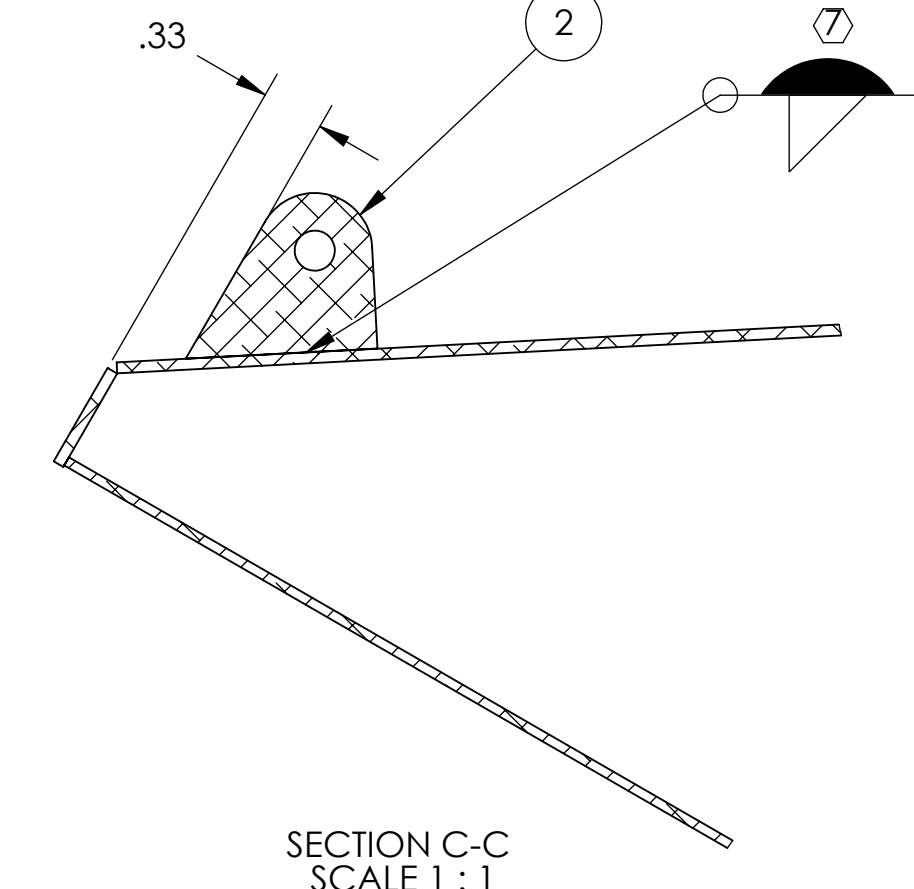
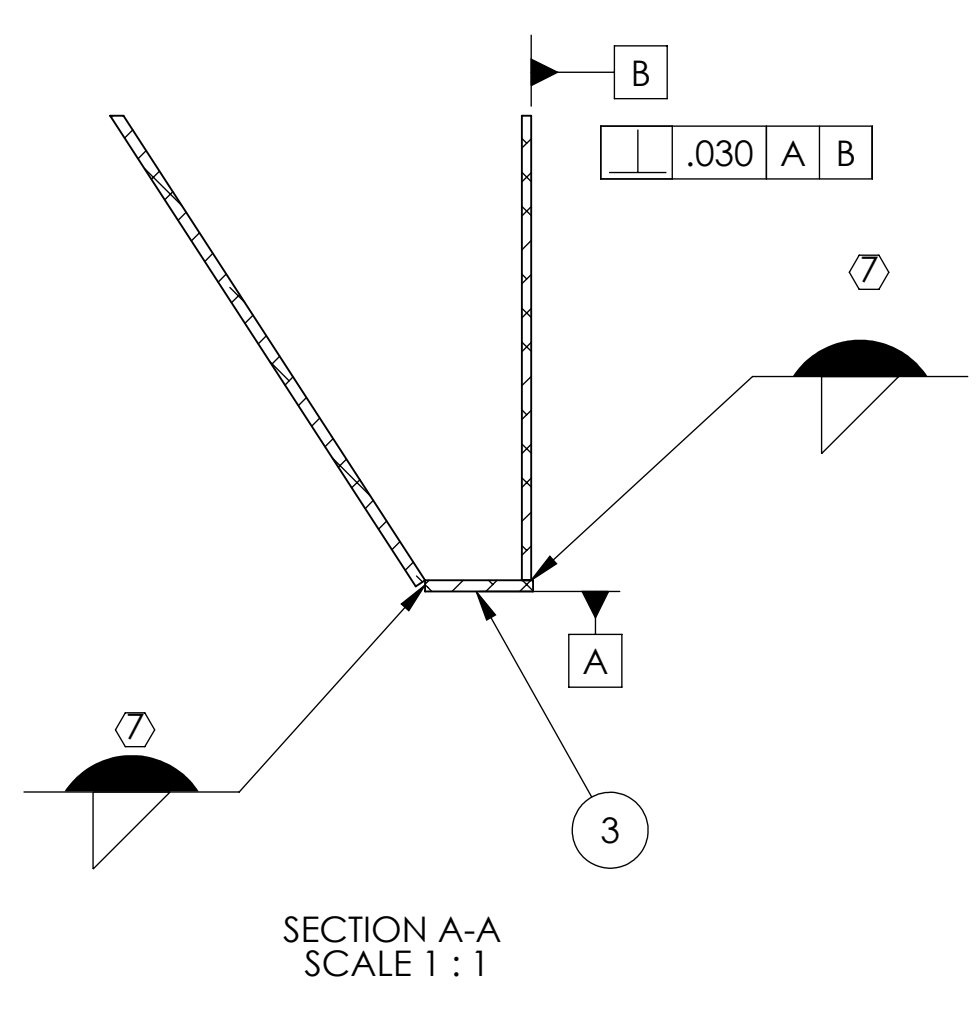


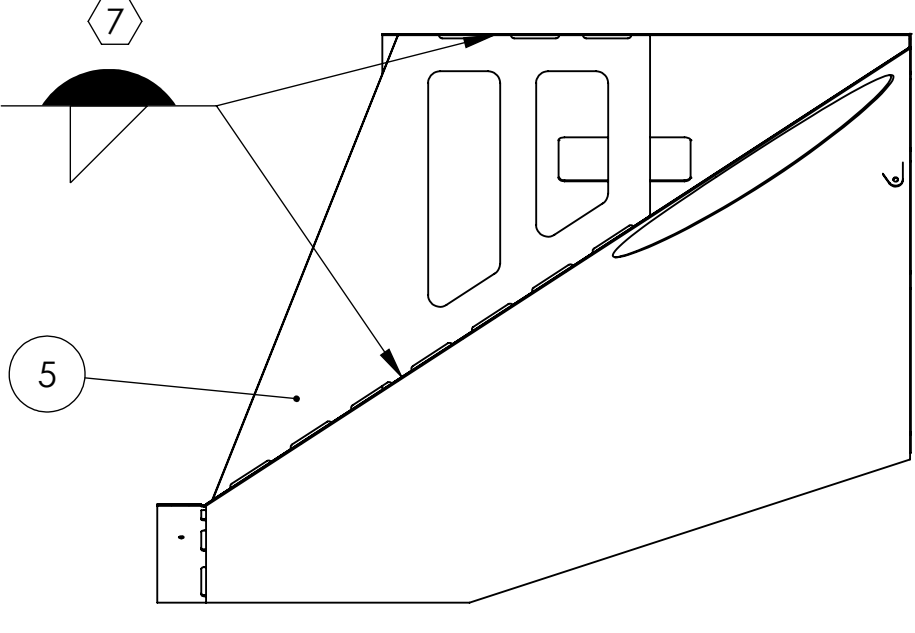
DETAIL B
SCALE 2 : 1



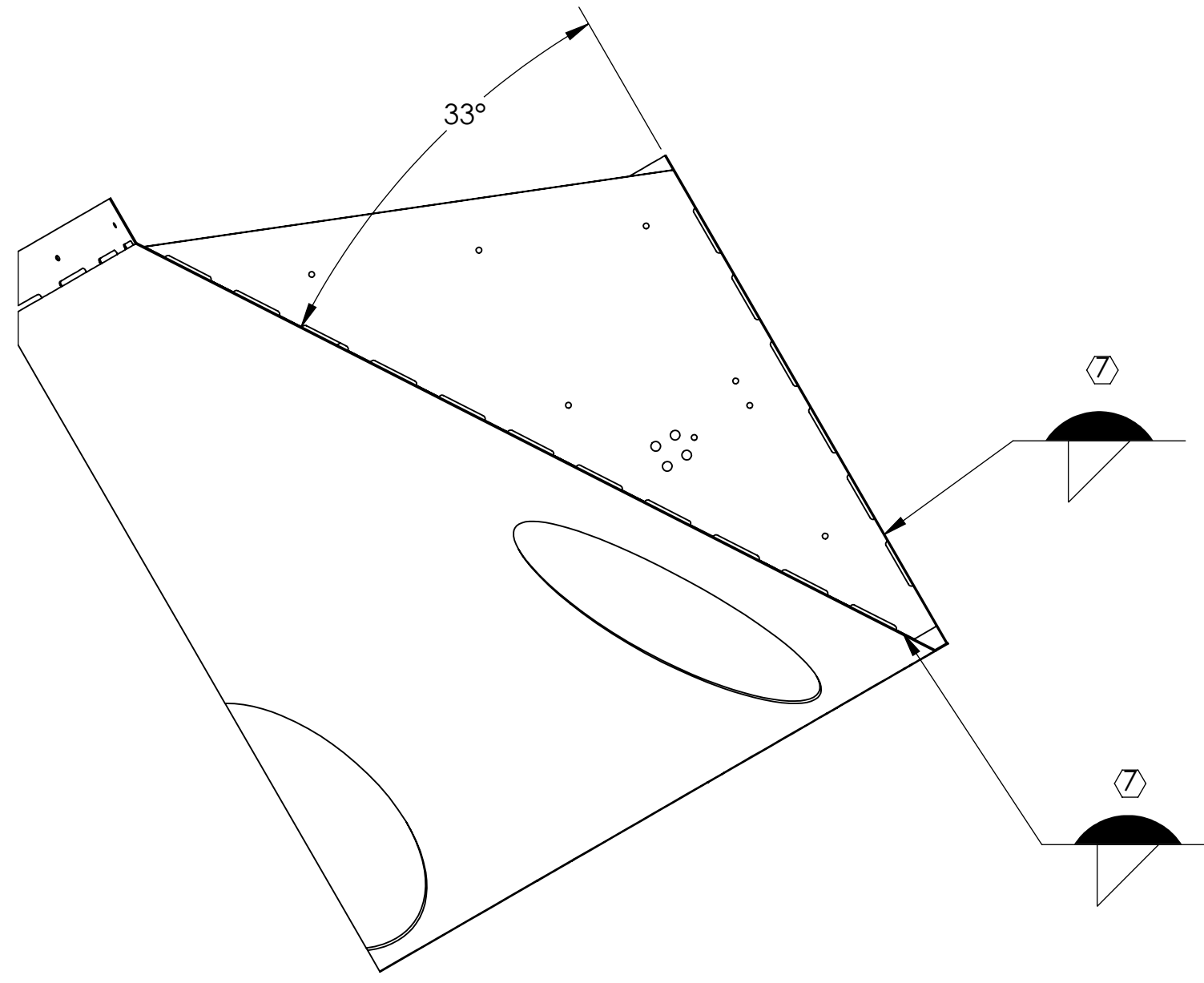
SECTION C-C
SCALE 1 : 1



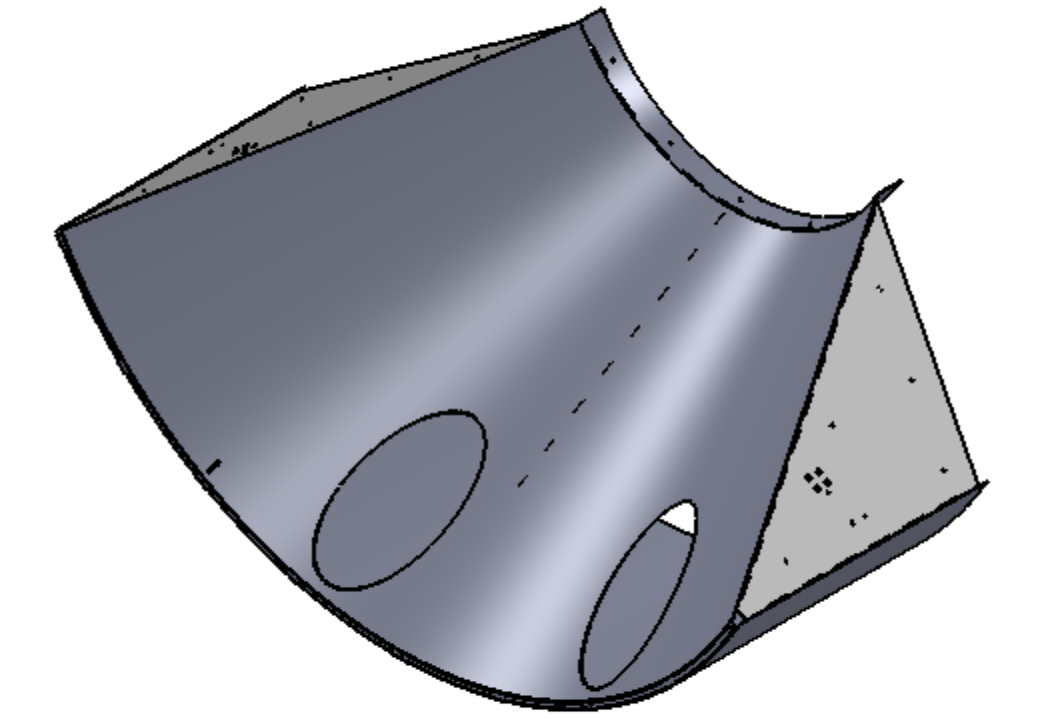
SECTION A-A
SCALE 1 : 1



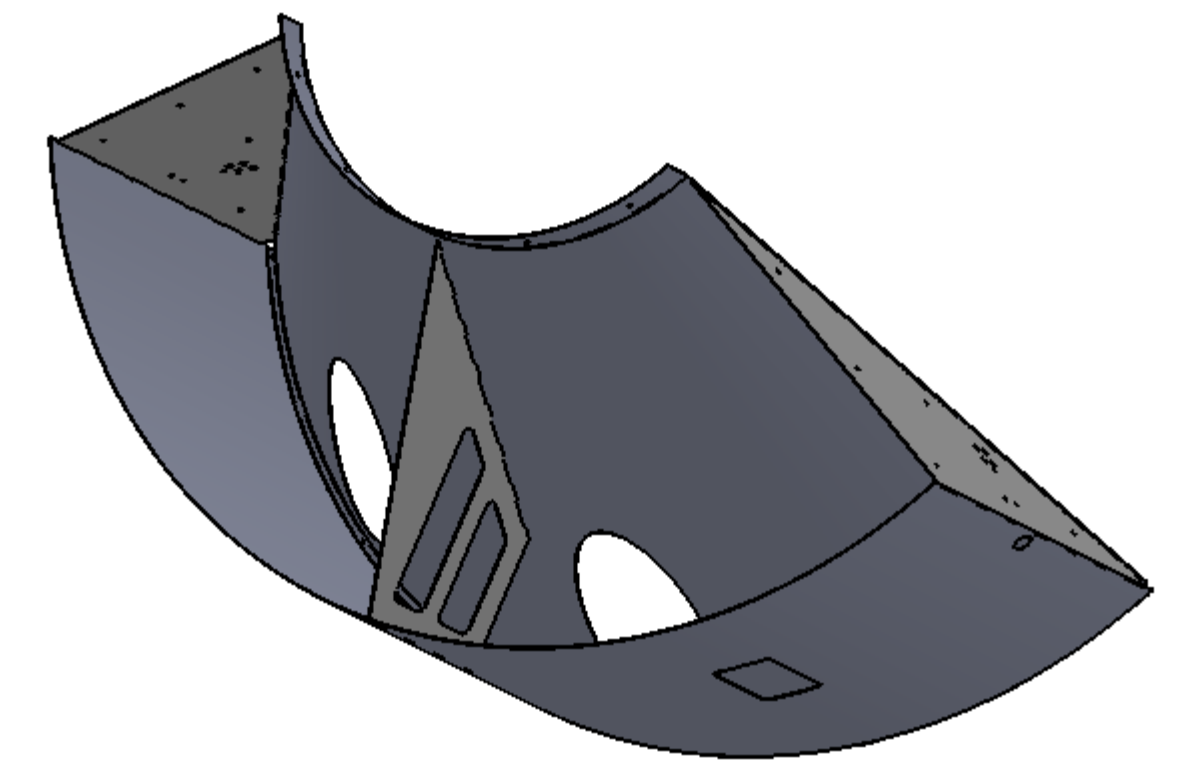
SECTION E-E



SECTION D-D
SCALE 1 : 6



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

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 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

REV.	DATE	DCN #	DRAWING TREE #
v1	28 JUL 2011	E1000360-v2	-
v2	20 OCT 2011	E1000360-v3	-
-	-	-	-

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1003191	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMX H1, LEFT	18 GAUGE 304 SSSL	1		1
5	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSSL	1		1
4	D1000558	RADIAL SEGMENT, LEFT	18 GAUGE 304 SSSL	1		1
3	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
2	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
1	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	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°	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

PART NAME: **MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMX H1, LEFT**

DESIGNER: H. KELMAN 20 MAY 2010 SIZE: **D** DWG. NO.: **D1003188** REV.: **v2**

DRAFTER: TQ. NGUYEN 07 SEP 2010

CHECKER: M. SMITH

APPROVAL: D. COYNE

SCALE: 1:8 PROJECTION:

SHEET 1 OF 1

D1003188.dwg: Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ETMX_H1_Left_PDF.PDF REV: X-005