NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIENT 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.
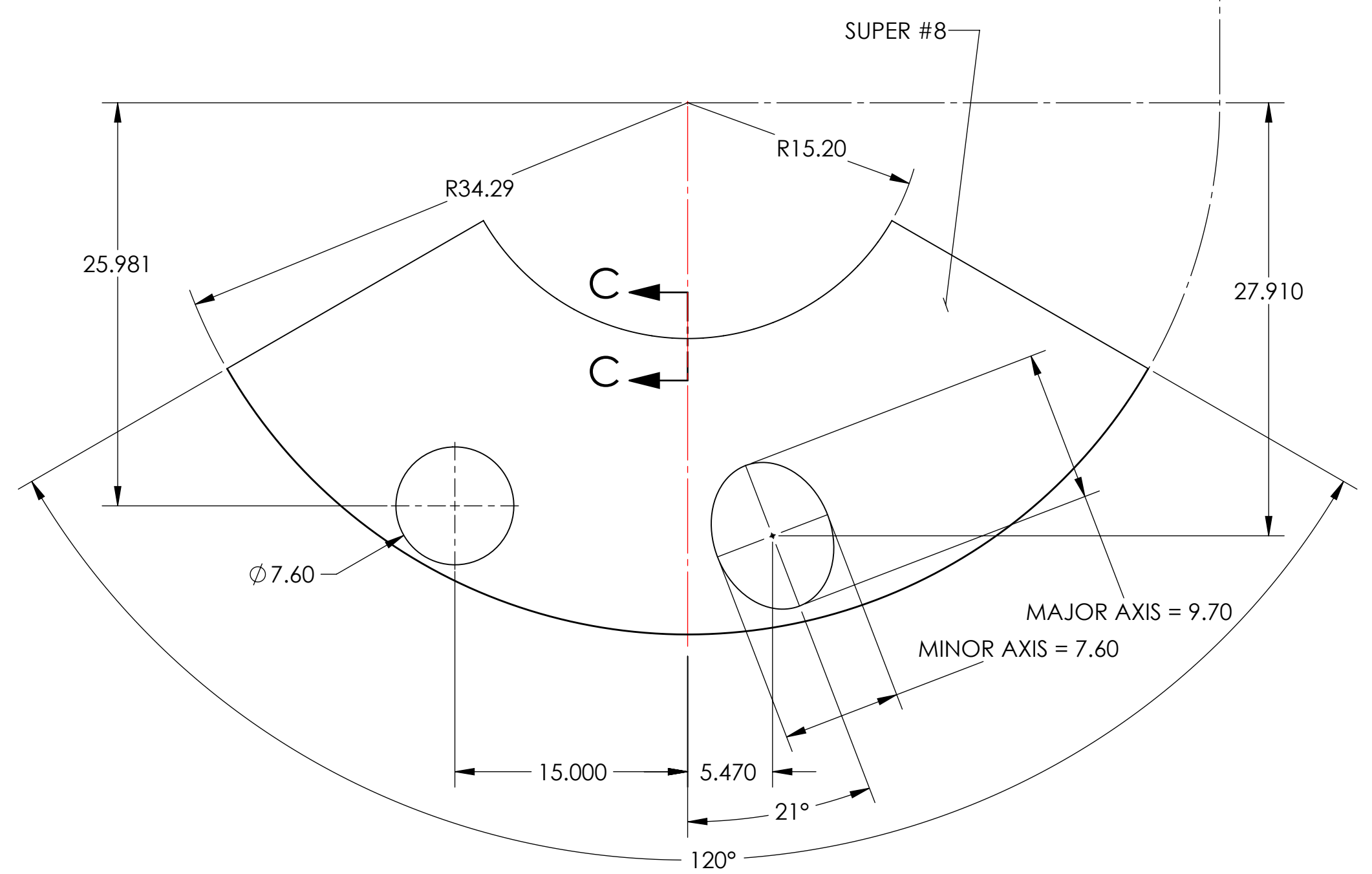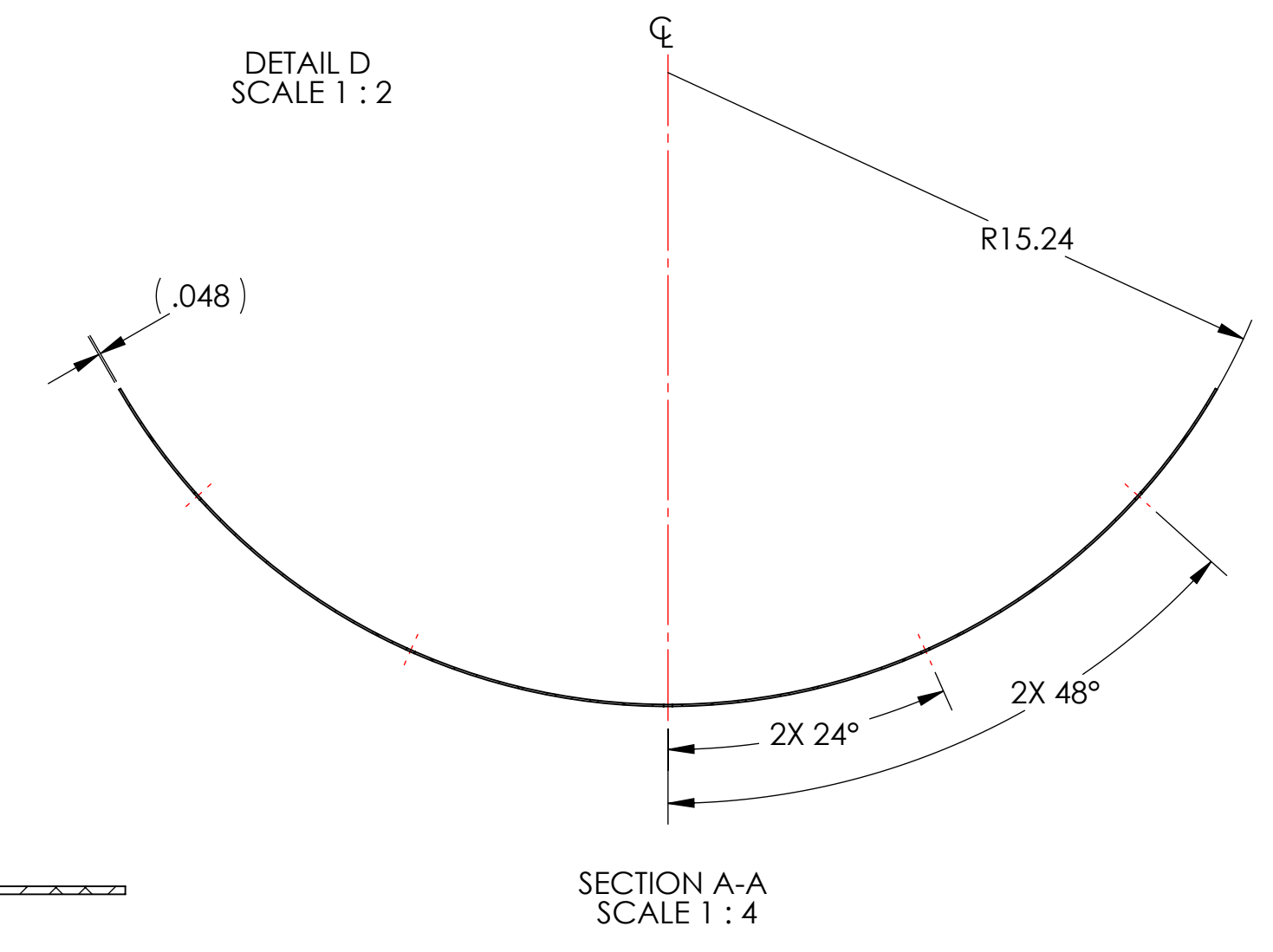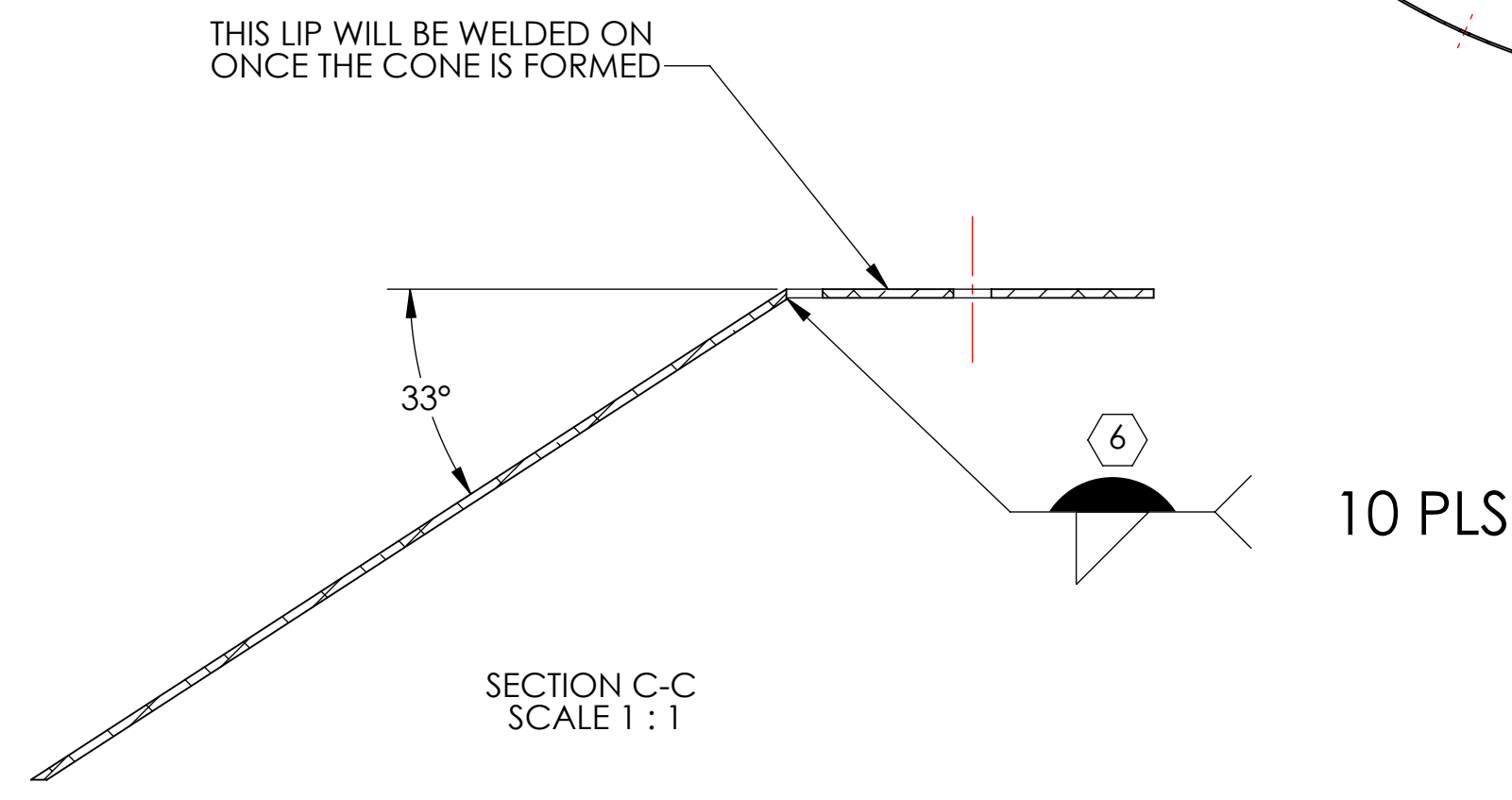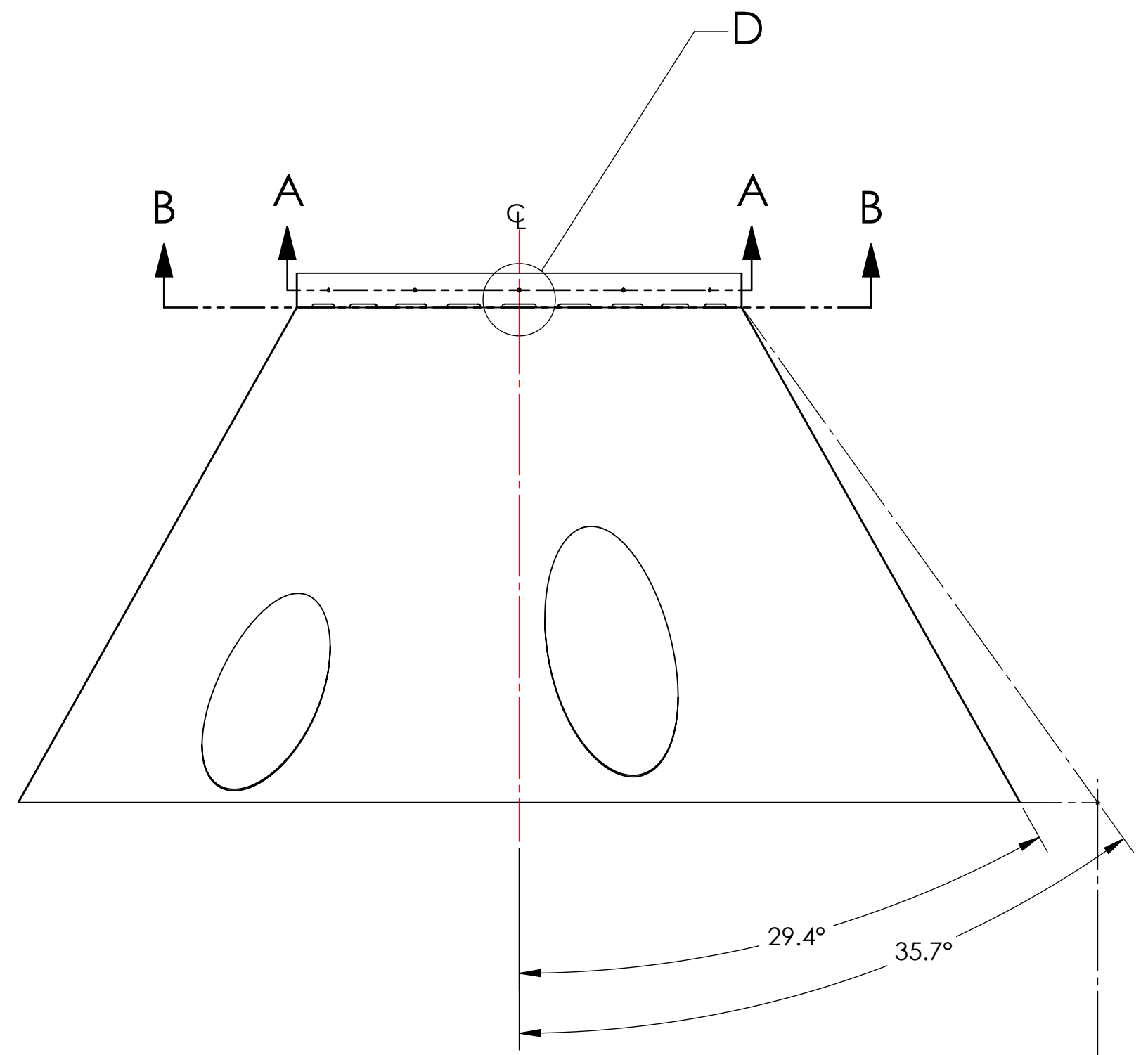EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
DO NOT APPLY MARK ON SUPER #8 SIDE

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

7. DELETED

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

⑩ SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

1.00

9X 12.5°

SECTION B-B
SCALE 1 : 1

5X ⌀ .209 THRU

R.13 TYP

.20 TYP

9X 2.00

DETAIL D
SCALE 1 : 2

(.048)

R15.24

2X 24°   2X 48°

SECTION A-A
SCALE 1 : 4

(SUPER #8)
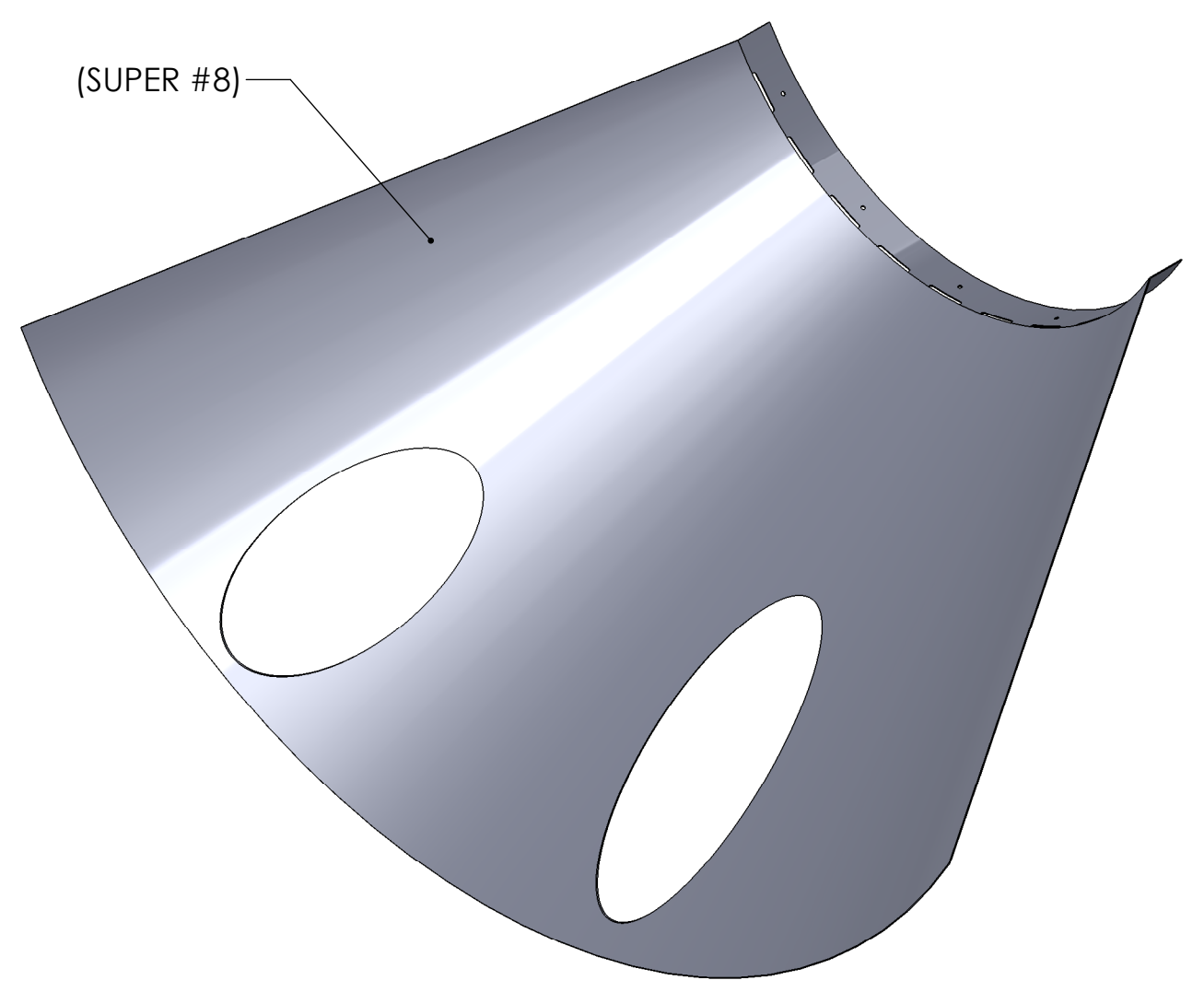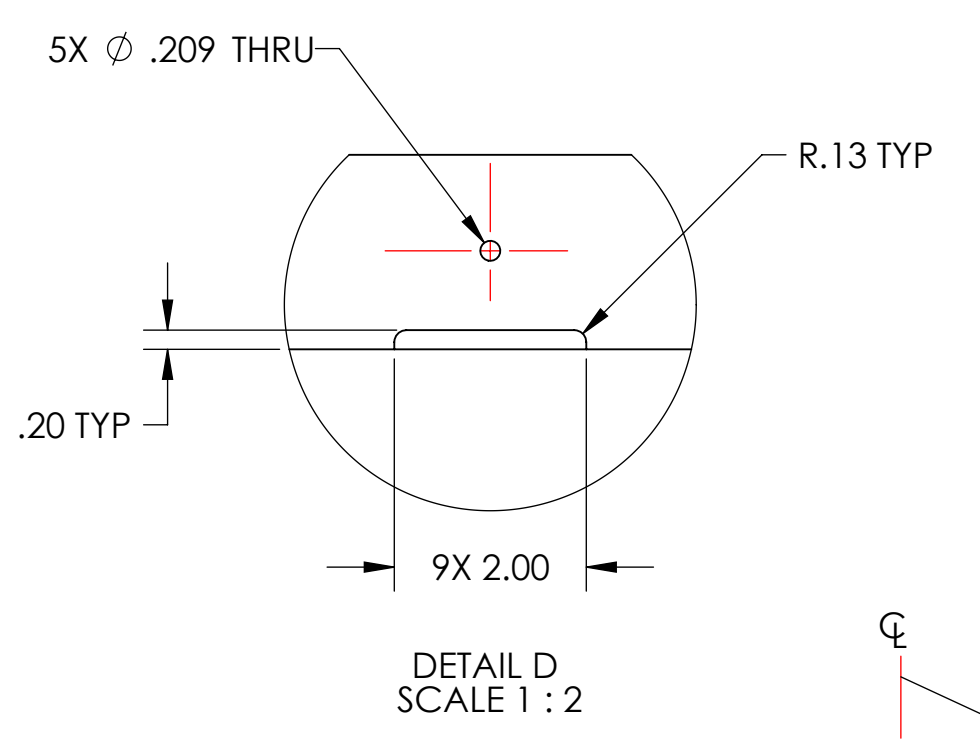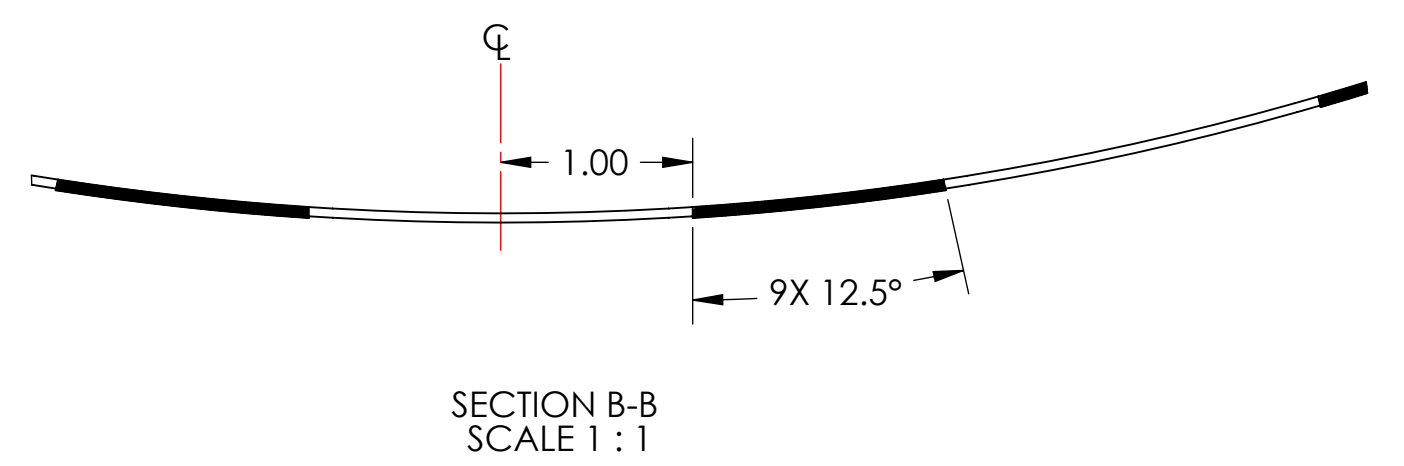
GENERAL VIEW
FOR REFERENCE
NO SCALE

D

B A   A B

29.4°   35.7°

THIS LIP WILL BE WELDED ON ONCE THE CONE IS FORMED

33°

⑥ 10 PLS

SECTION C-C
SCALE 1 : 1

R63.75   R27.94

65.4°

FLAT PATTERN
(ATTACHMENT LIP REMOVED)

SUPER #8

R34.29   R15.20

25.981   27.910

C
C

⌀7.60

MAJOR AXIS = 9.70
MINOR AXIS = 7.60

15.000   5.470

21°

120°

31.37

5X 1.00
2.03

18°

⑤ FARSIDE

SUPER #8
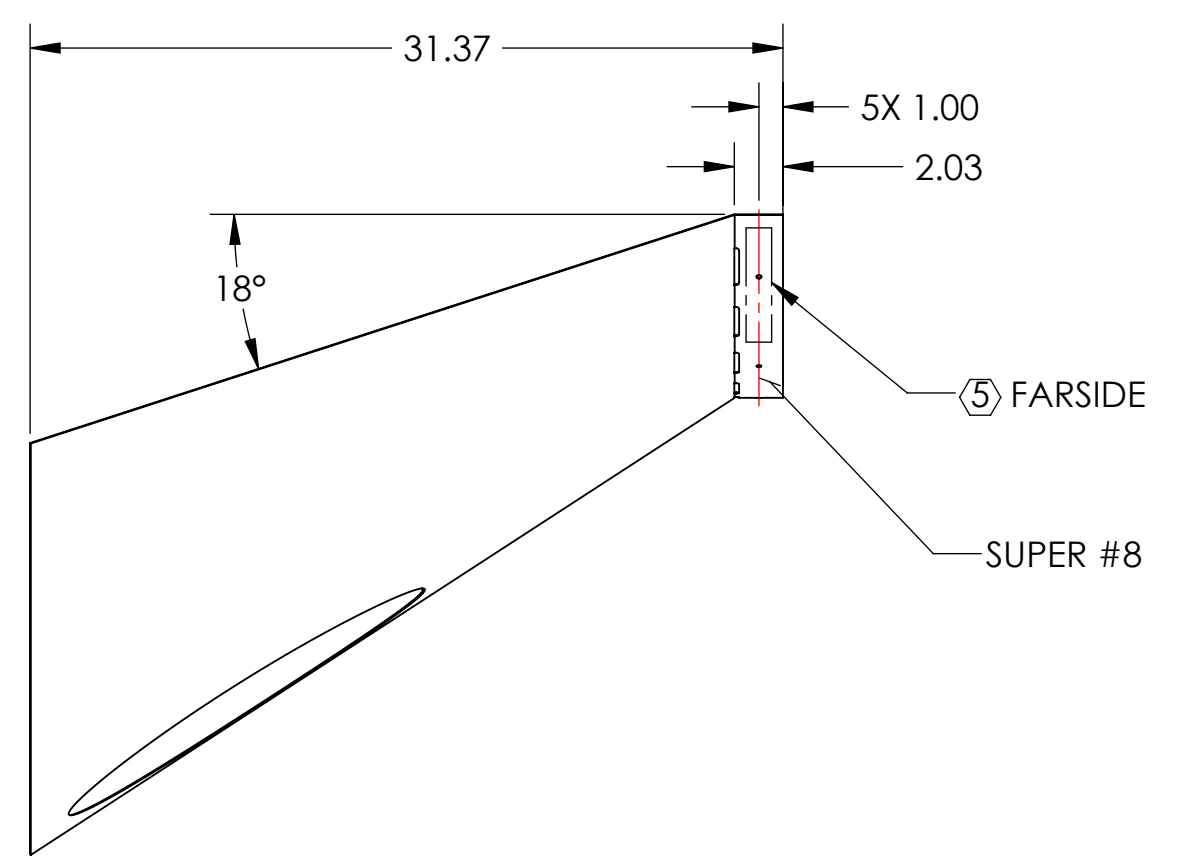
THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE:
WELD INDUCED SHRINKAGE OR FILL, AND POST WELD
ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED.
SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

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.

TOLERANCES:
.XX ± .06
.XXX ± .010

ANGULAR ±0.5°

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME
MANIFOLD-CRYO BAFFLE INNER
SEGMENT WELDMENT, ETMX H1, RIGHT

SYSTEM	SUB-SYSTEM			
ADVANCED LIGO	AOS	DESIGNER	TQ. NGUYEN	6 DEC 2010
		DRAFTER	TQ. NGUYEN	7 DEC 2010
MATERIAL	FINISH	CHECKER	M. SMITH	27 JAN 2012
18 GAUGE 304 SSTL	⑩ SUPER #8	APPROVAL	D. COYNE	27 JAN 2012

NEXT ASSY
D1003186

SIZE D   DWG. NO. D1003187   REV. v4

SCALE: 1:8   PROJECTION: SHEET 1 OF 1