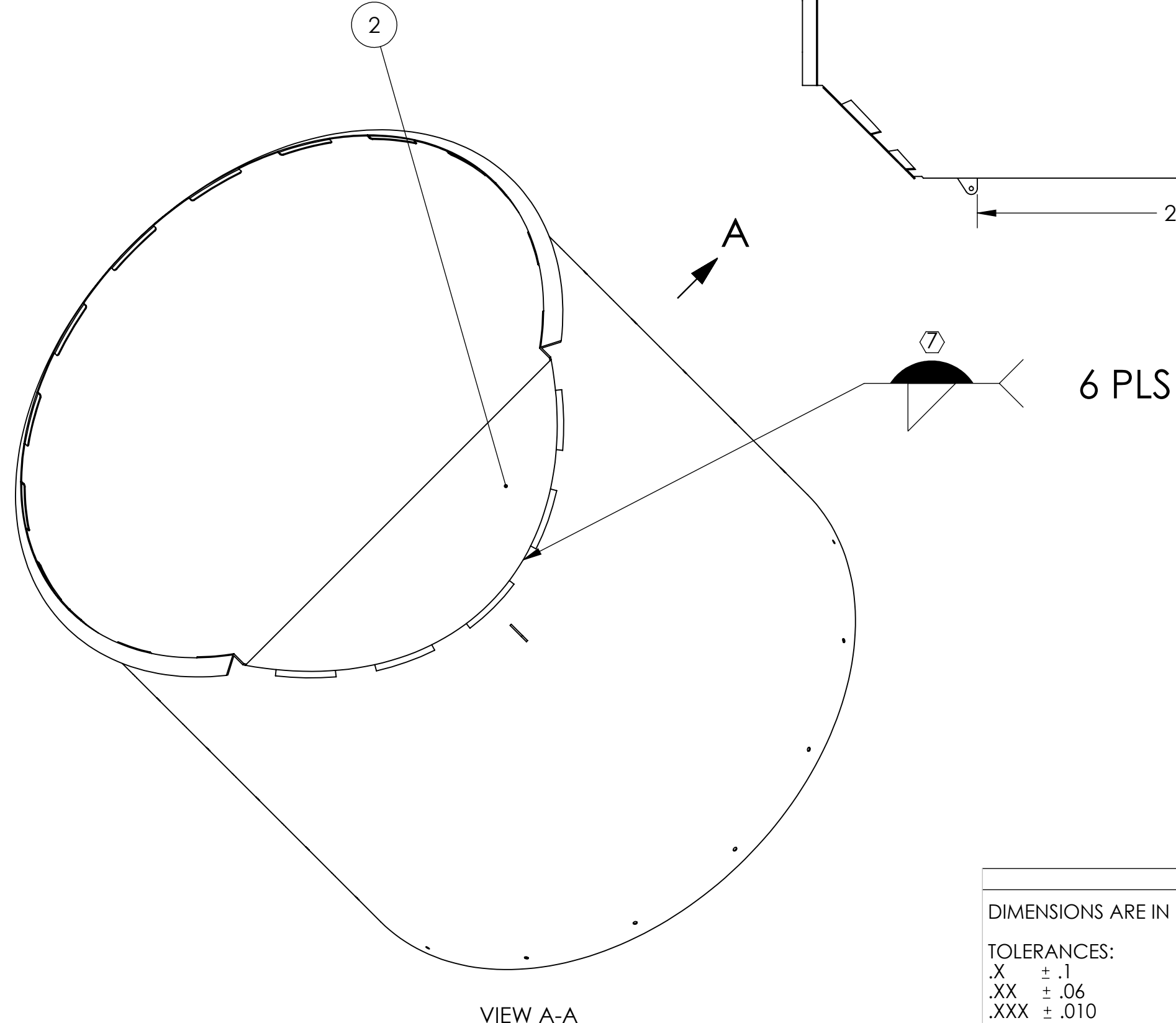
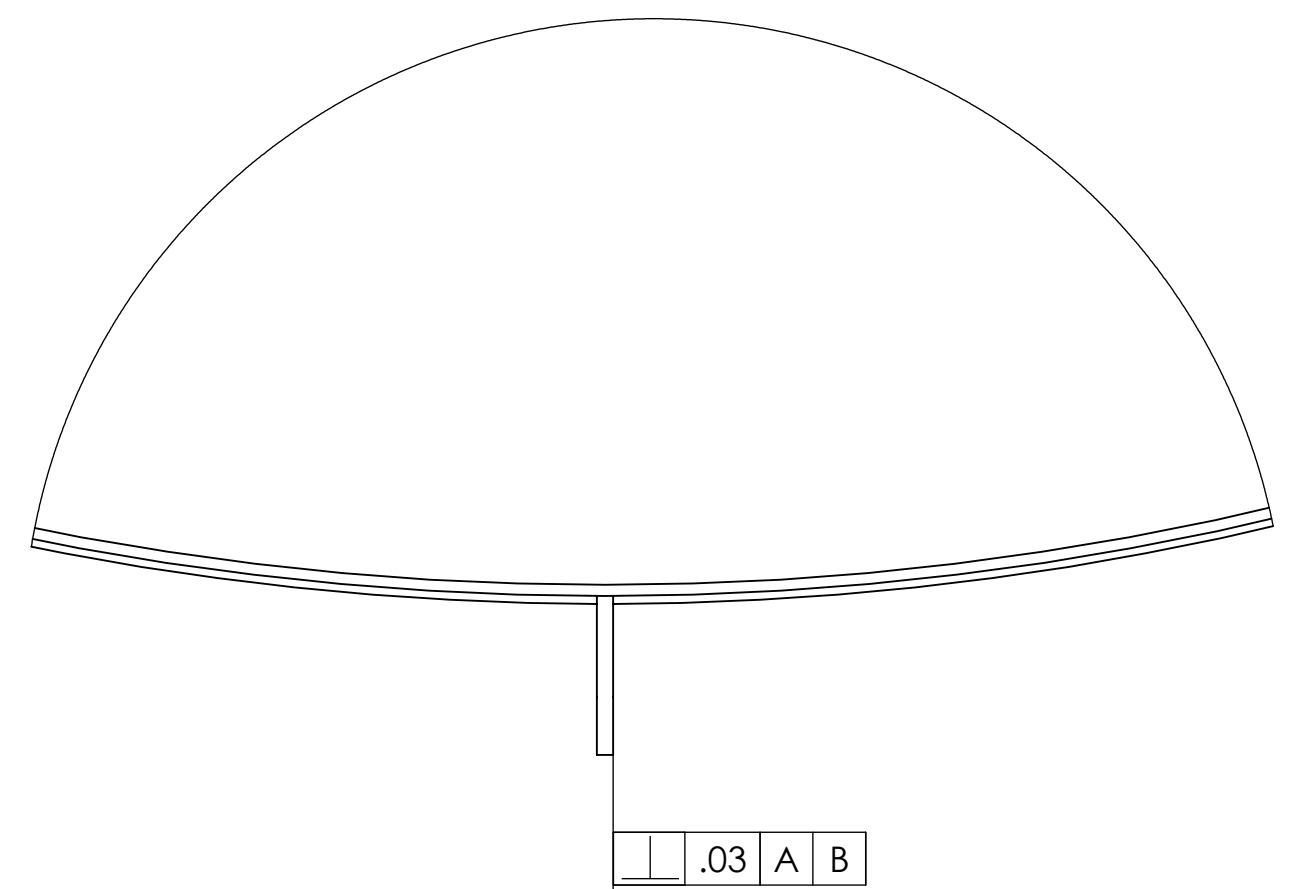
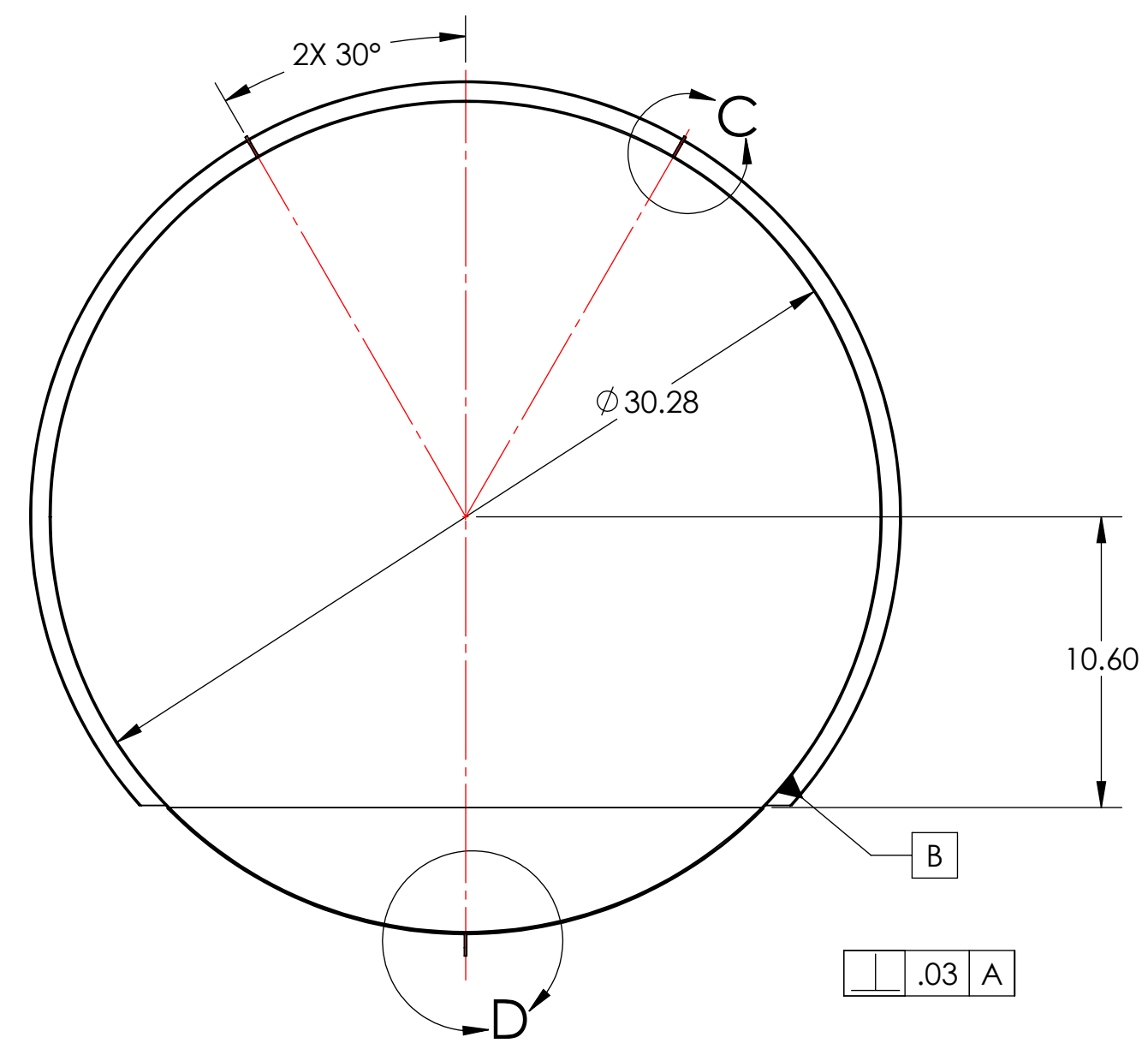
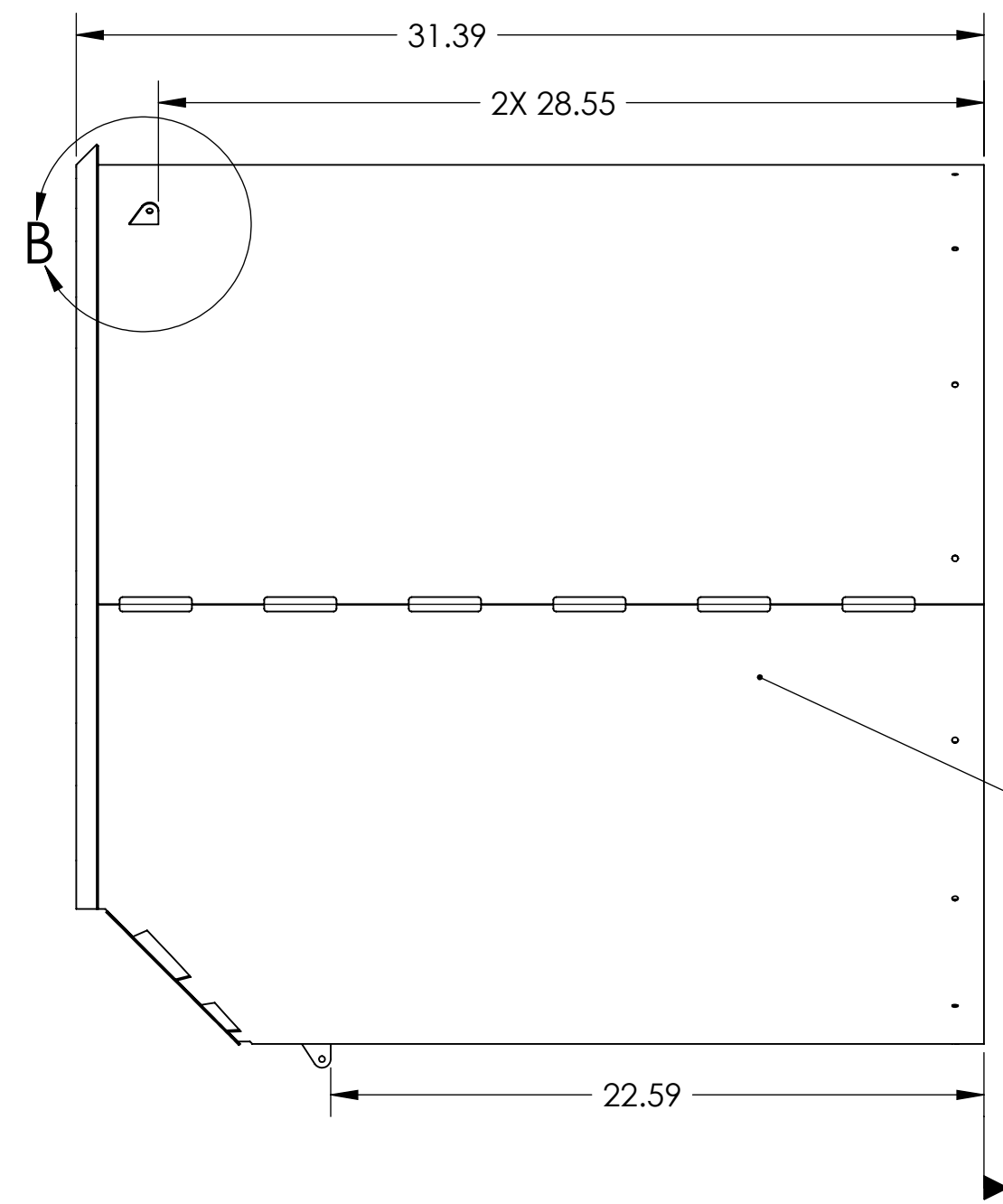
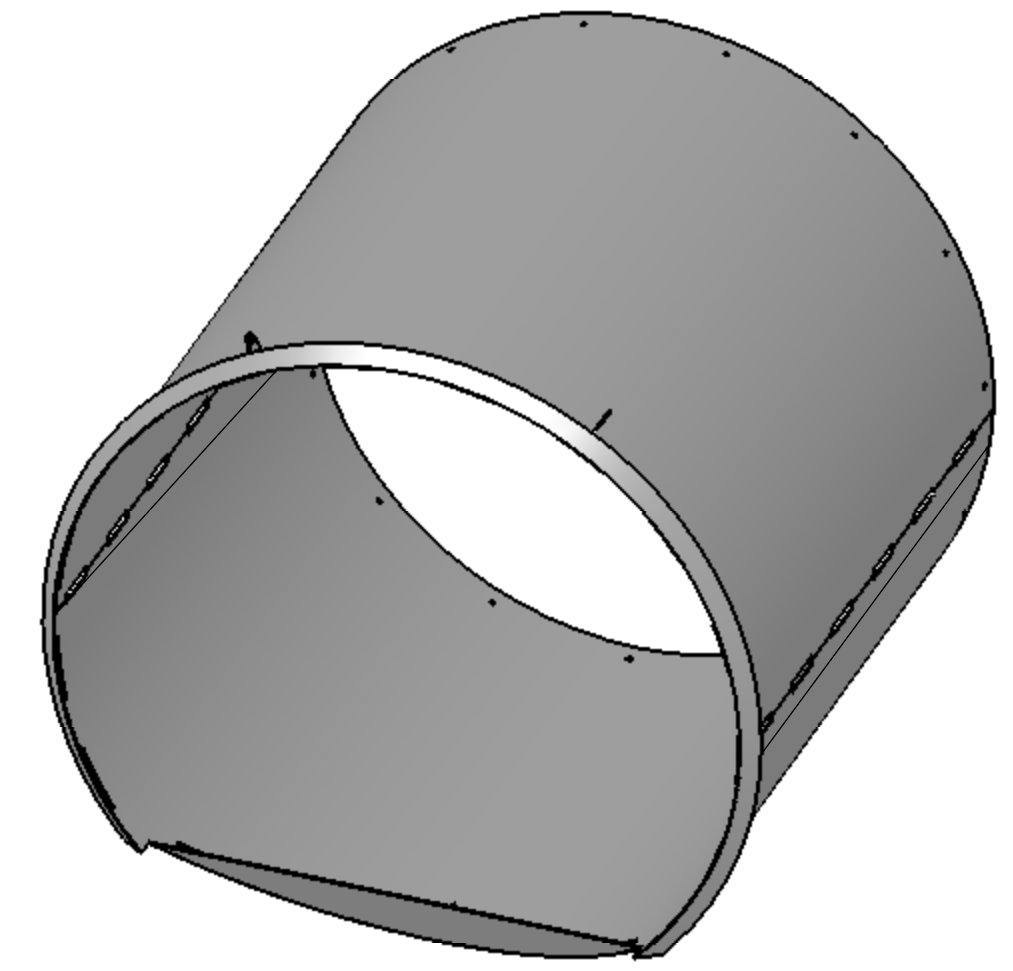
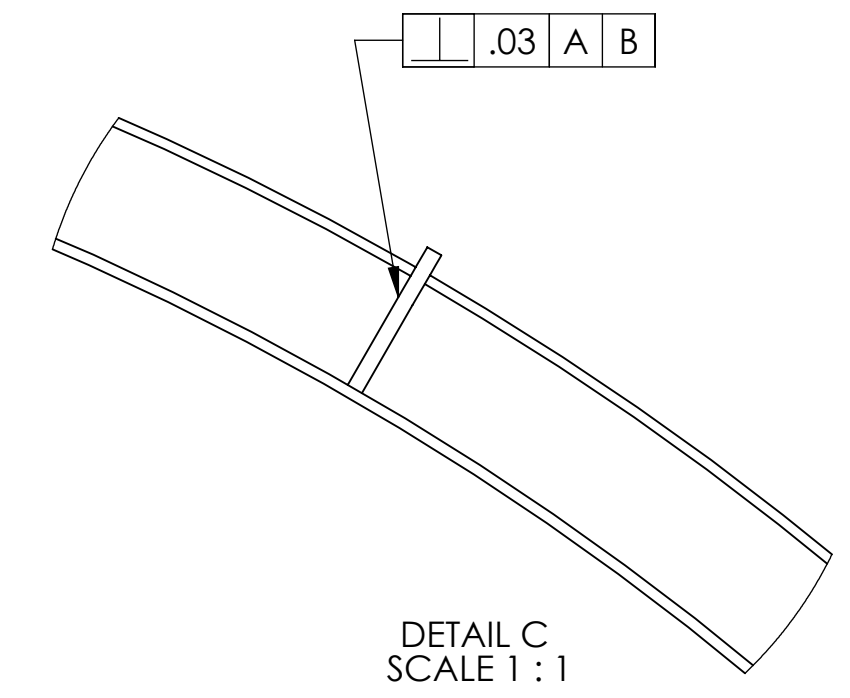
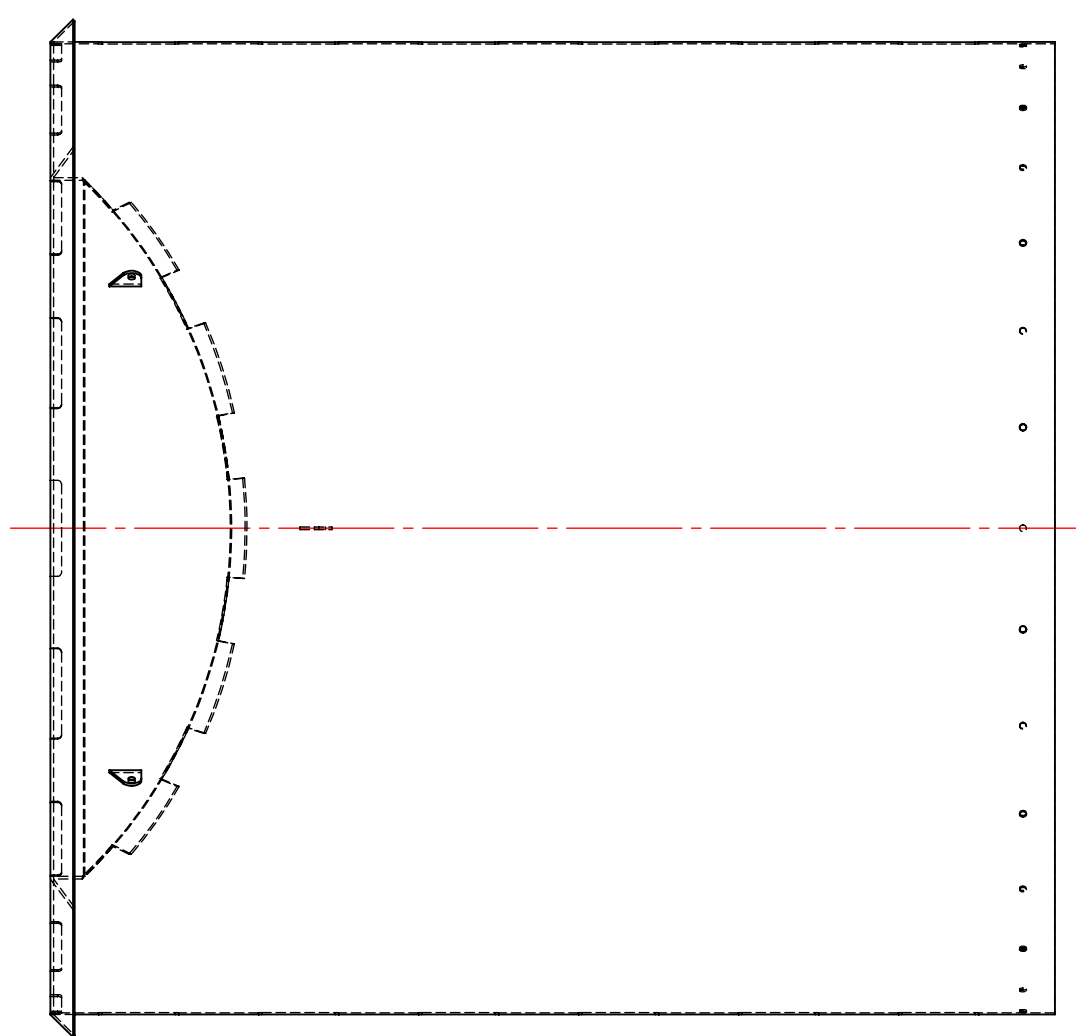
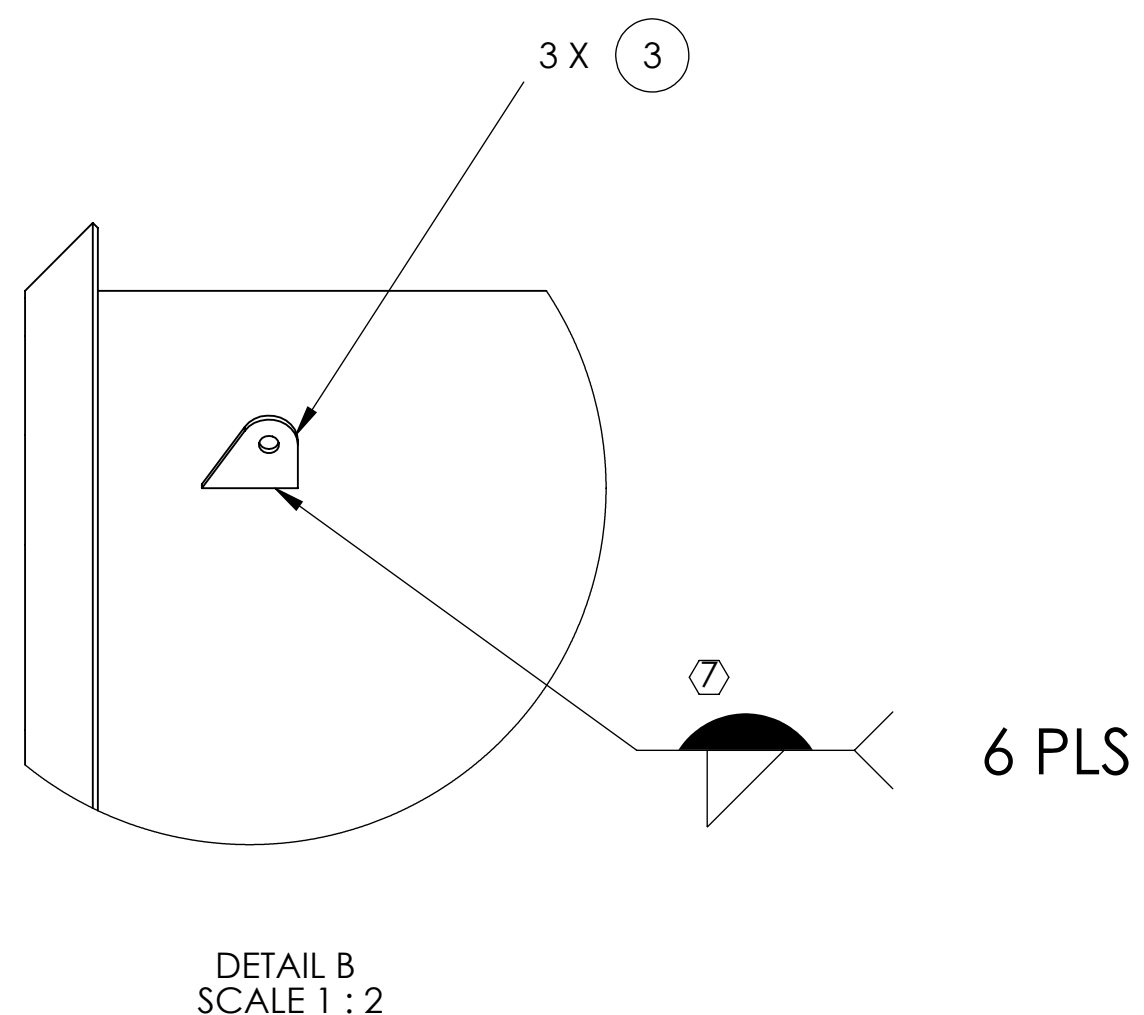


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR 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. ASSEMBLY WILL BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED.
 ⑦ FILLET WELD WHERE ITEMS ① & ③ AND ① & ② MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E1000083

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000367
v2	11 MAY 2011	E1000360-v2	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
3	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	3		3
2	D1001018	ELLIPSE SCRAPER BLADE	14GA A424 TYPE I STEEL	1		1
1	D1000570	MANIFOLD-CRYO BAFFLE CYLINDER	18GA A424 TYPE I STEEL	1		1

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .X ± .1
 .XX ± .06
 .XXX ± .010

ANGULAR ± 1.0°

MATERIAL: N/A
 FINISH: N/A

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS
 NEXT ASSY: D1002061

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY

DESIGNER: H. KELMAN 25 MAY 2010
 DRAFTER: TQ. NGUYEN 07 SEP 2010
 CHECKER: M. SMITH 27 SEP 2010
 APPROVAL: D. COYNE

SIZE: D
 DWG. NO.: D1001348
 REV.: v2

SCALE: 1:6
 PROJECTION: [Symbol]
 SHEET 1 OF 1

D:\001348_d\UGO_Monifield_Cryo_Baffle_Cyl_Scraper Assy_PART.PDM REV: X-033 DRAWING PDM REV: X-013