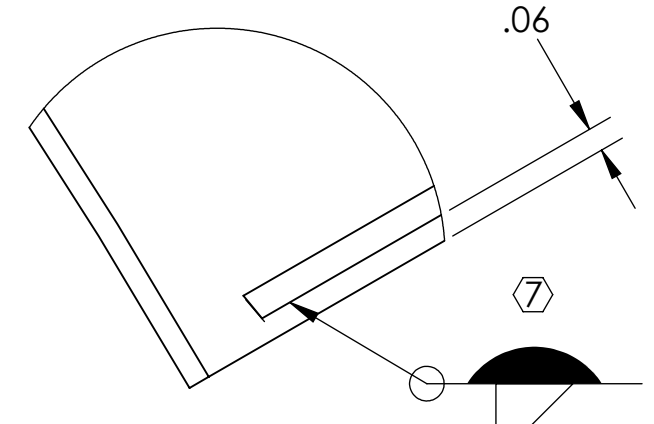


NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), DO NOT STAMP OR LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE 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

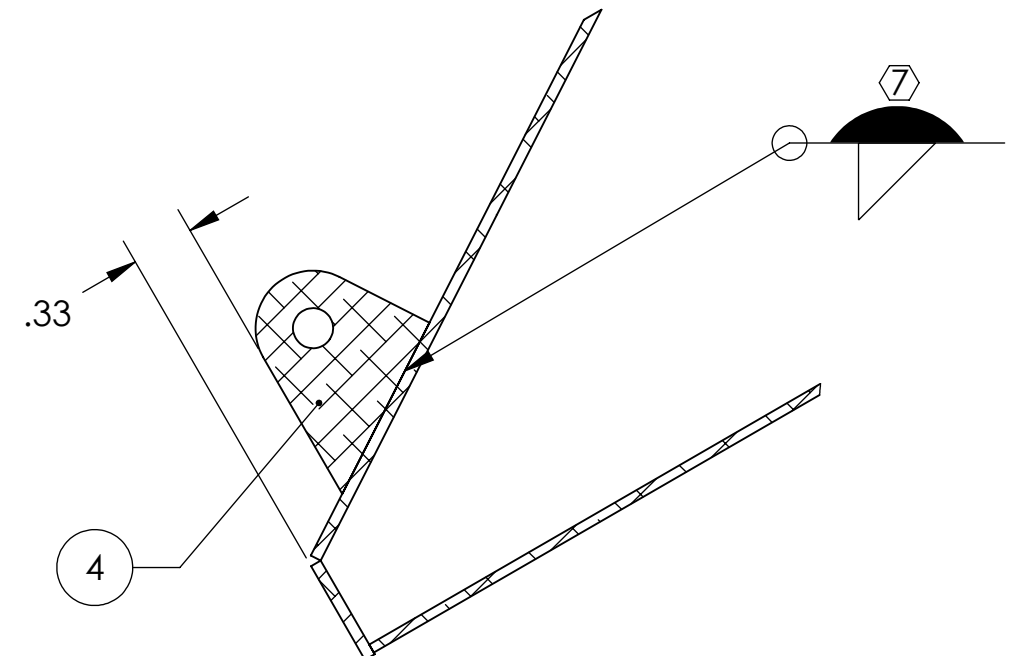
6. ASSEMBLY TO BE OXIDIZED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

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

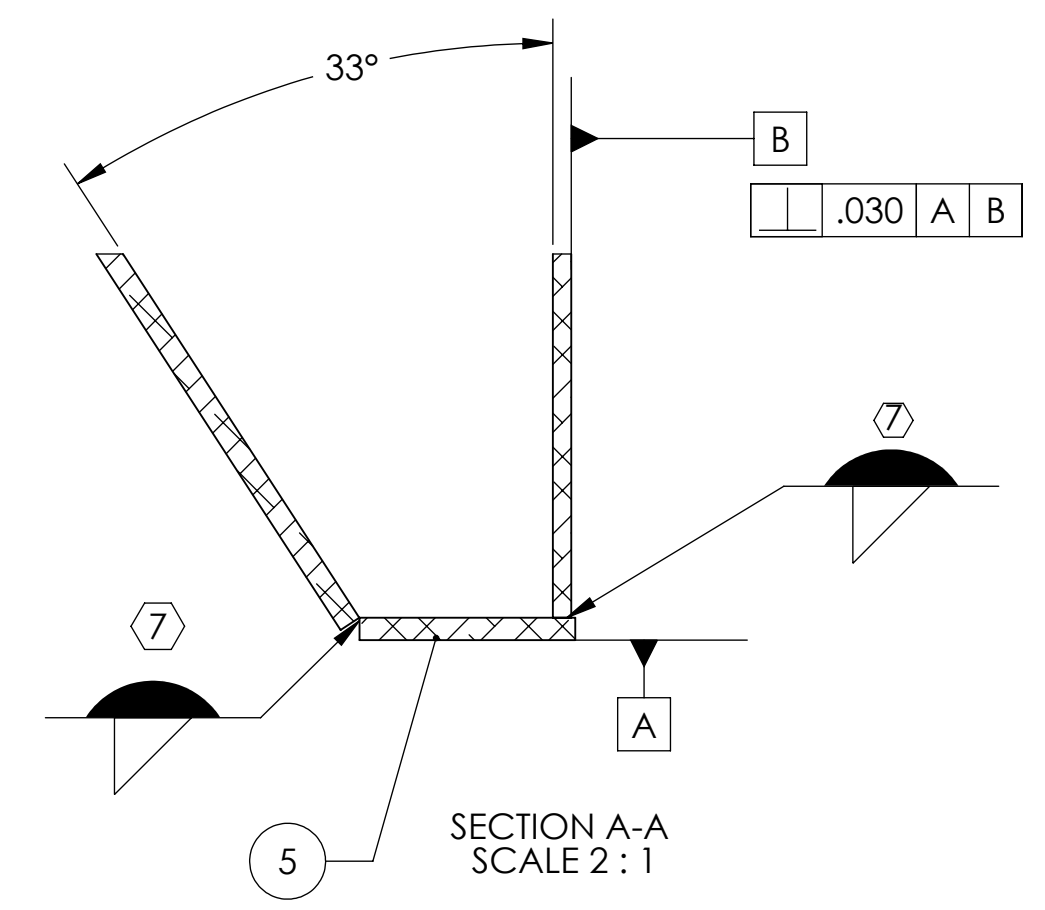
REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUL 2011	E1000360-v2	-
v2	17 OCT 2011	E1000360-v3	



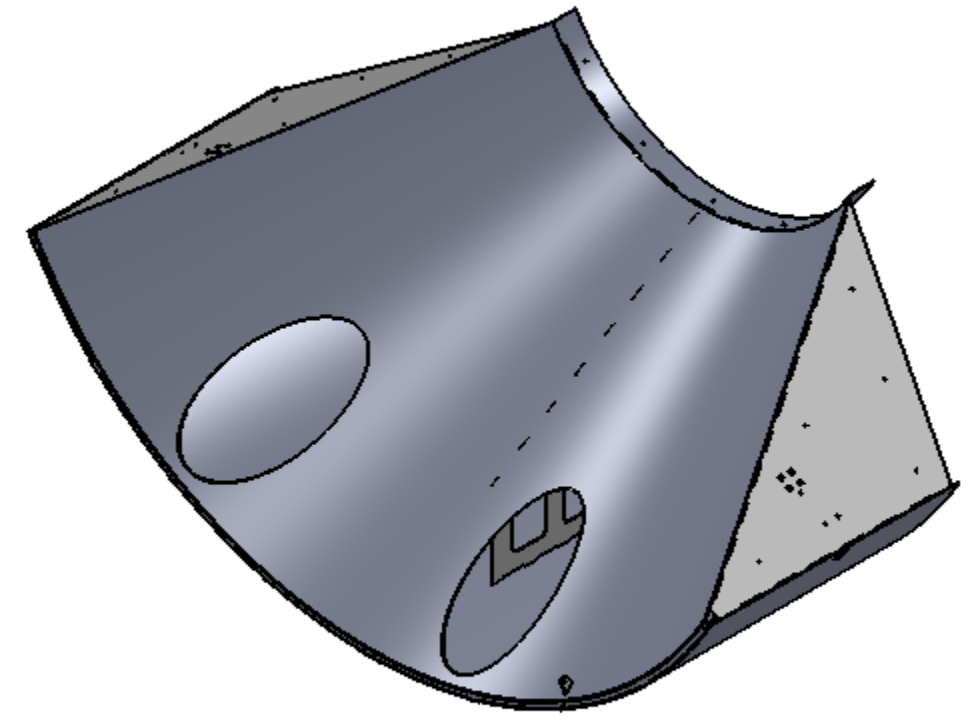
DETAIL B  
SCALE 2 : 1



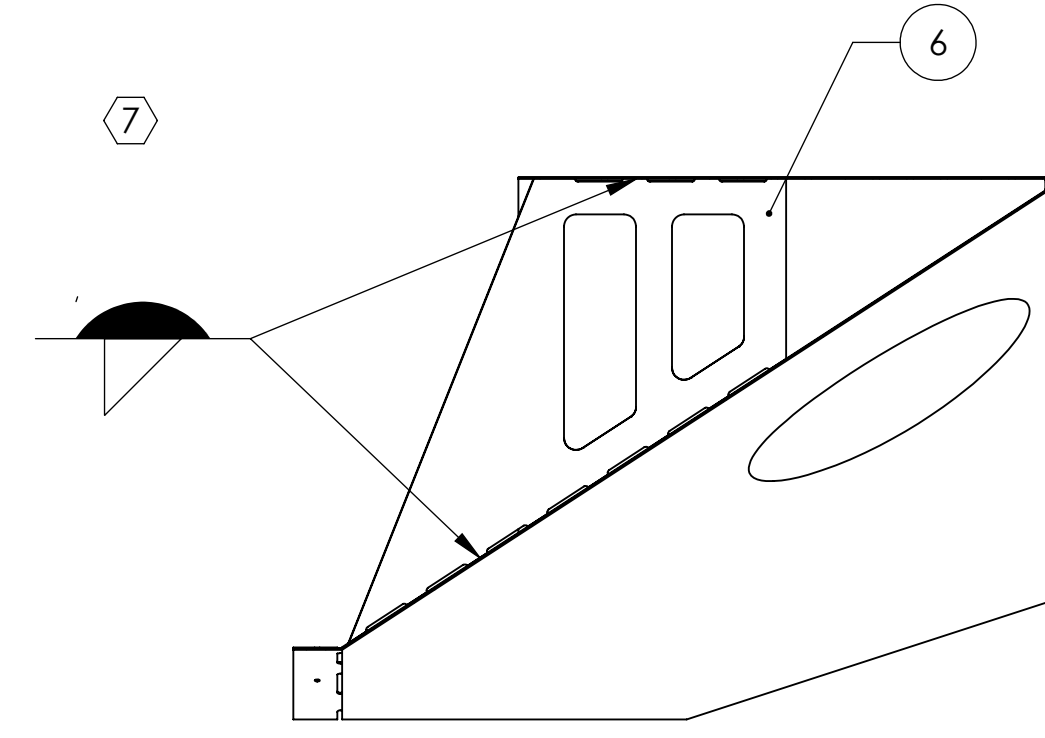
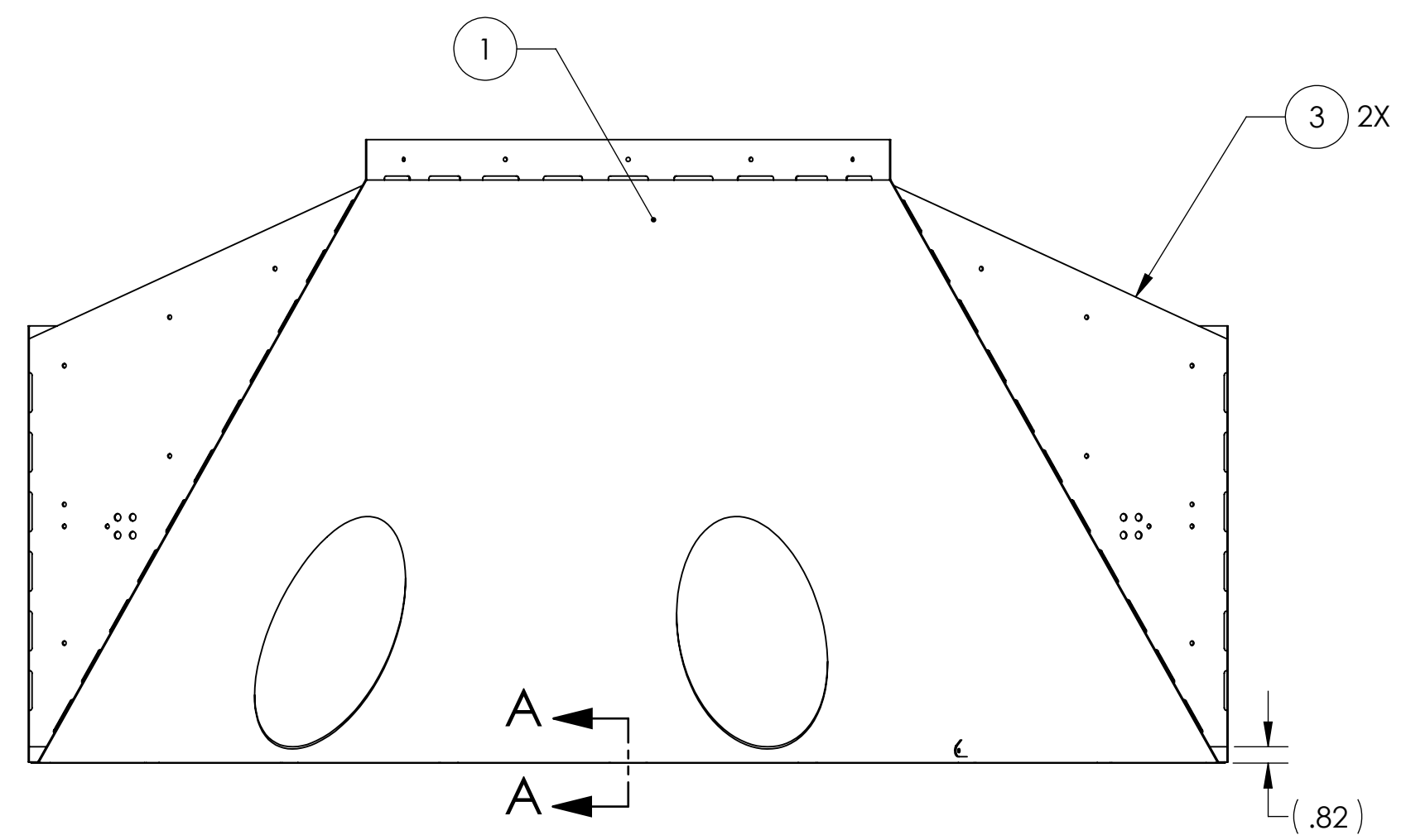
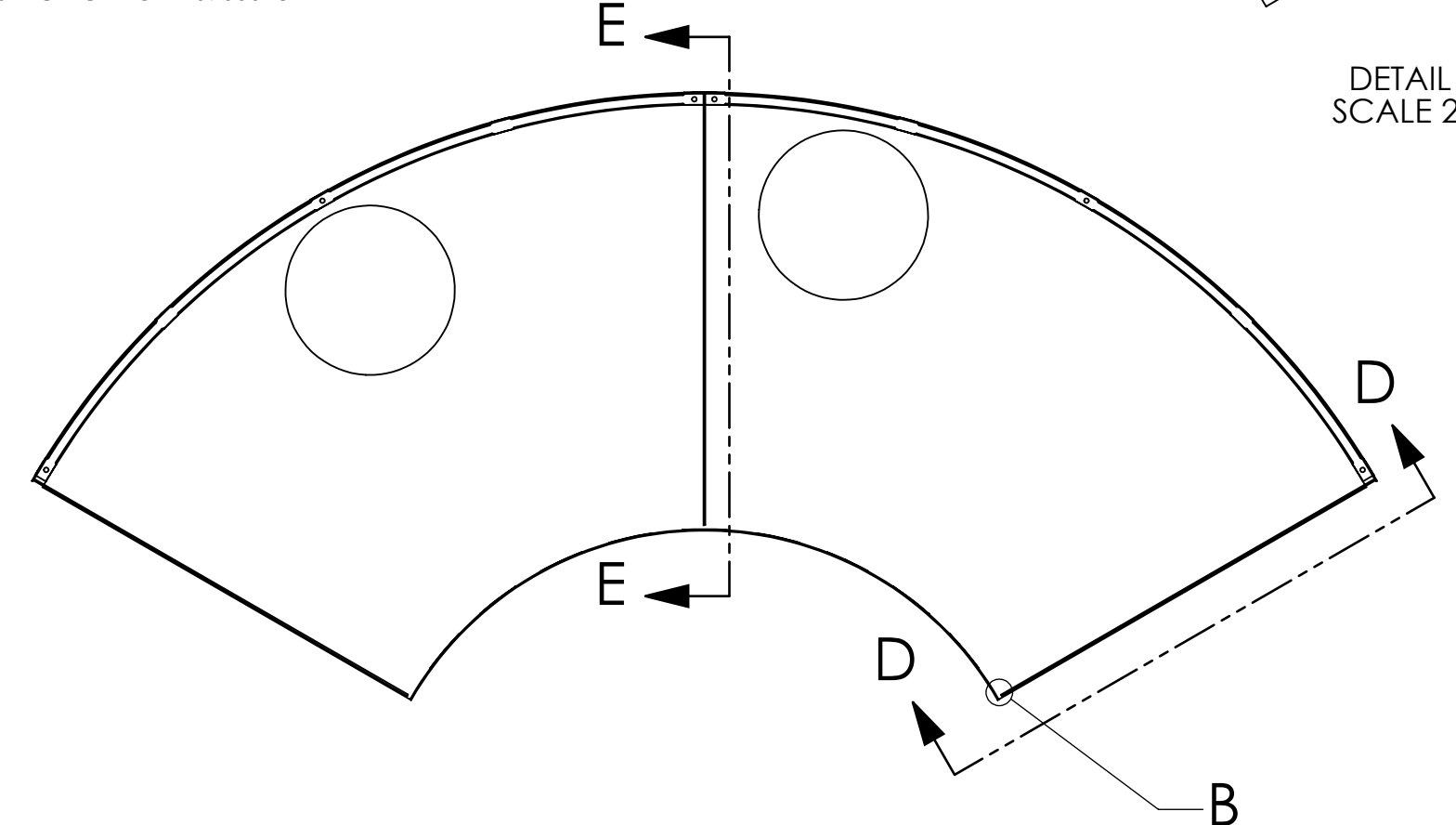
SECTION C-C  
SCALE 1 : 1



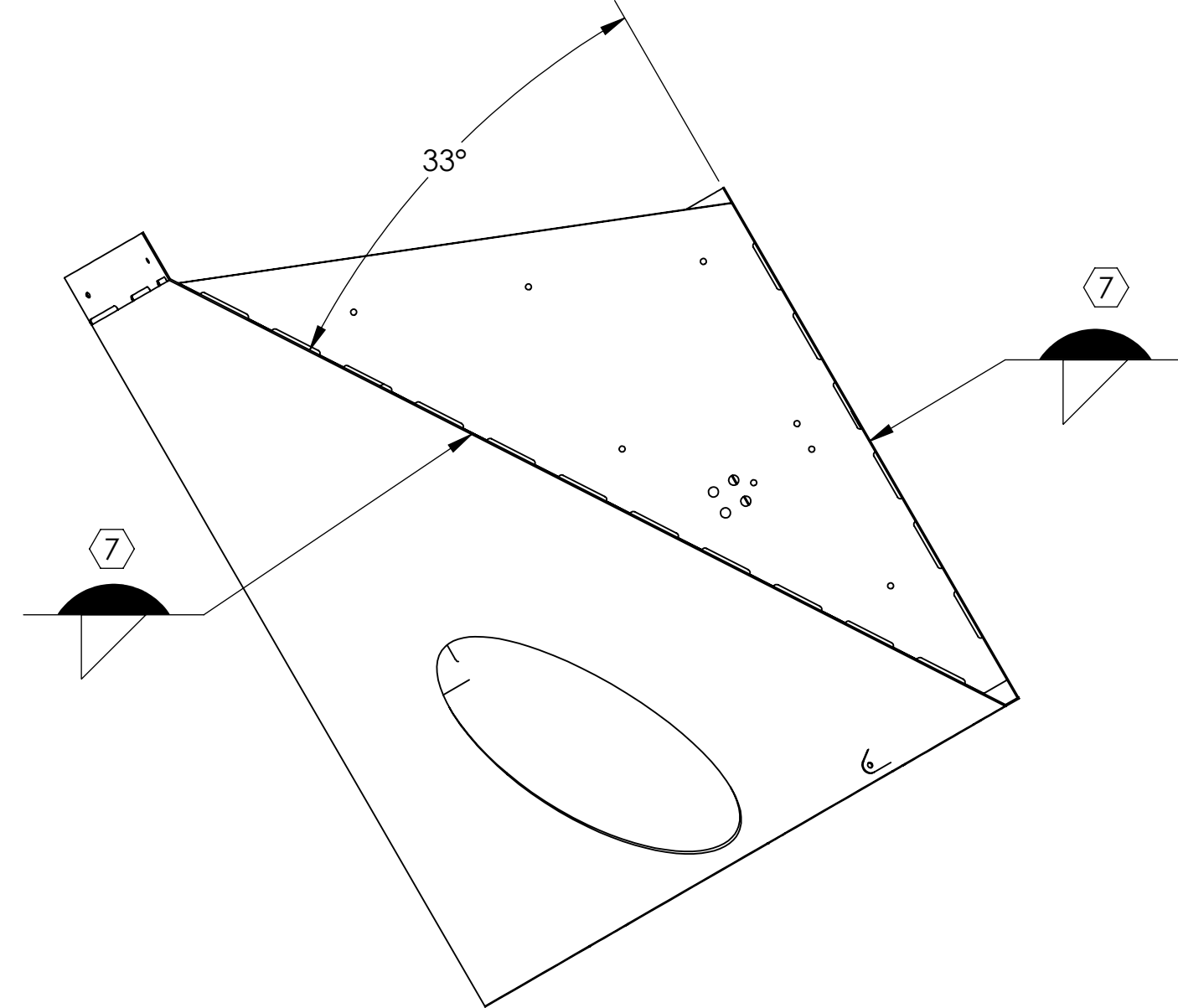
SECTION A-A  
SCALE 2 : 1



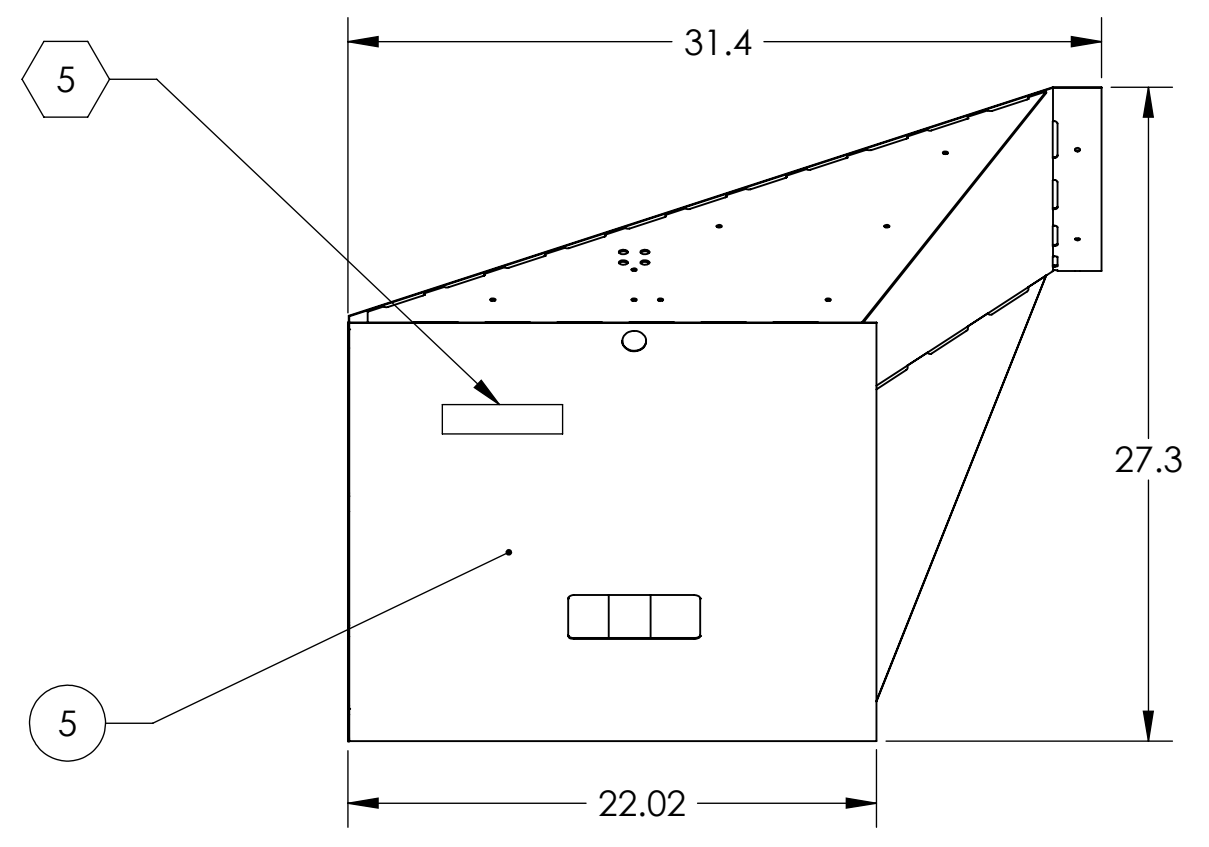
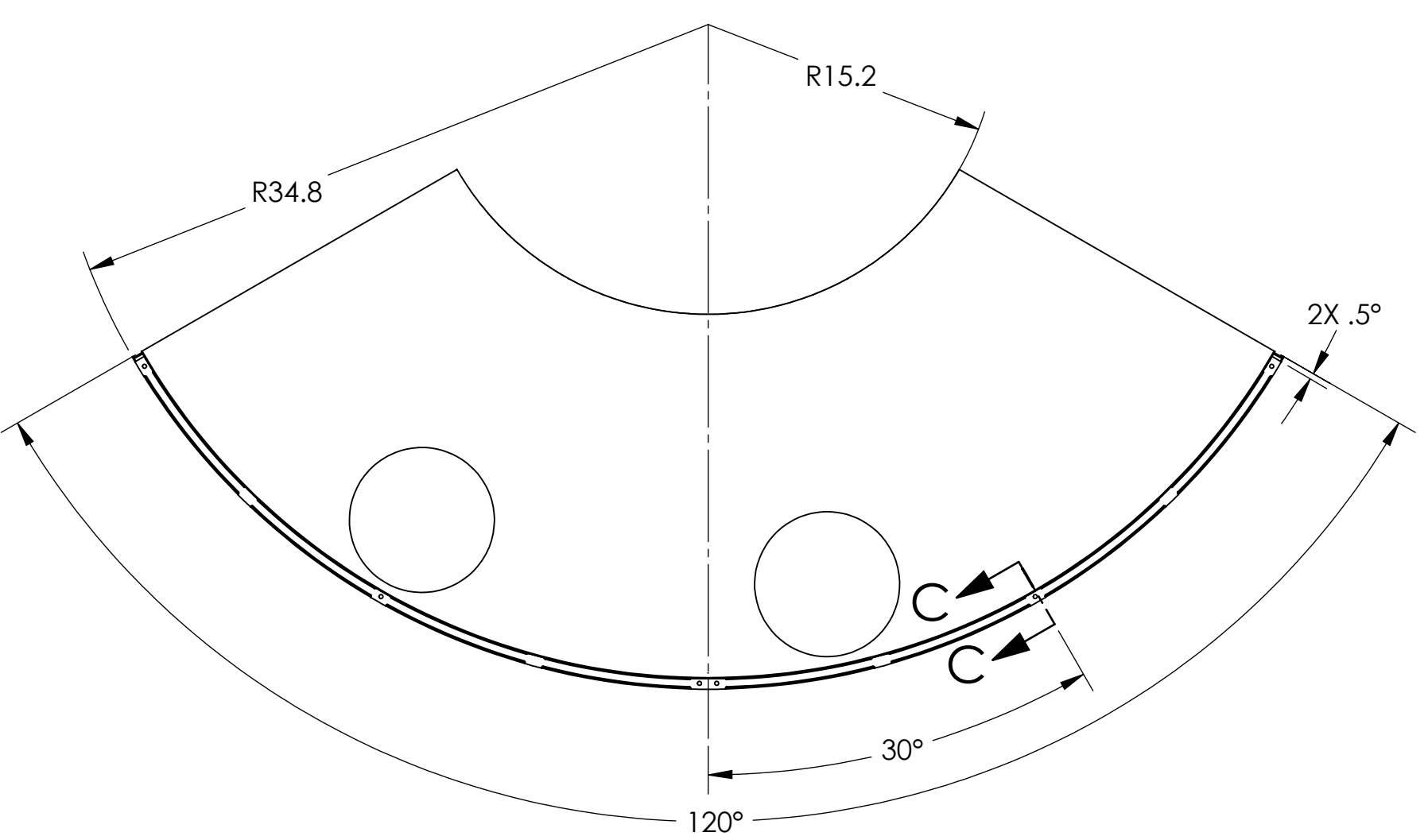
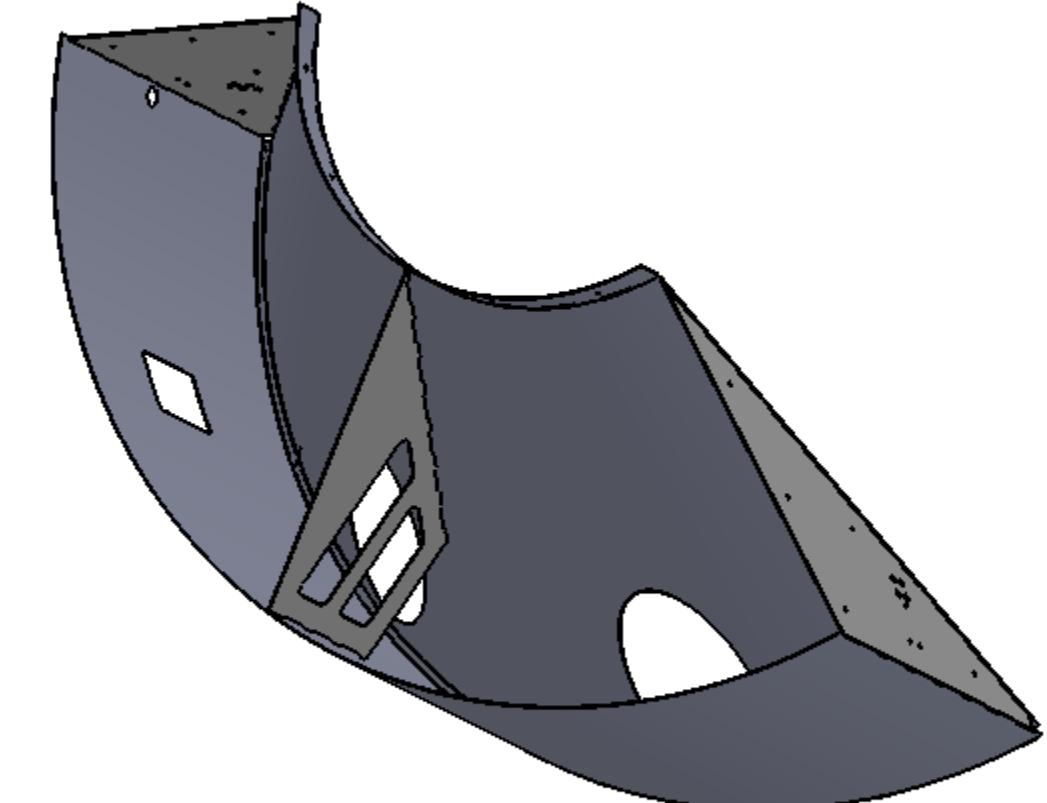
GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



SECTION E-E



SECTION D-D  
SCALE 1 : 6



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSTL	1		0
5	D1000559	RADIAL SEGMENT, RIGHT	18 GAUGE 304 SSTL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSTL	1		0
3	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSTL	1		0
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSTL	2		0
1	D1003232	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMY H1, RIGHT	18 GAUGE 304 SSTL	1		0

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:  
 .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 D1003227

PARTS LIST  
 PART NAME MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMY H1, RIGHT

DESIGNER TQ. NGUYEN 16 DEC 2010  
 DRAFTER TQ. NGUYEN 29 SEP 2011  
 CHECKER M. SMITH  
 APPROVAL D. COYNE

SIZE DWG. NO. D D1003231  
 SCALE: 1:8 PROJECTION: SHEET 1 OF 1

REV. v2

D1003231\_LIGO\_Manifold\_Cryo\_Baffle\_Segment\_Subassembly\_Weldment\_ETMY\_H1\_Right\_PART\_PDM\_REV\_X-014\_DRAINING\_PDM\_REV\_X-006