

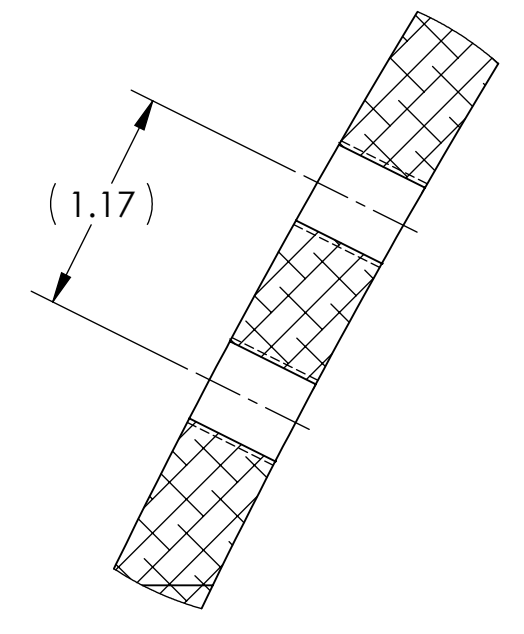
**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT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

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

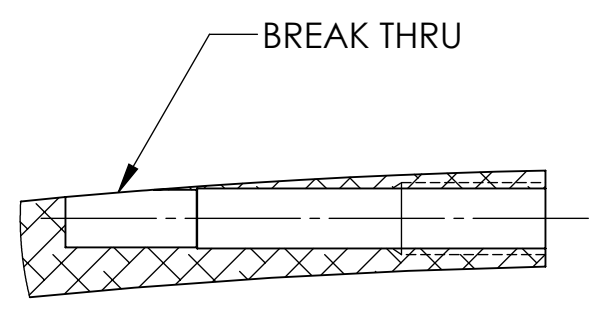
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. NOTICE ALTERNATE CENTER POINT LOCATION.

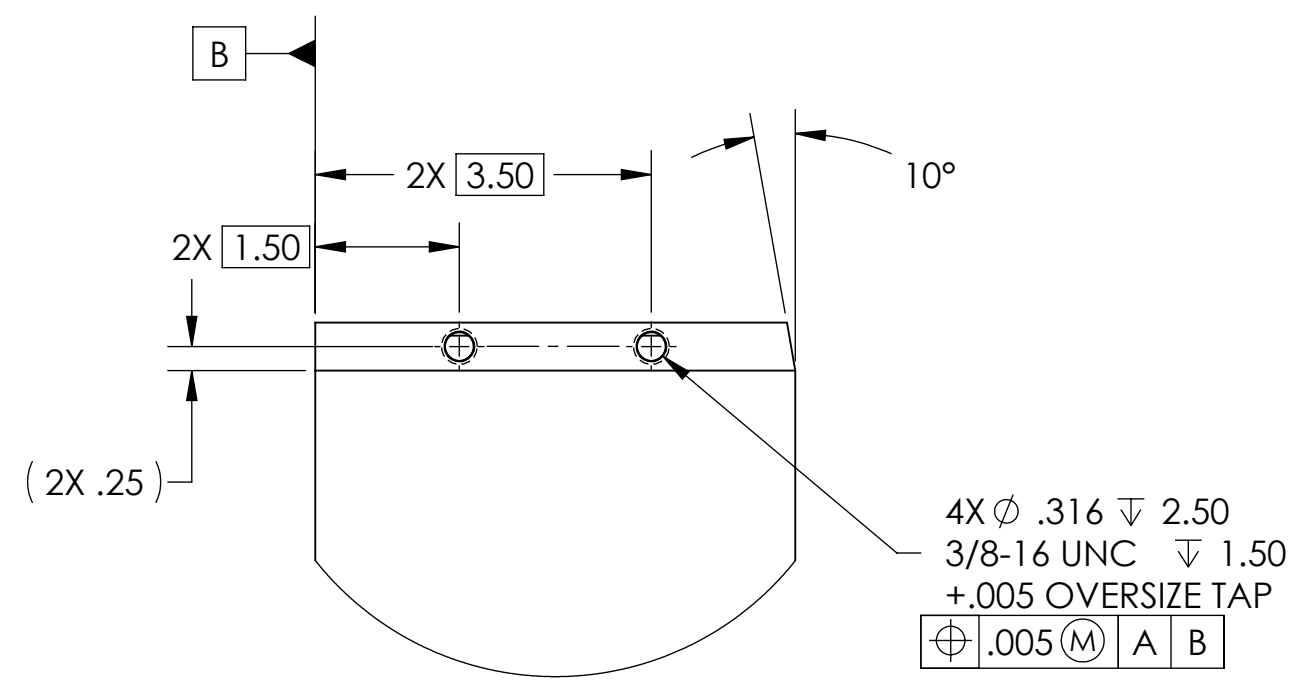
REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000358
v2	11 MAY 2011	E1000360-v2	-
-	-	-	-



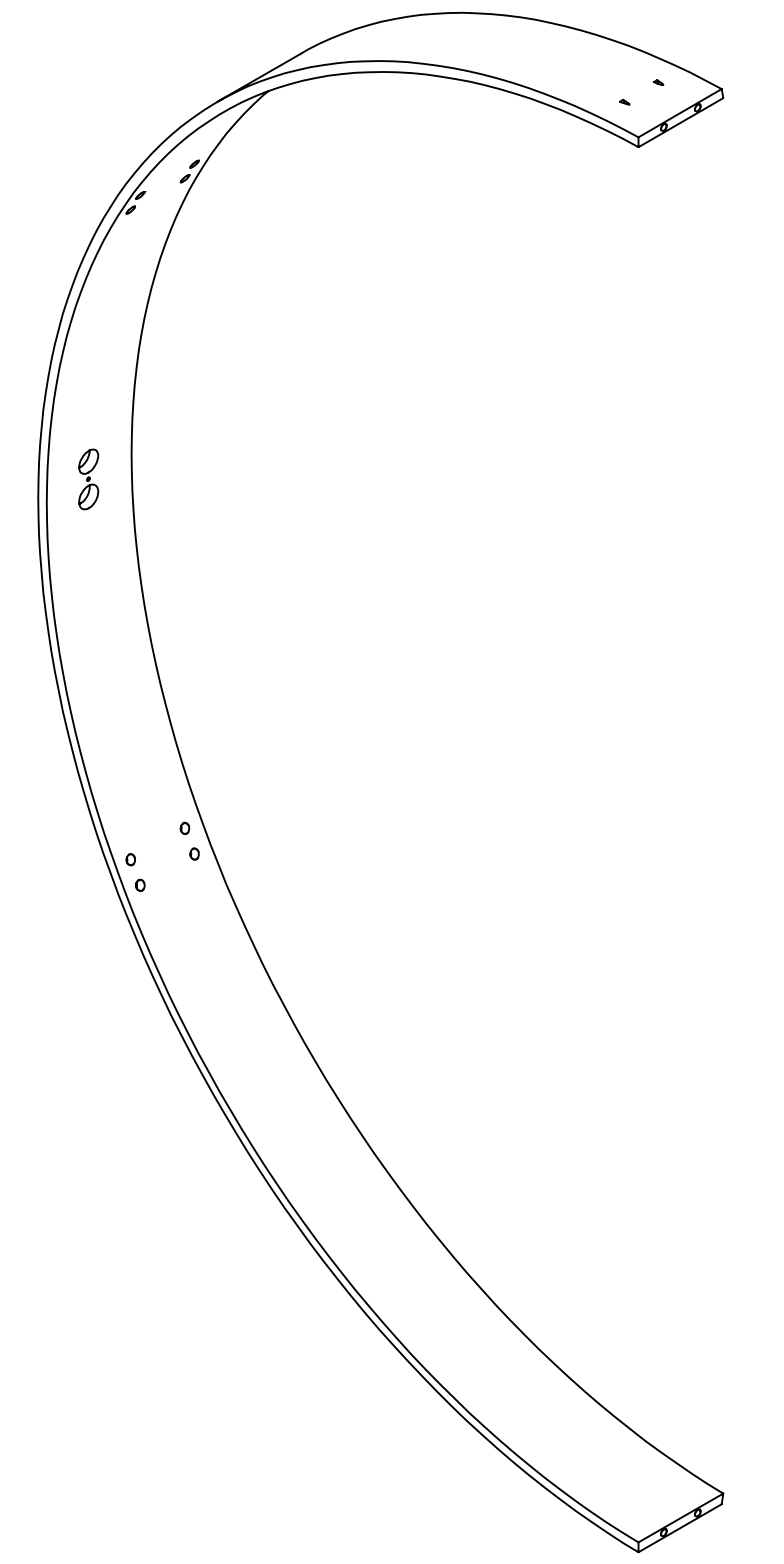
DETAIL D  
SCALE 1 : 1



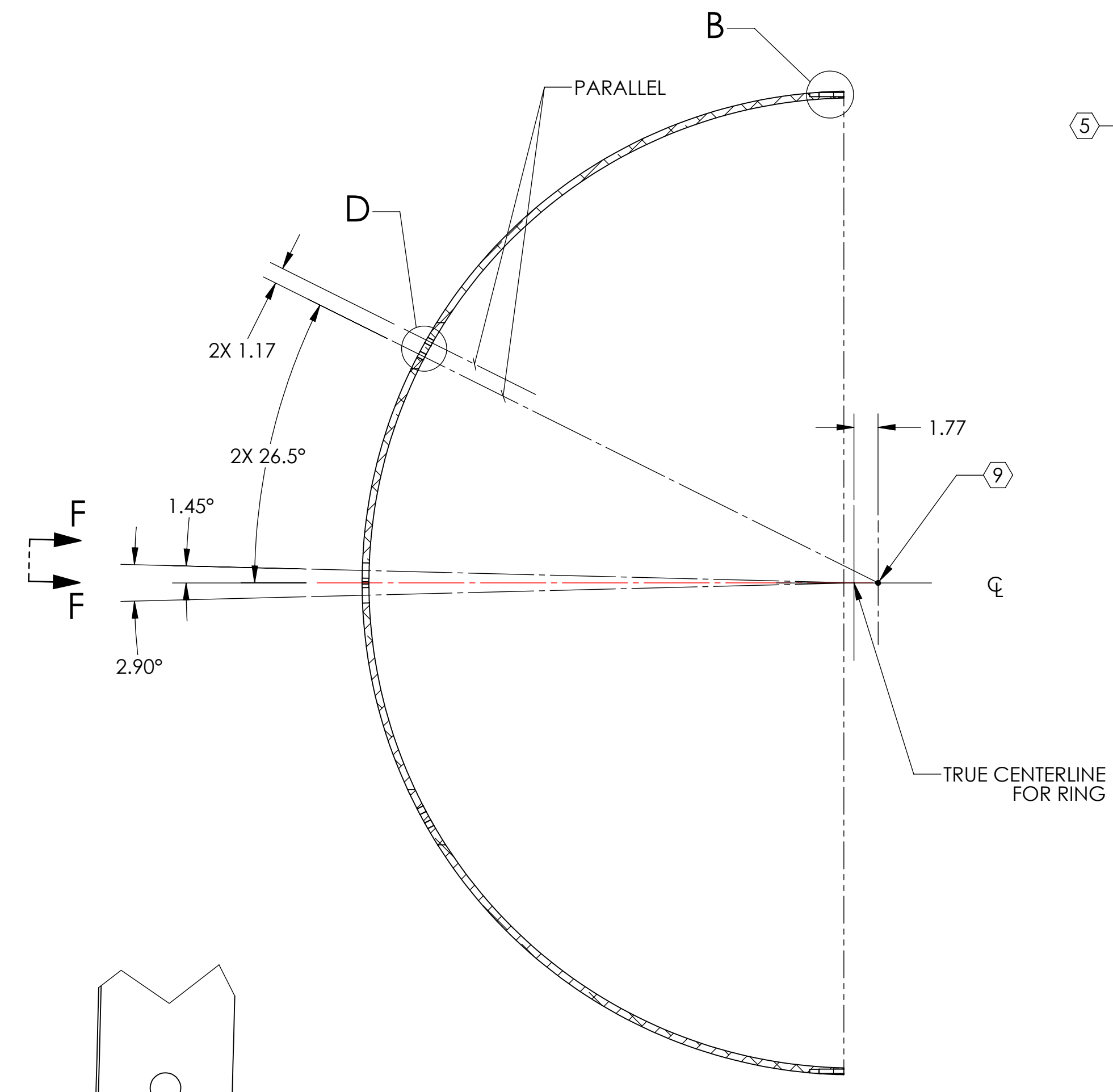
DETAIL B  
SCALE 1 : 1



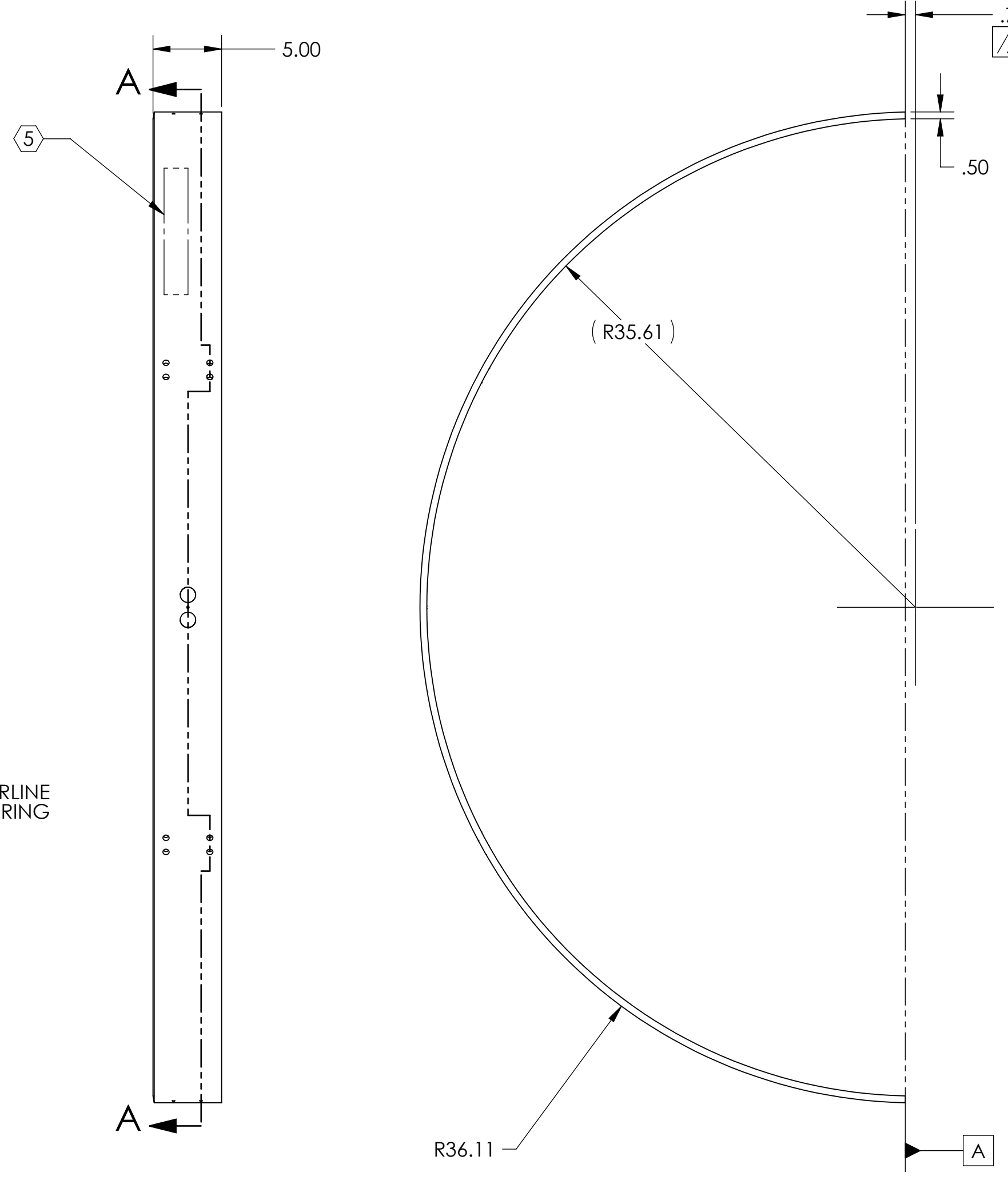
DETAIL C  
SCALE 1 : 2  
2 PLACES



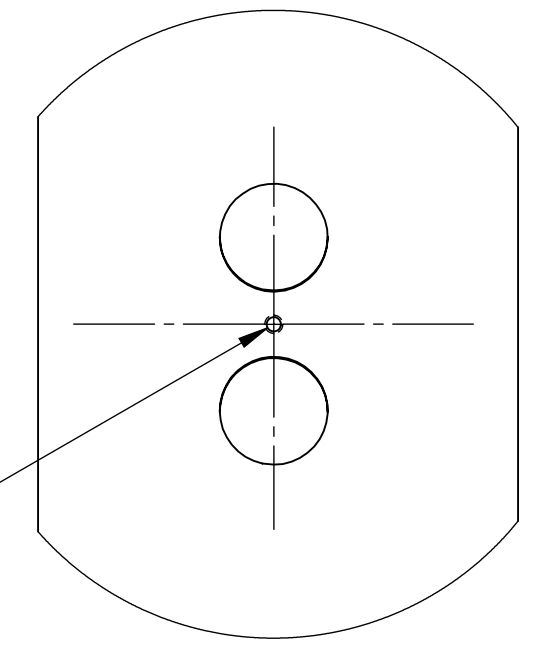
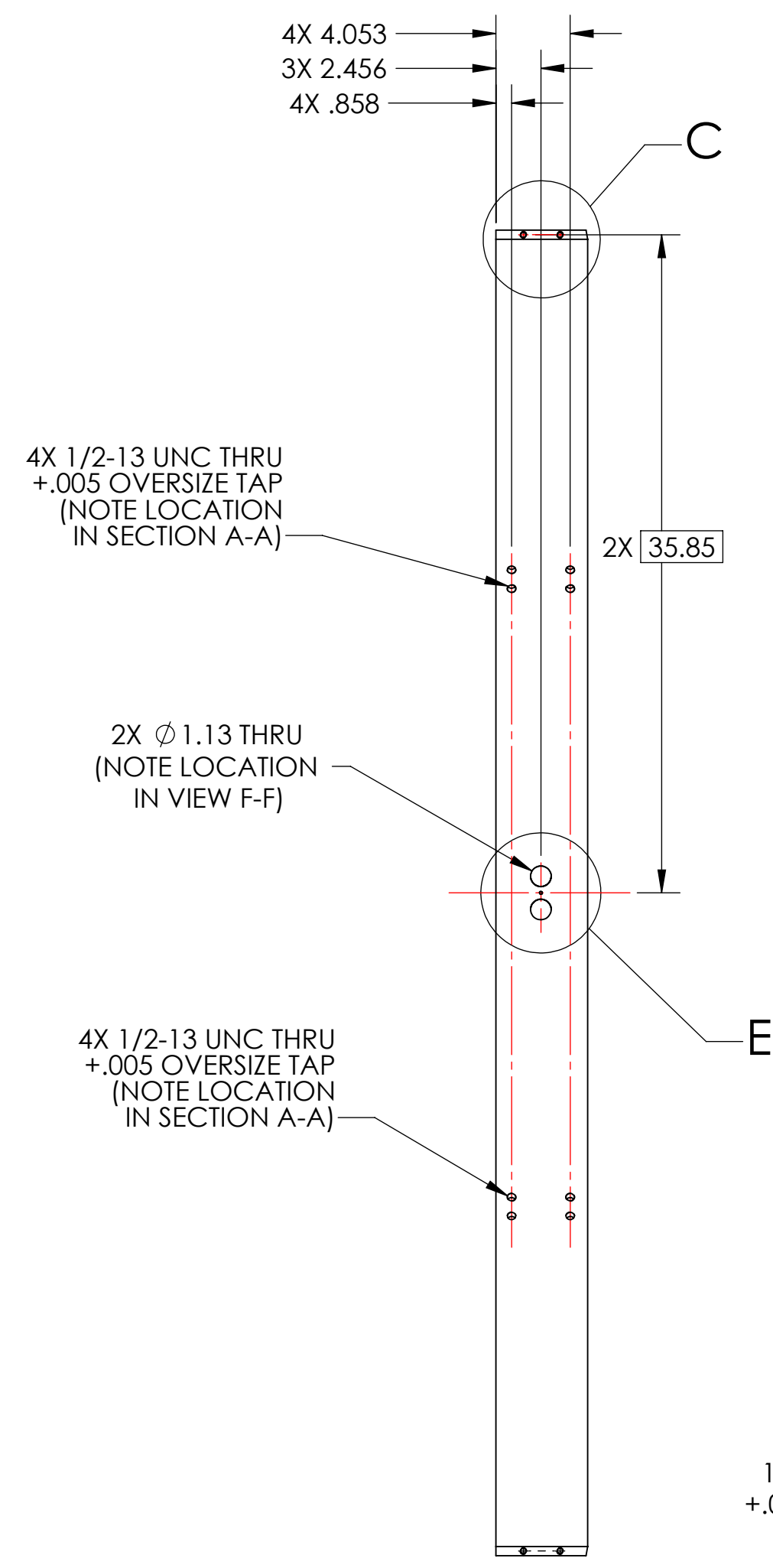
GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



SECTION A-A



R36.11



DETAIL E  
SCALE 1 : 2

VIEW F-F  
SCALE 1 : 4

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ± .03 .XXX ± .010
MATERIAL	FINISH
6061-T6 Al	63 μinch
ANGULAR ± 1.0°	

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D0902617	

PART NAME		MANIFOLD-CRYO BAFFLE SUSPENSION RING, TOP	
DESIGNER	H. KELMAN	1 JUNE 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	19 AUG 2010	D D0902815
CHECKER	M. SMITH	27 SEP 2010	REV. v2
APPROVAL	D. COYNE	SCALE: 1:8	PROJECTION:
		SHEET 1 OF 1	

D0902815.dwg\_Monitichil\_Cryo\_Baffle\_Suspension\_Ring\_Top\_PART\_PDM\_REV.X-061\_DRAWING\_PDM\_REV.X-019