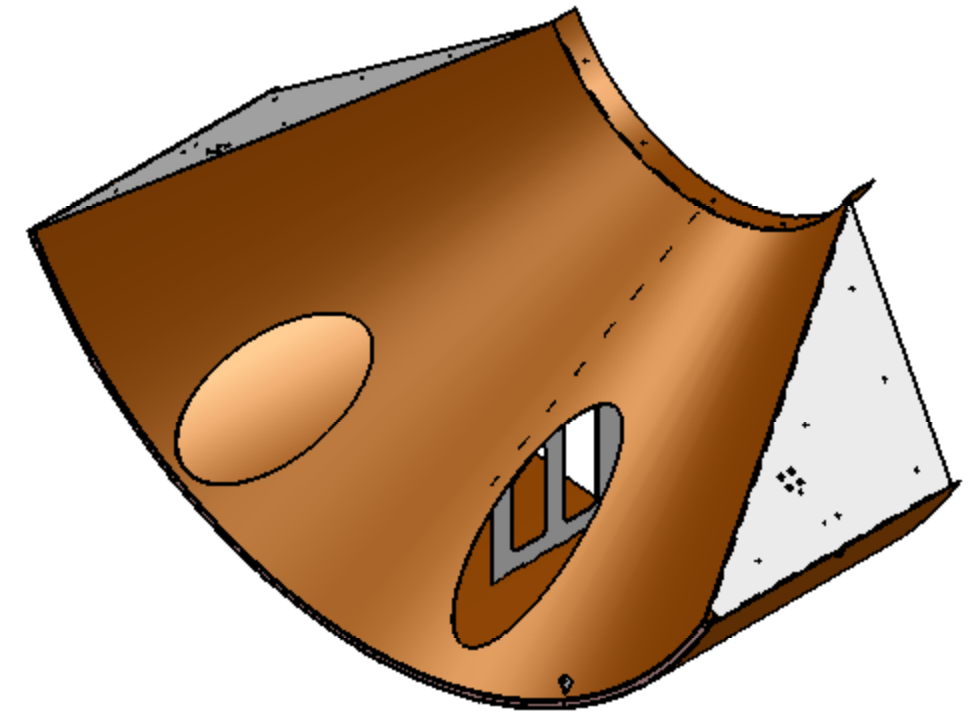
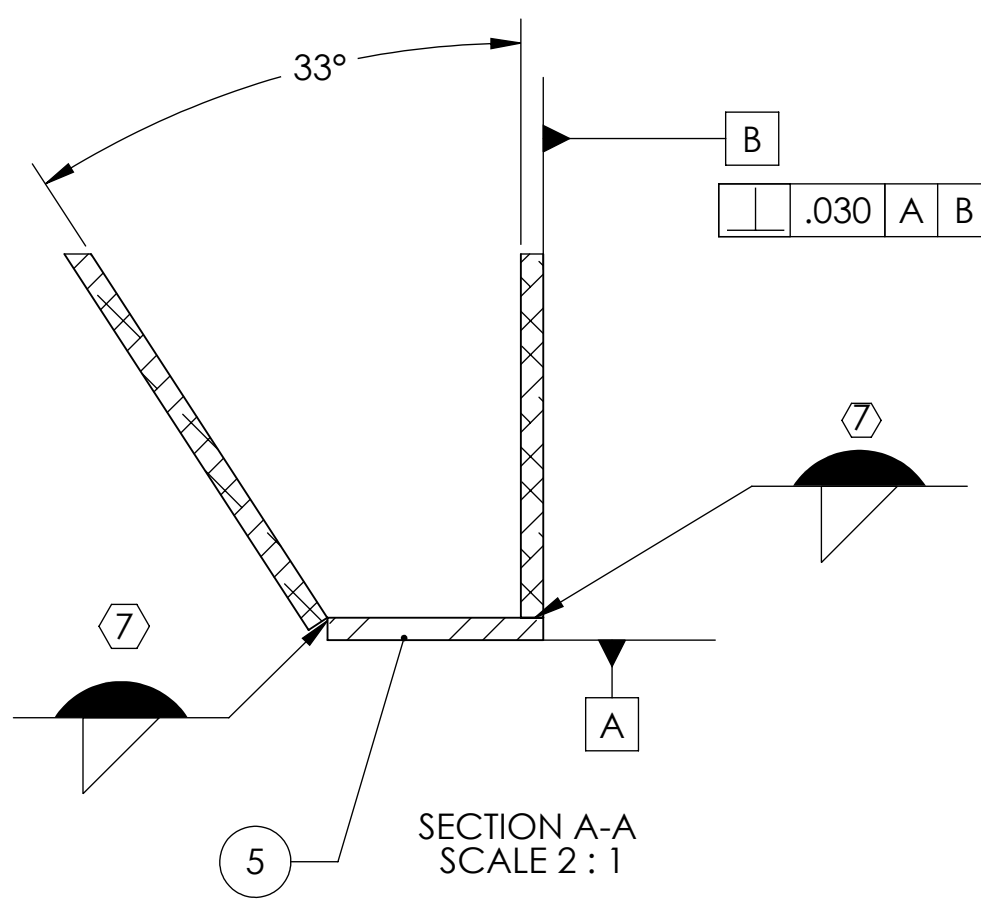
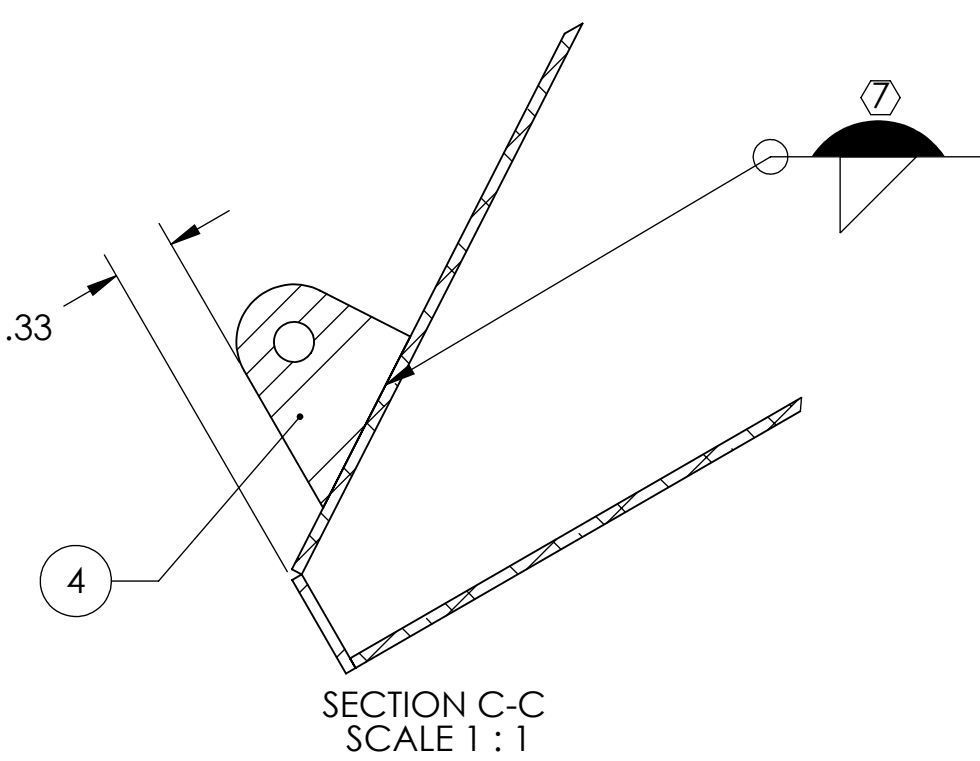
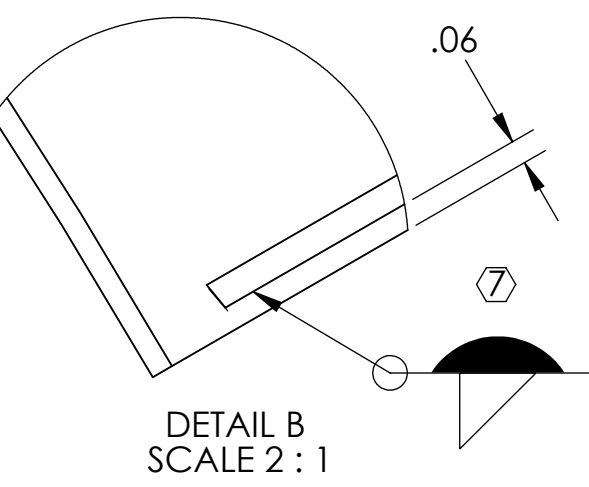
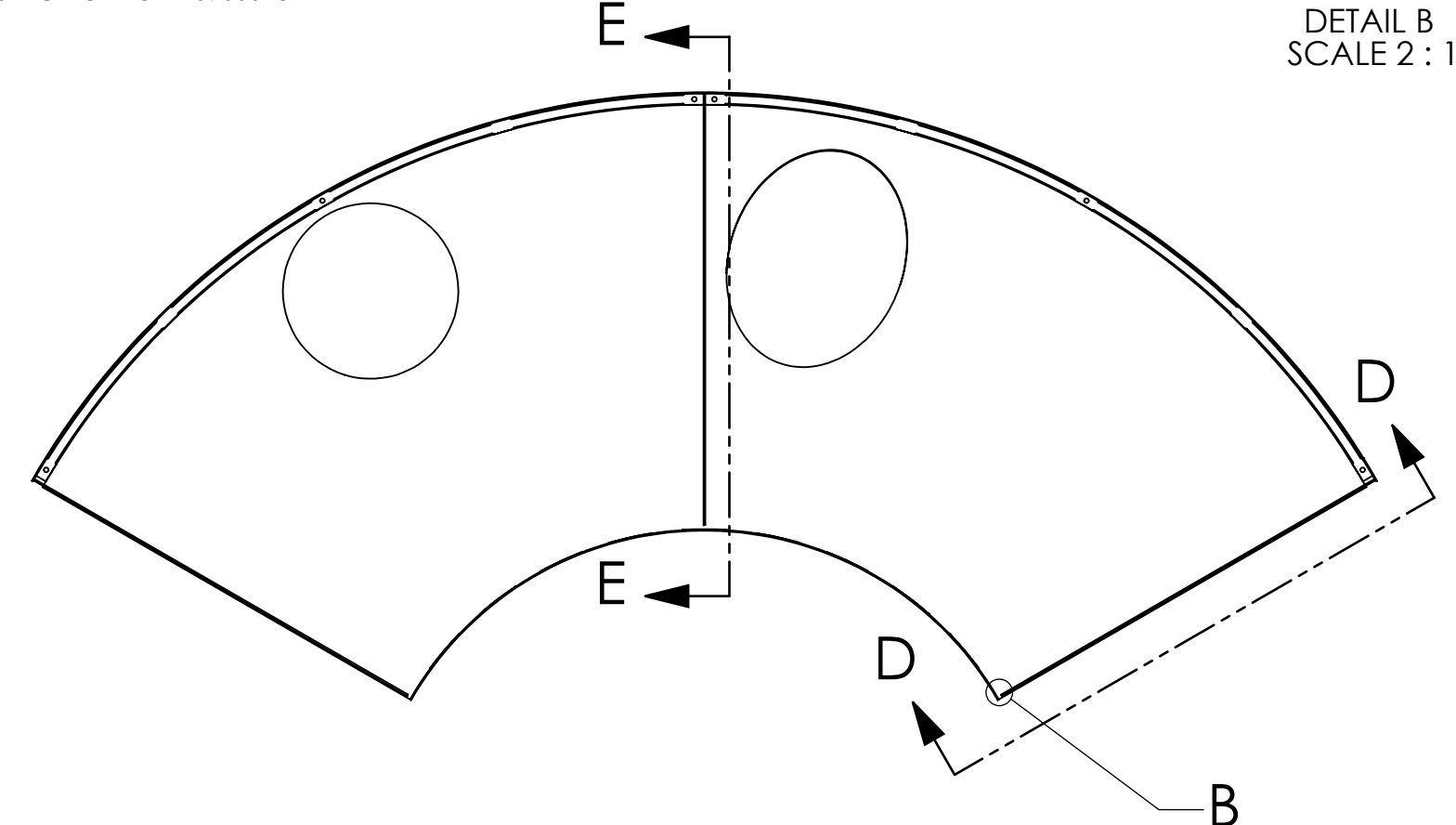


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001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

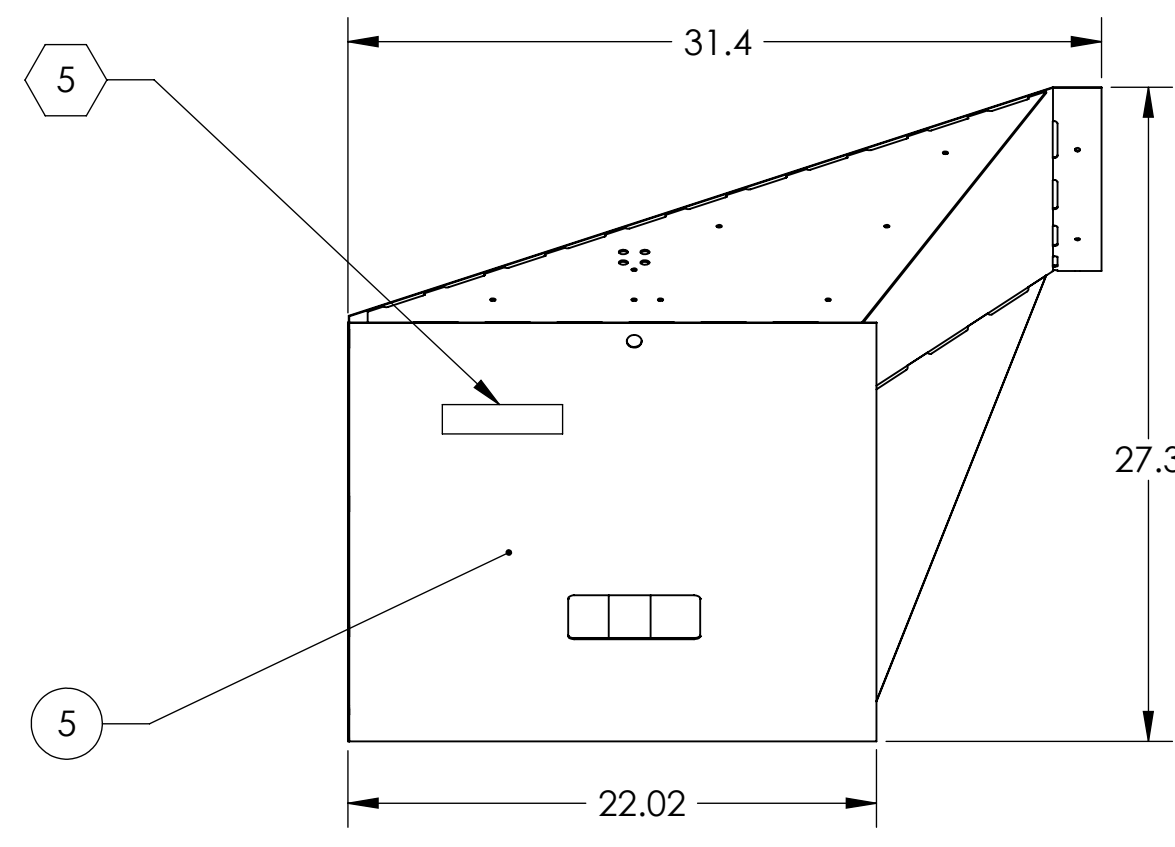
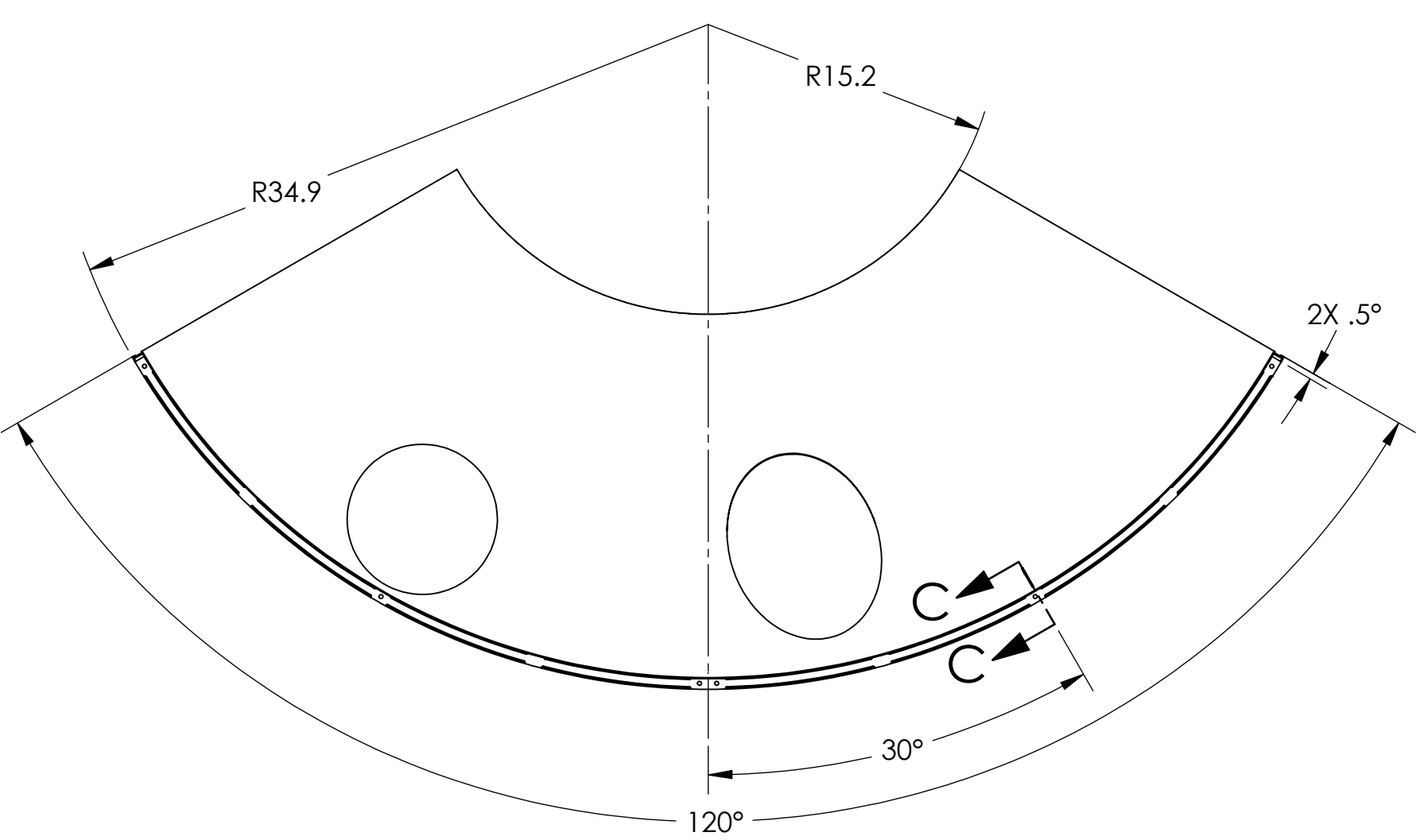
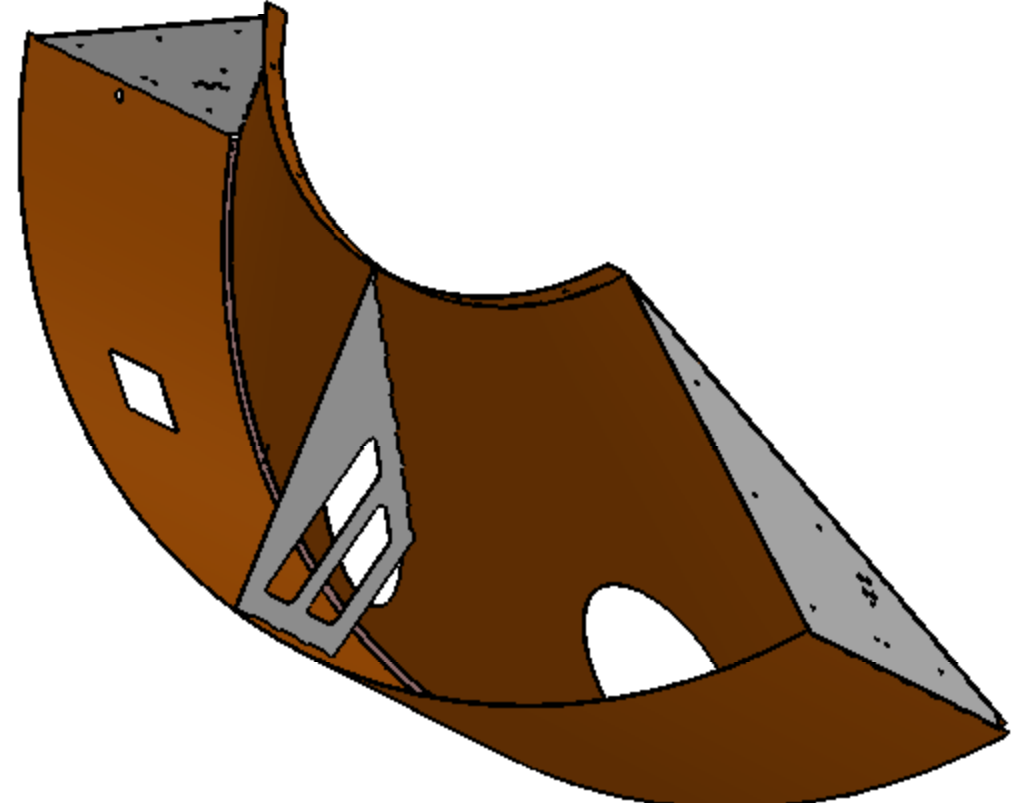
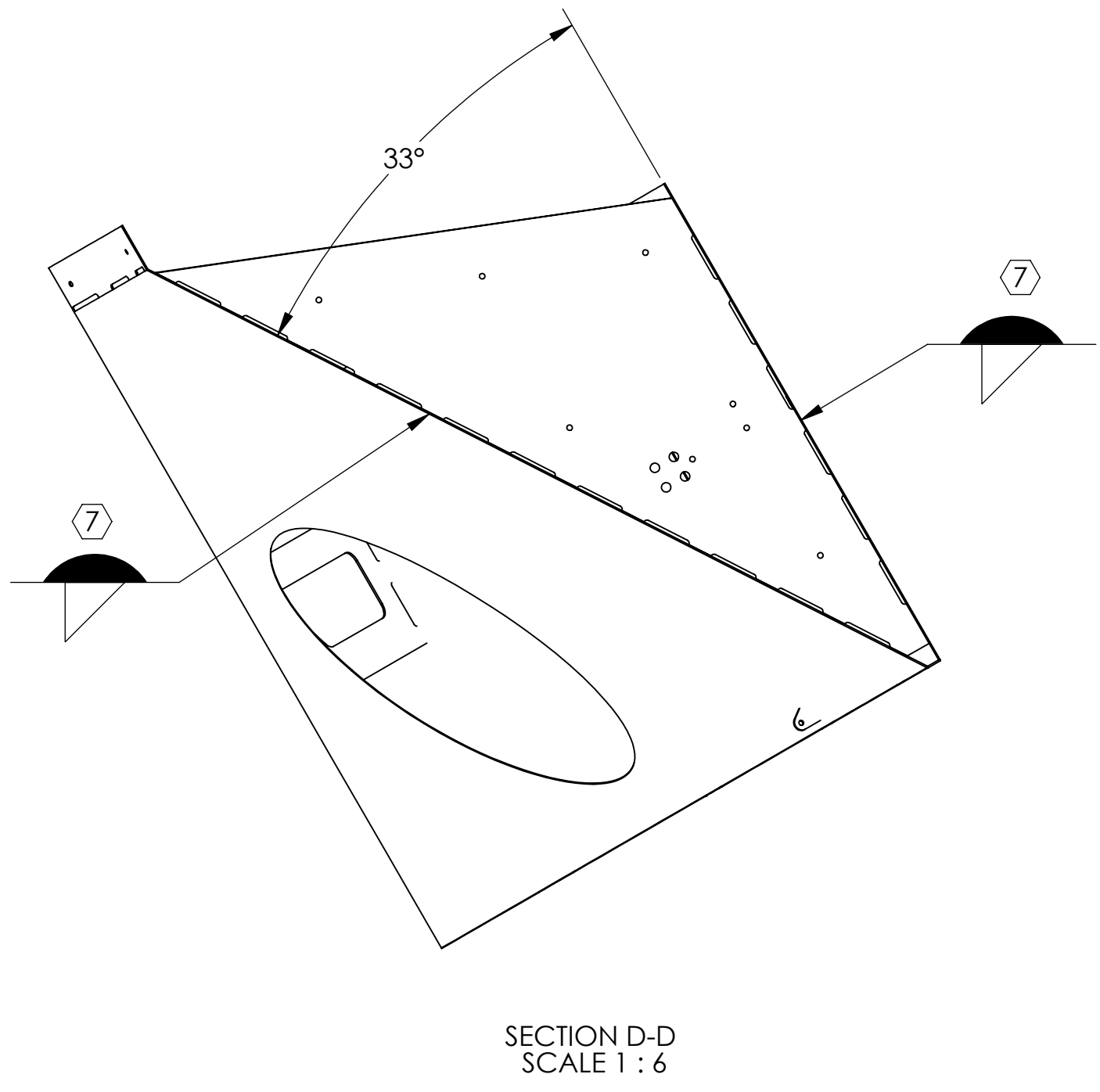
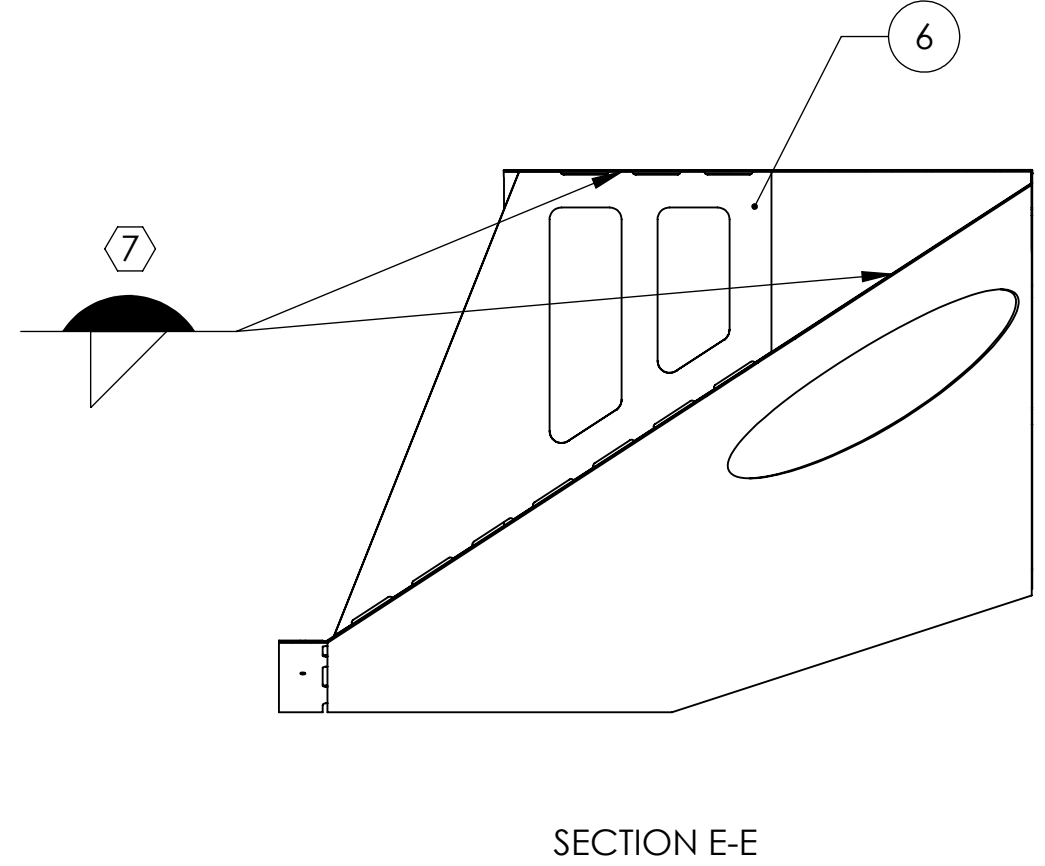
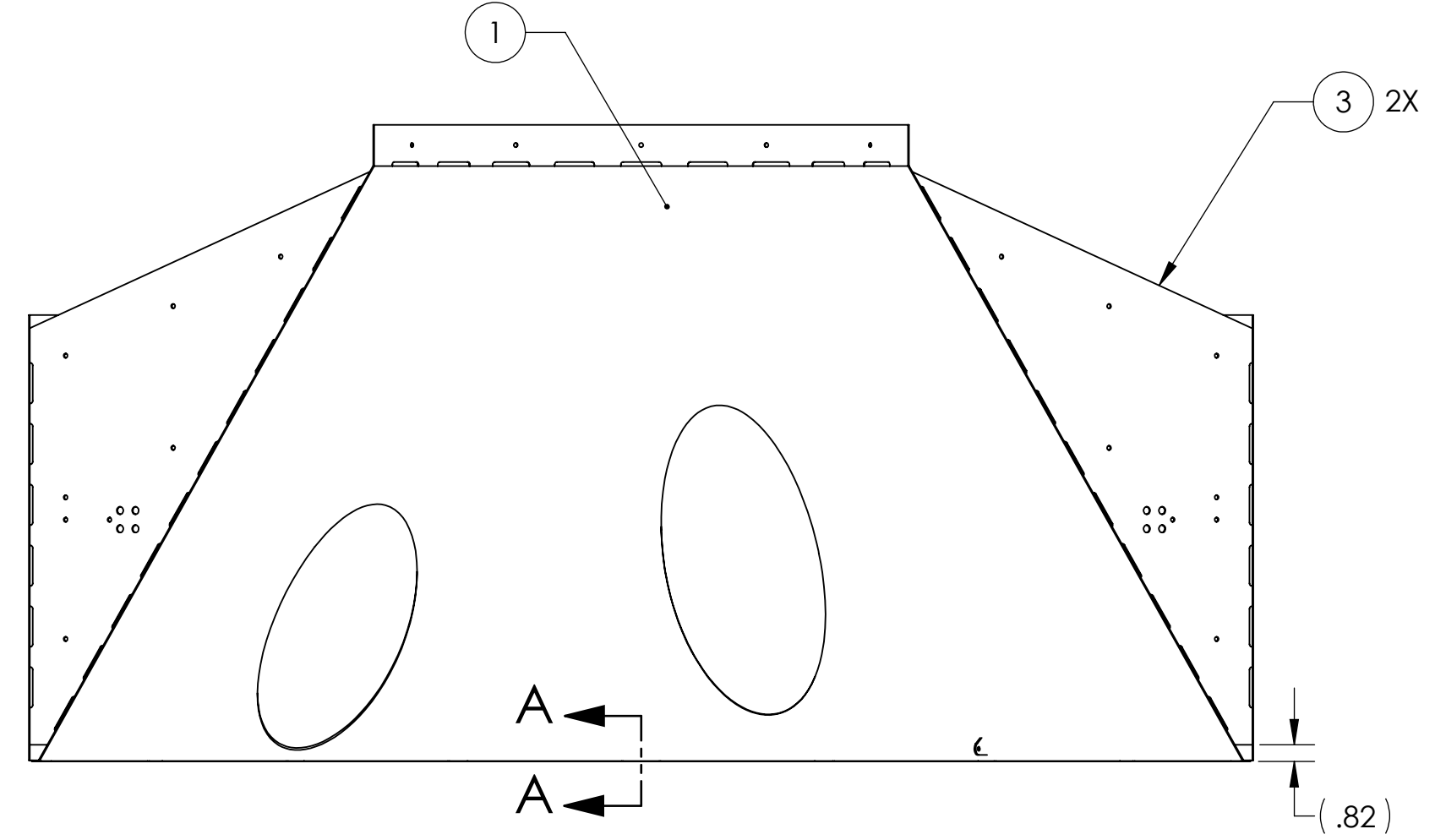
6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	1 OCT 2010	E1000360-v2	E1000091
-	-	-	-



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		0
5	D1000559	RADIAL SEGMENT, RIGHT	18GA A424 TYPE I STEEL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		0
3	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		0
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		0
1	D1003187	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, RIGHT	18GA A424 TYPE I STEEL	1		0

DIMENSIONS ARE IN INCHES TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010 ANGULAR ± 1.0°		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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMX H1, RIGHT	
MATERIAL N/A		FINISH N/A		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1003183		DESIGNER H. KELMAN		DATE 20 MAY 2010		SIZE D	
CHECKER M. SMITH		DATE 07 SEP 2010		DWG. NO. D1003186		REV. v1	
APPROVAL D. COYNE		SCALE 1:8		PROJECTION 		SHEET 1 OF 1	

D1003186.dwg: d:\lco_monofield_cryo_baffle_segment_subassembly_weldment_etmx_h1_right_part.pdm REV: X072 DRAWING PDM REV: X003