NOTES CONTINUED:

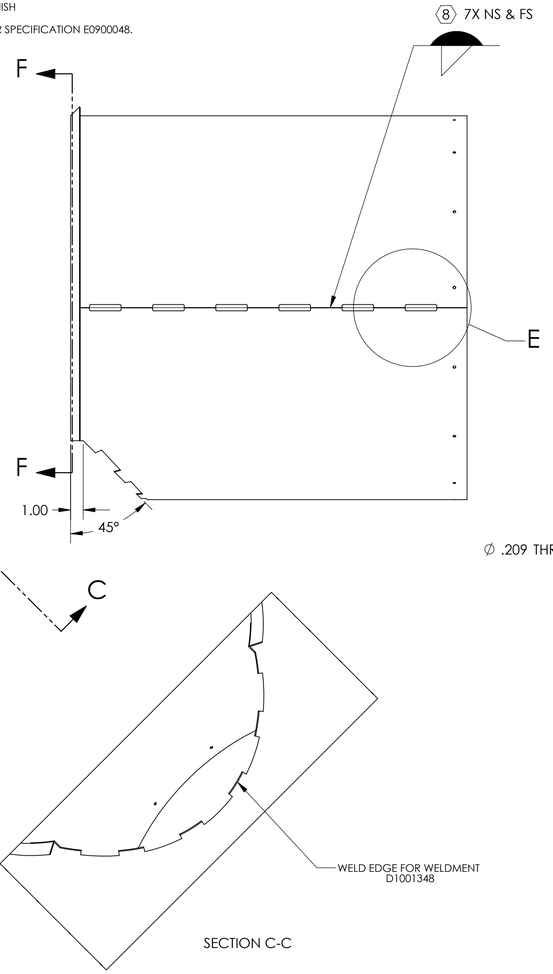
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE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

⑥ FILLET WELD WHERE RING AND CYLINDER MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

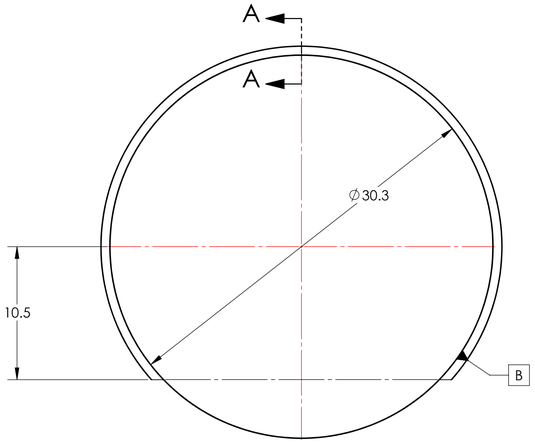
⑦ AS RECEIVED MACHINE FINISH

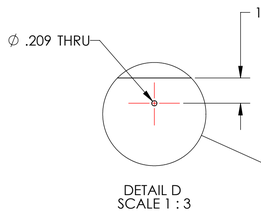
⑧ SEAM WELD CYLINDER PER SPECIFICATION E0900048.

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000367
V2	11 MAY 2011	E1000360-v2	

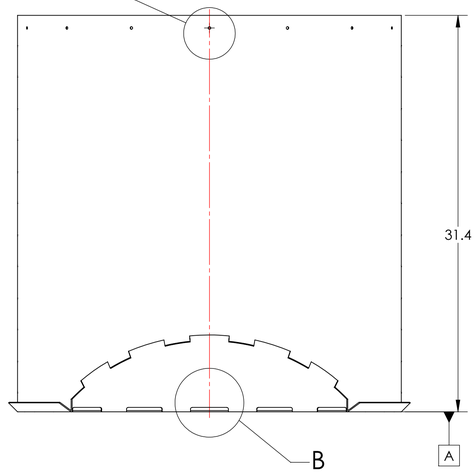


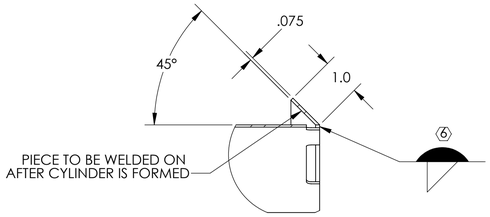
SECTION C-C



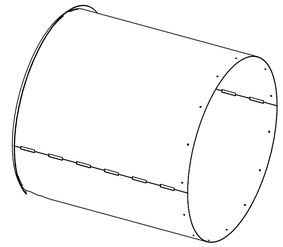


DETAIL D
SCALE 1 : 3
15X

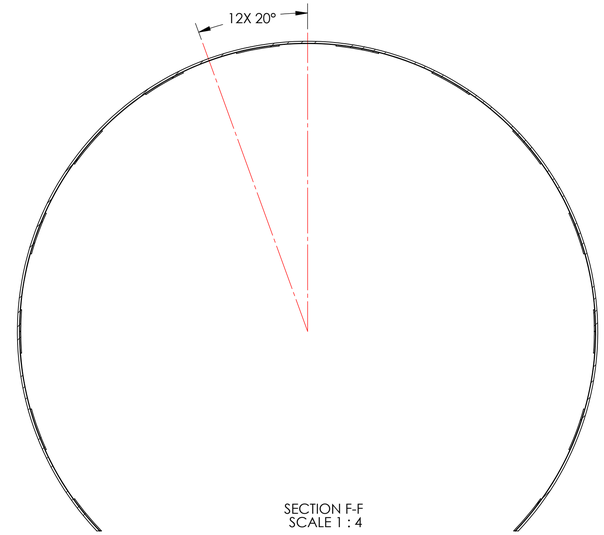




SECTION A-A
SCALE 1 : 2

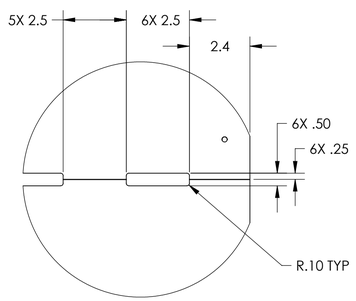


GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

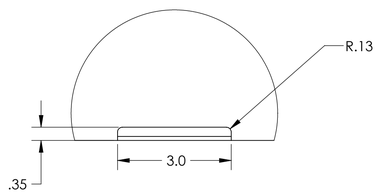


SECTION F-F
SCALE 1 : 4

SECTION C-C



DETAIL E
SCALE 1 : 3
2X



DETAIL B
SCALE 1 : 2
(19X EQUALLY SPACED)

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.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)			
DIMENSIONS ARE IN INCHES TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010 ANGULAR ± 1.0°	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	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	PART NAME: MANIFOLD-CRYO BAFFLE CYLINDER					
		DESIGNER	H. KELMAN	5 APR 2010	SIZE: D	DWG. NO.: D1000570	REV.: v2
		DRAFTER	TQ. NGUYEN	07 SEP 2010			
NEXT ASSY: D1001348		CHECKER	M. SMITH		SCALE: 1:6	PROJECTION:	SHEET 1 OF 1
		APPROVAL	D. COYNE				