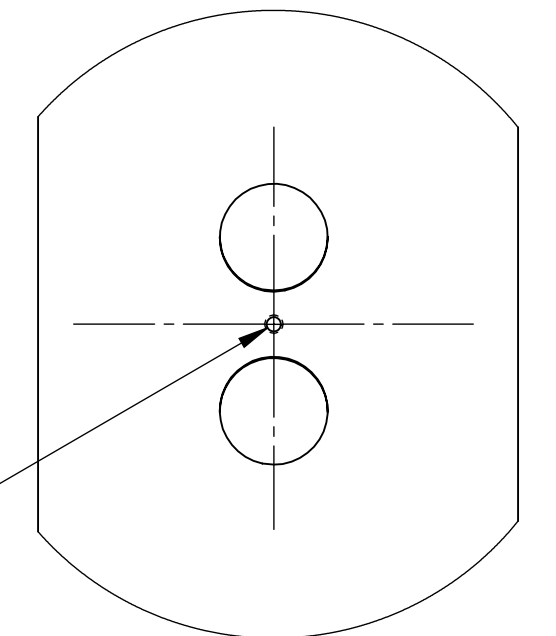
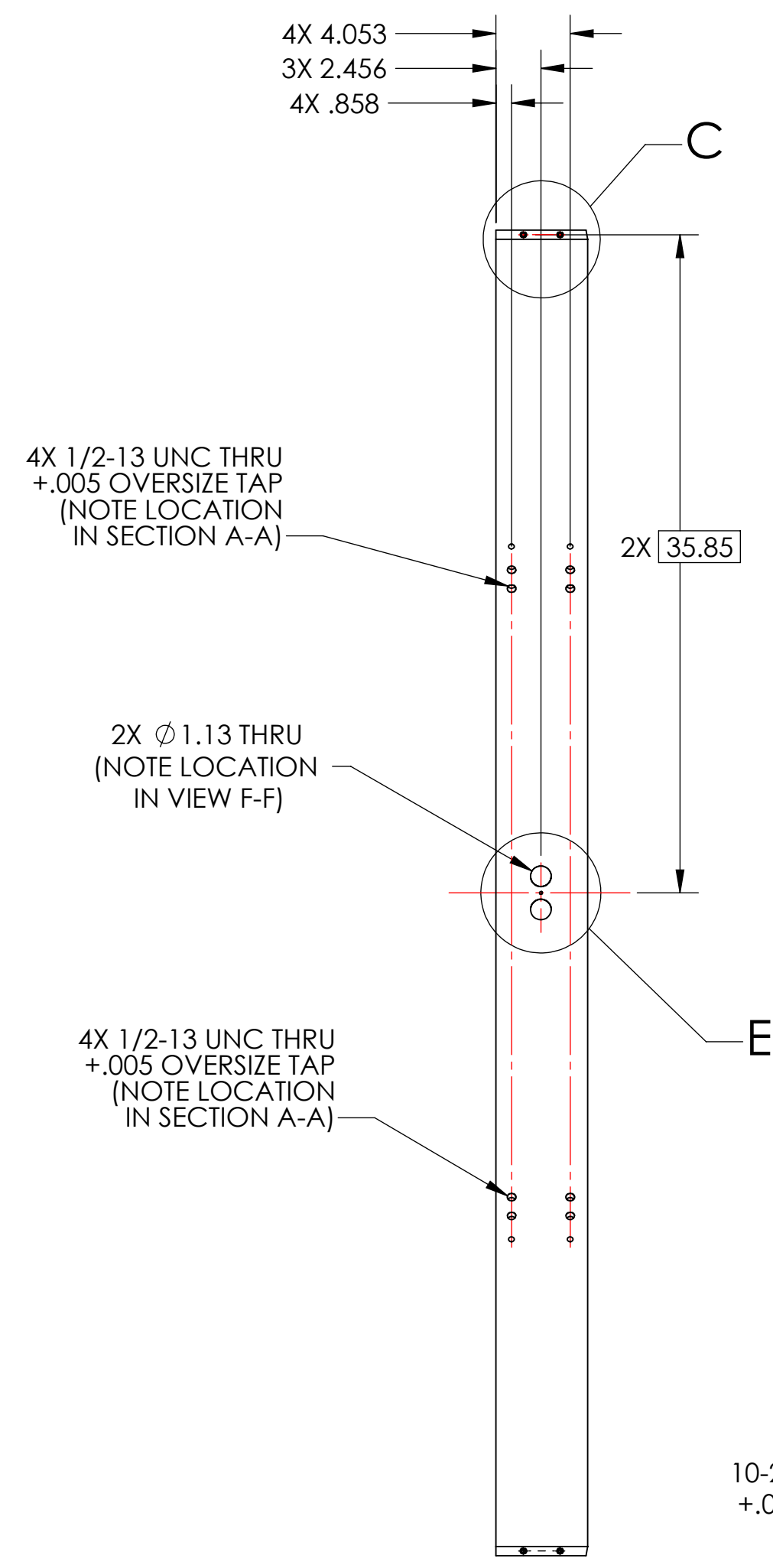
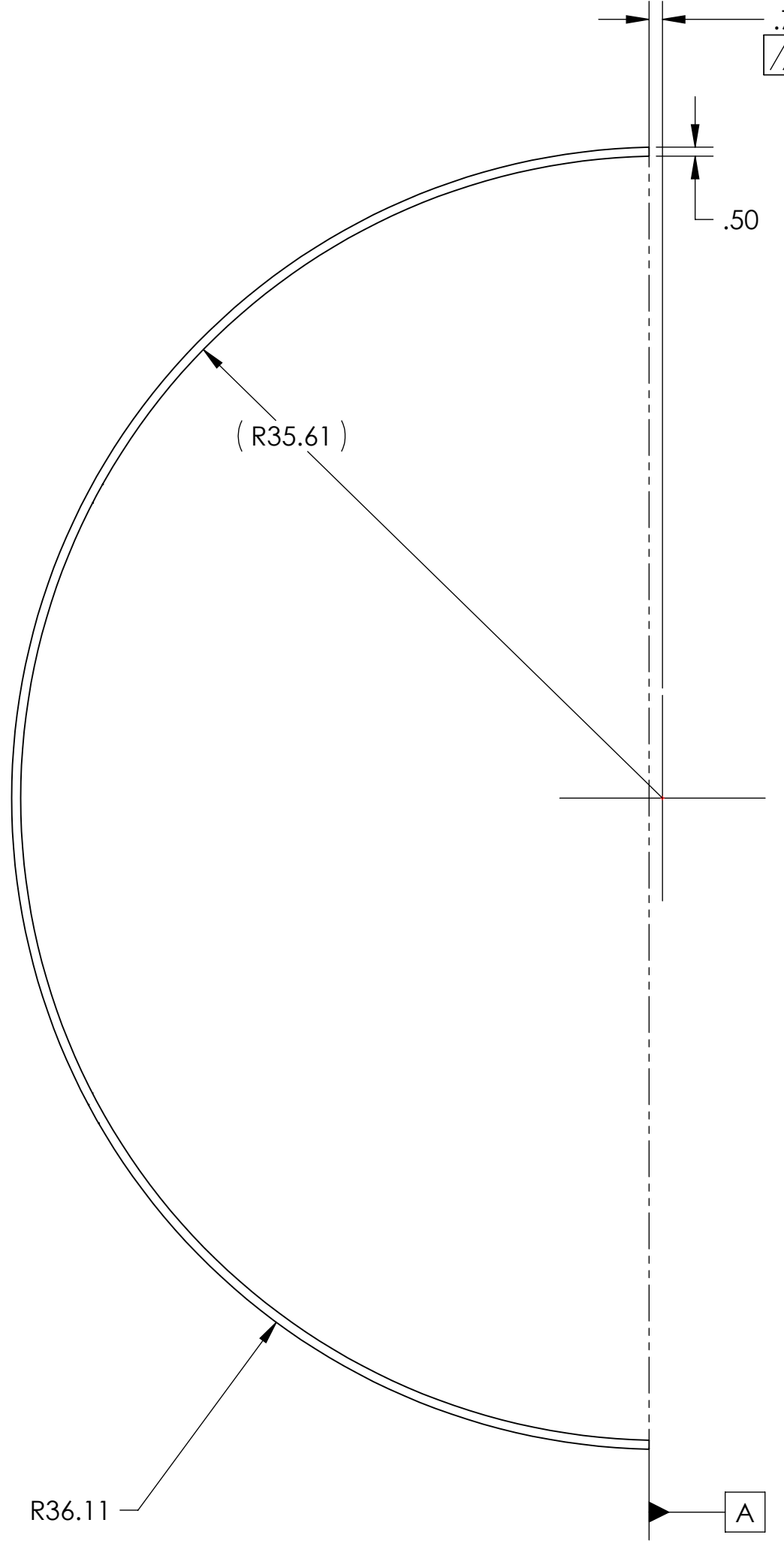
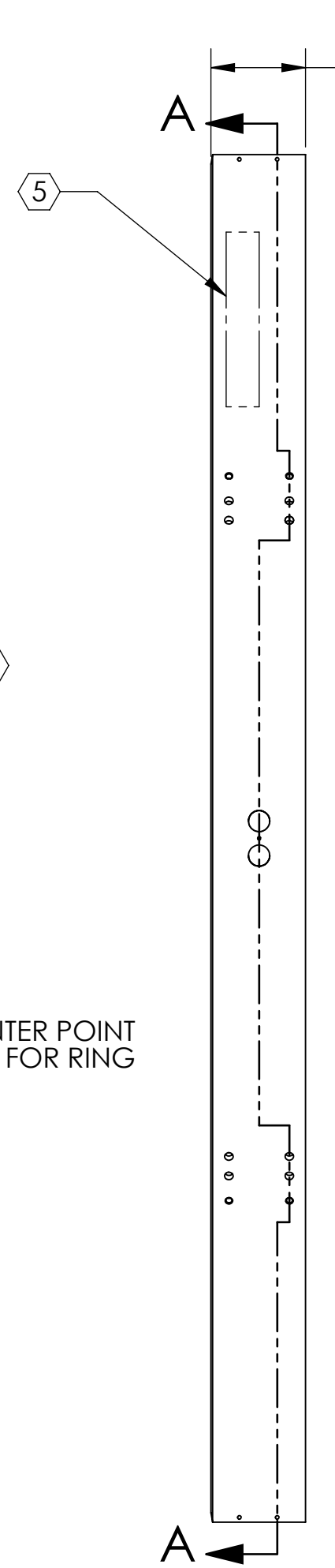
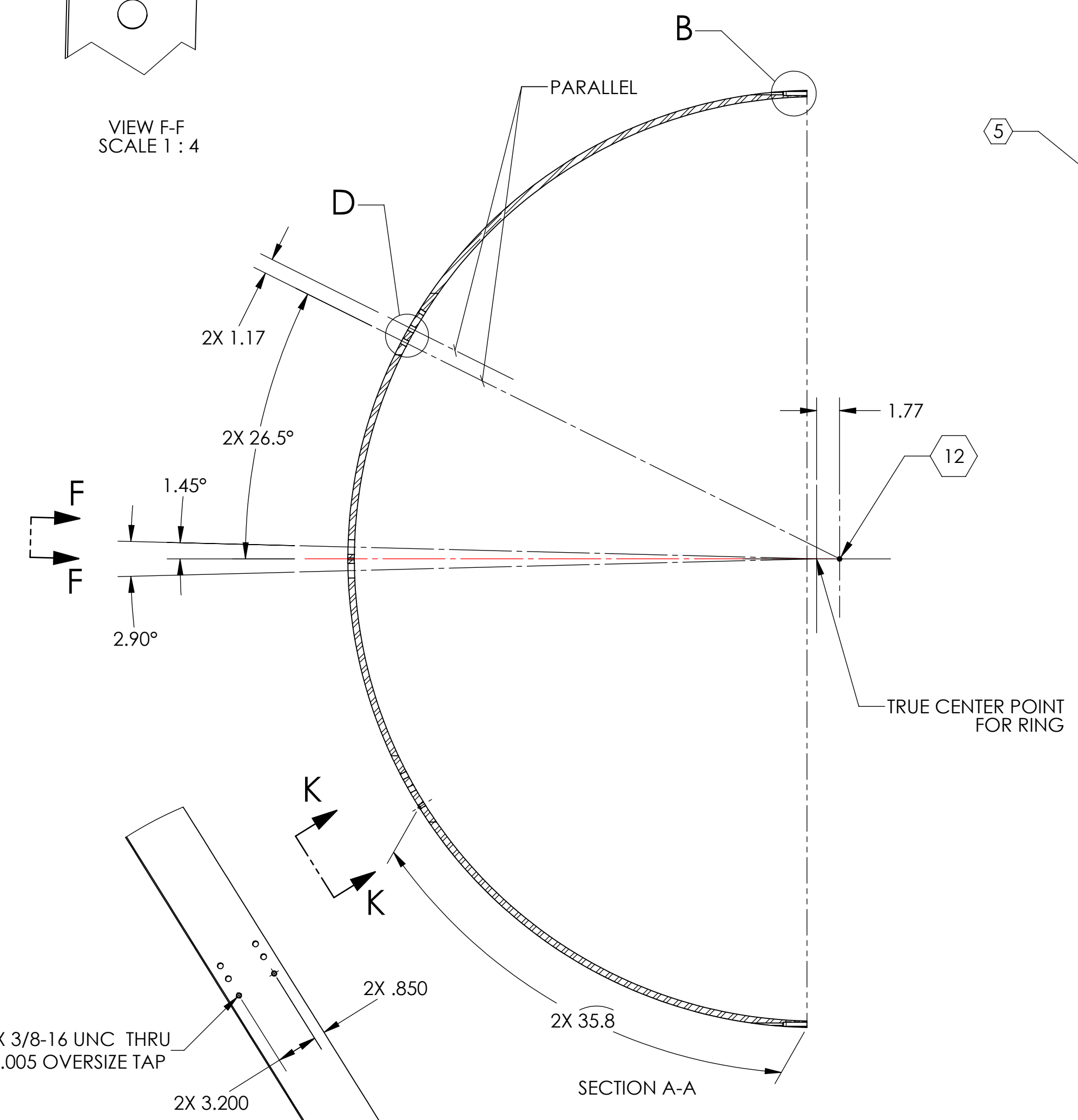
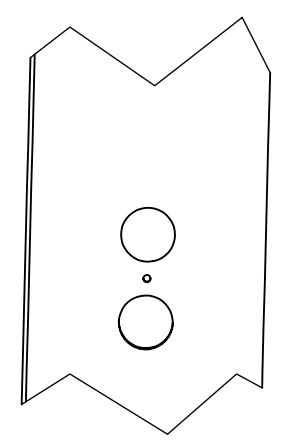
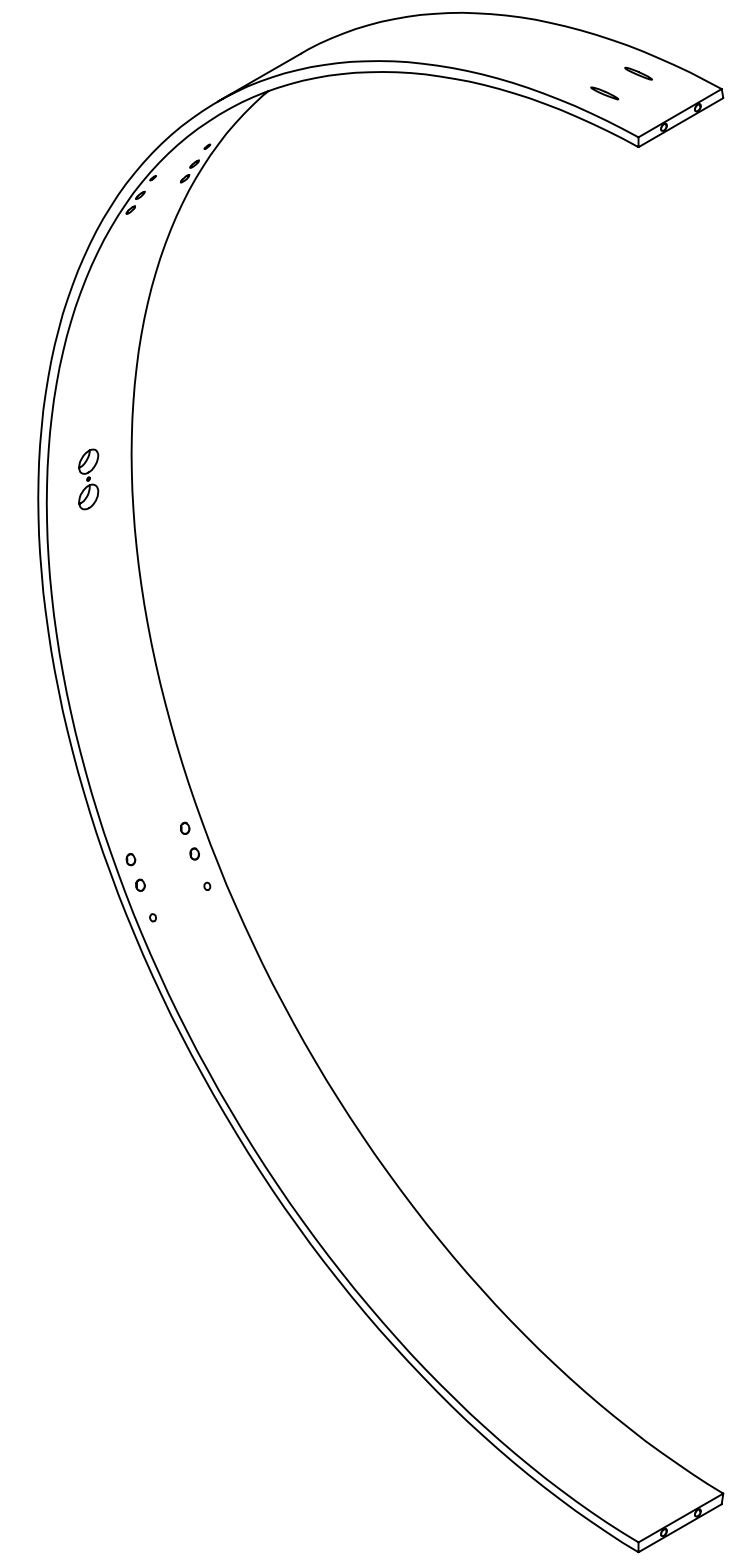
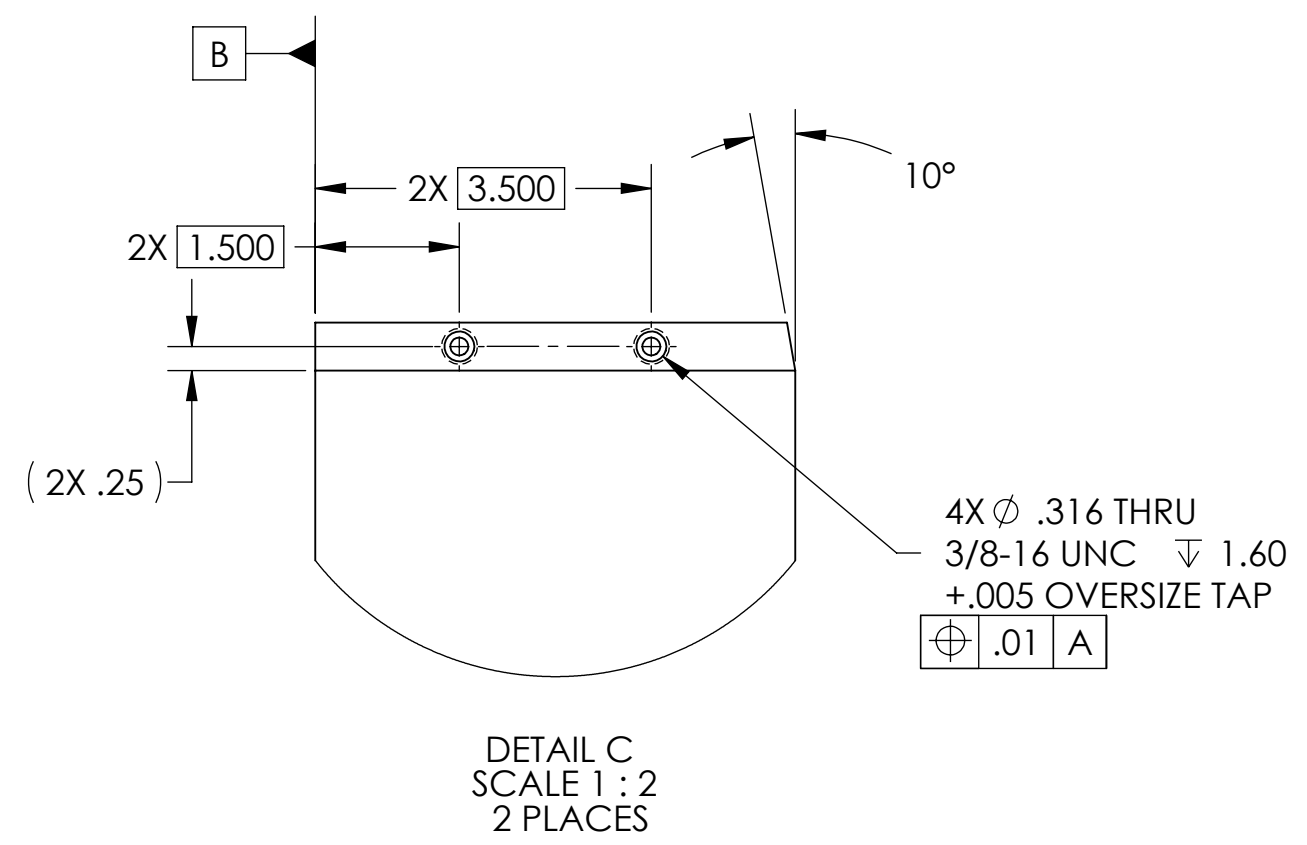
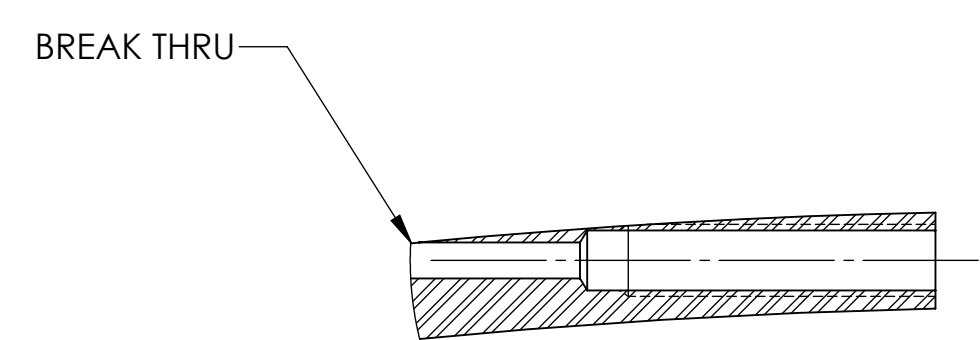
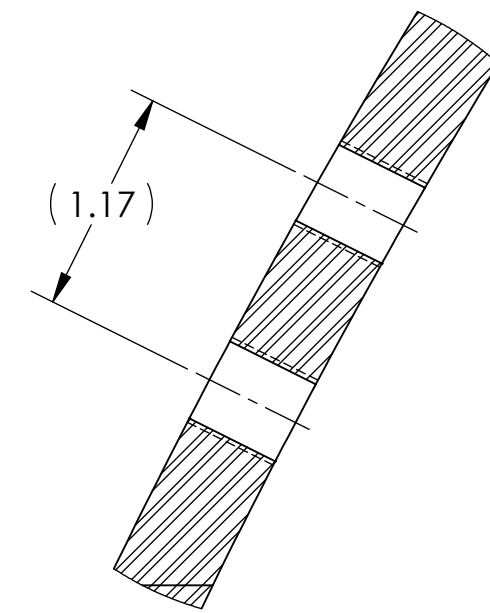


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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. APPROXIMATE WEIGHT = 26.60 LBS.
  - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - 8. 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-E0900364.
  - 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - 10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING.
  - 11. ELECTRO POLISH TO REMOVE .0005-.001 PER SIDE.
  - 12. NOTICE ALTERNATE CENTER POINT LOCATION.

REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000358
v2	11 MAY 2011	E1000360-v2	-
v3	29 AUG 2012	E1000360	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994 2. REMOVE ALL SHARP EDGES, .005-.015 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 ± 1.0	
.XX ± .03	
.XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	6061-T6 Al
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1002084

PART NAME		MANIFOLD-CRYO BAFFLE SUSPENSION RING, TOP	
DESIGNER	H. KELMAN	1 JUN 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	19 AUG 2010	D D0902815
CHECKER	M. SMITH	27 JAN 2012	
APPROVAL	D. COYNE	27 JAN 2012	SCALE: 1:8
PROJECTION:		SHEET 1 OF 1	

D0902815.dwg\_Material\_Cryo\_Baffle\_Suspension\_Ring\_Top.PART.PDM.REV.X-071.DRAWING.PDM.REV.X-025