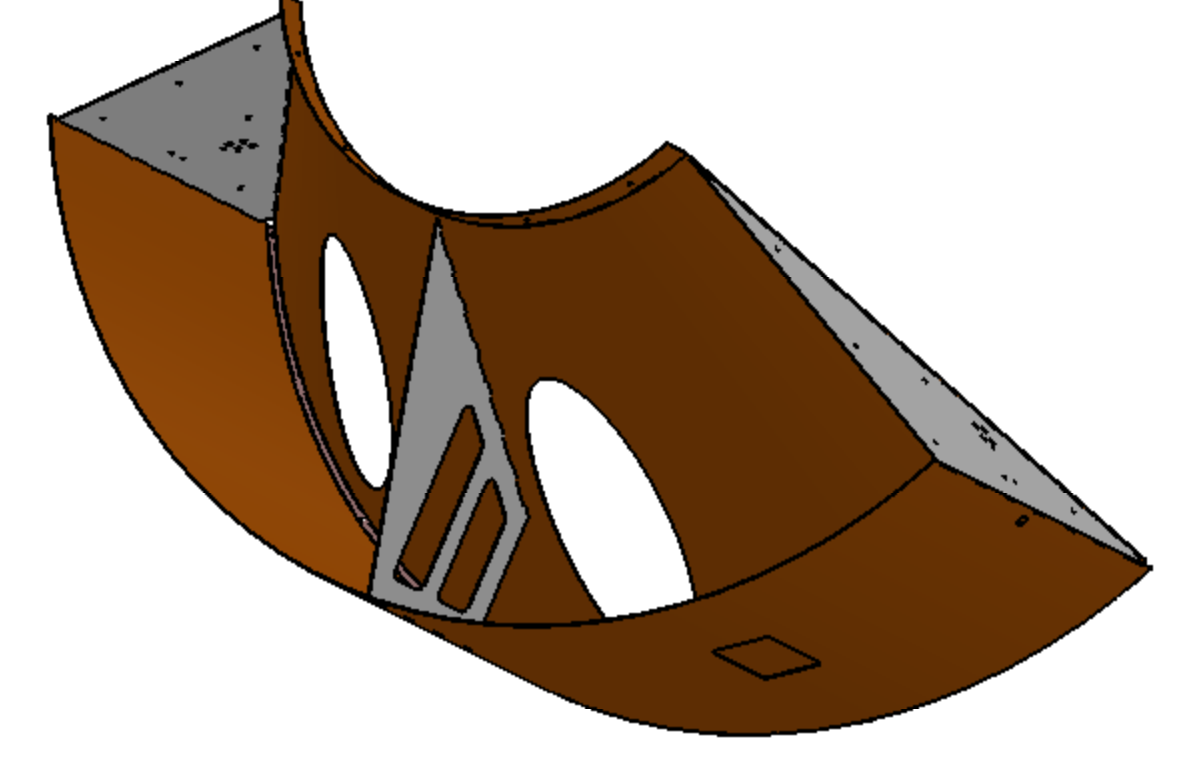


GENERAL VIEW FOR REFERENCE ONLY NO SCALE



GENERAL VIEW FOR REFERENCE ONLY NO SCALE

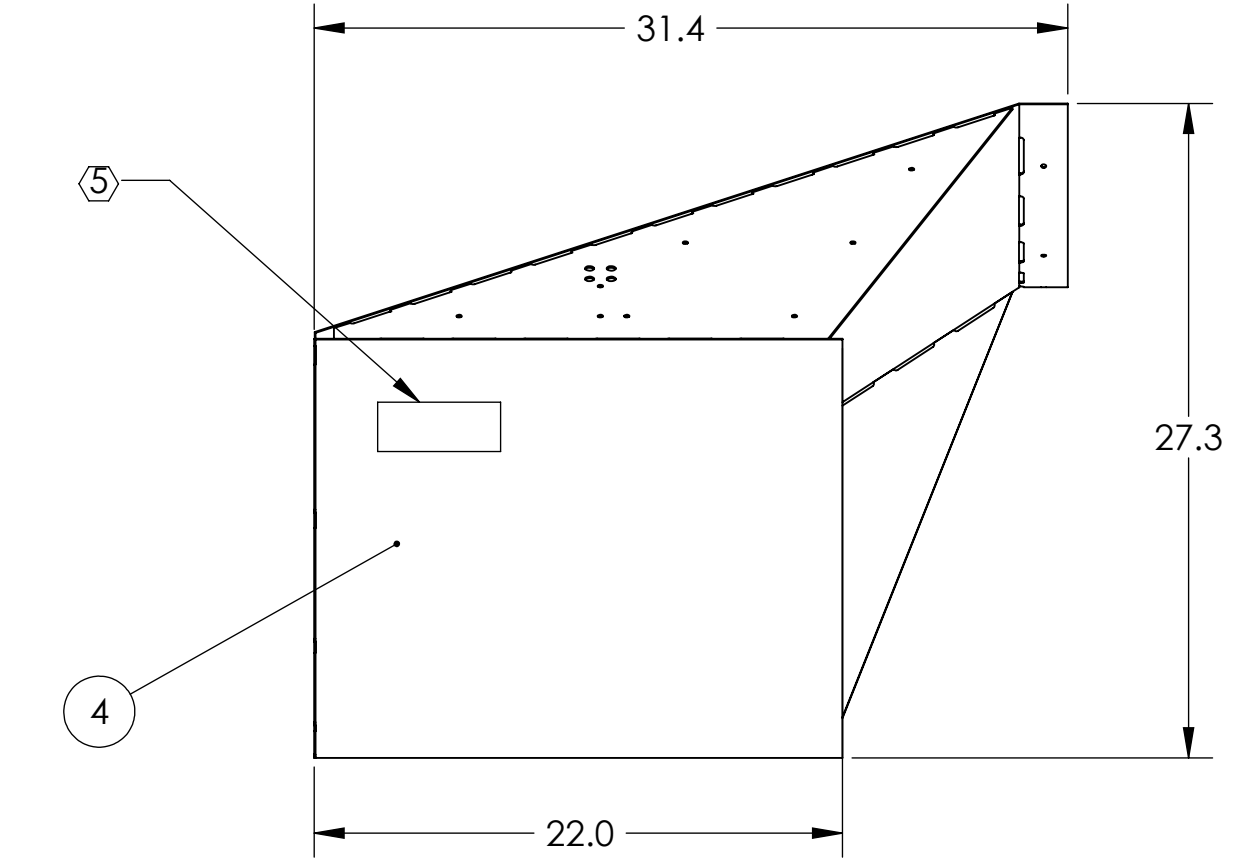
REV.	DATE	DCN #	DRAWING TREE #
v1	28 JUL 2011	E1000360-v2	-
-	-	-	-
-	-	-	-

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.

D1003188.dwg: Manifold_Cryo_Baffle_Segment_Weldment_ETMX_H1_Left_PART_PDM_REV:K010_DRAWING_PDM_REV:K003



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1003191	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, LEFT	18GA A424 TYPE I STEEL	1		1
5	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		1
4	D1000558	RADIAL SEGMENT, LEFT	Steel w/ glass	1		1
3	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
2	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		1
1	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		2

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

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMX H1, LEFT	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER H. KELMAN 20 MAY 2010	SIZE DWG. NO. D D1003188
NEXT ASSY D1003183	DRAFTER TQ. NGUYEN 07 SEP 2010	CHECKER M. SMITH	REV. v1
		APPROVAL D. COYNE	SCALE: 1:8 PROJECTION: SHEET 1 OF 1