

- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), 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 CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELD MUST BE PER SPECIFICATION E900048.
 - ⑦ SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 9. 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.

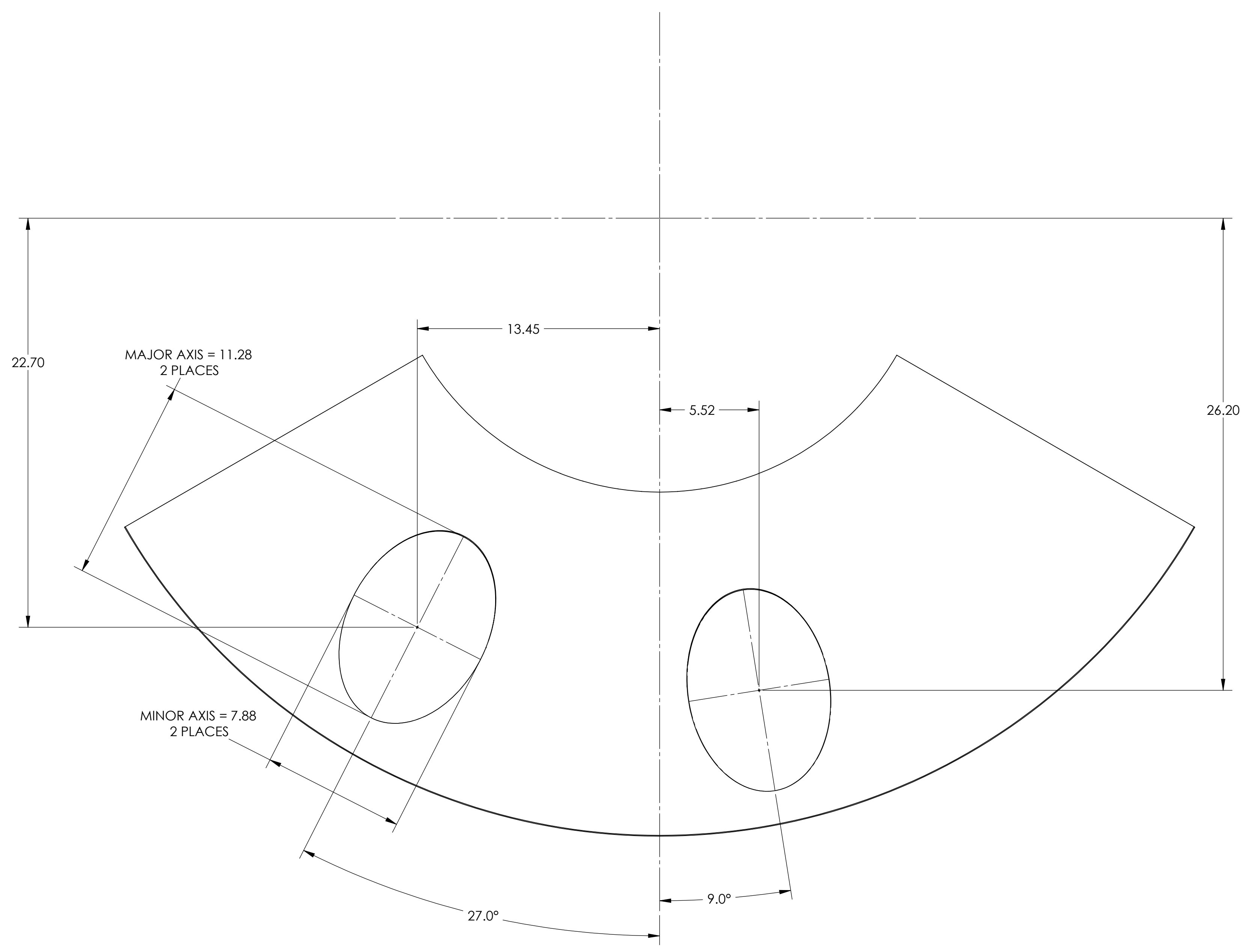
REV.	DATE	DCN #	DRAWING TREE #
V1	1 SEP 2010	E1000360	E1000091
V2	17 OCT 2011	E1000360-V3	-
-	-	-	-

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 D0902654 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°	
MATERIAL	FINISH
18 GAUGE 304 SSSL	⑦ SUPER #8

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS
NEXT ASSY D1003231	PART NAME MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMY H1, RIGHT	

DESIGNER TQ. NGUYEN	16 DEC 2010	SIZE D	DWG. NO. D1003232	REV. v2
DRAFTER TQ. NGUYEN	17 AUG 2010	APPROVAL D. COYNE		
CHECKER M. SMITH	SCALE: 1:8 PROJECTION:			
SHEET 1 OF 2				



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SIZE	DWG. NO.	REV.
D	D1003232	v2

SCALE: 1:8 PROJECTION: SHEET 2 OF 2

D:\003232.dwg_Montréal_Civ2_Baffle_Imes_SegmentIEM1.rvt_RIGHT PART PDM REV: X-304L DRAWING PDM REV: X-003