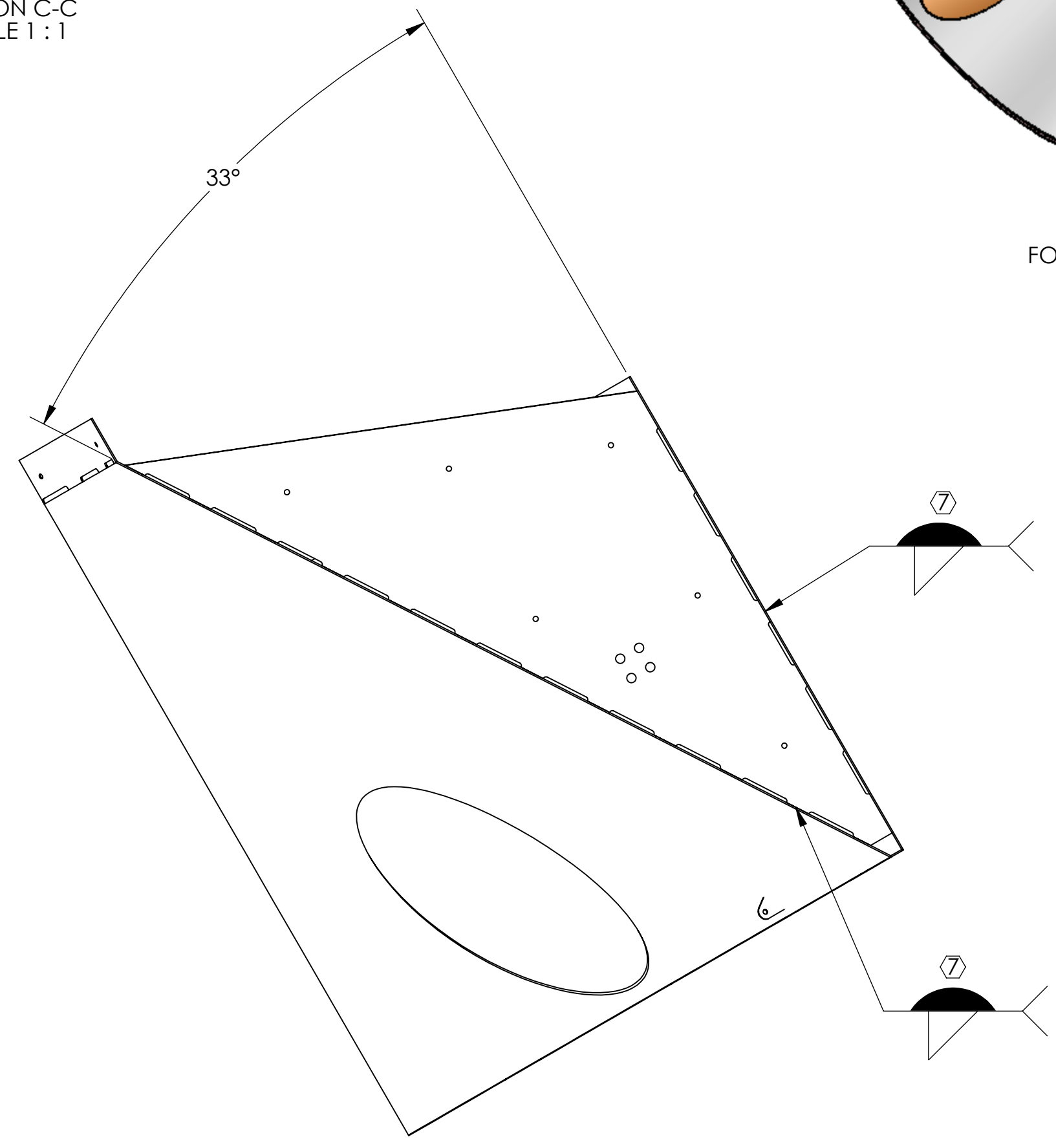
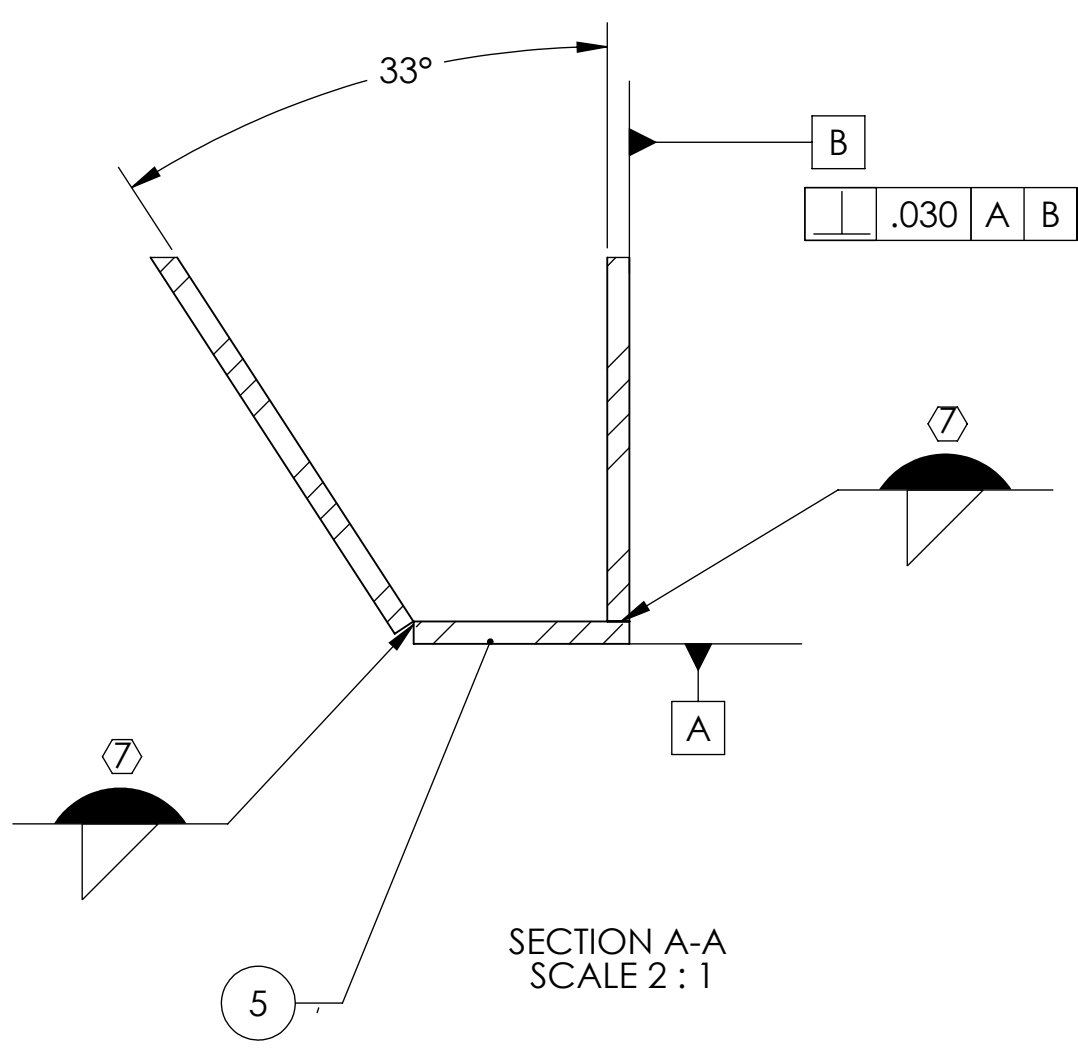
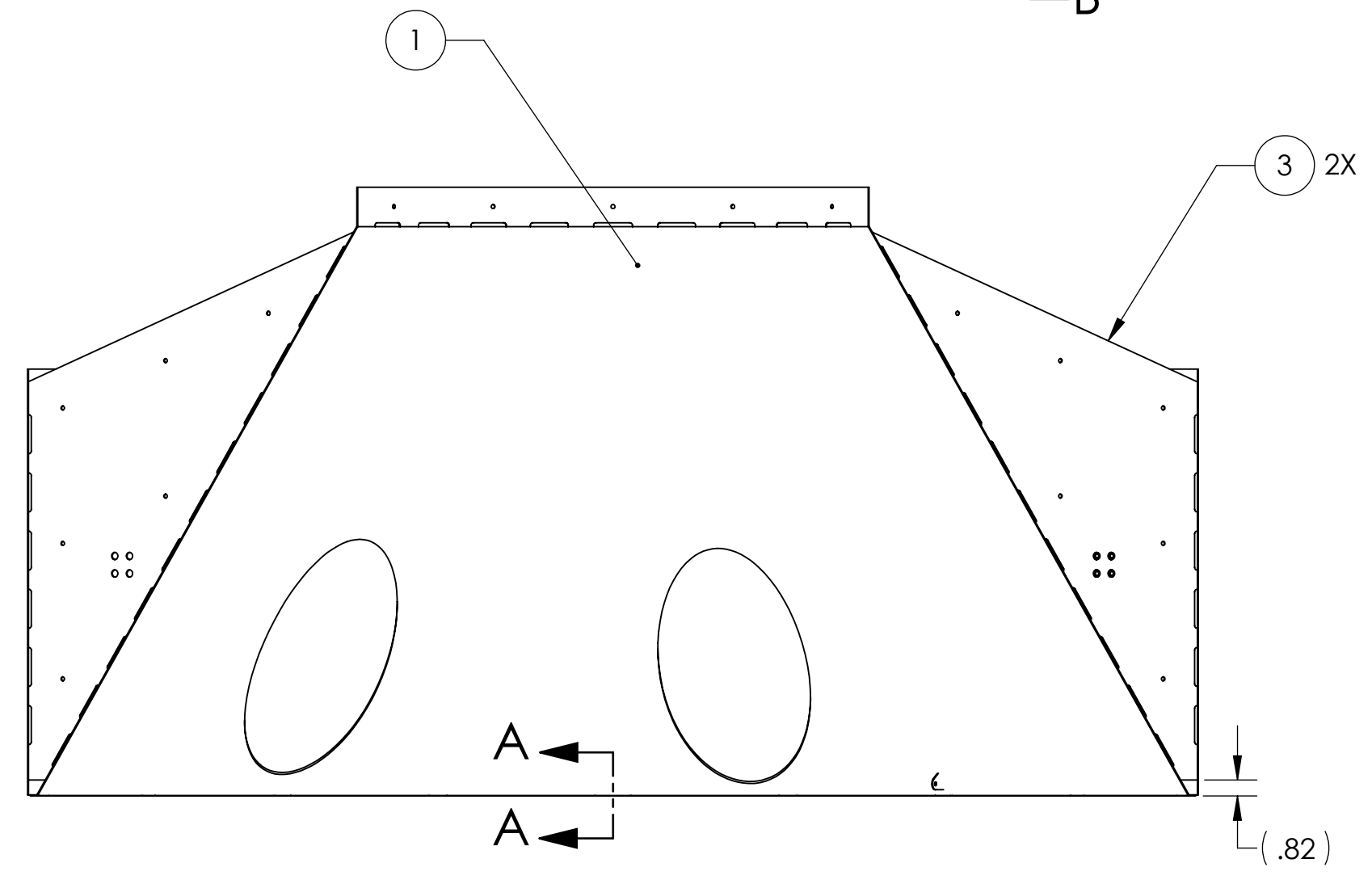
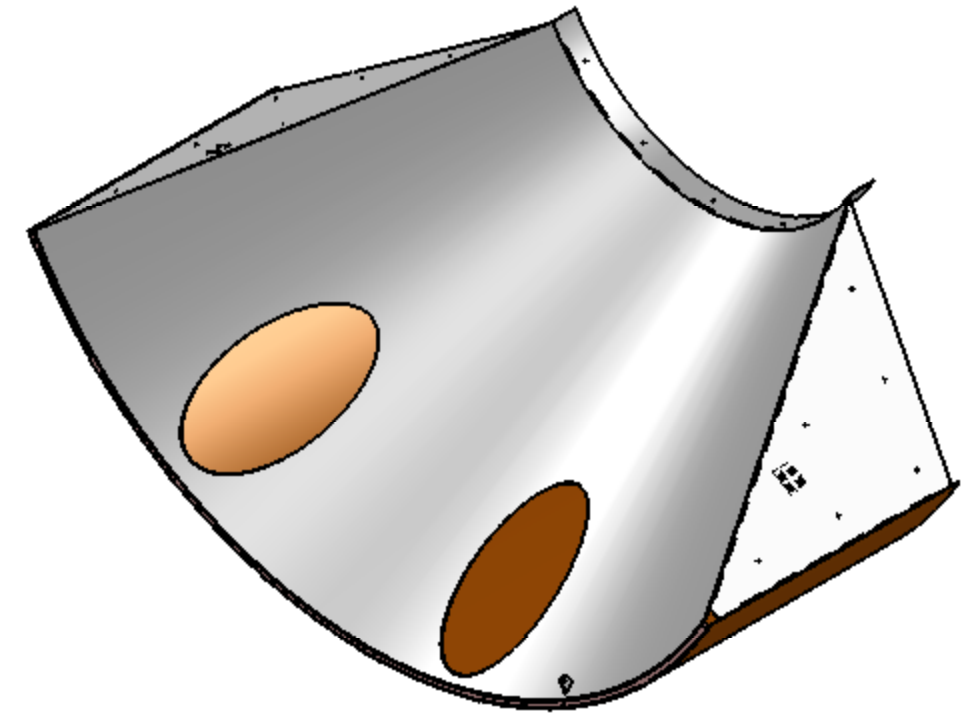
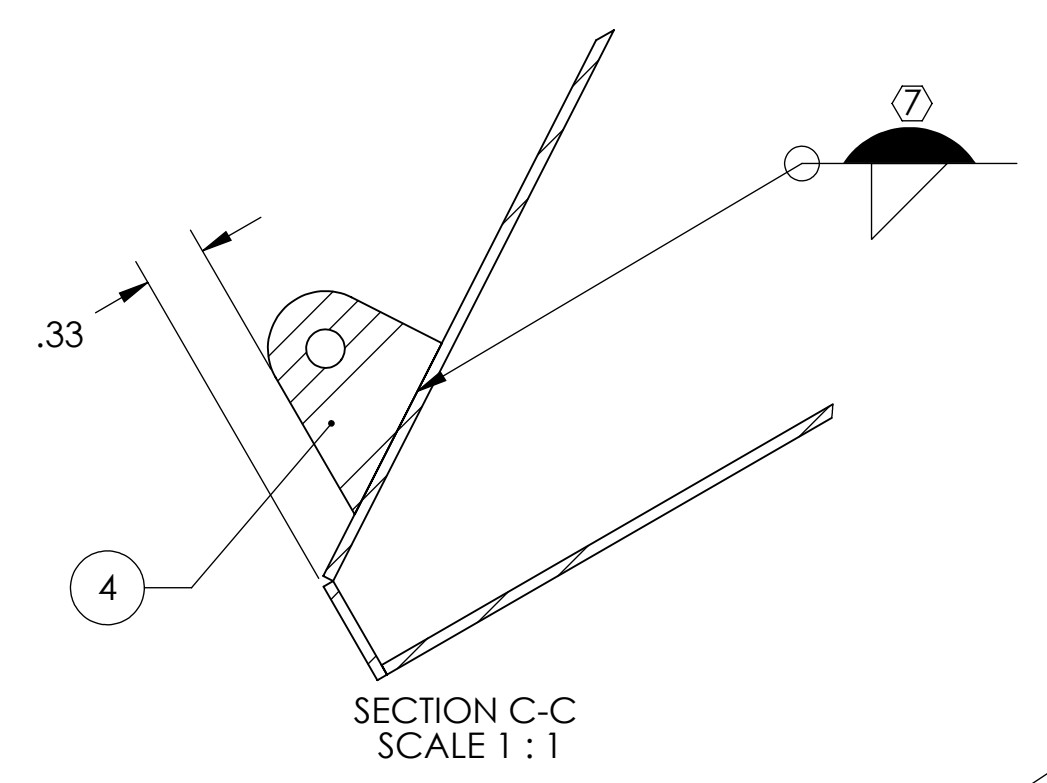
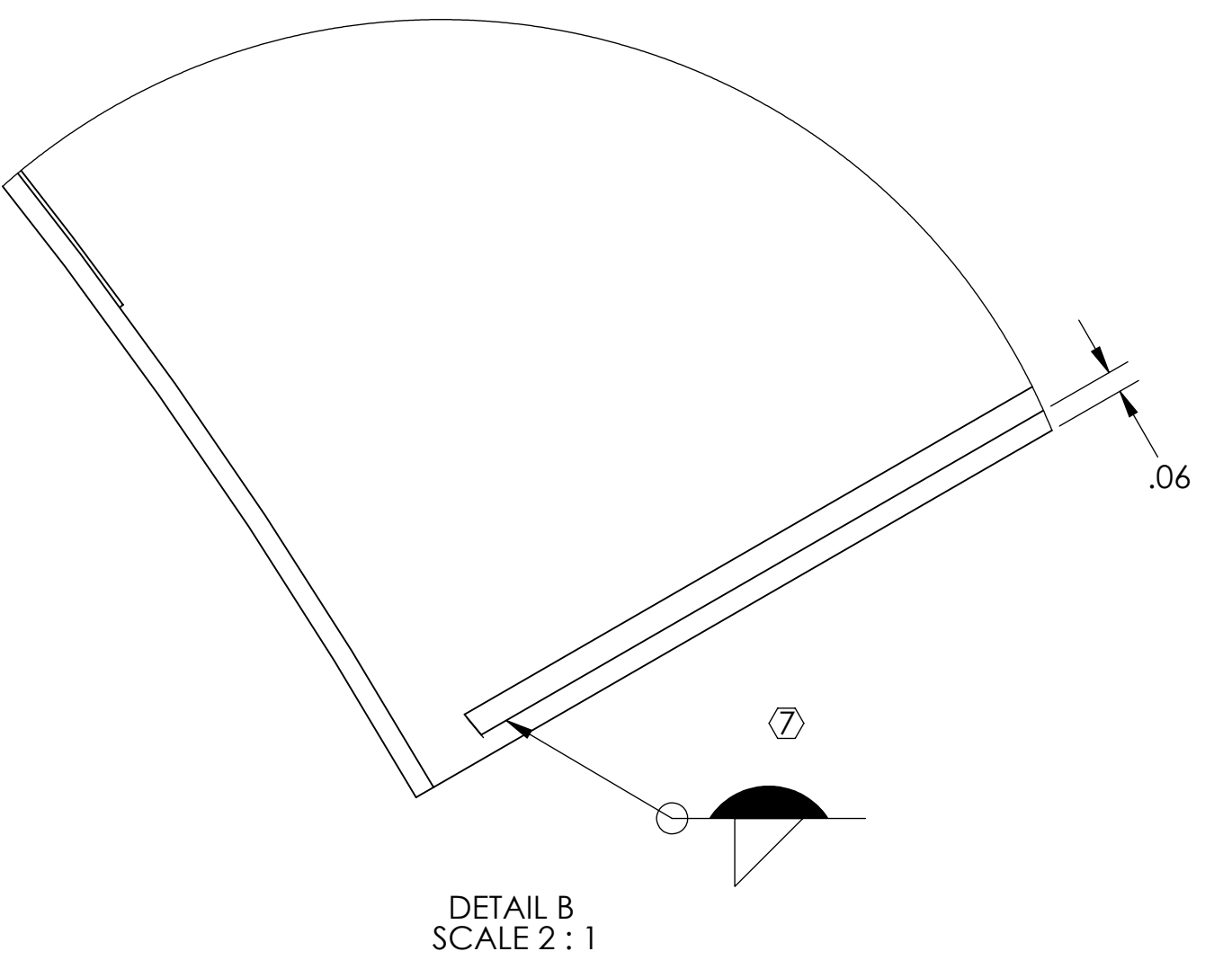
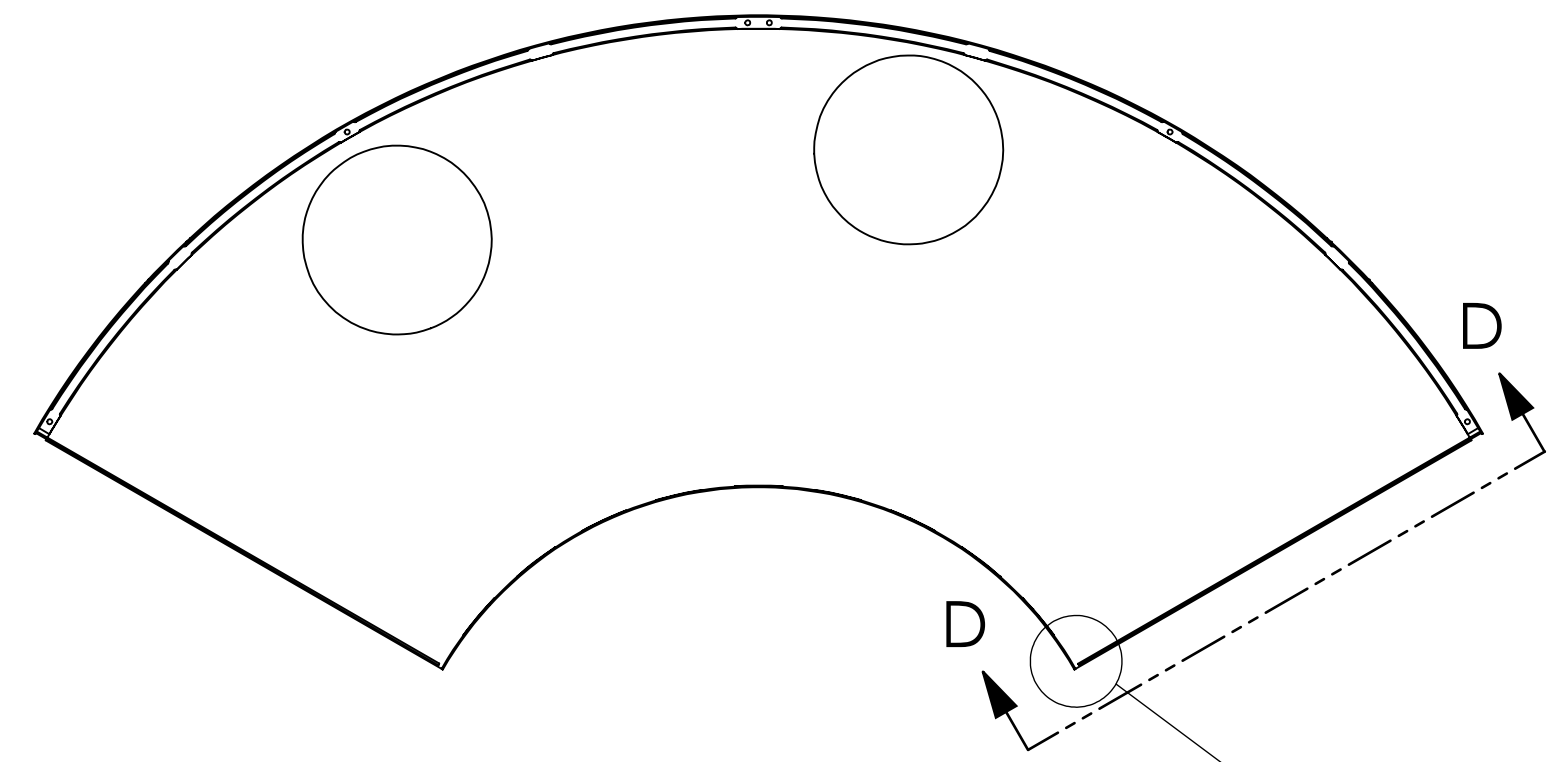


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

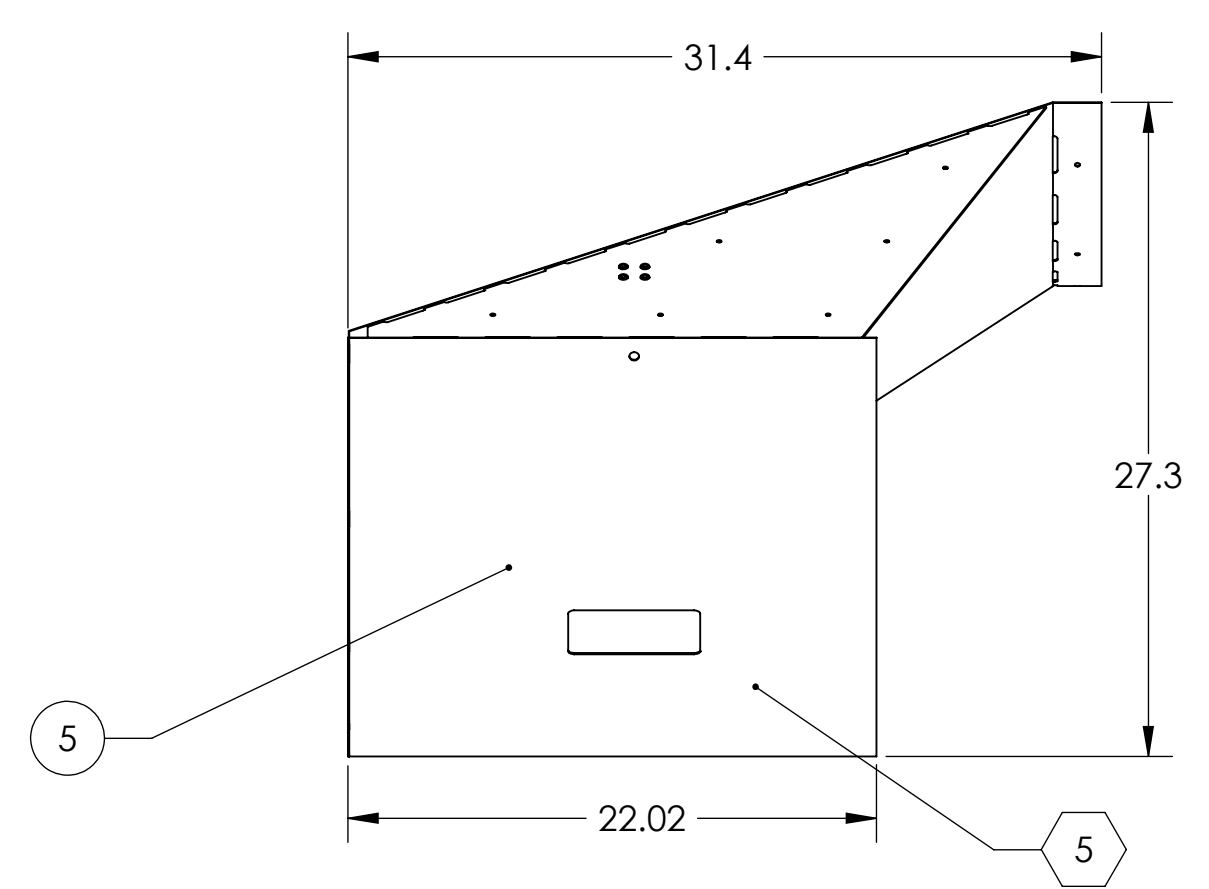
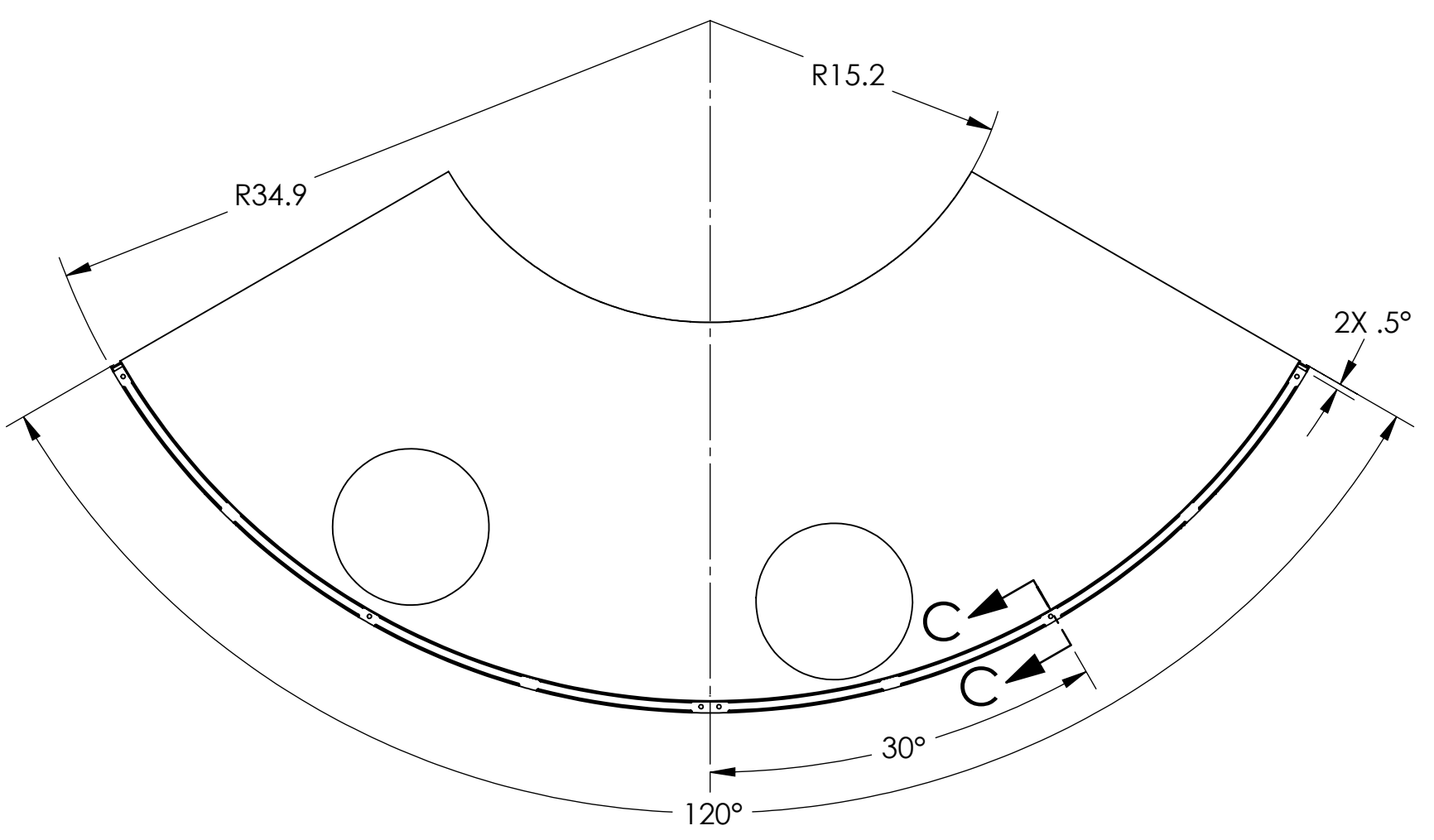
⑦ FILLET WELDS WHERE ITEMS ① & ③, ① & ⑤, & ① & ④ MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000091



7 PLS

12 PLS



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
5	D1000559	RADIAL SEGMENT, RIGHT	18GA A424 TYPE I STEEL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		0
3	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		0
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		0
1	D0902619	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, RIGHT	18GA A424 TYPE I STEEL	1		0

DIMENSIONS ARE IN INCHES	
TOLERANCES:	
.X ± .1	
.XX ± .06	
.XXX ± .010	
ANGULAR ± 1.0°	

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	N/A
FINISH	⑧

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS
NEXT ASSY D1002061		

PARTS LIST		PART NAME	
MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, RIGHT		DESIGNER	H. KELMAN
DATE	20 MAY 2010	CHECKER	TG. NGUYEN
DATE	07 SEP 2010	CHECKER	M. SMITH
DATE		APPROVAL	D. COYNE
SIZE	D	DWG. NO.	D0902654
REV.	v1	SCALE	1:8
		PROJECTION	
		SHEET 1 OF 1	

D:\0202654\atUGO_Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ITMX_H1-H2_Right_PARR_PDM_REV.X-008.DRAWING.PDM REV: X-008