

NOTES CONTINUED:
 5 SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (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 DO NOT APPLY MARK ON SUPER #8 SIDE

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

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

8 SEAM WELD CYLINDER PER SPECIFICATION E0900048.

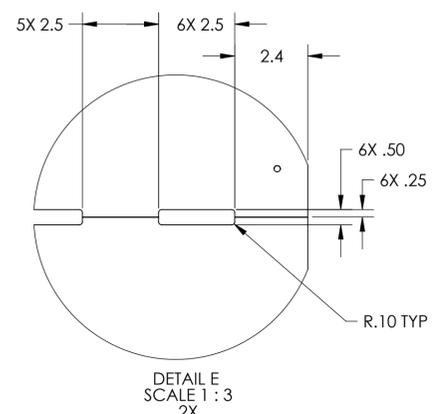
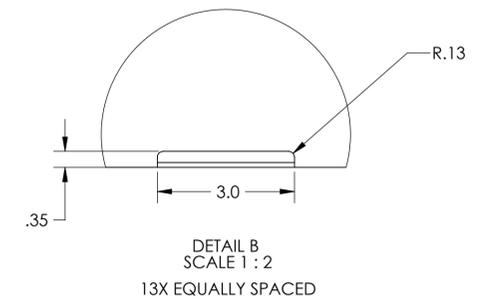
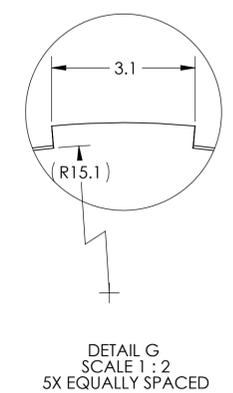
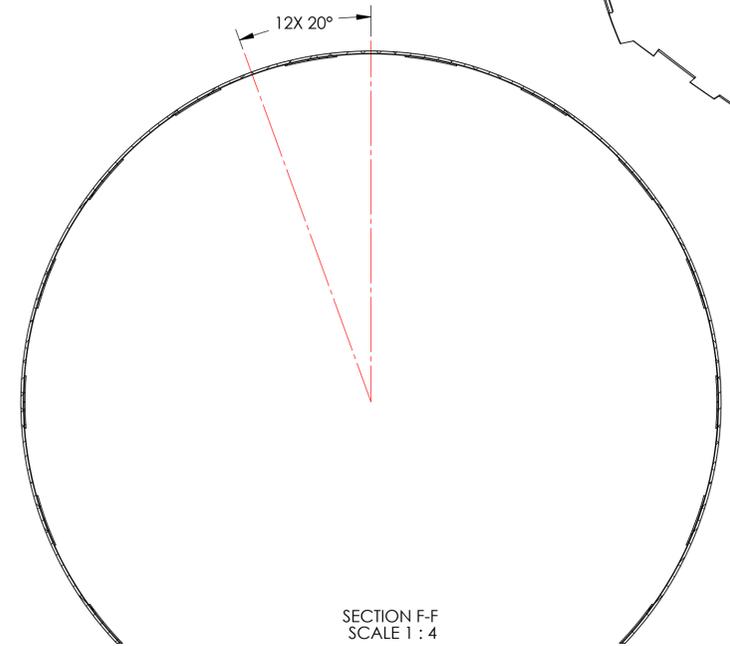
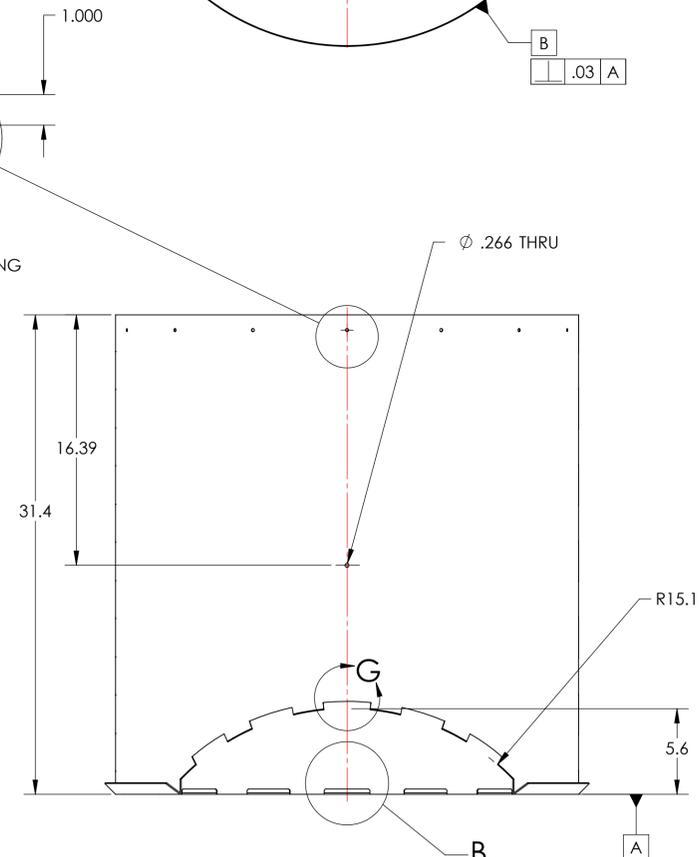
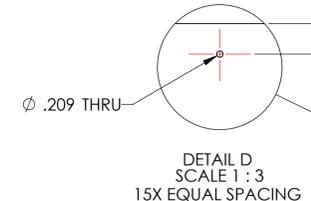
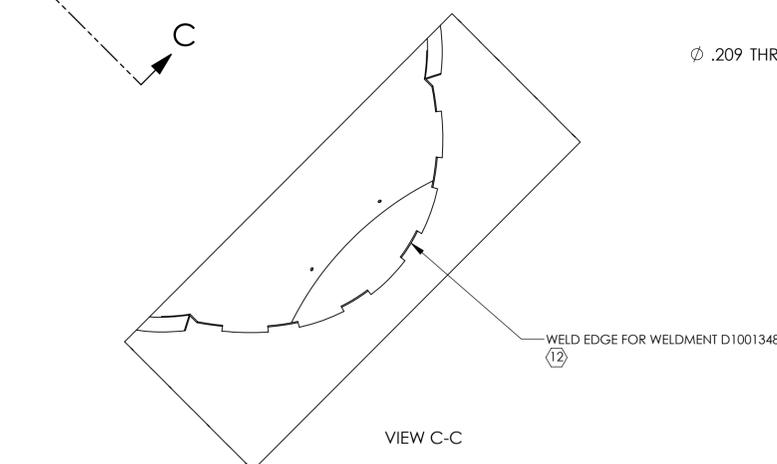
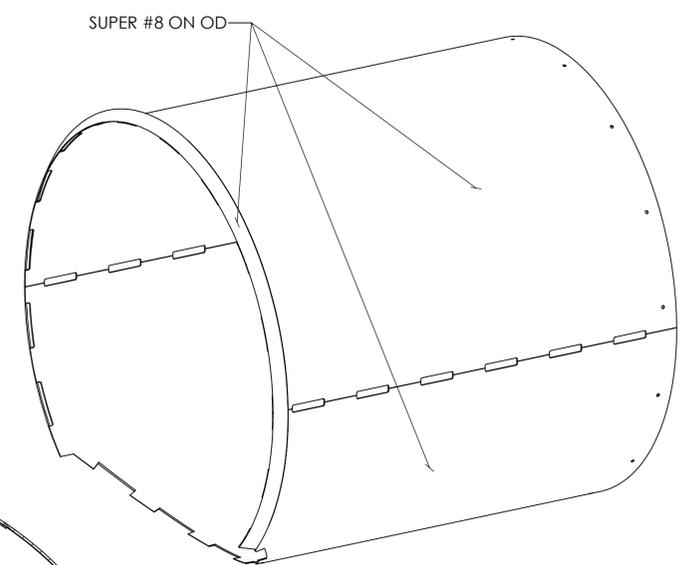
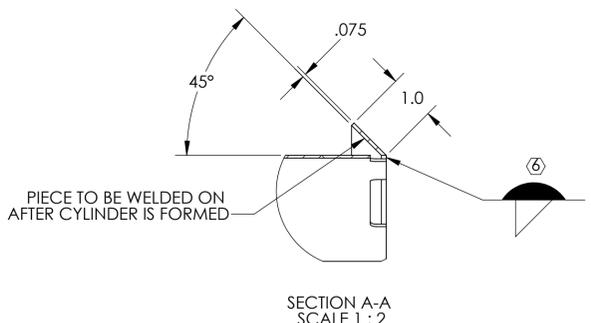
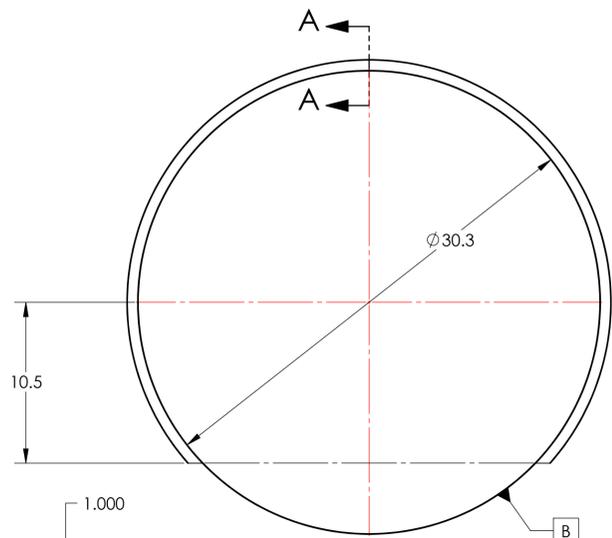
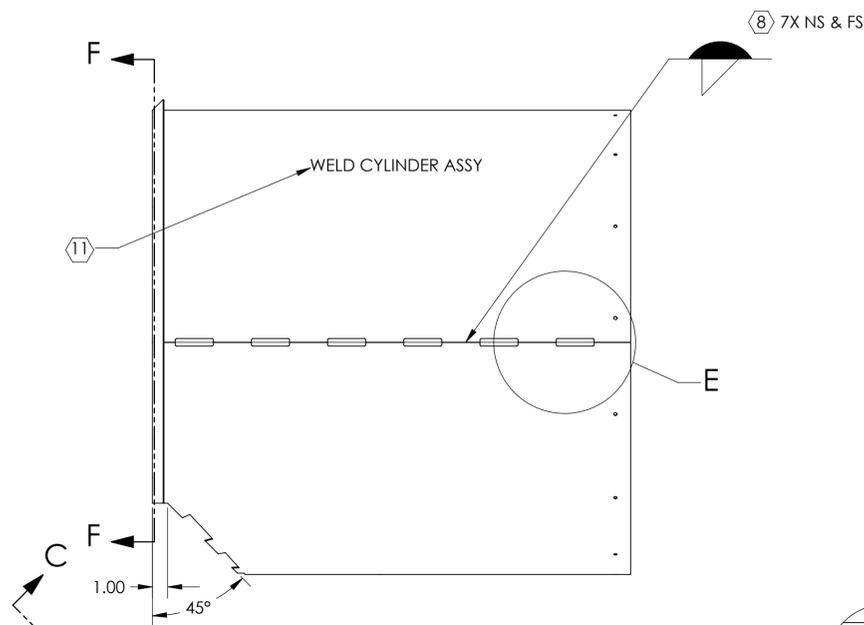
9 ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

10 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.

11 SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) LETTERS AS SHOWN.

12 VENDOR RESPONSIBLE FOR EDGE WELD PREP, IF REQUIRED.

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000367
V2	11 MAY 2011	E1000360-v2	
V3	13 SEP 2011	E1000360-v3	



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		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES:		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.		SYSTEM		MANIFOLD-CRYO BAFFLE CYLINDER	
.X ± .1		MATERIAL		ADVANCED LIGO		DESIGNER	
.XX ± .06		18 GAUGE 304 SSSL		SUB-SYSTEM		H. KELMAN	
.XXX ± .010		FINISH		AOS		5 APR 2010	
ANGULAR ± 1.0°		SUPER #8		NEXT ASSY		SIZE	
				D1001348		DWG. NO.	
						D	
						D1000570	
						REVISION	
						v3	
						SCALE: 1:6	
						PROJECTION:	
						SHEET 1 OF 1	