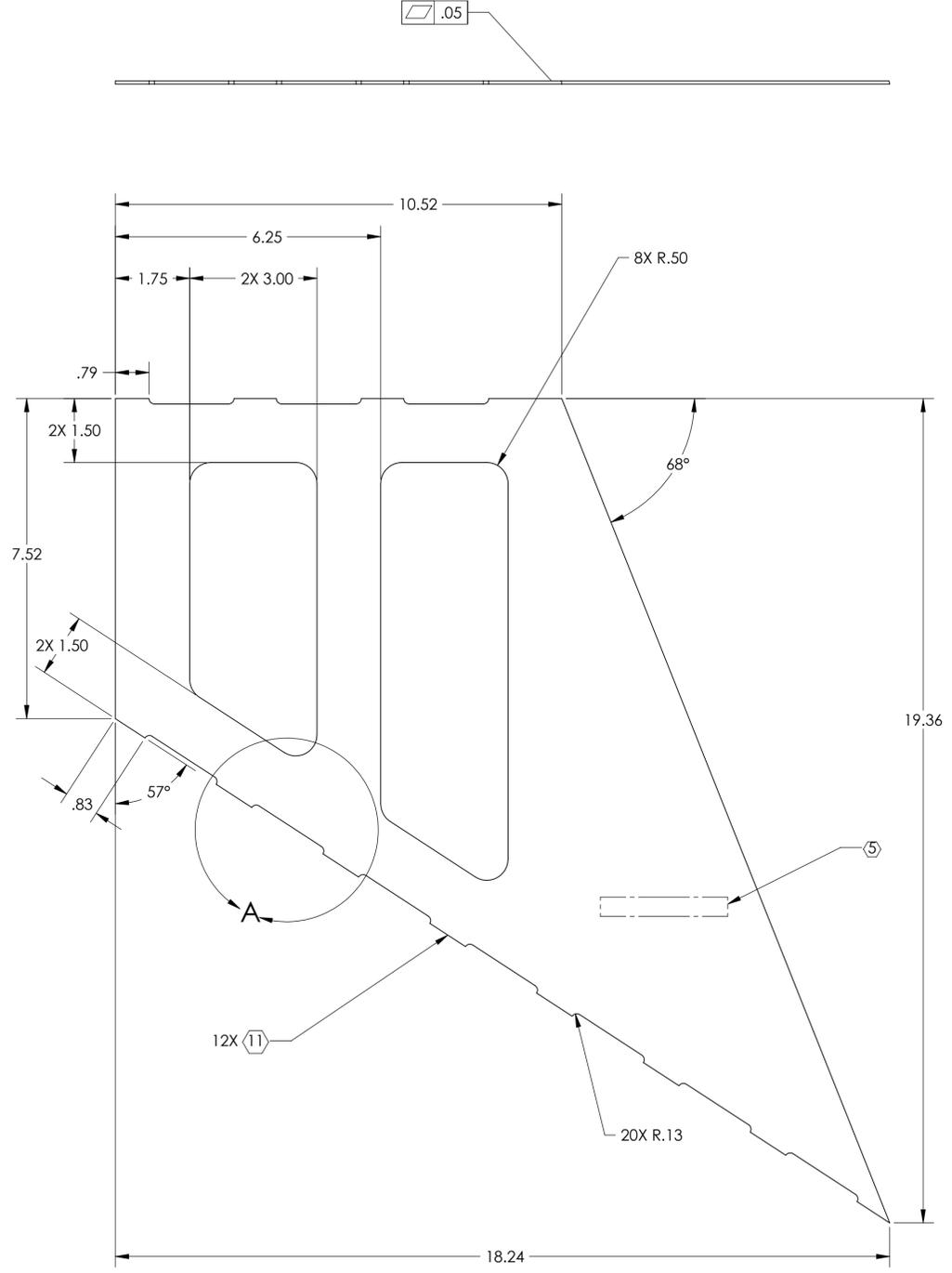
8. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.

9. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

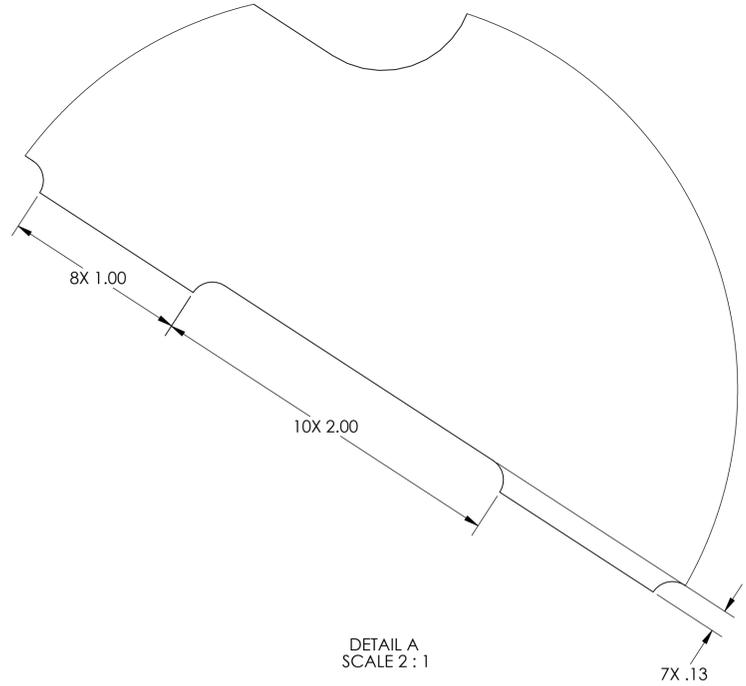
10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

11. CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).
 12. AS RECEIVED MACHINE FINISH.

REV.	DATE	DCN #	DRAWING TREE #
v1	2 OCT 2010	E1000360	E1000085-v1
v2	12 MAY 2011	E1000360-v2	E1000090-v1
-	-	-	E1000091-v1



GENERAL VIEW FOR REFERENCE ONLY
NO SCALE



DETAIL A
SCALE 2 : 1

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 NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
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
14GA A424 TYPE I STEEL	12

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D0902654, D0902655, D0902656	

PART NAME					
MANIFOLD CRYO BAFFLE WELDMENT BRACE					
DESIGNER	H. KELMAN	27 OCT 2010	SIZE	DWG. NO.	
DRAFTER	TG. NGUYEN	2 OCT 2010	D	D1002849	
CHECKER	M. SMITH	27 SEP 2011	SCALE	1:2	PROJECTION:
APPROVAL	D. COYNE				SHEET 1 OF 1
					REV.
					v2

D:\002849\alUGO_Manifold_Cryo_Baffle_Weldment_Brace_PDR_PDM_REV-X-014_DBAWING-PDM_REV-X-007