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 VARIENT 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) CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).

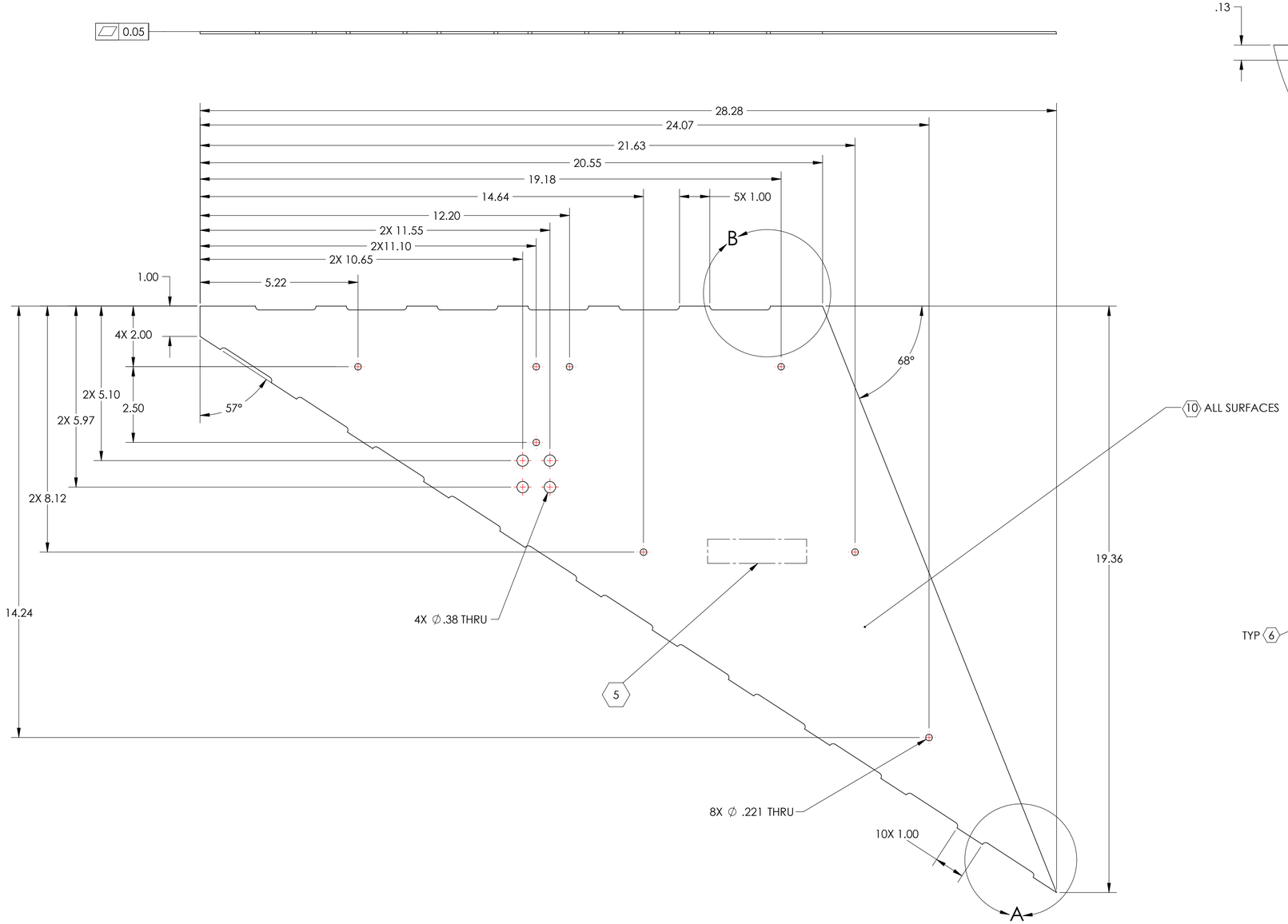
7. DELETED

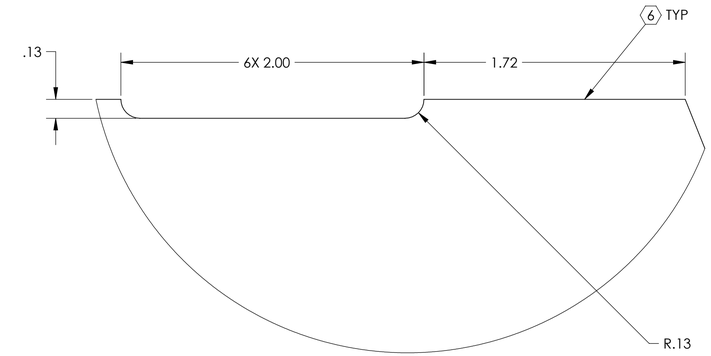
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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.

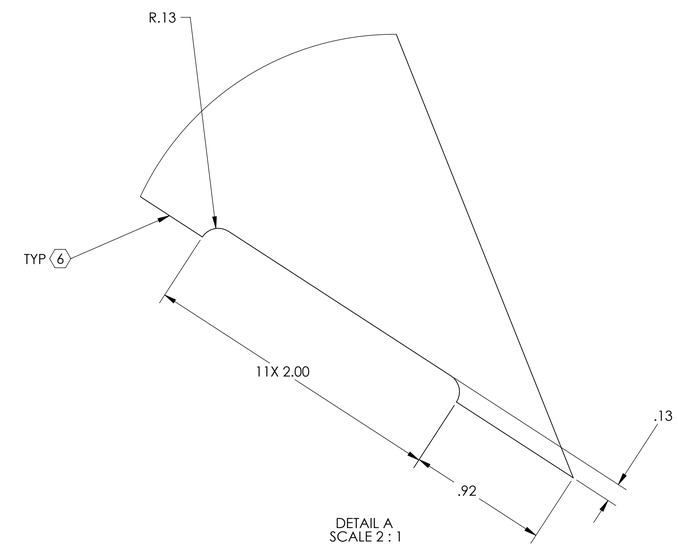
(10) SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 MAR 2010	E1000360	E1000085-v1
v2	12 MAY 2011	E1000360-v2	E1000090-v1
v3	4 OCT 2011	E1000360-v3	E1000091-v1





DETAIL B
SCALE 2 : 1



DETAIL A
SCALE 2 : 1

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 NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .06
.XXX ± .010

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: 14 GAUGE 304 SSTL
FINISH: (10)

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

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

PART NAME: MANIFOLD CRYO BAFFLE BRACKET

DESIGNER	H. KELMAN	17 MAR 2010	SIZE: D	DWG. NO.: D0902621
DRAFTER	TQ. NGUYEN	16 AUG 2010		REV.: v3
CHECKER	M. SMITH	27 SEPT 2011		
APPROVAL	D. COYNE		SCALE: 1:8	PROJECTION:

SHEET 1 OF 1

D0902621 aLIGO_Manifold_Cryo_Baffle_Bracket_PART PDM REV:X-067_DRAWING PDM REV:X-035