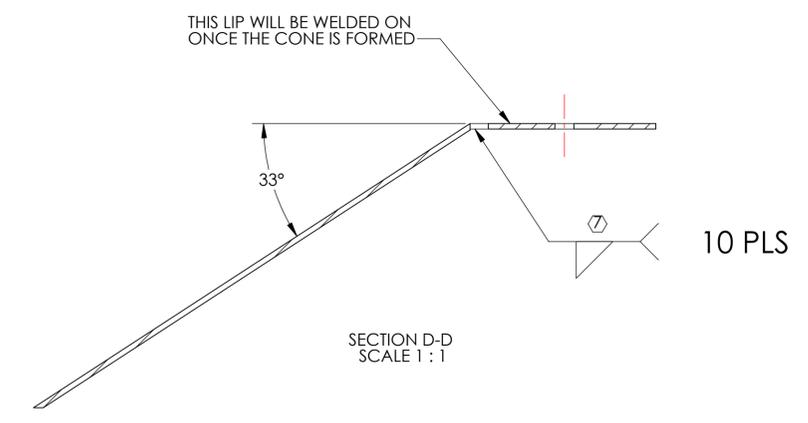
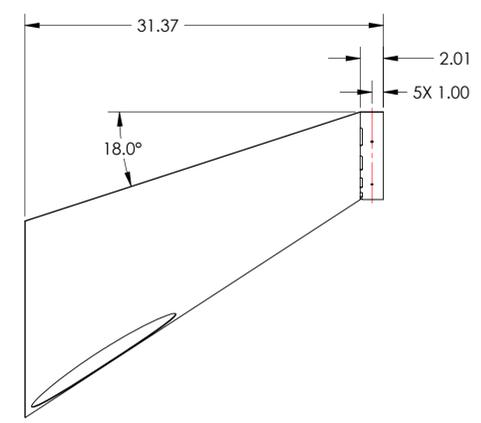
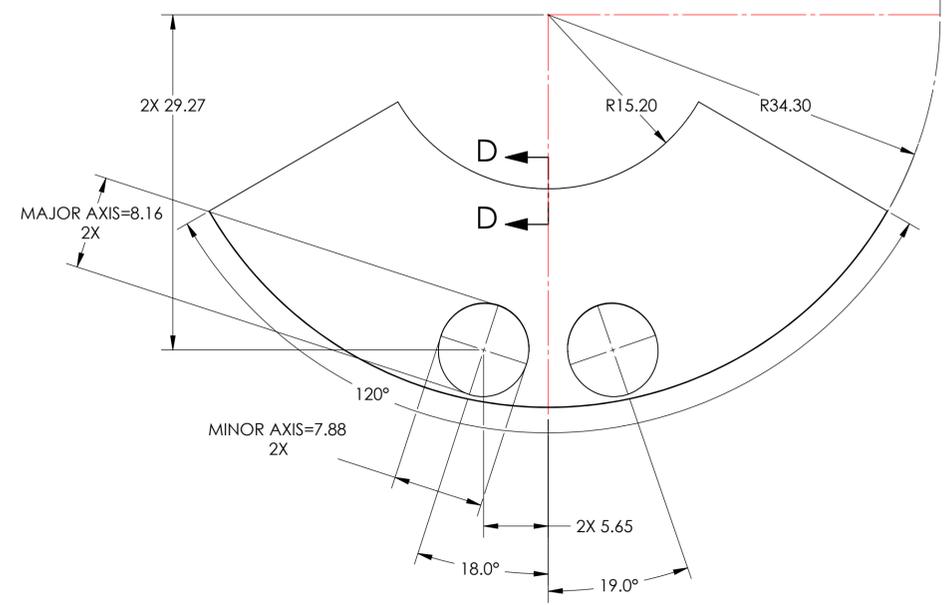
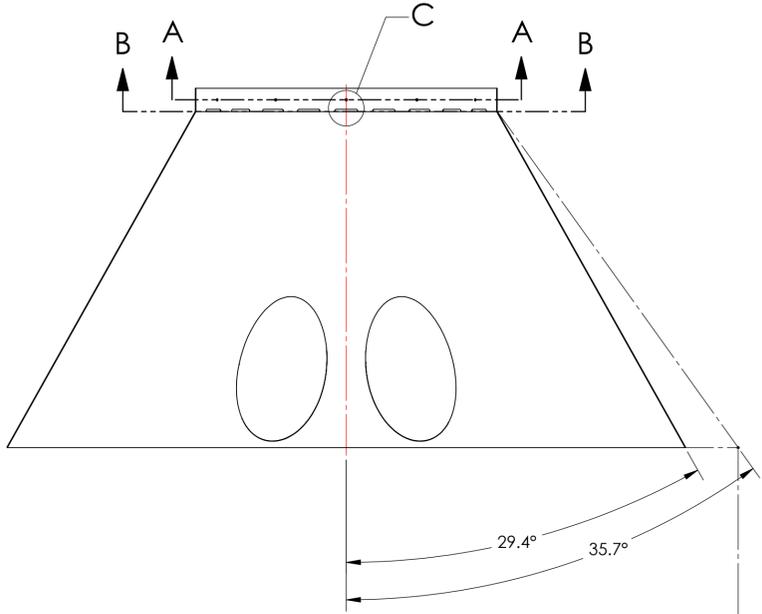
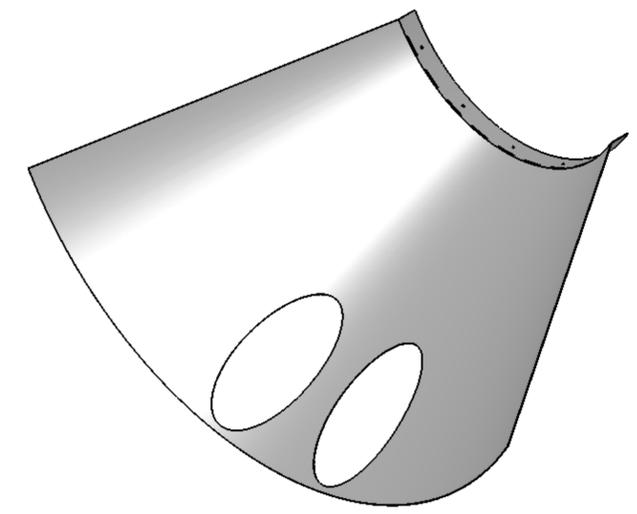
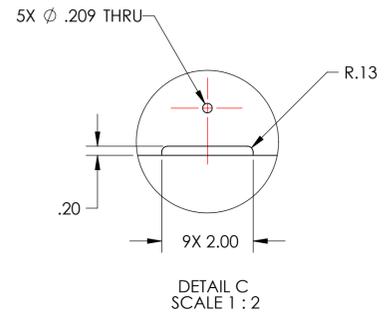
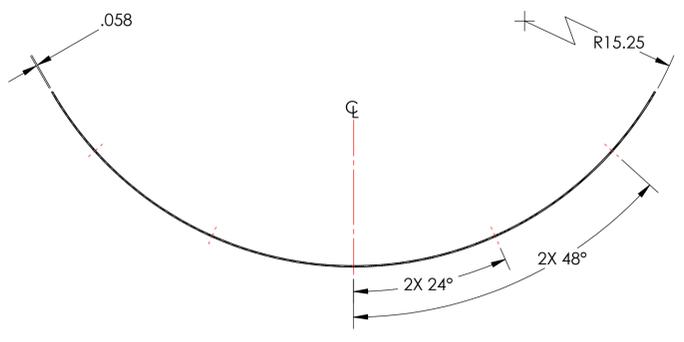
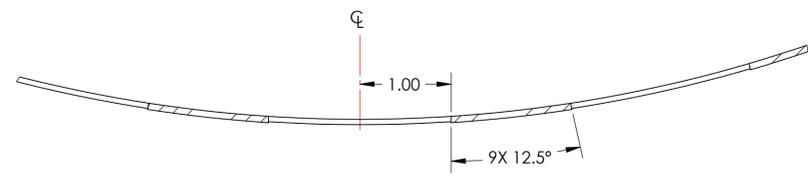


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001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

- 6. ASSY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED.
- 7. CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT.
- 8. MATERIAL AS RECEIVED MACHINE FINISH



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 ± .03 .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	8	

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMY H1, BOTTOM	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS
NEXT ASSY	D0902655		

DESIGNER	TQ. NGUYEN	16 DEC 2010	SIZE	DWG. NO.	REV.
DRAFTER	TQ. NGUYEN	17 AUG 2010	D	D0902623	v2
CHECKER	M. SMITH				
APPROVAL	D. COYNE		SCALE: 1:8	PROJECTION:	SHEET 1 OF 1

D0902623.dwg; C:\Users\nguyen\OneDrive\Documents\Projects\Advanced LIGO\Drawings\Part\PDW\REV-X\004.DRAWING.PDW; REV-X\004