

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 D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

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|------------------------------------------------------------------------------------------------------------------|------------------------|-----------------------------------------|--------|----------------|--|
| DIMENSIONS ARE IN INCHES | | TOLERANCES: .XX ± .06 .XXX ± .010 | | ANGULAR ± 0.5° | |
| 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. | | | | | |
| MATERIAL | 18GA A424 TYPE 1 STEEL | | FINISH | ⑦ | |

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|-----------------------------------------------------------------------------|---------------|---------------------------------------------------------------------------------|-----|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, RIGHT | |
| SYSTEM | ADVANCED LIGO | SUB-SYSTEM | AOS |
| NEXT ASSY | D1003186 | | |

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|----------|------------|------------|------------|-------------|--------------|
| DESIGNER | TQ. NGUYEN | 6 DEC 2010 | SIZE | DWG. NO. | REV. |
| DRAFTER | TQ. NGUYEN | 7 DEC 2010 | D | D1003187 | v1 |
| CHECKER | M. SMITH | | | | |
| APPROVAL | D. COYNE | | SCALE: 1:8 | PROJECTION: | SHEET 1 OF 2 |

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 CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

SECTION B-B
SCALE 1 : 1

DETAIL D
SCALE 1 : 2

SECTION A-A
SCALE 1 : 4

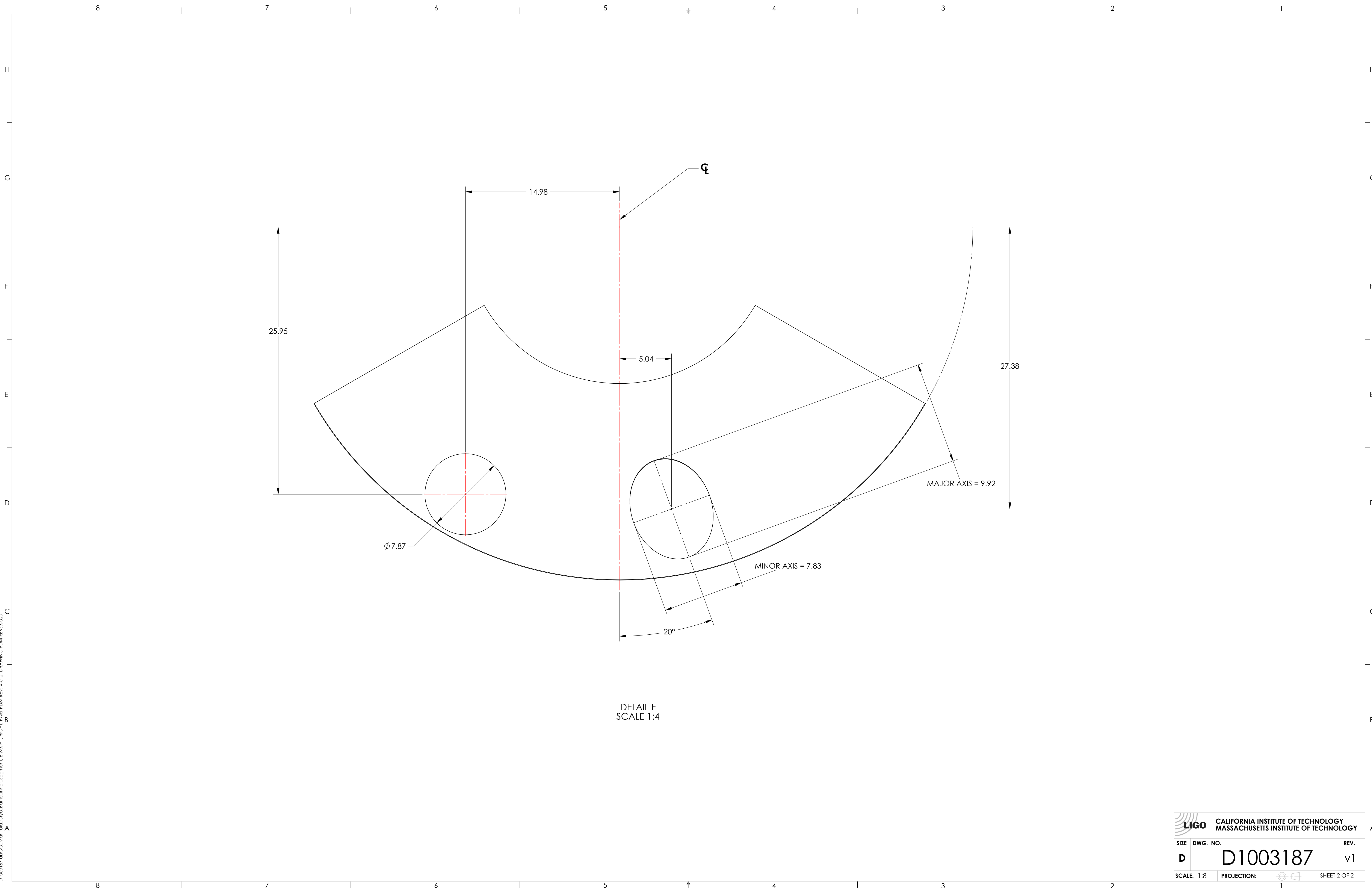
SECTION C-C
SCALE 1 : 1

GENERAL VIEW
FOR REFERENCE
NO SCALE

FLAT PATTERN
(ATTACHMENT LIP REMOVED)

SEE DETAIL F ON NEXT SHEET

D:\003187\alUGO_MonField_Cryo_Baffle_Inner_Segment1_ETMX_H1_RIGHT_PDM.PDM REV: X-012_DRAWING_PDM REV: X-020



DETAIL F
SCALE 1:4

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|  CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | REV. |
| SIZE | DWG. NO. | v1 |
| D | D1003187 | |
| SCALE: 1:8 | PROJECTION: | SHEET 2 OF 2 |

D:\003187\duco_monfield_cryo_baffle_inner_segment1_elliptical_right.prt.pdm REV: X-012.DRAWING PDM REV: X-020