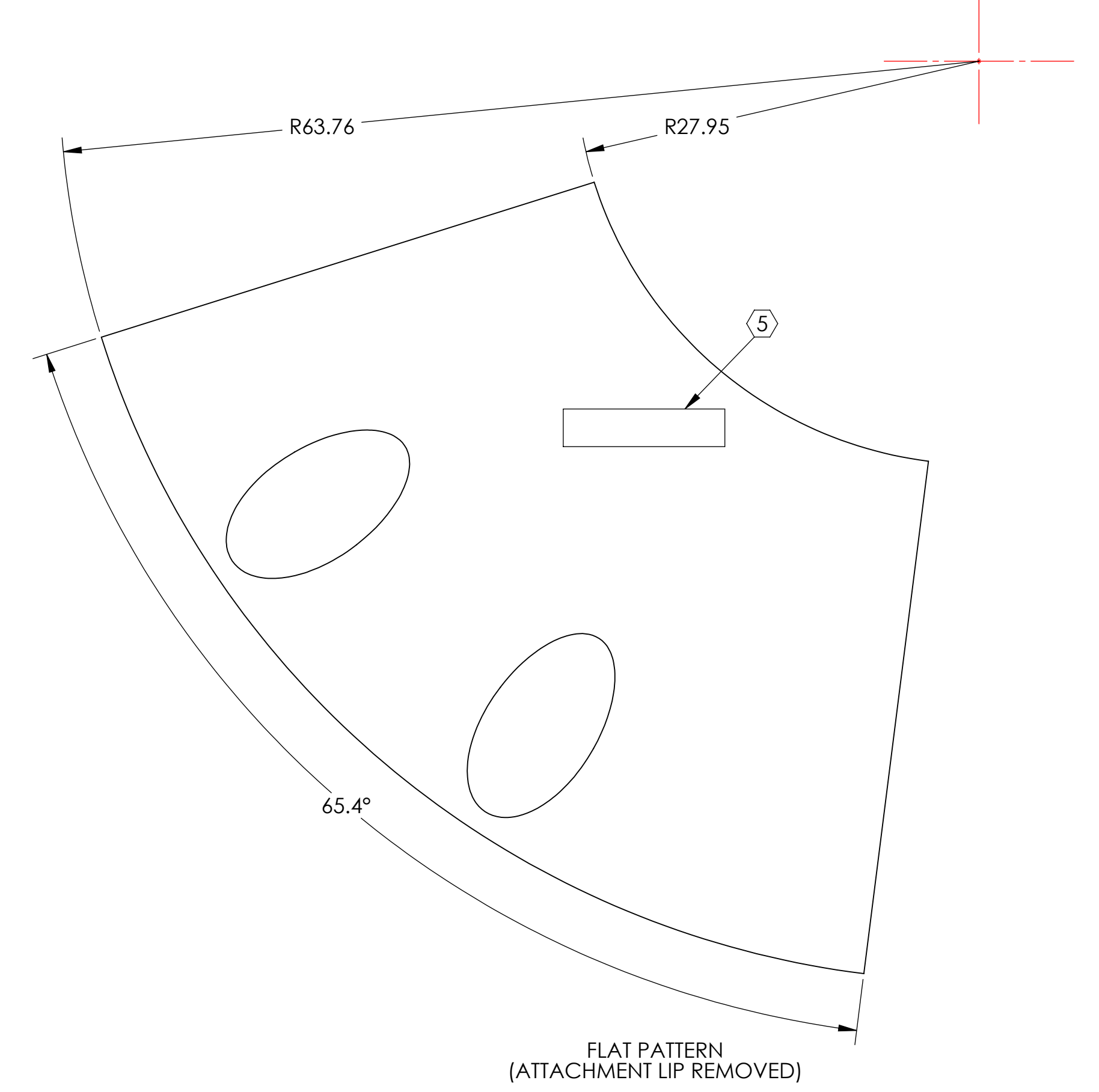
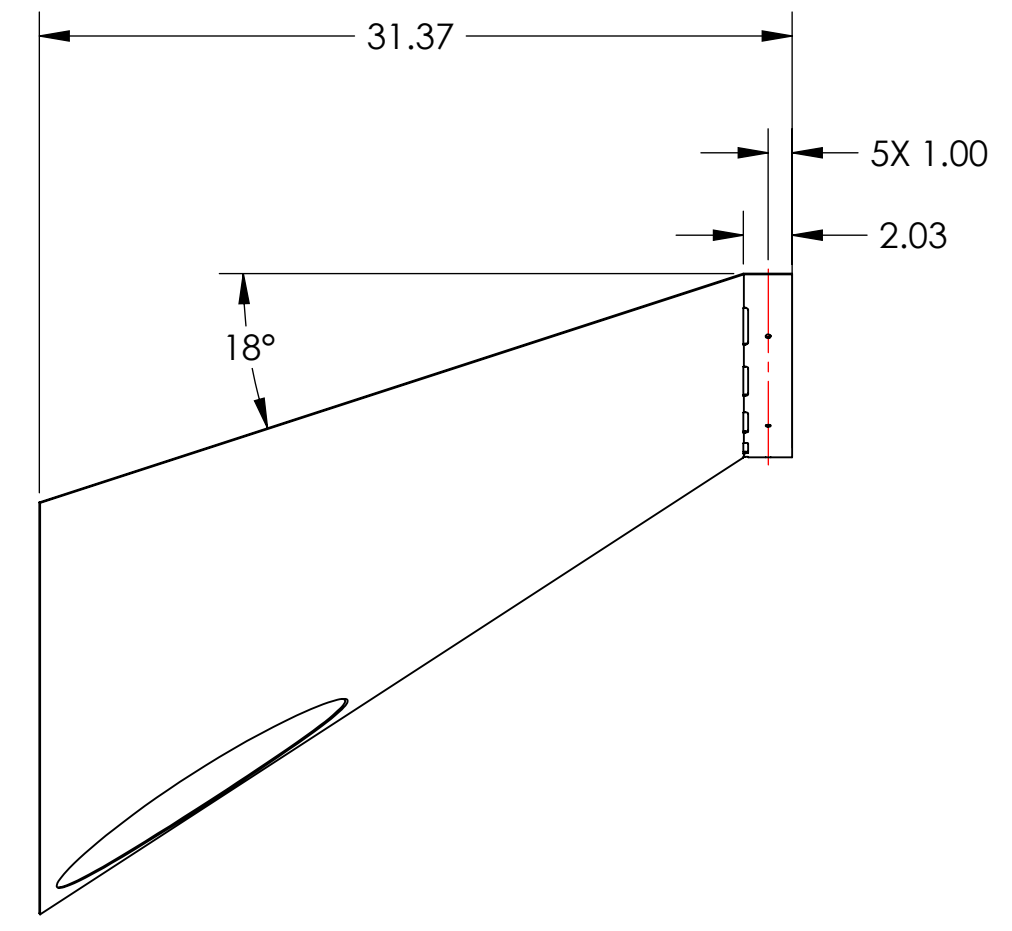
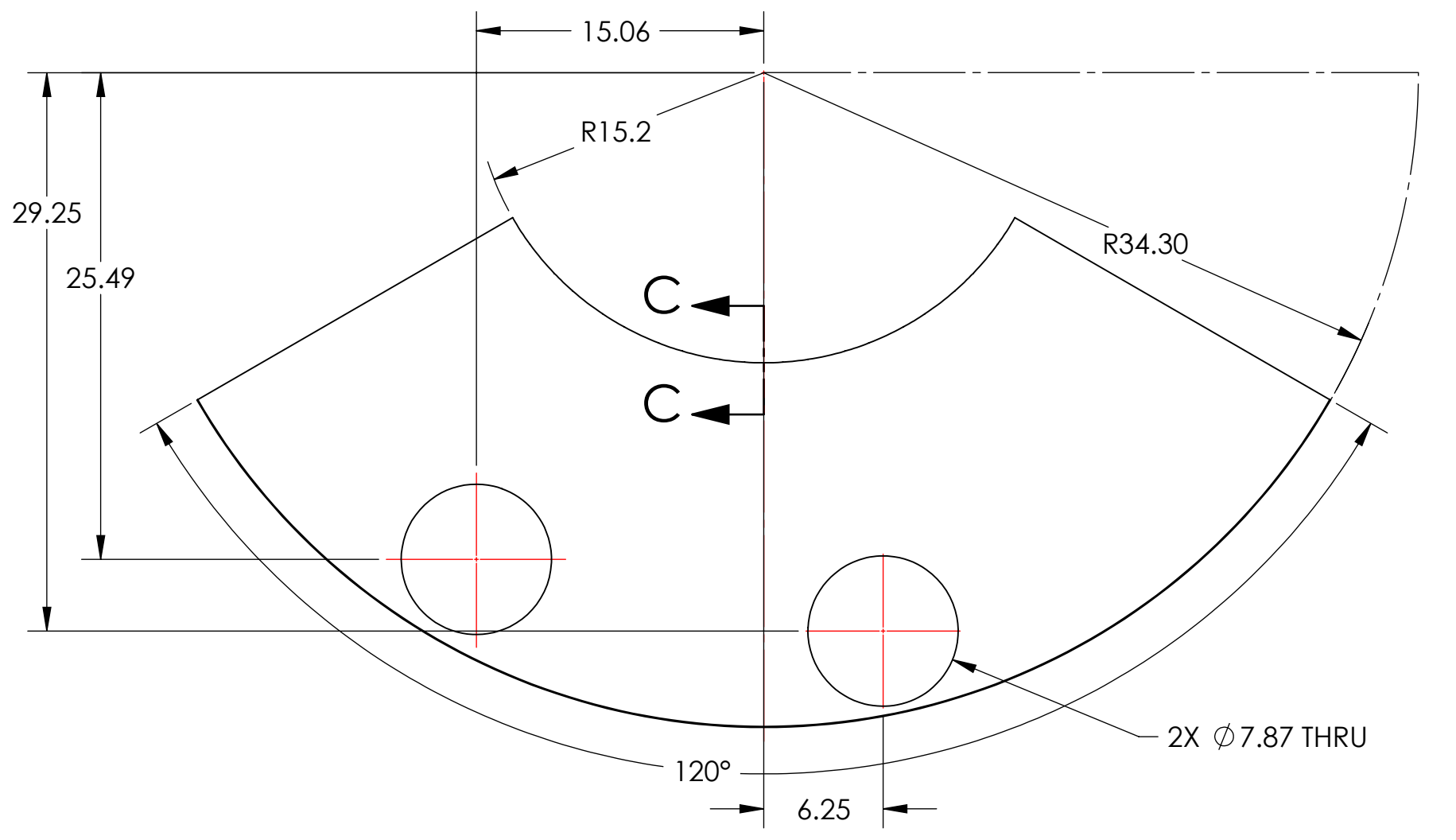
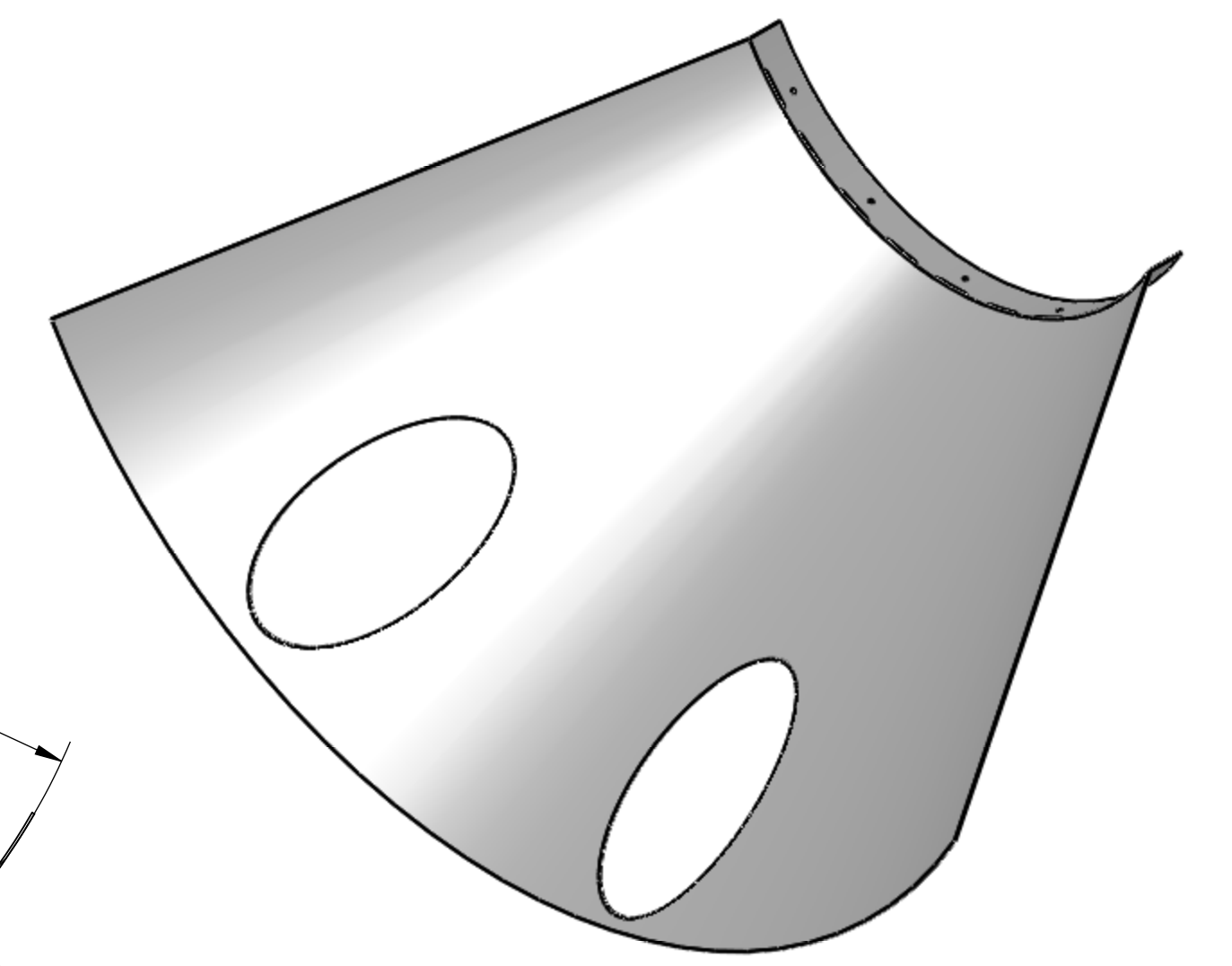
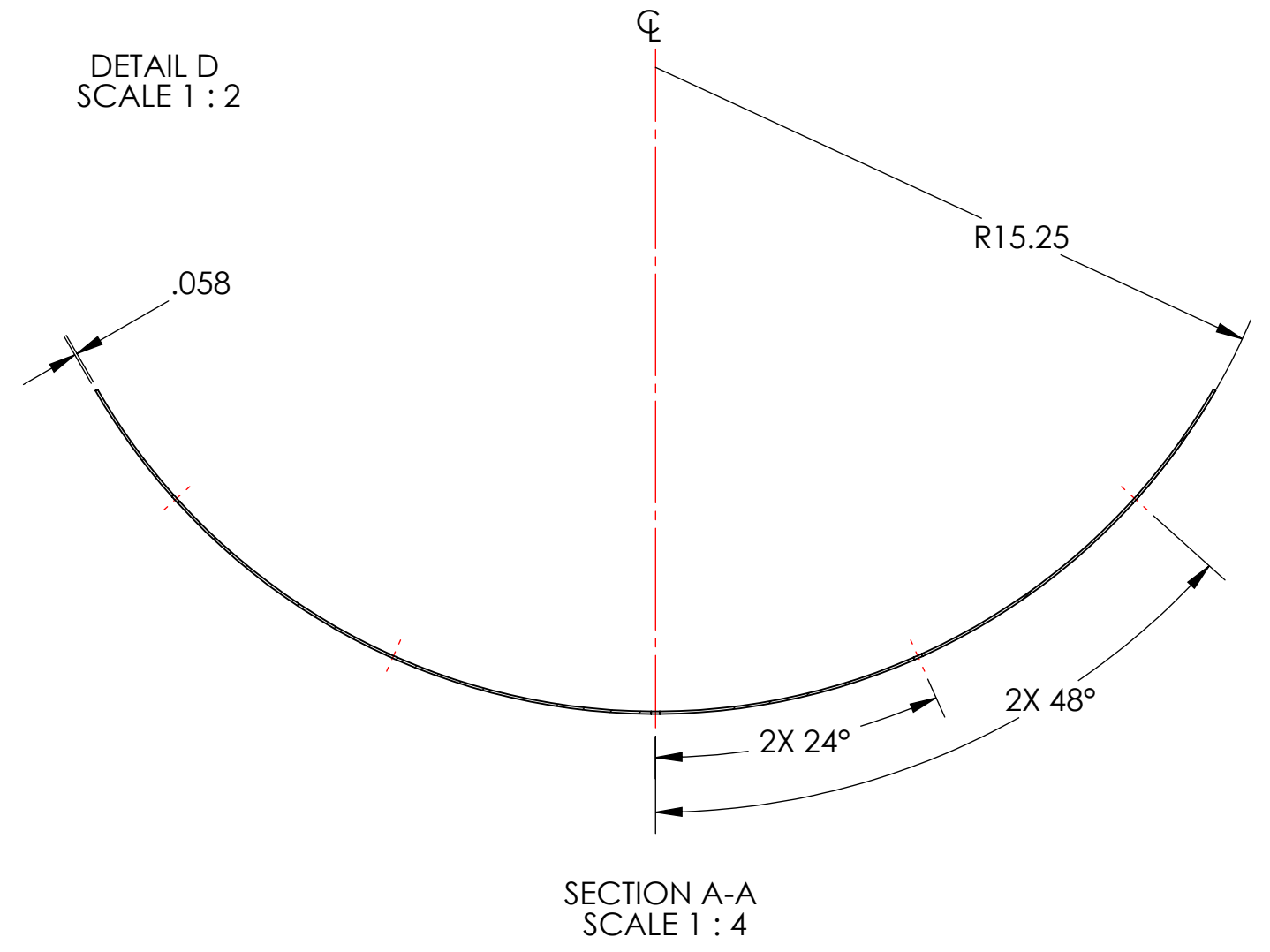
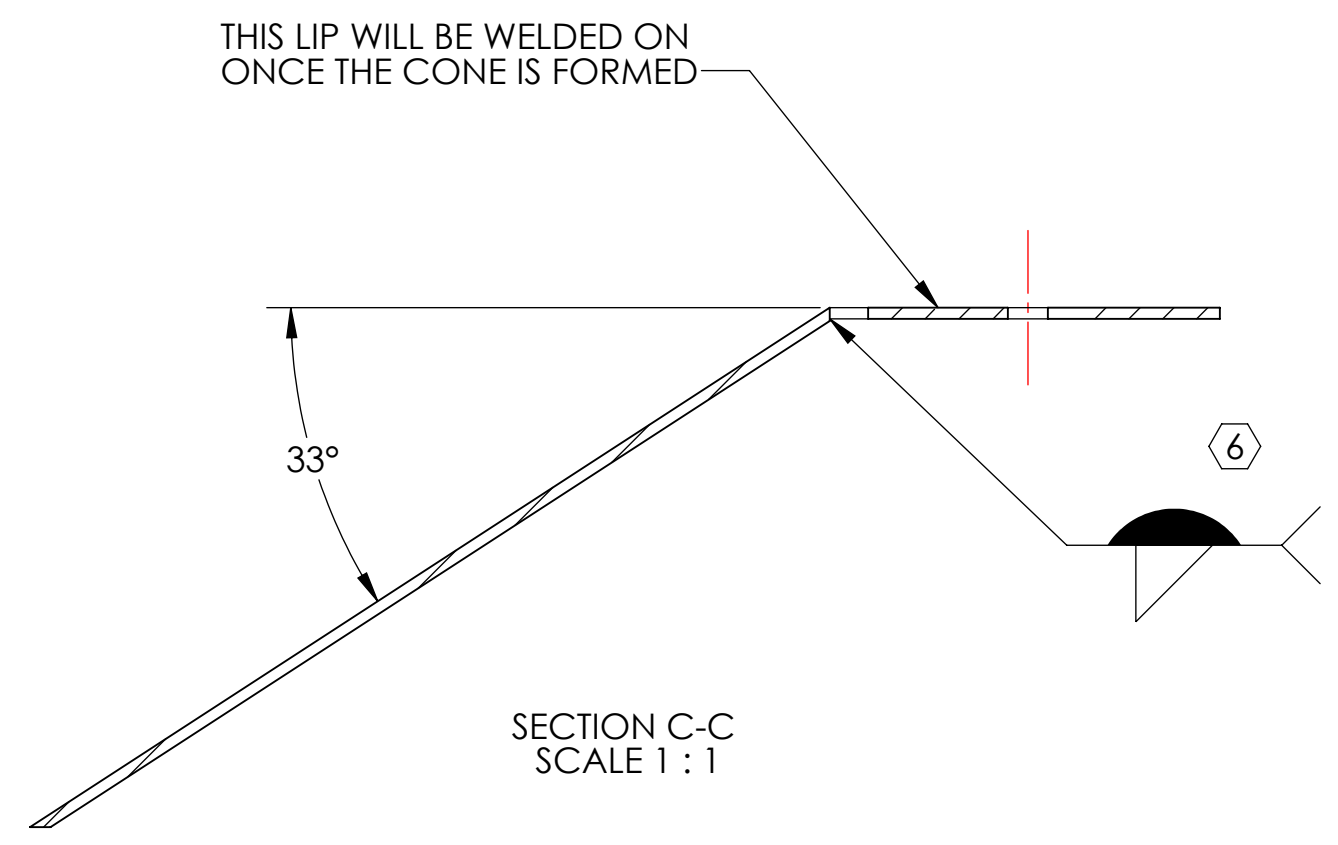
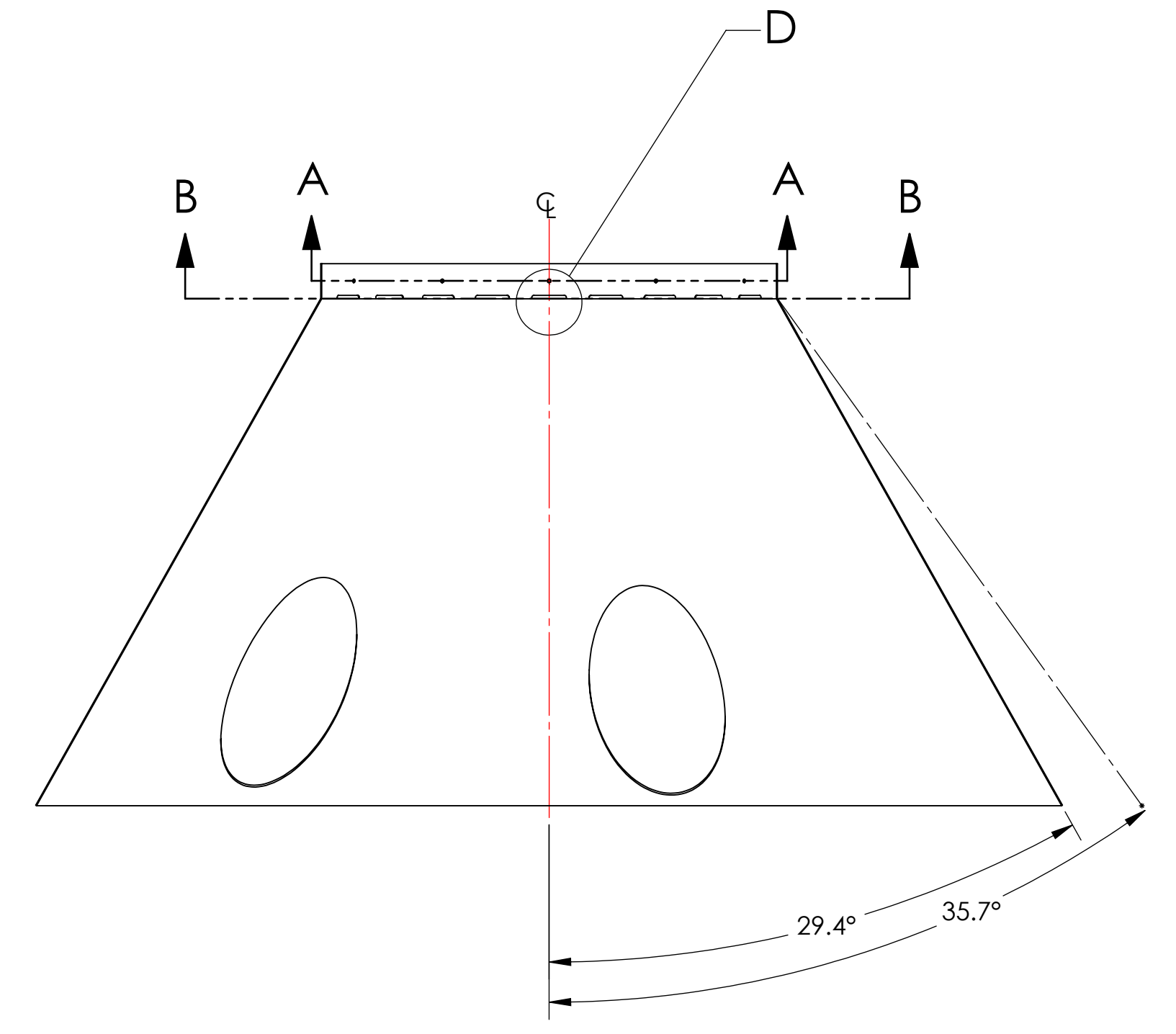
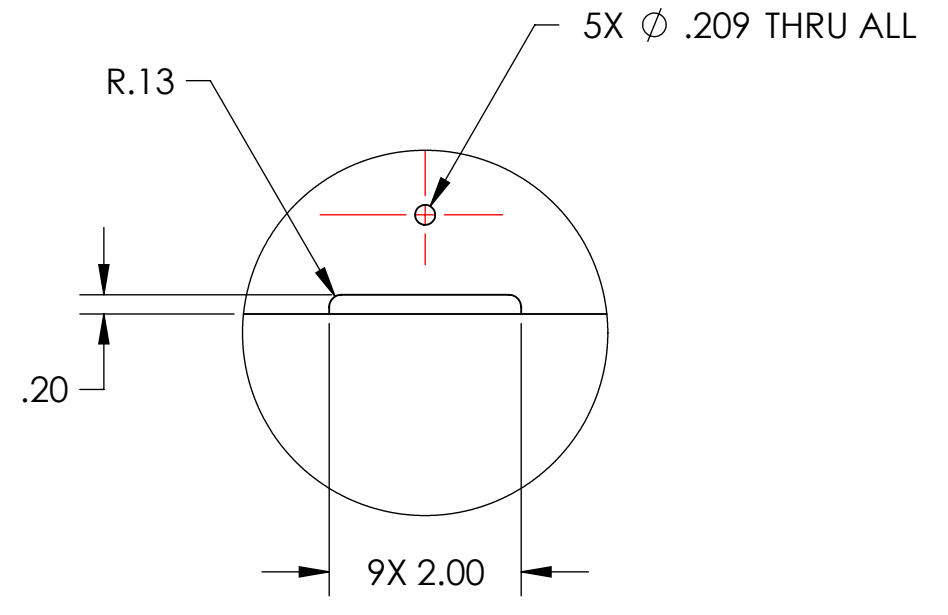
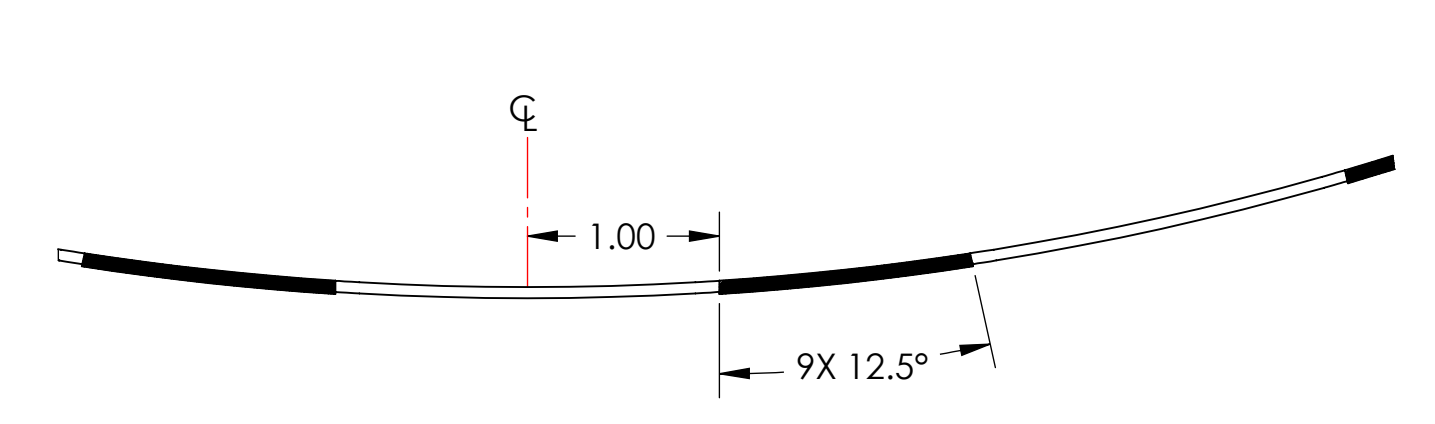


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	1 SEP 2010	E1000360	E1000091
-	-	-	-
-	-	-	-



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.

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .06 .XXX ± .010		ANGULAR ± 0.5°	
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.					
MATERIAL	18GA A424 TYPE I STEEL		FINISH	⑦	

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		MANIFOLD-CRYO BAFFLE INNER	
SYSTEM ADVANCED LIGO		SUB-SYSTEM		AOS	
NEXT ASSY		D0902654		DESIGNER: H. KELMAN 12 MAY 2010 DRAFTER: TQ. NGUYEN 17 AUG 2010 CHECKER: M. SMITH APPROVAL: D. COYNE	

PART NAME SEGMENT WELDMENT, ITMX H1-H2, RIGHT		DESIGNER	H. KELMAN	12 MAY 2010	SIZE	DWG. NO.	REV.
		DRAFTER	TQ. NGUYEN	17 AUG 2010	D	D0902619	V1
		CHECKER	M. SMITH		SCALE: 1:8	PROJECTION:	SHEET 1 OF 1