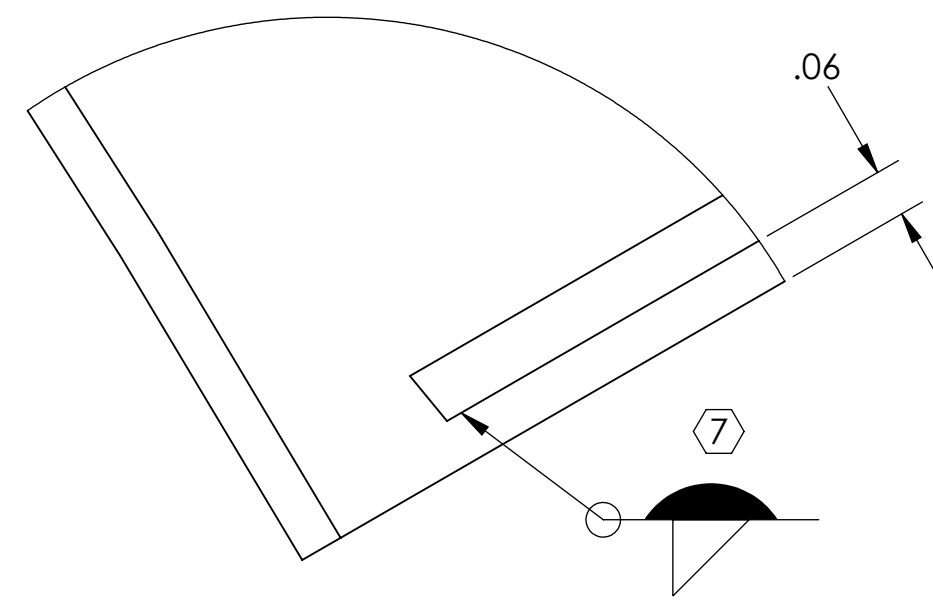
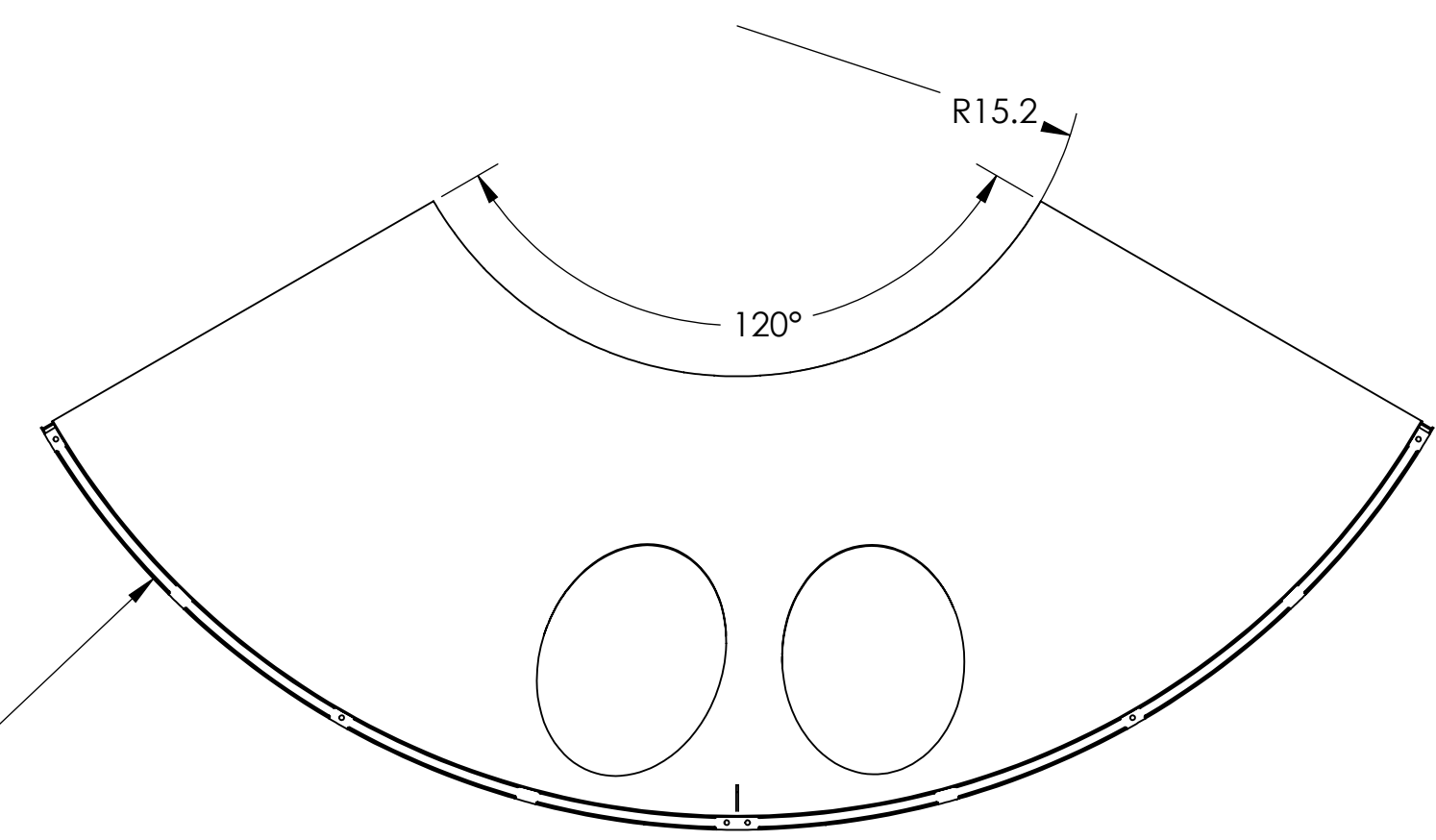
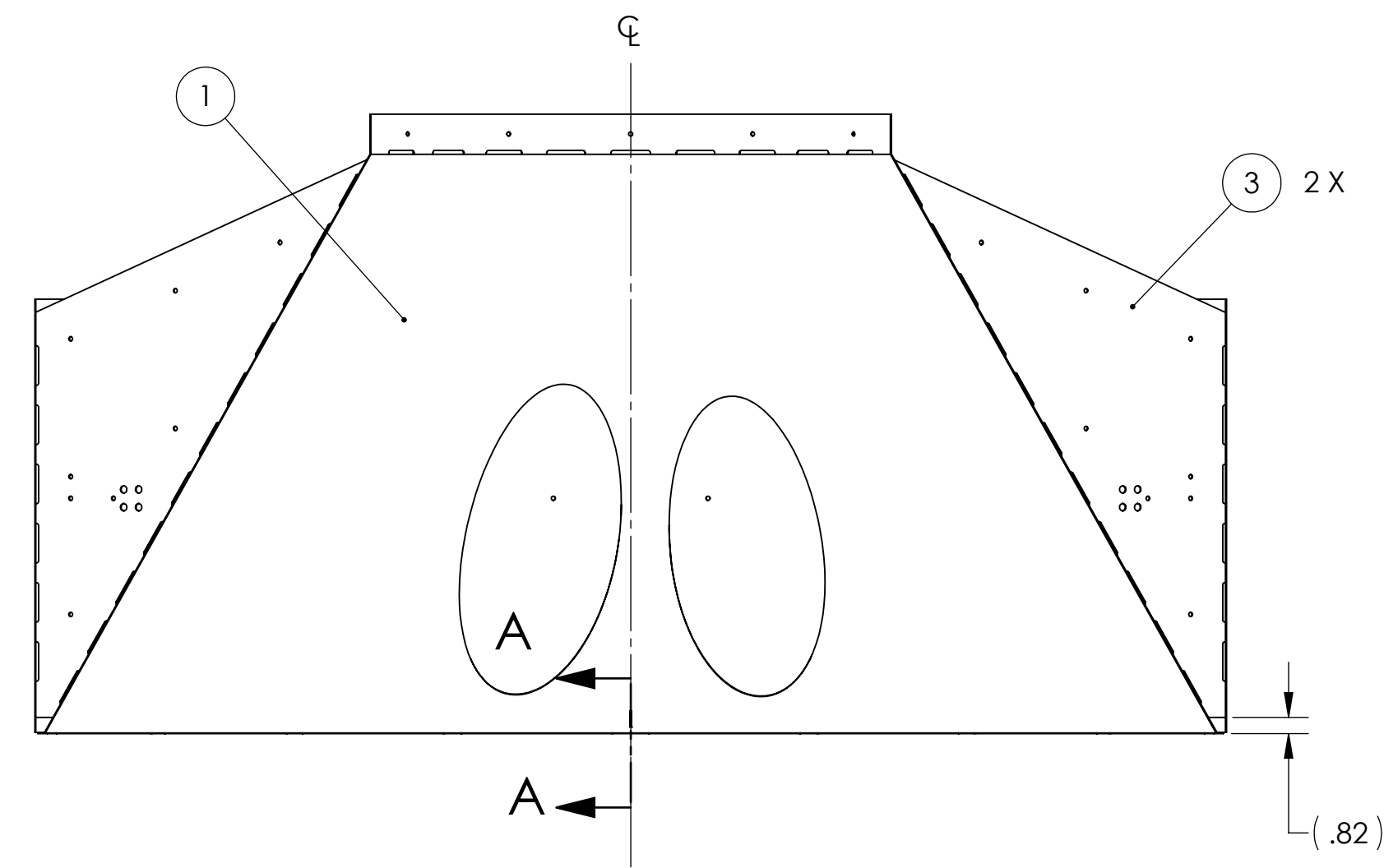
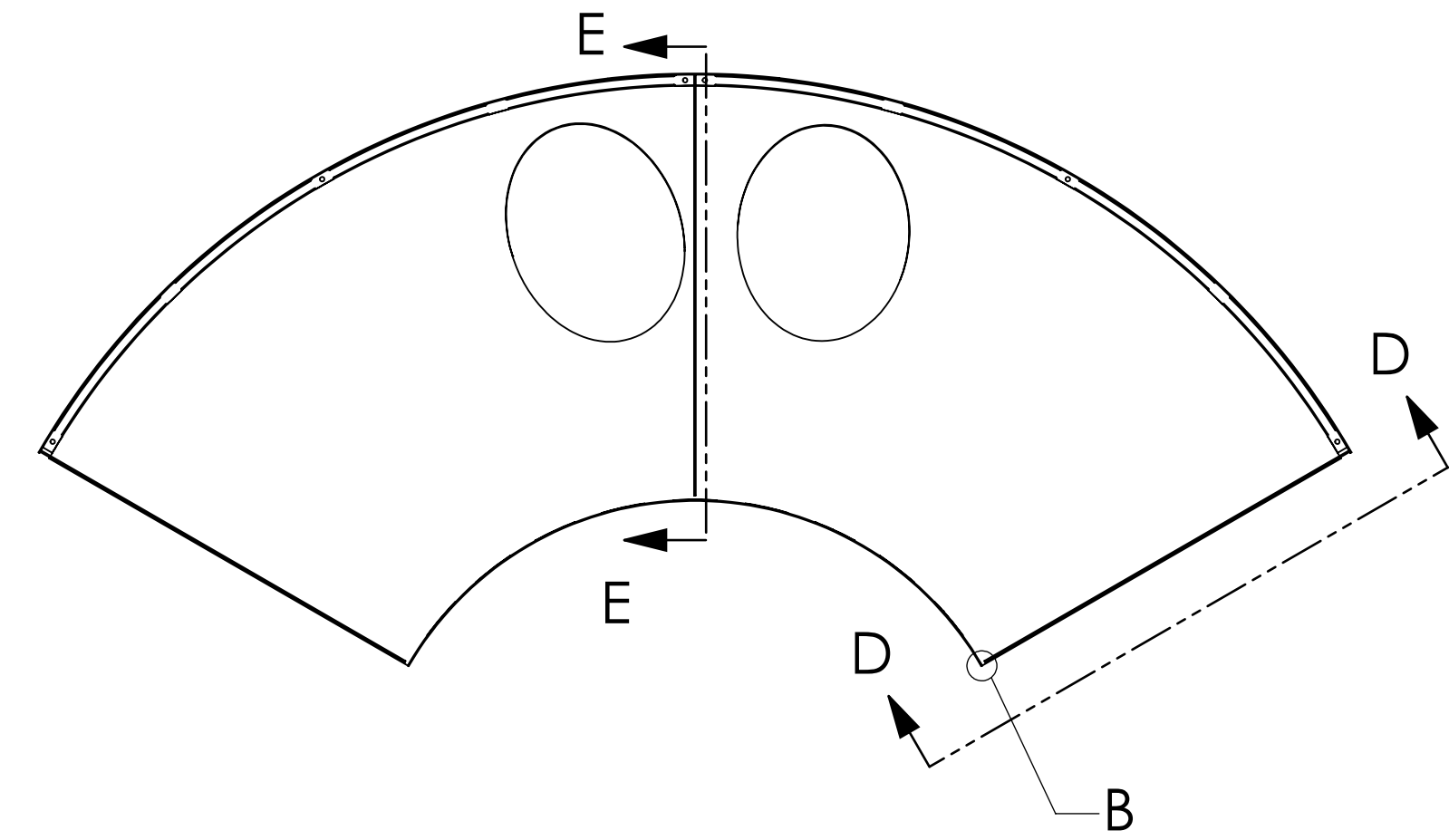


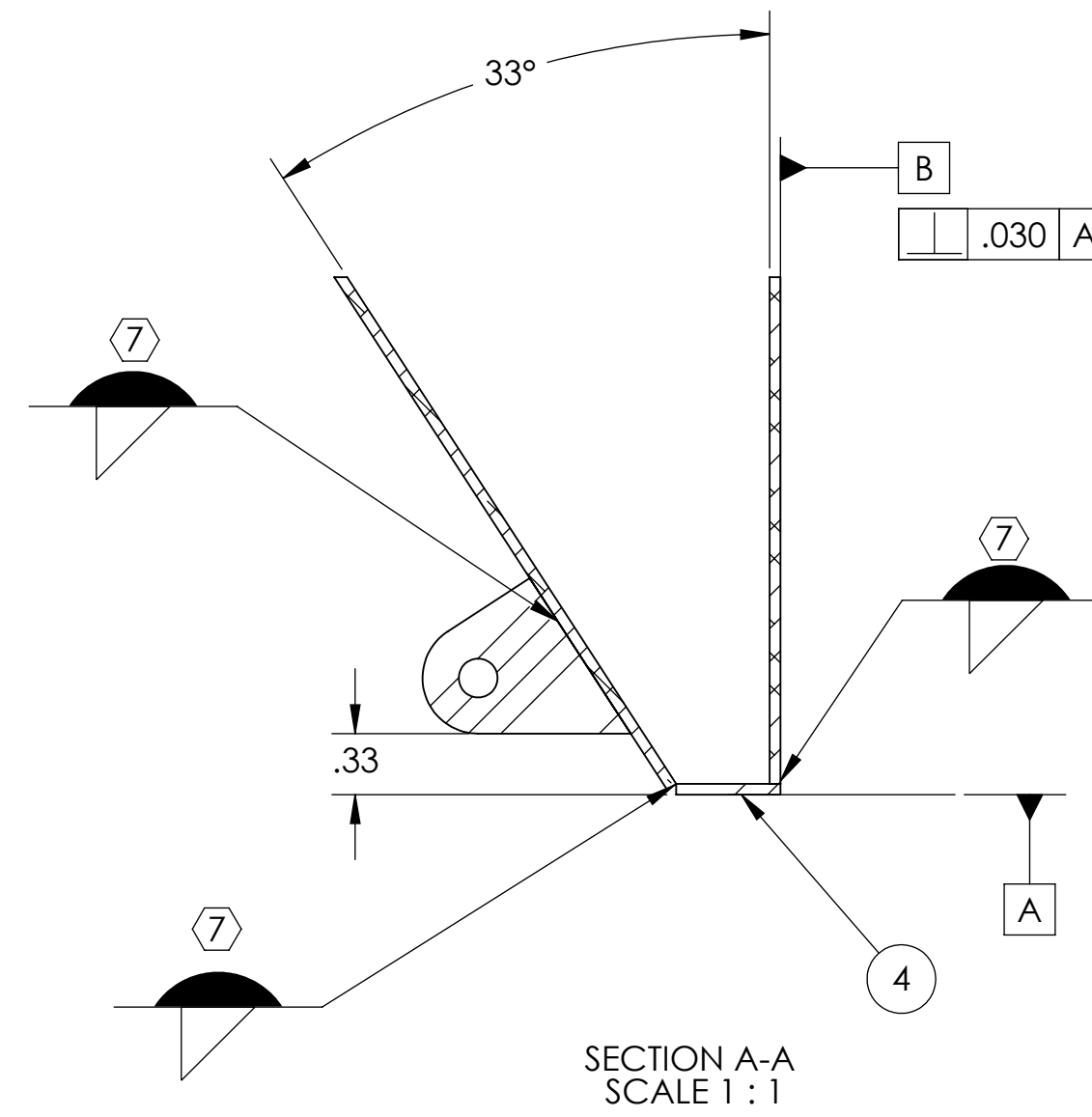
NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001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

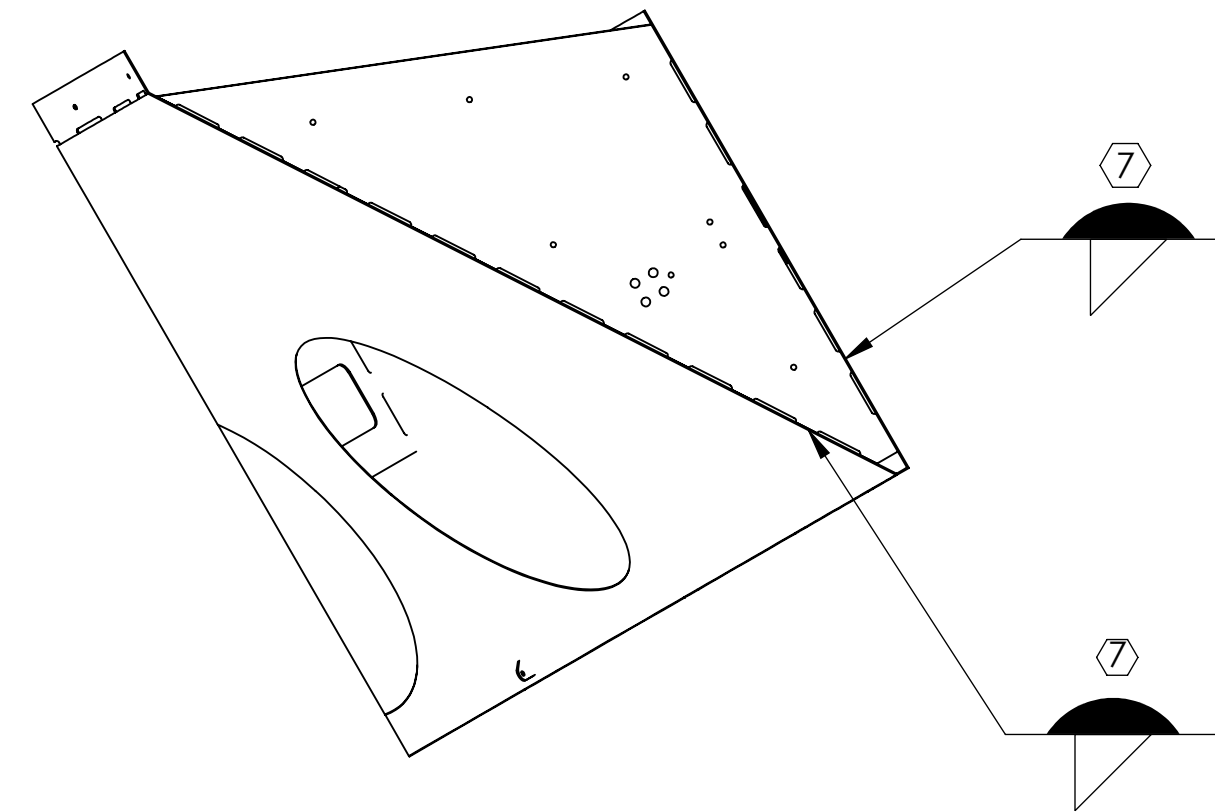
7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, 2 & 3, 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



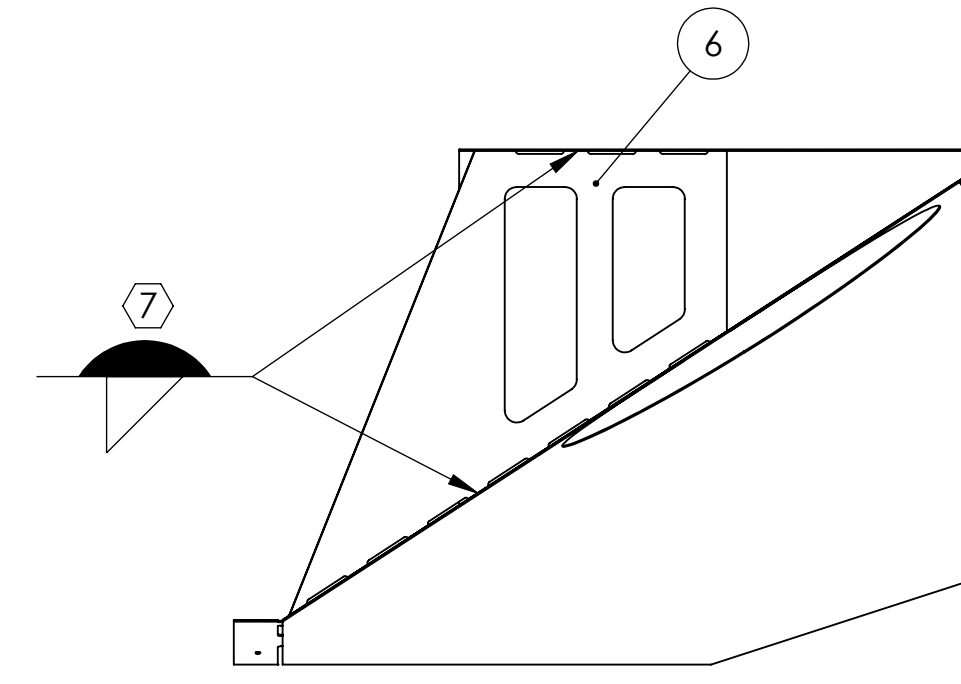
DETAIL B  
SCALE 4 : 1



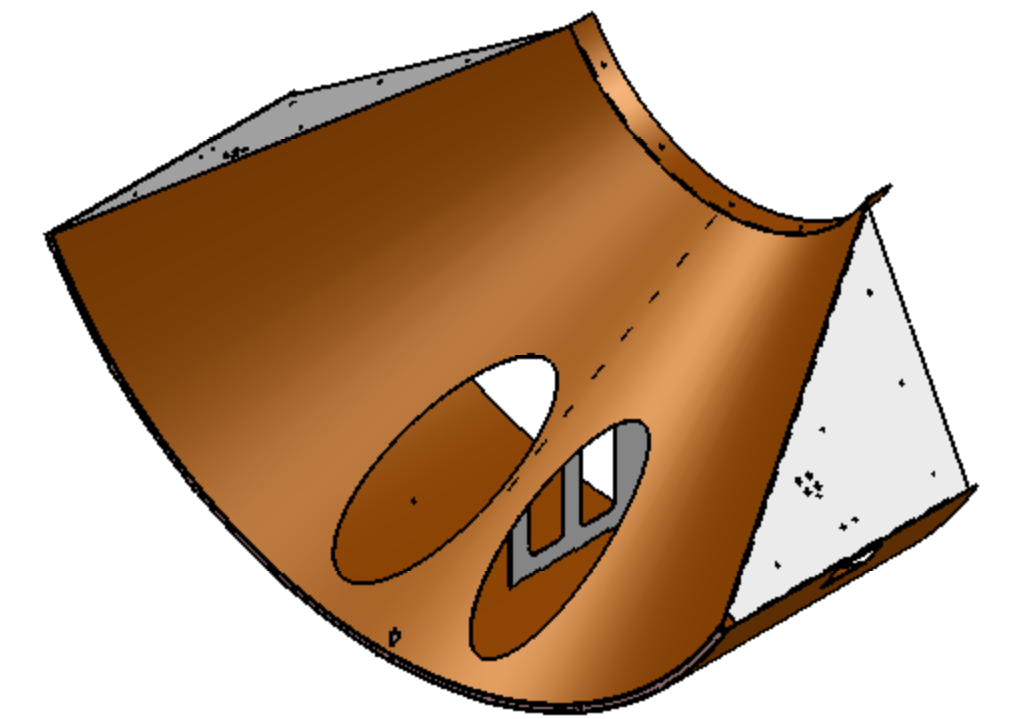
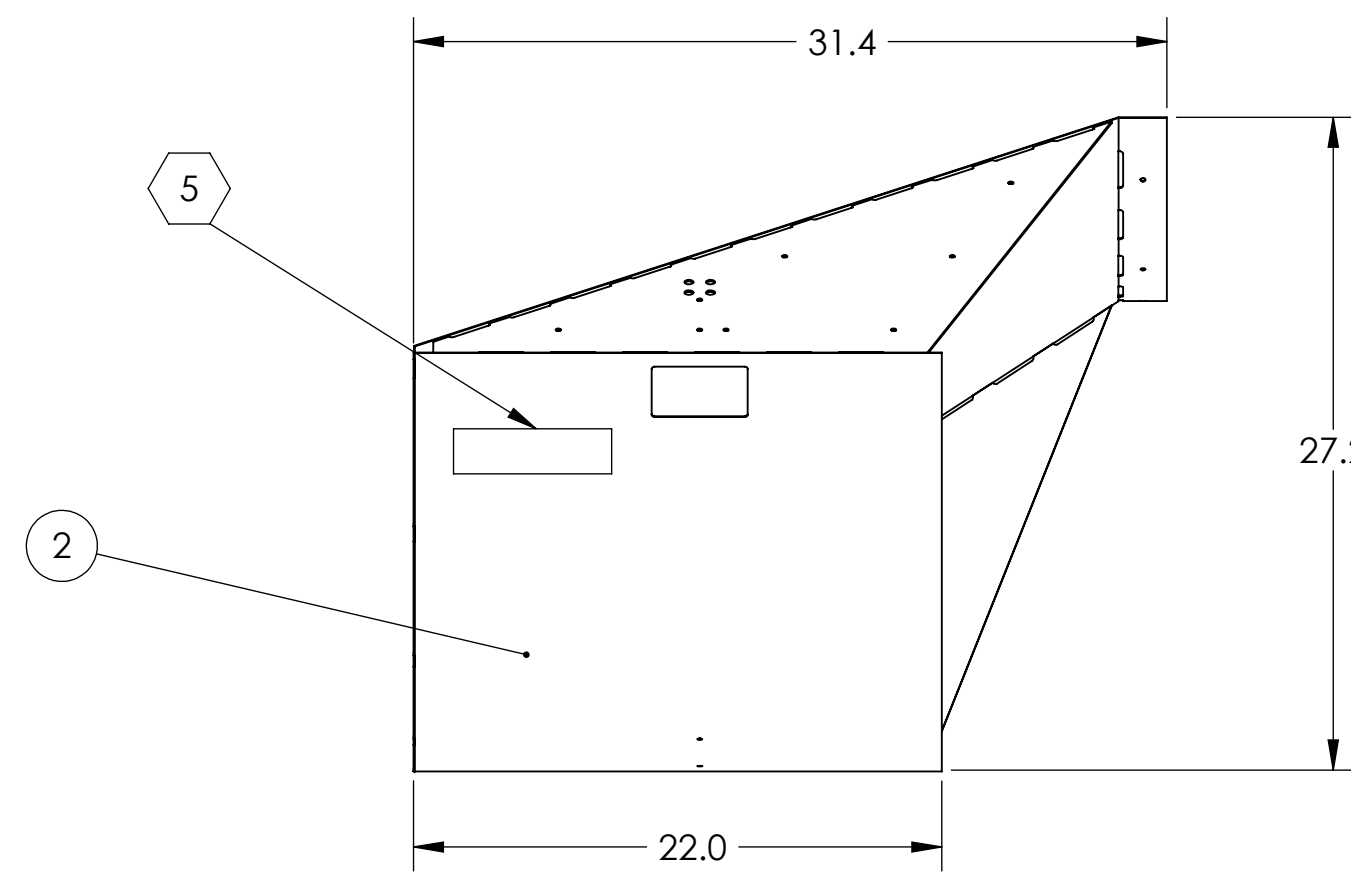
SECTION A-A  
SCALE 1 : 1



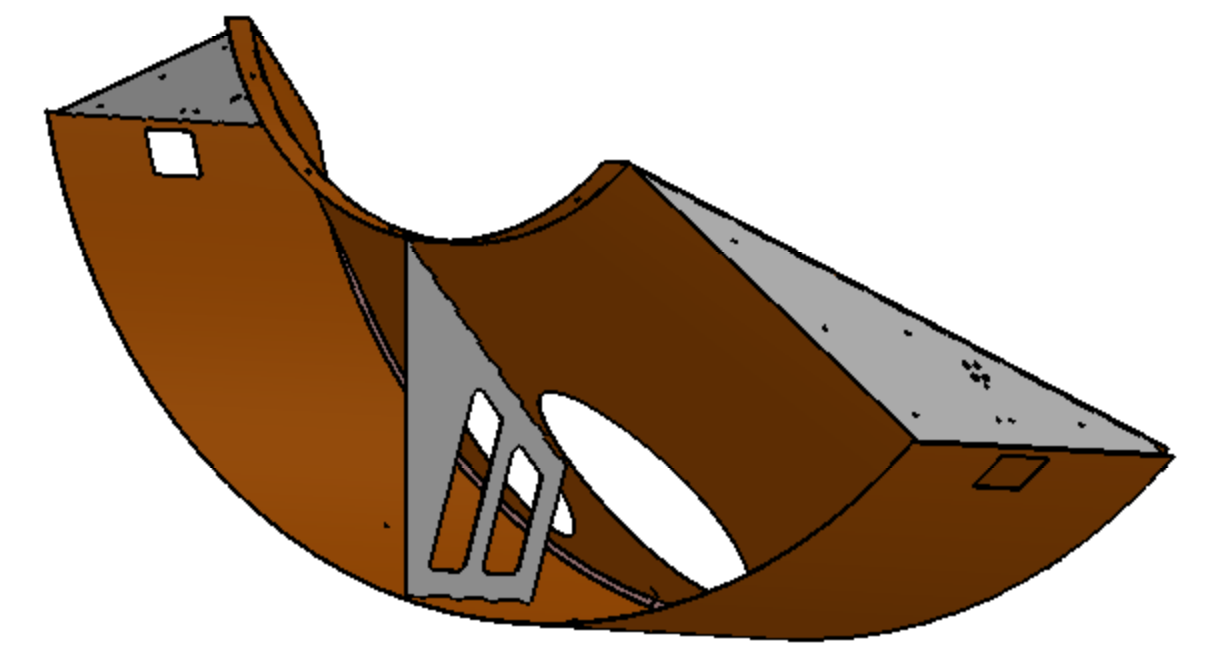
SECTION D-D



SECTION E-E



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18GA A424 TYPE I STEEL	1		1
1	D1003185	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMX H1 BOTTOM	18GA A424 TYPE I STEEL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	FINISH
A424 TYPE I STEEL	N/A

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

NEXT ASSY: **D1003183**

PART NAME: **MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMX H1, BOTTOM**

DESIGNER: H. KELMAN 17 MAR 2010  
 DRAFTER: TQ. NGUYEN 3 SEP 2010  
 CHECKER: M. SMITH  
 APPROVAL: D. COYNE

SIZE: **D** DWG. NO.: **D1003184** REV.: **v1**

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

D1003184.dwg: Manifold\_Cryo\_Baffle\_Segment\_Subassembly\_Weldment - PART PDM REV: X-016, DRAWING PDM REV: X-002