



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 D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

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. WELD MUST BE PER SPECIFICATION E900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .06 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	FINISH
18GA A424 TYPE I STEEL	⑦

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	SUB-SYSTEM
ADVANCED LIGO		AOS
NEXT ASSY	D0902656	

PART NAME		MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT	
DESIGNER	H. KELMAN	12 MAY 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	17 AUG 2010	D
CHECKER	M. SMITH		D0902622
APPROVAL	D. COYNE		SCALE: 1:8 PROJECTION:
			SHEET 1 OF 1

D0902622.dwg; Manifold_Cryo_Baffle_Inner_Segment; ITMX H1-H2; Left; PART PDM REV: X01; DRAWING PDM REV: X004