REV.	DATE	DCN #	DRAWING TREE #
v1	2 OCT 2010	E1000360	E1000085-v1
-	-	-	E1000090-v1
-	-	-	E1000091-v1

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

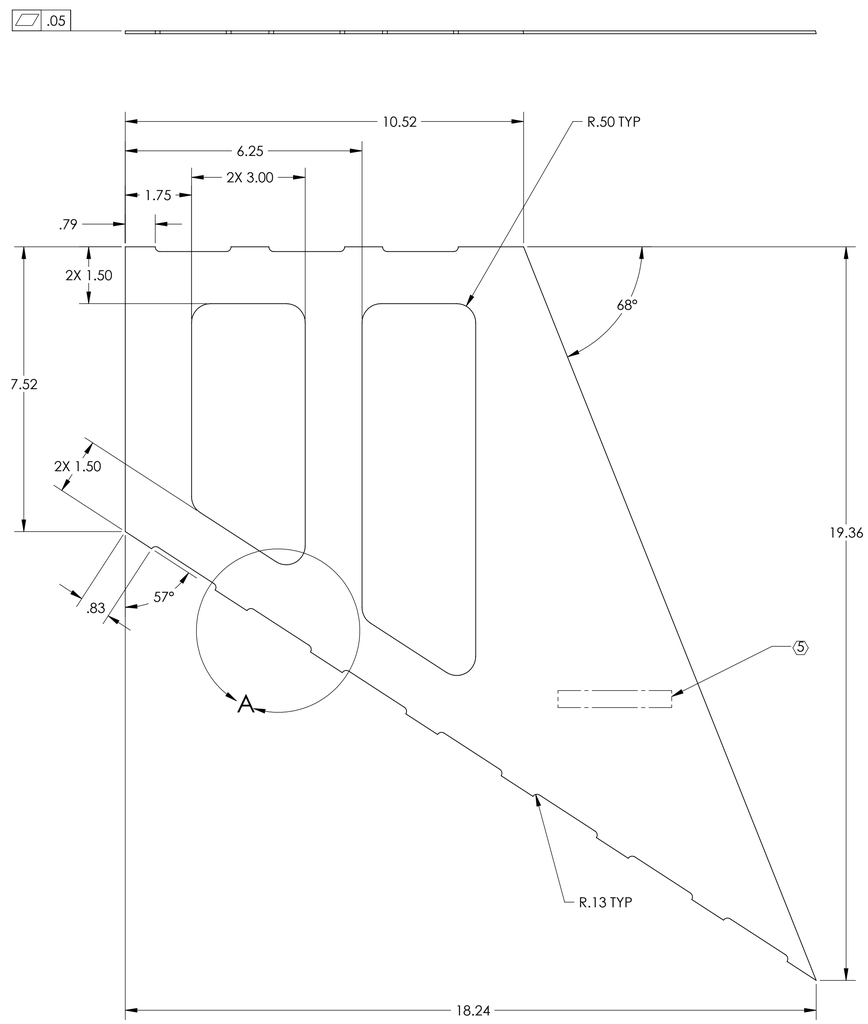
6. APPROXIMATE WEIGHT = X.XXX LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

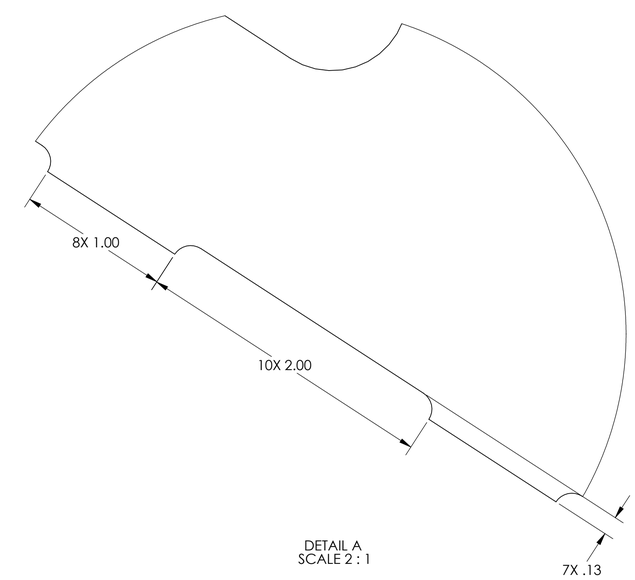
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOUL DBE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

(11) CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).

(12) AS RECEIVED MACHINE FINISH.





DETAIL A
SCALE 2 : 1

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 NEXT ASSMEBLE FOR REQUIRED DIMENDIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.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: 14GA A424 TYPE I STEEL

FINISH: (12)

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: AOS

NEXT ASSY: D0902654,D0902655,D0902656

PART NAME: Manifold Cryo Baffle Weldment Brace

DESIGNER	H. KELMAN	27 OCT 2010
DRAFTER	TQ. NGUYEN	2 OCT 2010
CHECKER	M. SMITH	
APPROVAL	D. COYNE	

SIZE: D

DWG. NO.: D1002849

REV.: v1

SCALE: 1:2

PROJECTION:

SHEET 1 OF 1

D1002849 aLIGO_Manifold_Cryo_Baffle_Weldment_Brace, PART PDM REV:X-005, DRAWING PDM REV:X-001