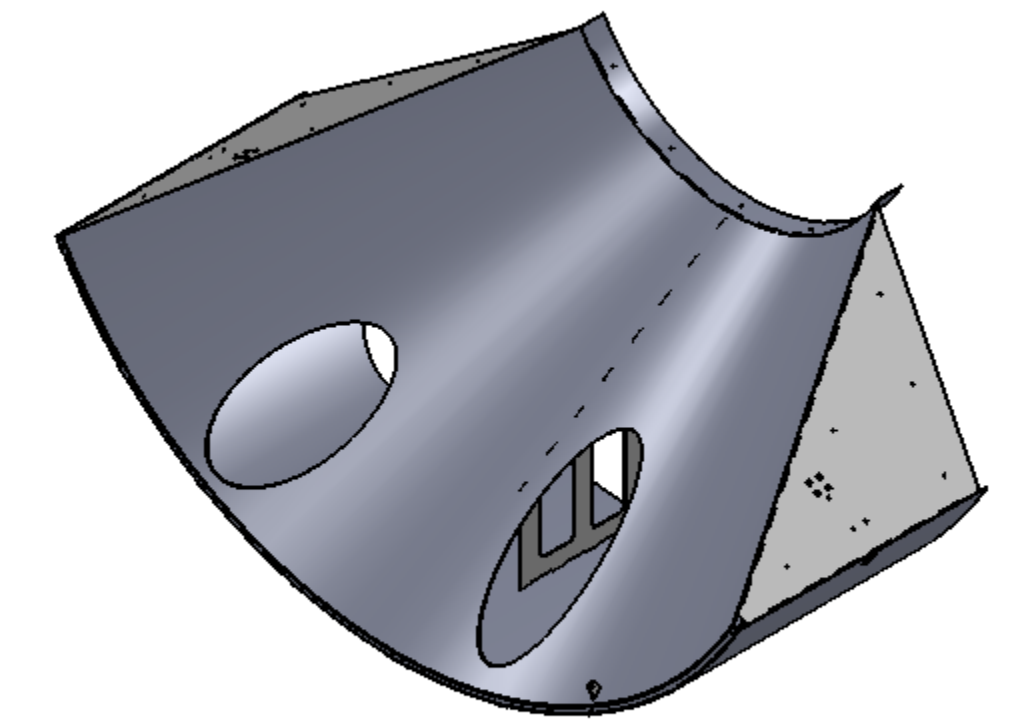
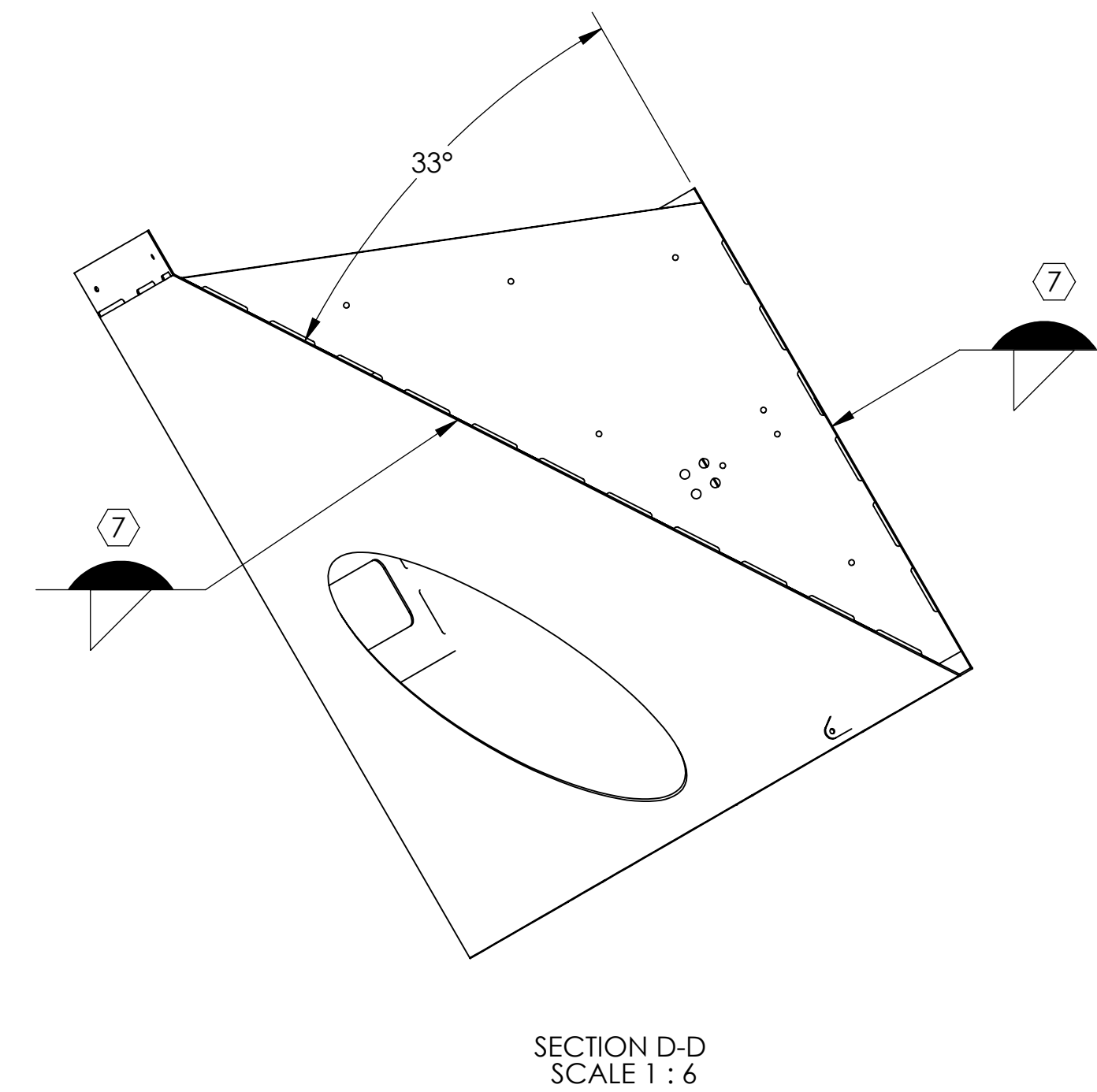
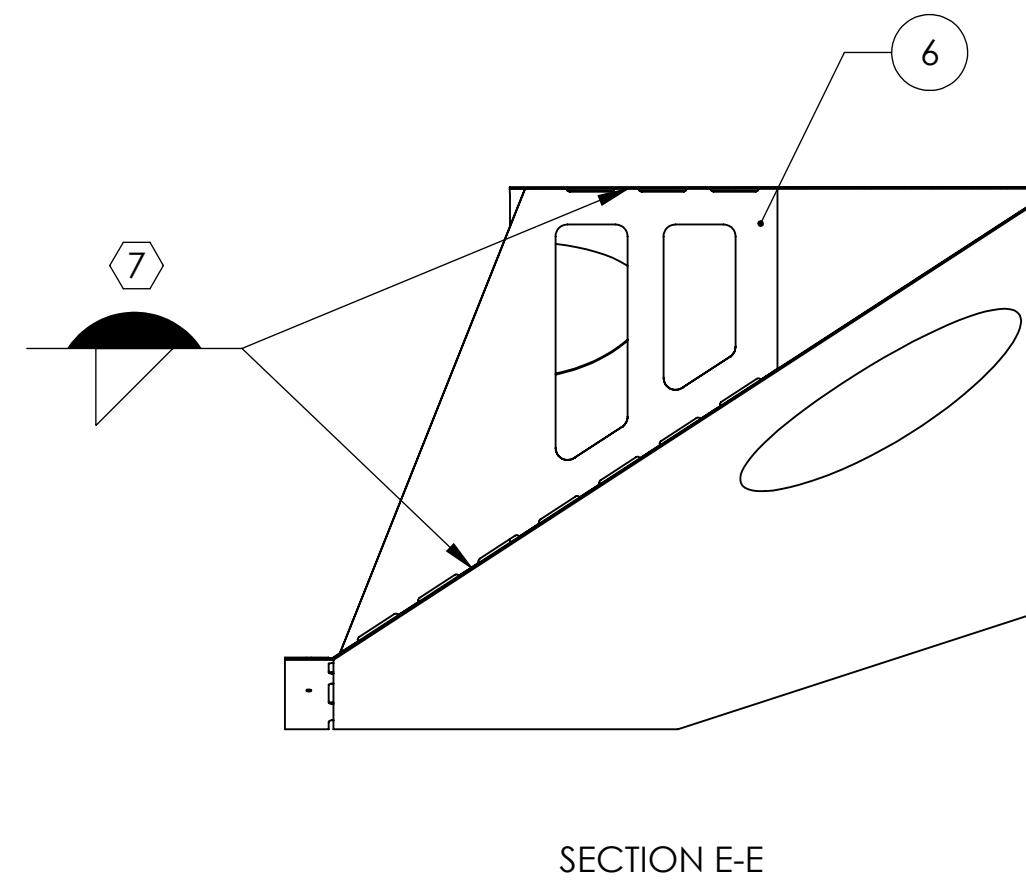
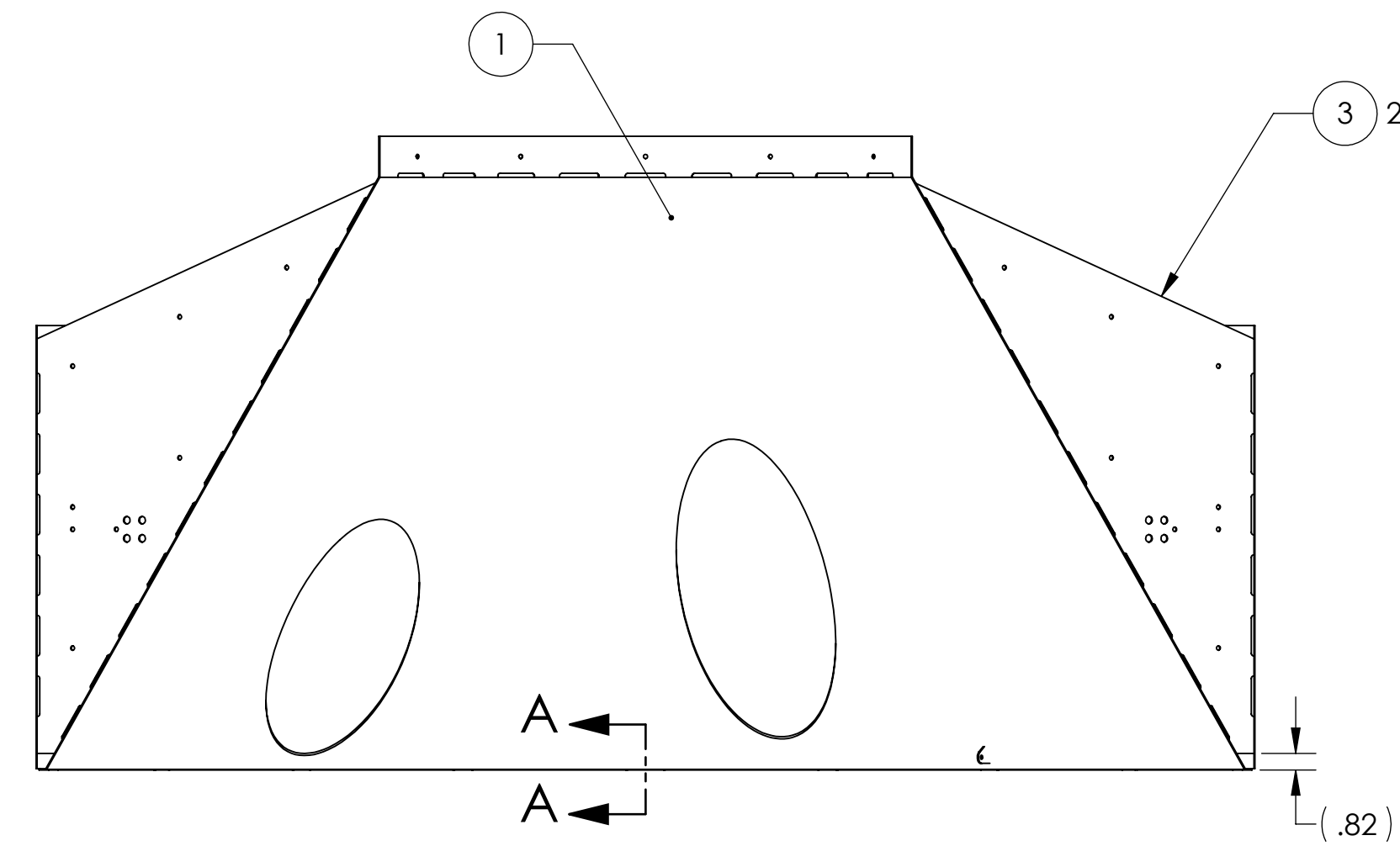
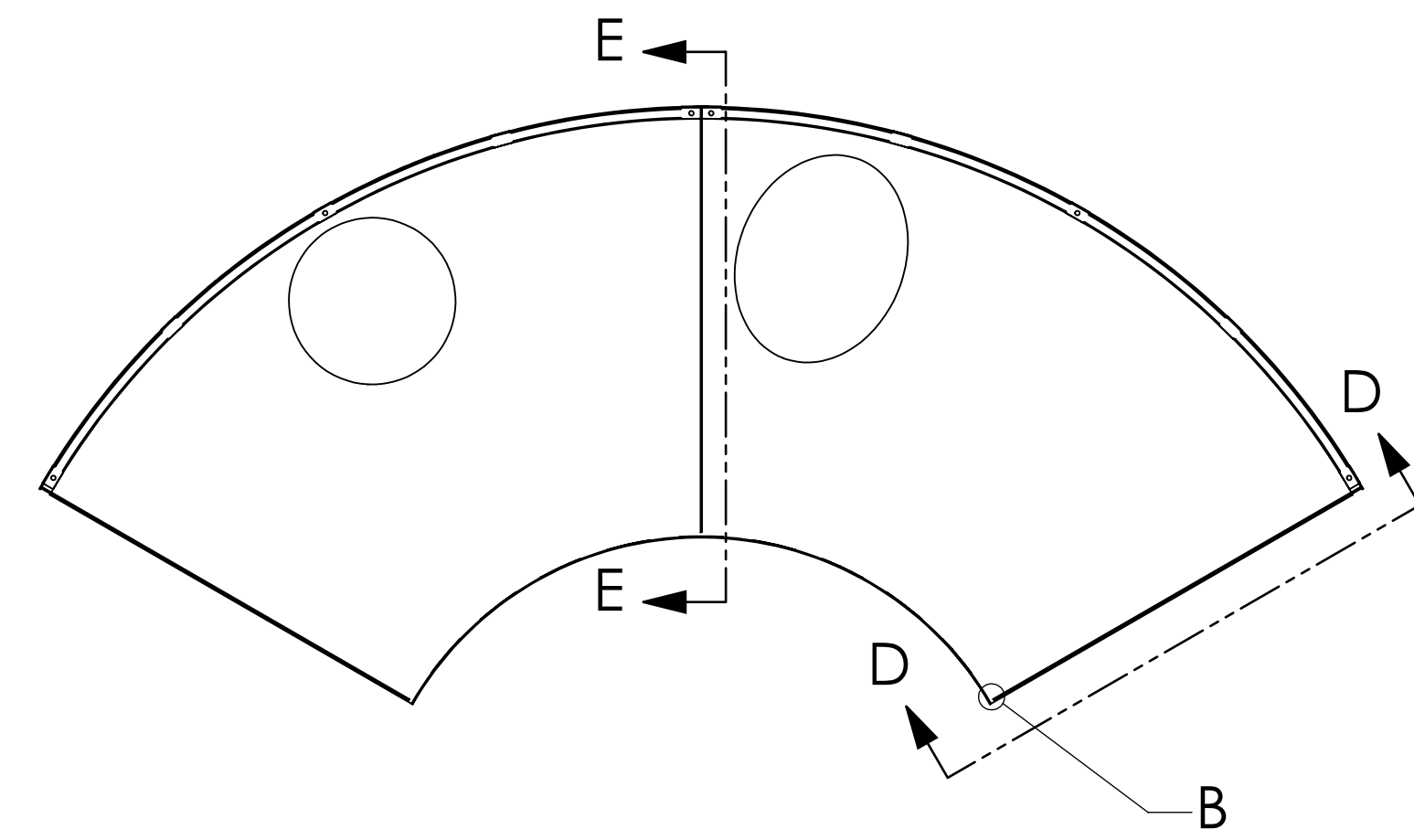
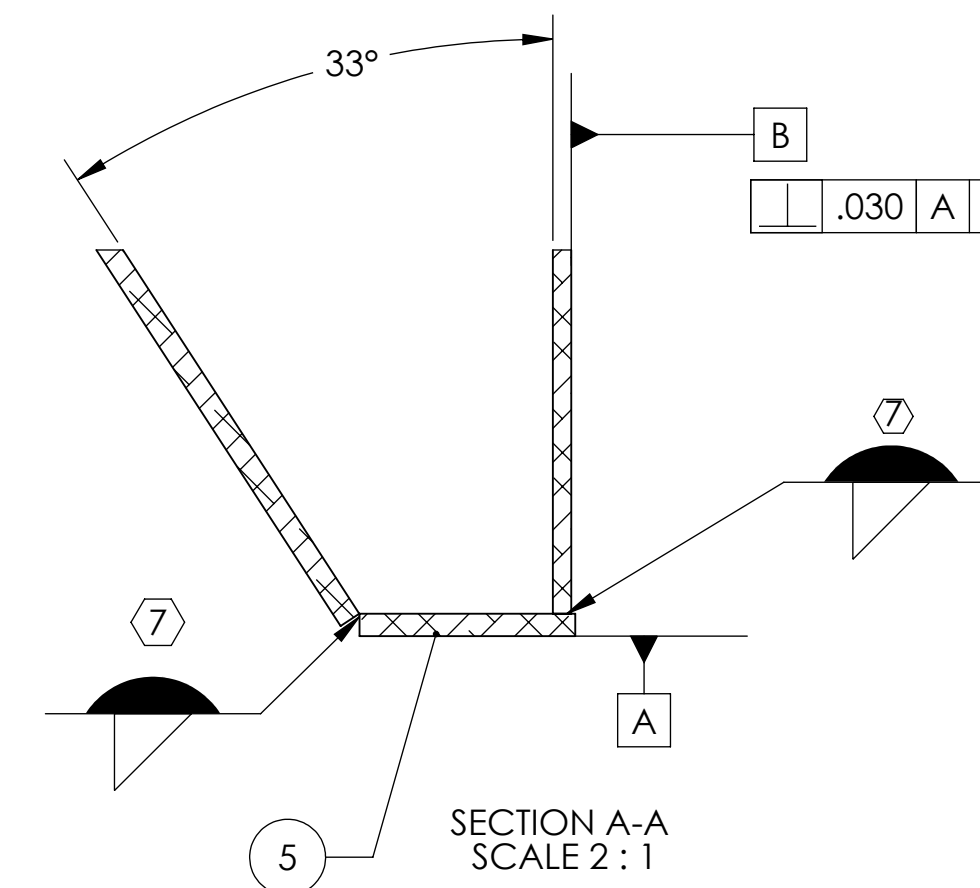
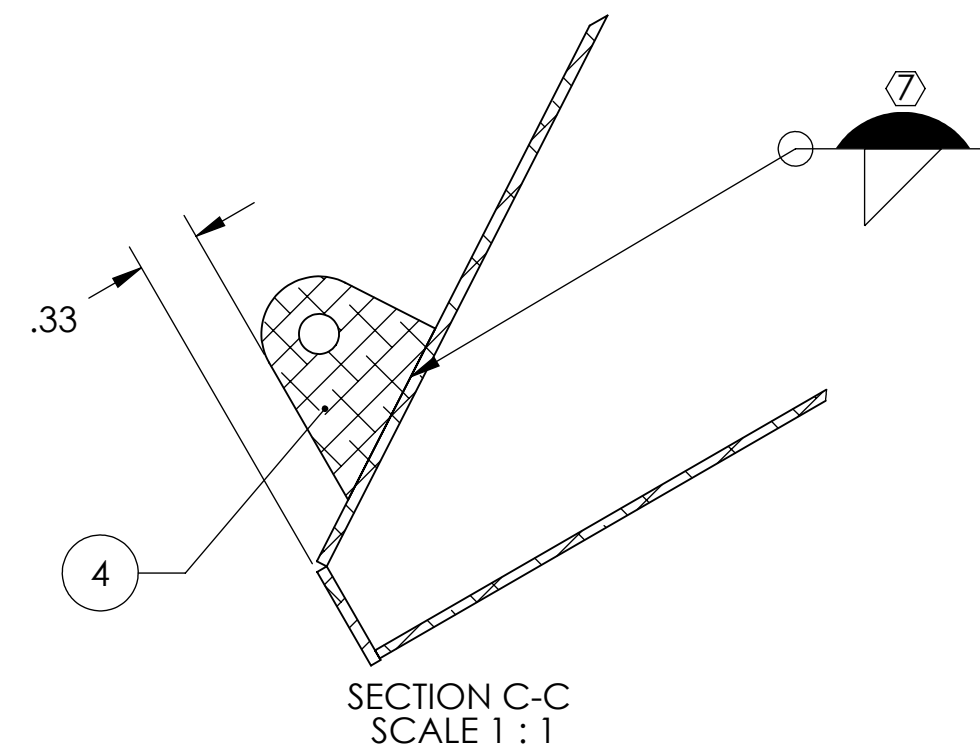
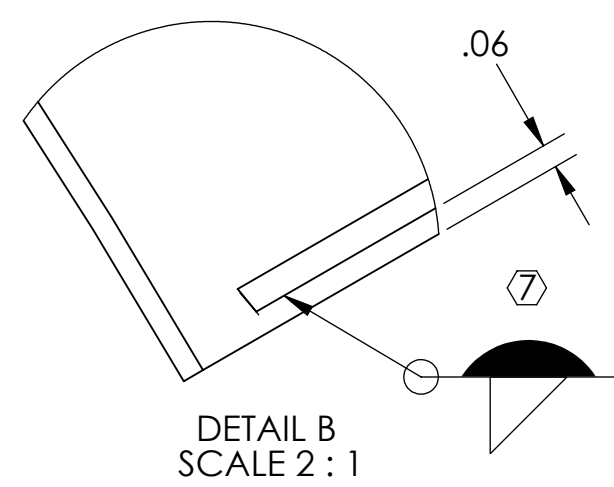


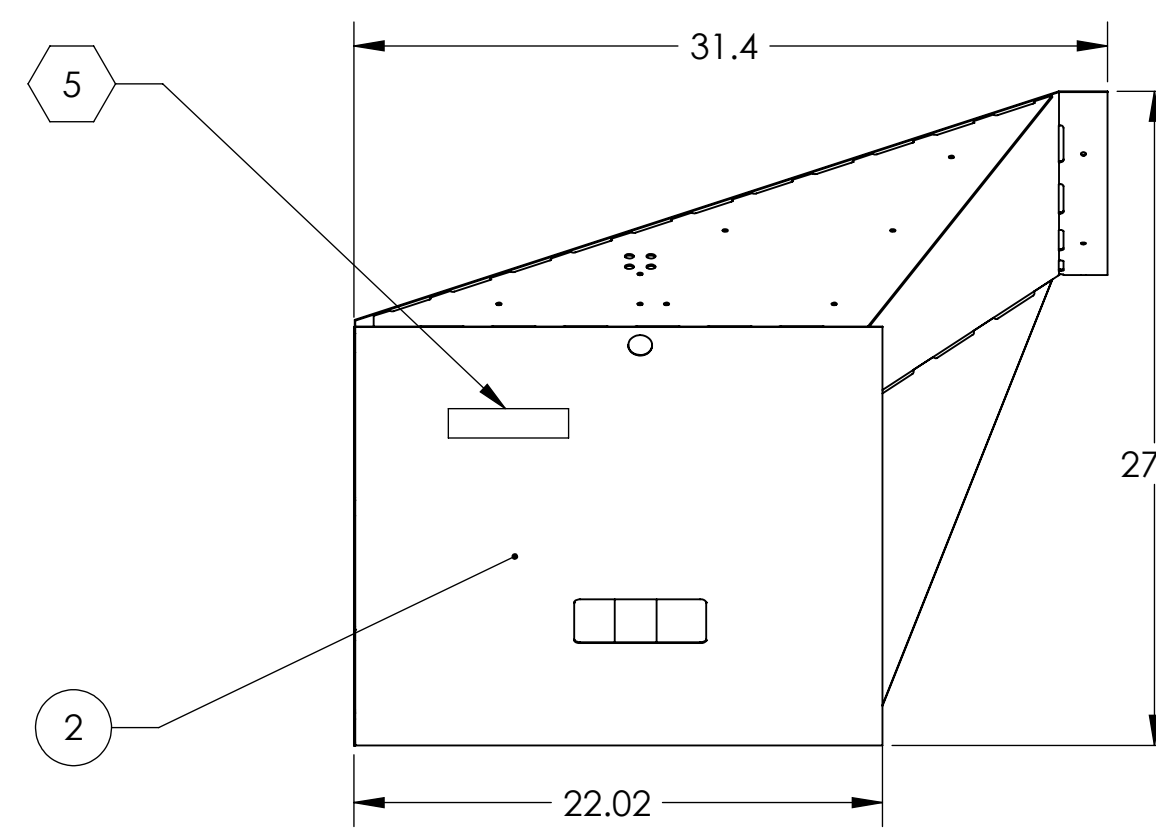
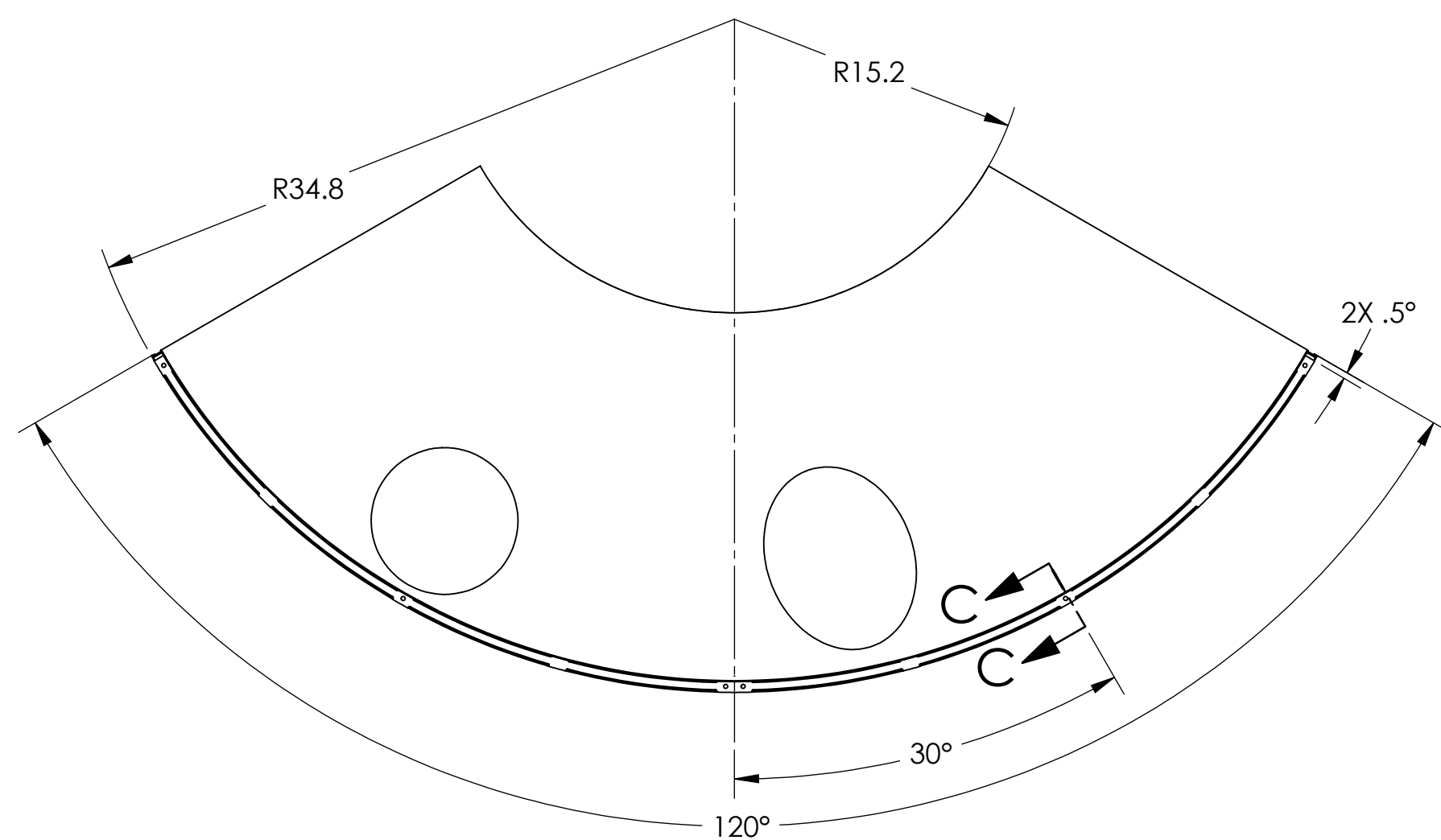
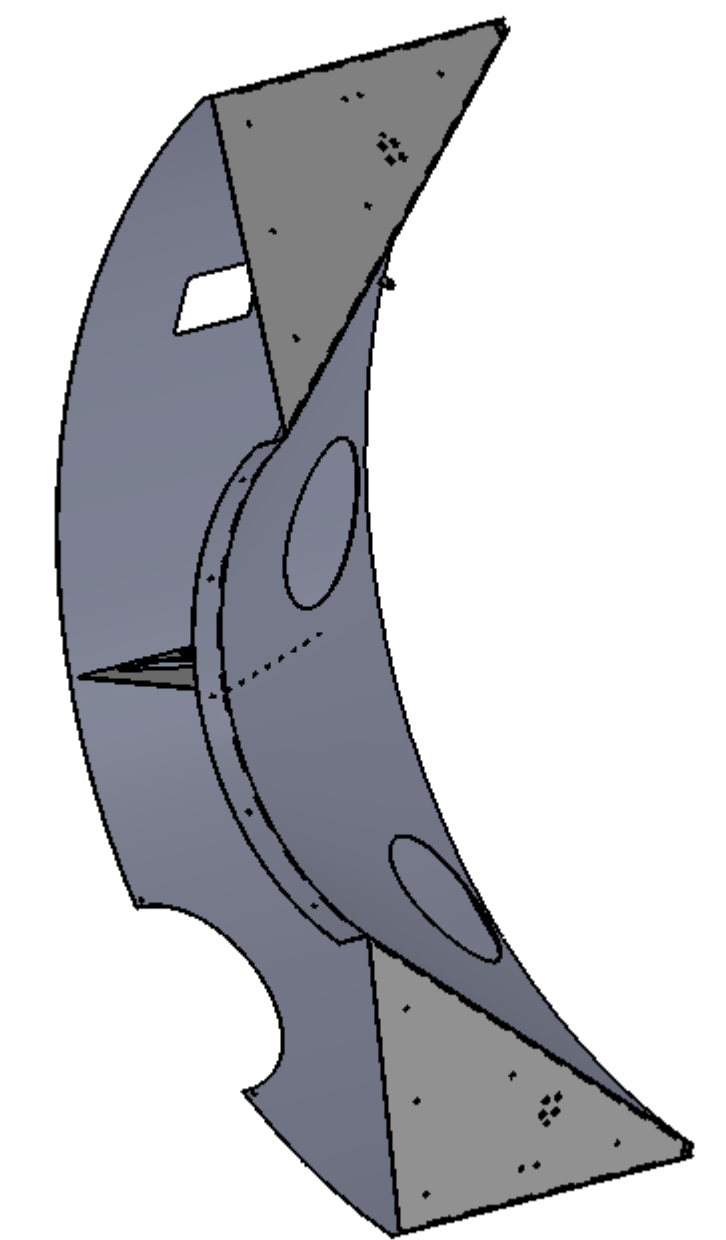
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), DO NOT STAMP OR LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE 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. ASSEMBLY TO BE OXIDIZED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1100842.

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



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSTL	1		0
5	D1201125	RADIAL SEGMENT, RIGHT	18 GAUGE 304 SSTL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSTL	1		0
3	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSTL	1		0
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSTL	2		0
1	D1003187	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, RIGHT	18 GAUGE 304 SSTL	1		0

DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1003183

PART NAME		MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMX H1, RIGHT	
DESIGNER	H. KELMAN	20 MAY 2010	SIZE DWG. NO.
DRAFTER	TG. NGUYEN	07 SEP 2010	D
CHECKER	M. SMITH		D1003186
APPROVAL	D. COYNE		REV. v3
SCALE:	1:8	PROJECTION:	SHEET 1 OF 1

REV.	DATE	DCN #	DRAWING TREE #
v1	1 OCT 2010	E1000360-v2	E1000091
v2	20 OCT 2010	E1000360-v3	

D1003186.dwg - LIGO_Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ETMX_H1_Right_PRT_PDM_REV:025_DRAWING_PDM_REV:006