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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

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

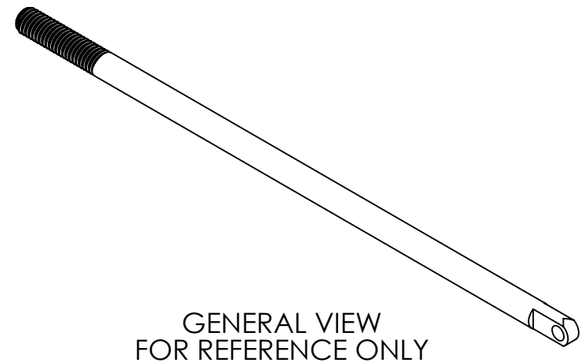
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

9. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

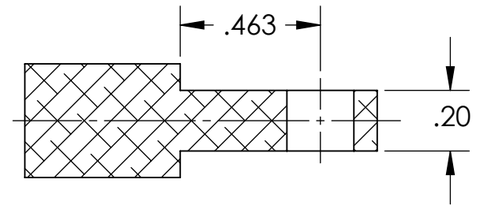
10. ELECTRO POLISH TO REMOVE .0005-.001 PER SIDE.

TABLE OF LENGTH		
	D1100866-01	D1100866-02
X	11.750	10.25

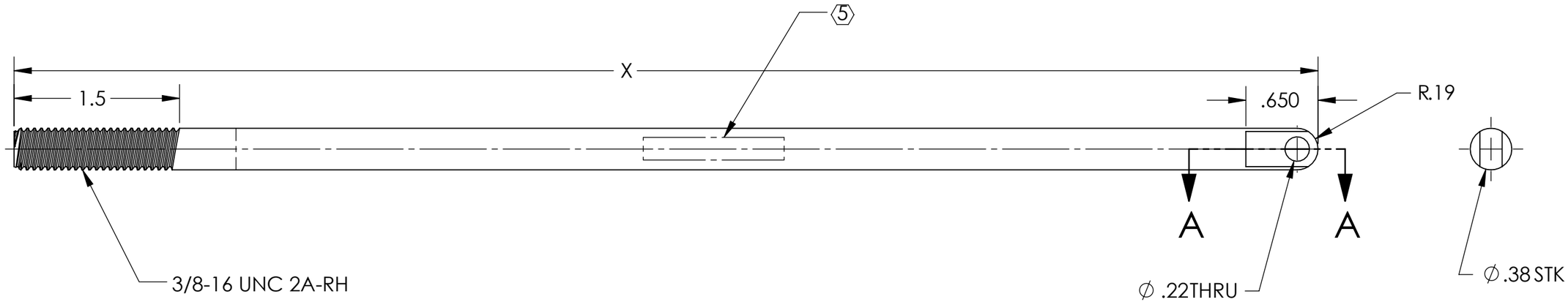
REV.	DATE	DCN #	DRAWING TREE #
v1	9 MAY 2011	E1000360-v2	-
v2	14 SEP 2011	E1000360-V3	-
v3	21 DEC 2011		-



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



SECTION A-A
SCALE 2 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .02
.XXX ± .005

ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, ON ALL EDGES AND HOLES.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: 304 SSTL
FINISH: 32 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1100865

PART NAME: MANIFOLD CRYO PUMP BAFFLE, ROD

DESIGNER	H. KELMAN	9 MAY 2011
DRAFTER	TQ. NGUYEN	9 MAY 2011
CHECKER	M. SMITH	
APPROVAL	D. COYNE	

SIZE: B | DWG. NO.: D1100866 | REV.: v3
SCALE: 1:1 | PROJECTION: | SHEET 1 OF 1

D1100866_aLIGO_Manifold_Cryo_Baffle_Rod, PART PDM REV: X-024, DRAWING PDM REV: X-023