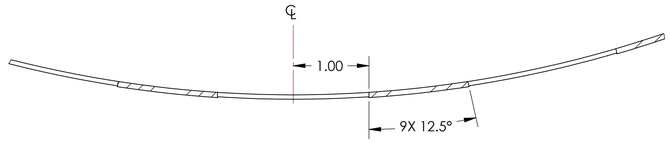
NOTES CONTINUED:

(5) SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

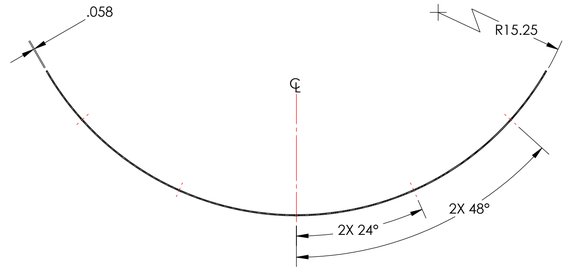
(6) CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

(7) MATERIAL AS RECEIVED MACHINE FINISH

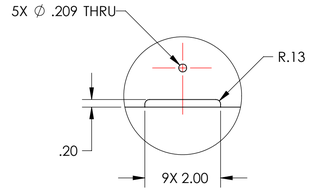
REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000085
-	-	-	-
-	-	-	-



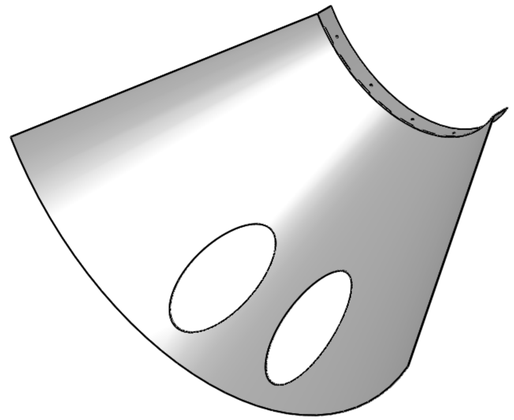
SECTION B-B
SCALE 1 : 1



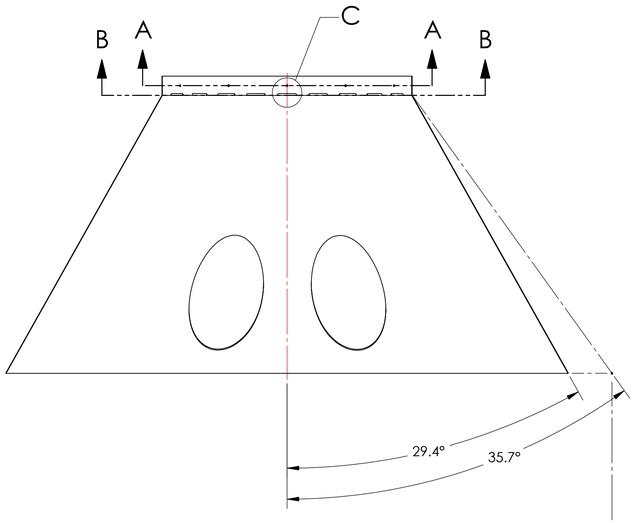
SECTION A-A
SCALE 1 : 4

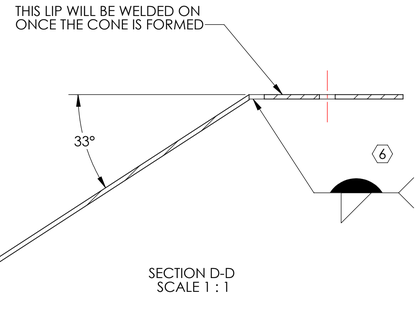


DETAIL C
SCALE 1 : 2



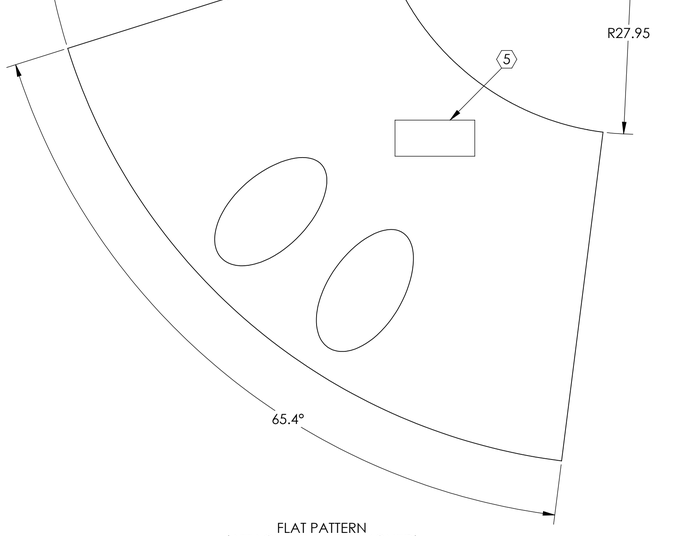
GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



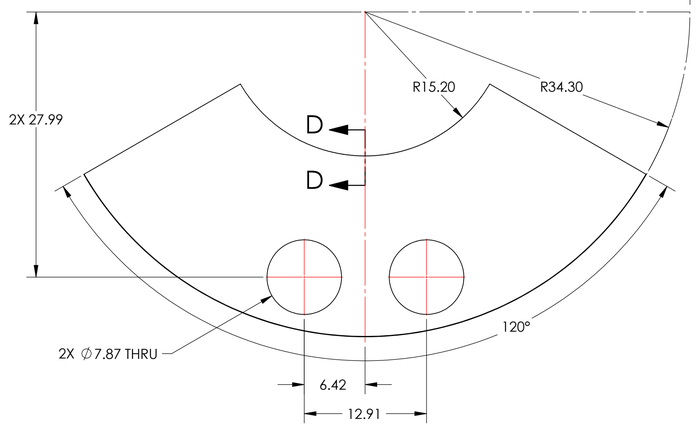


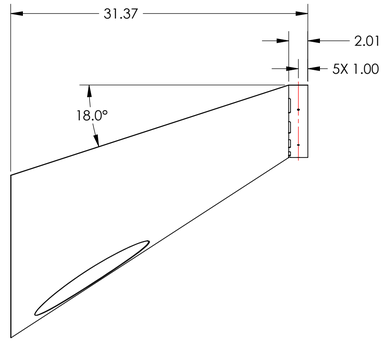
SECTION D-D
SCALE 1 : 1

10 PLS



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 D0902655 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°	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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1-H2, BOTTOM		
	MATERIAL: 18GA A424 TYPE I STEEL	FINISH: (7)	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: H. KELMAN 03-15-10	SIZE: D	DWG. NO.: D0902623	REV.: v1
			NEXT ASSY: D0902655		DRAFTER: TQ. NGUYEN 17 AUG 2010			
					CHECKER: M. SMITH			
					APPROVAL: D. COYNE	SCALE: 1:8	PROJECTION:	SHEET 1 OF 1

D0902623 aLIGO_Manifold_Cryo_Baffle_Inner_Segment, ITMX H1-H2_Bottom, PART PDM REV= X-X015, DRAWING PDM REV= X-X007