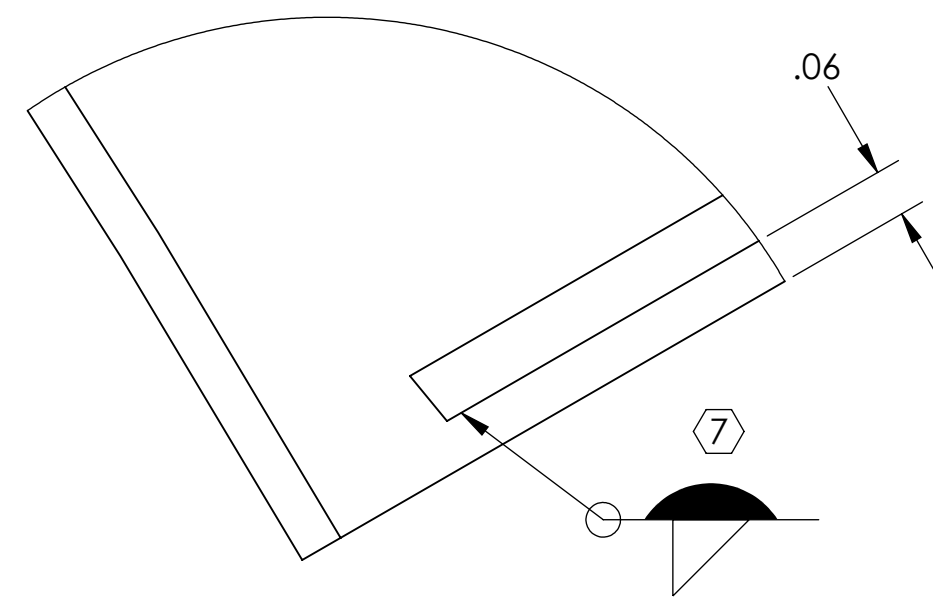
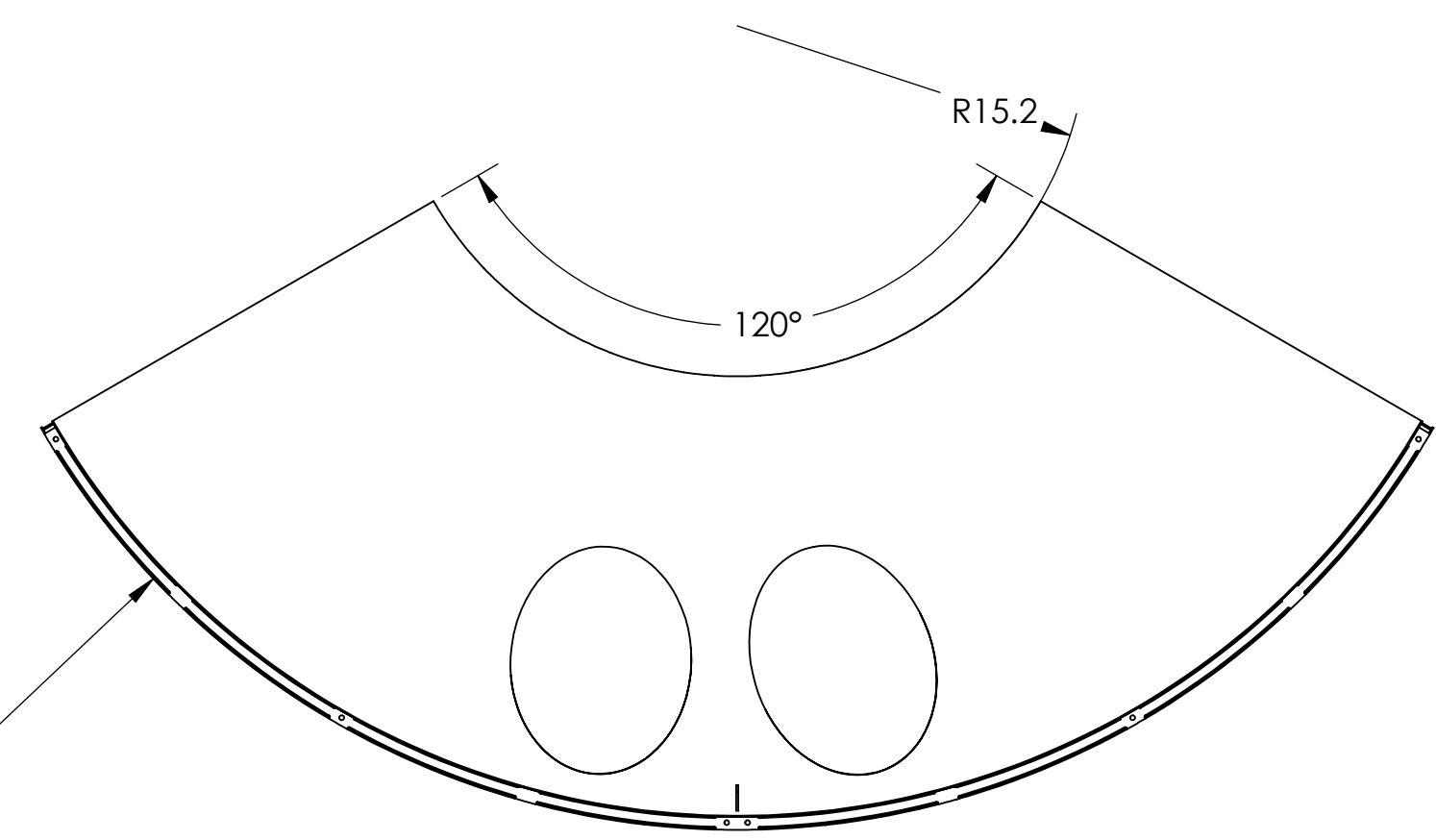
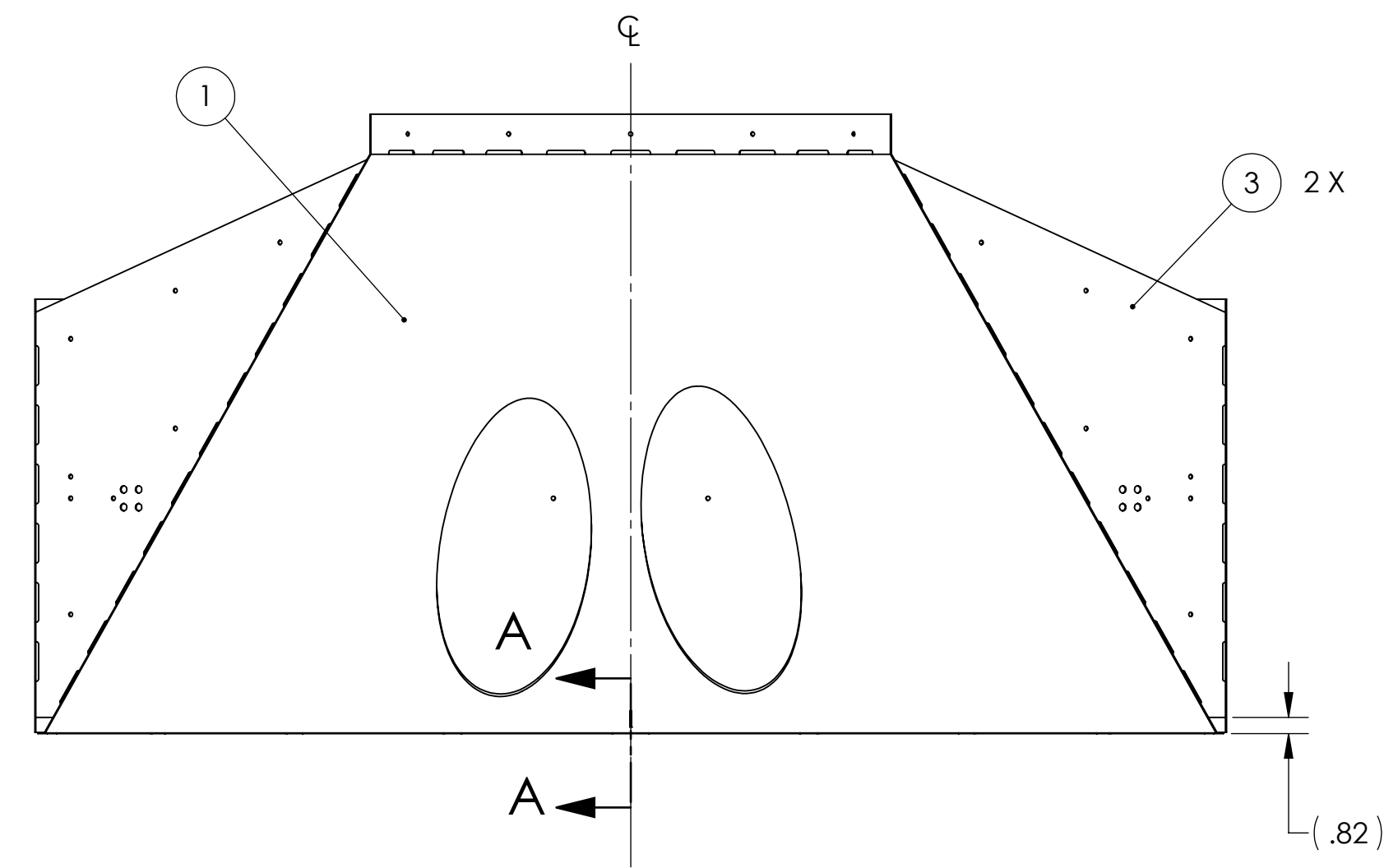
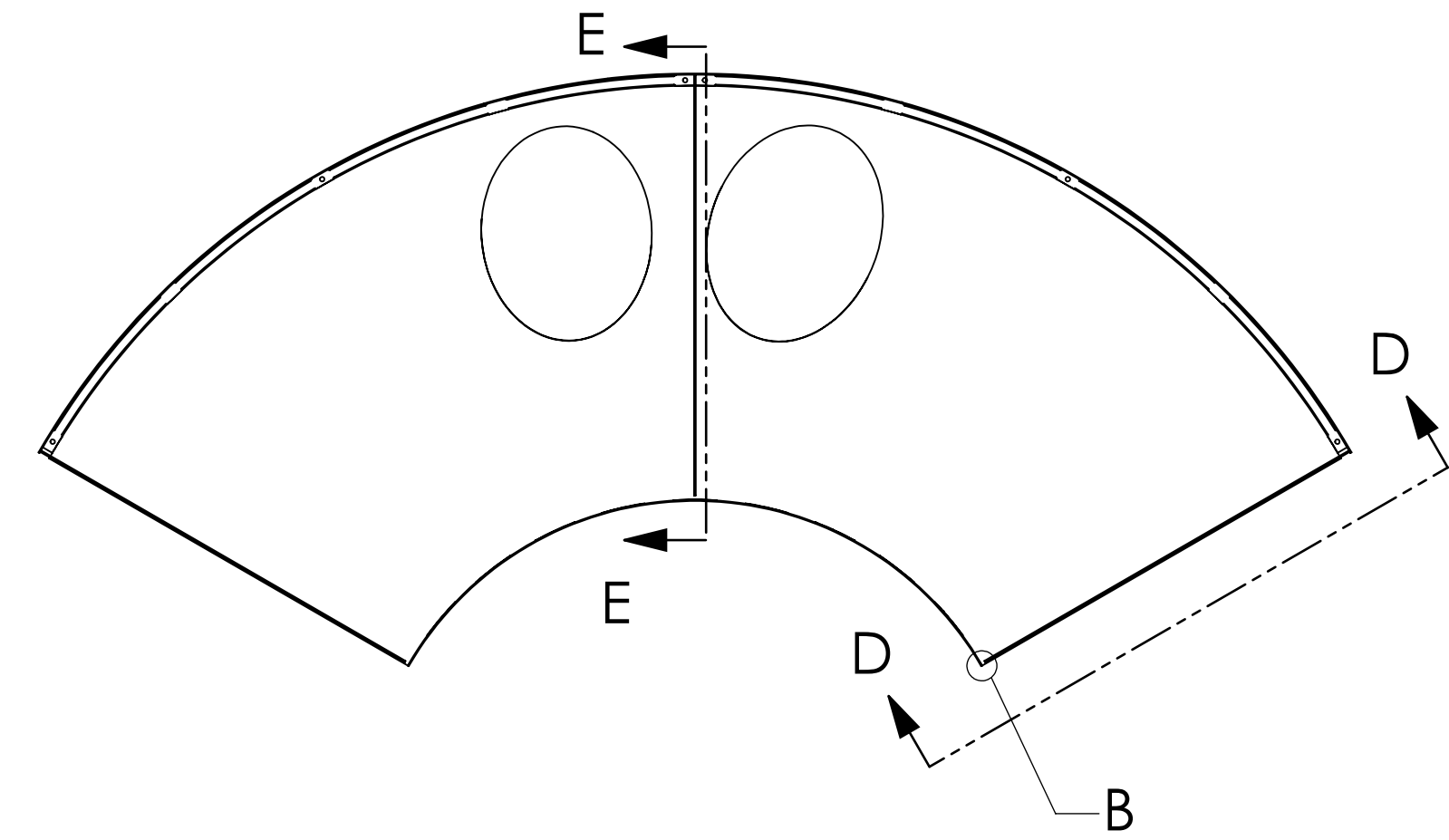


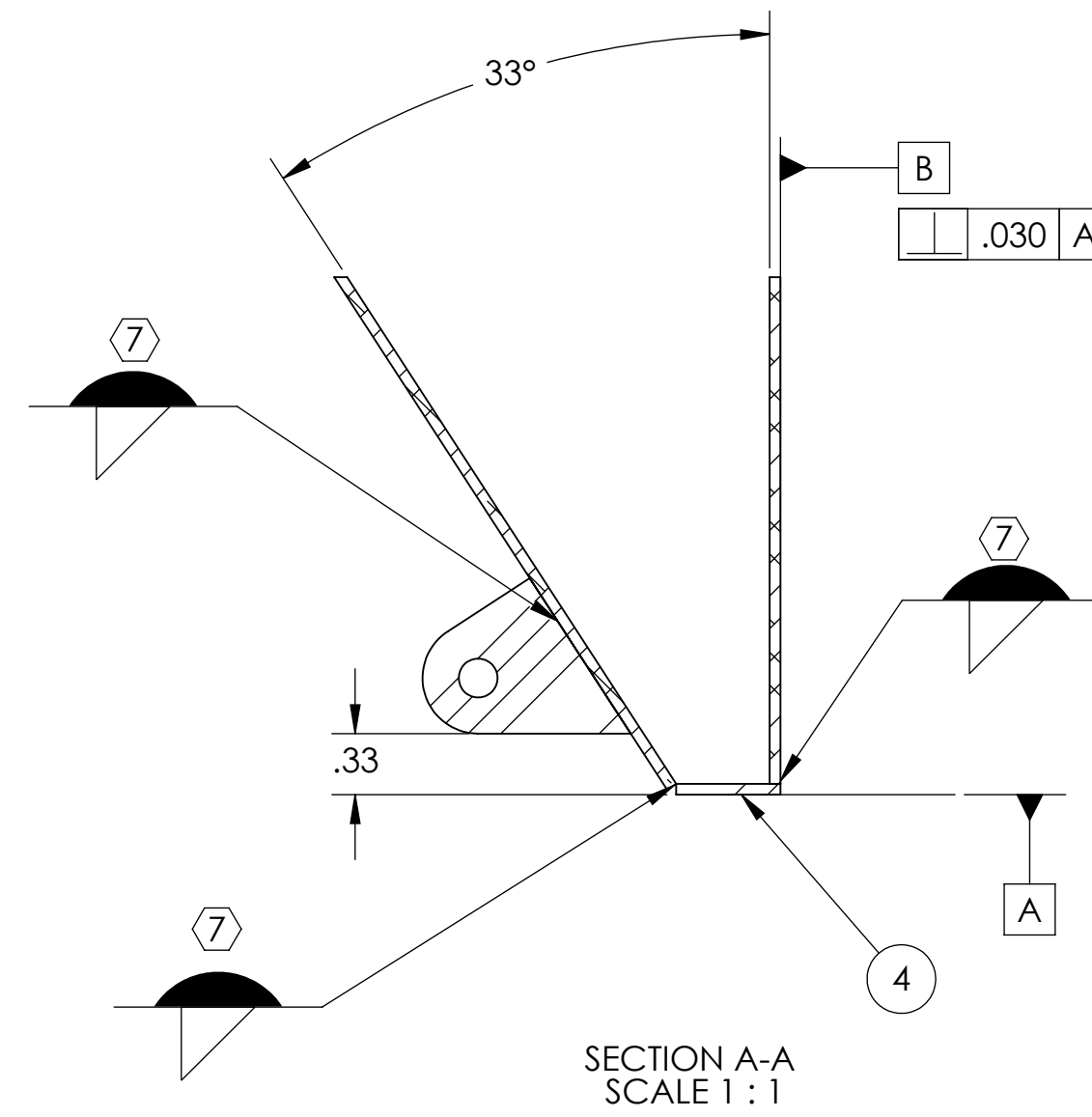
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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

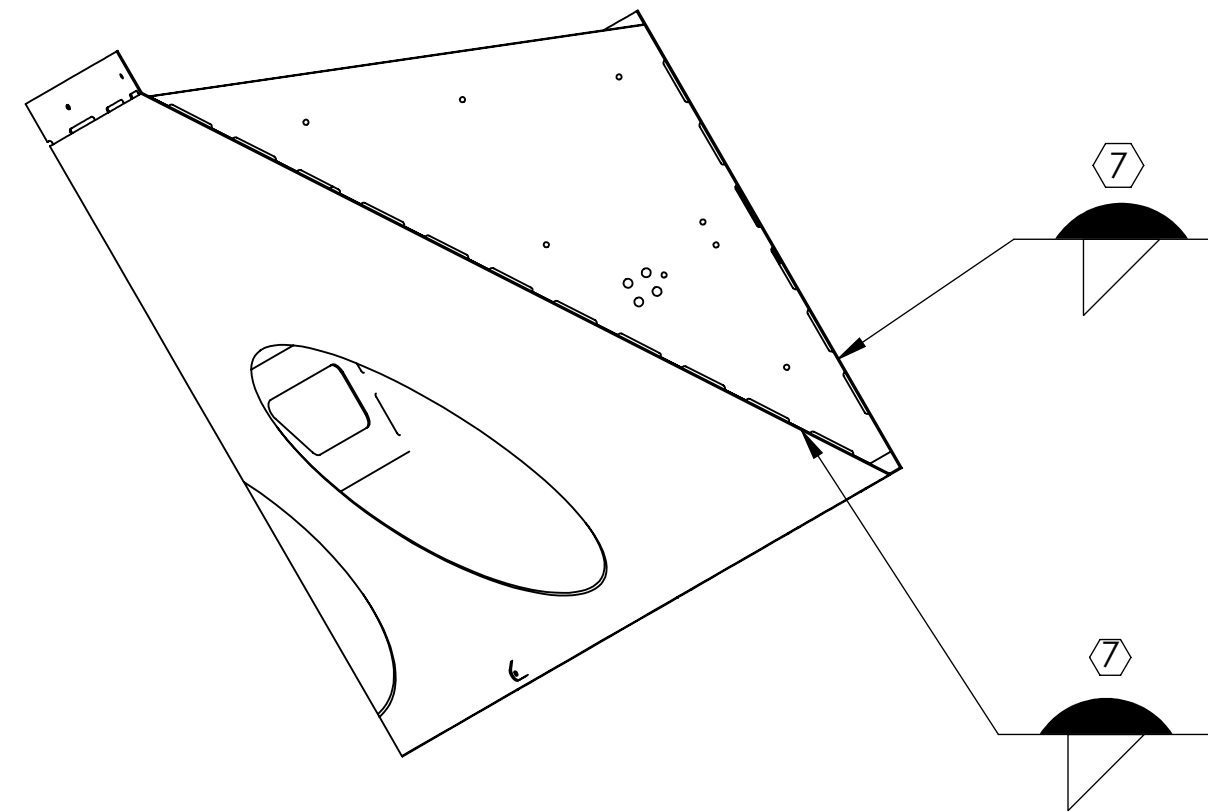
7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, 2 & 3, 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



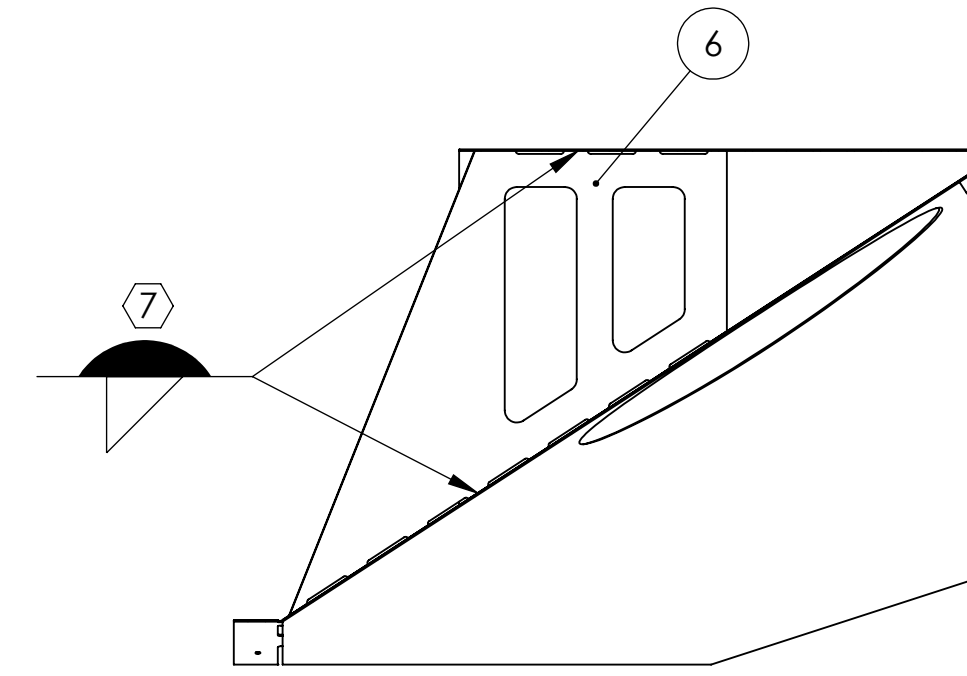
DETAIL B
SCALE 4 : 1



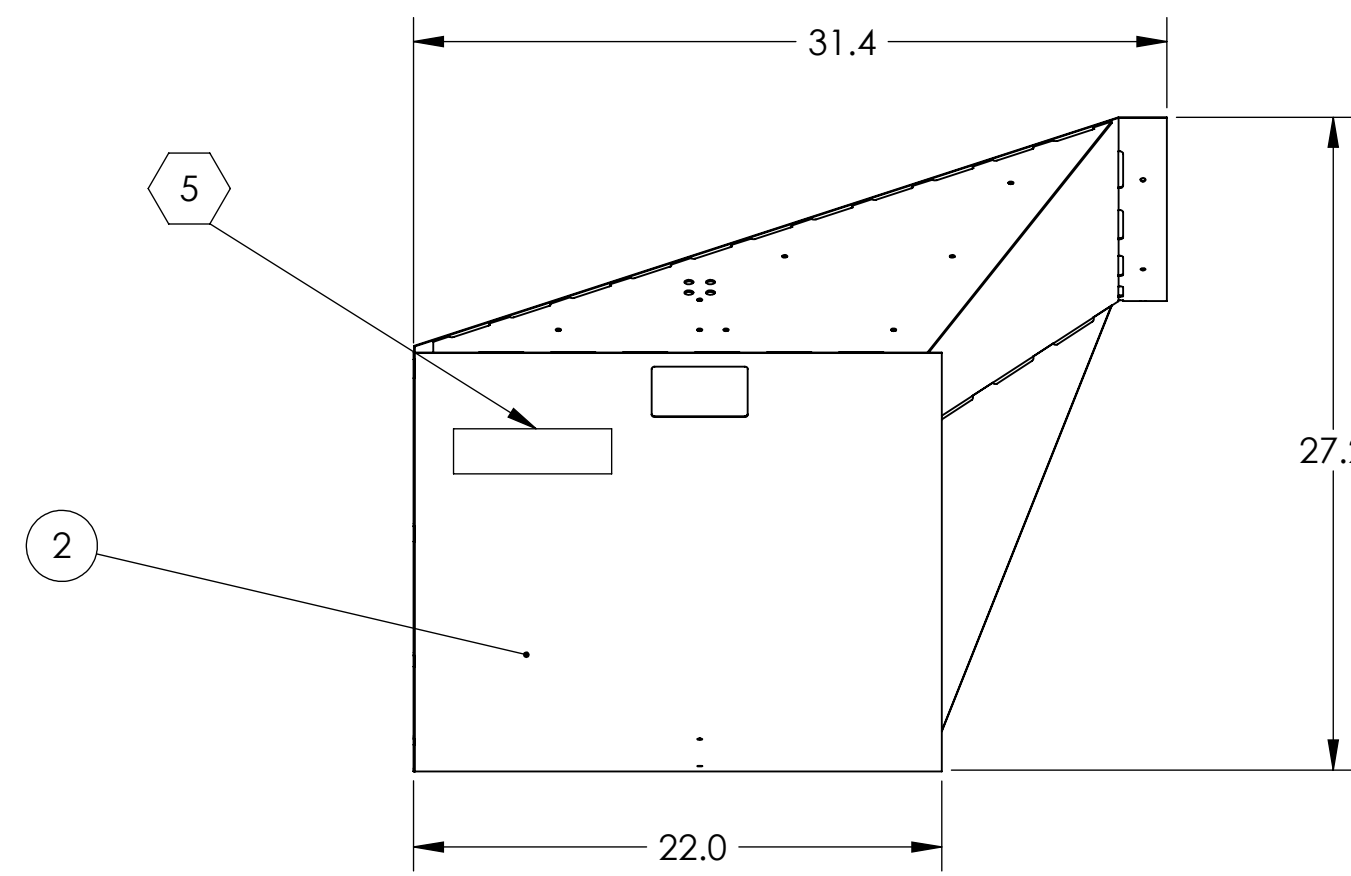
SECTION A-A
SCALE 1 : 1



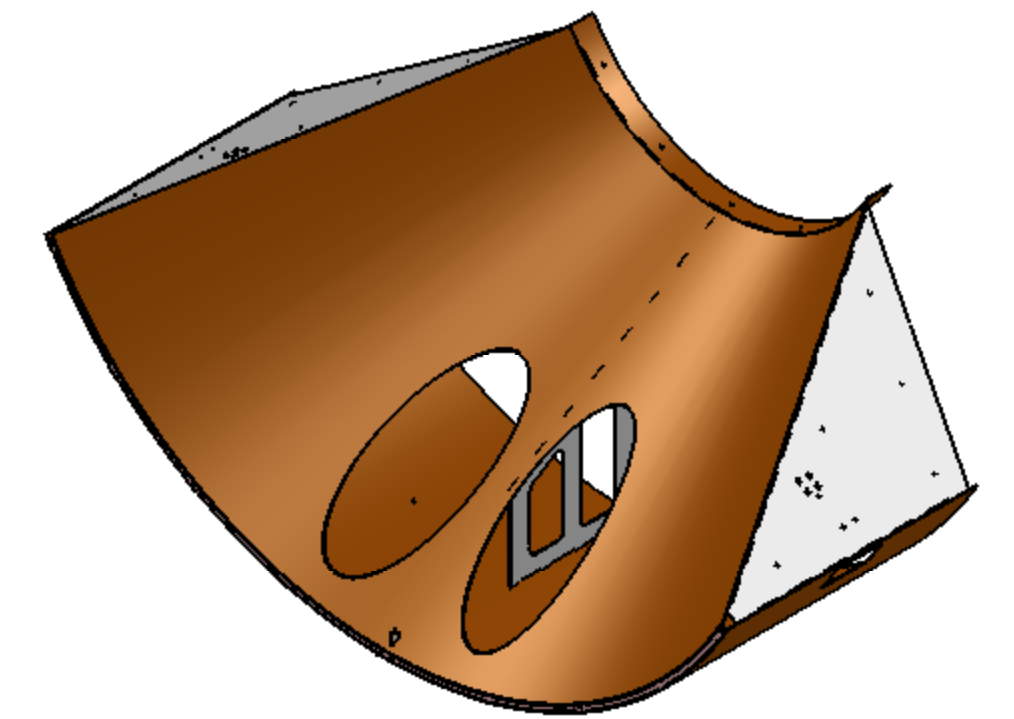
SECTION D-D



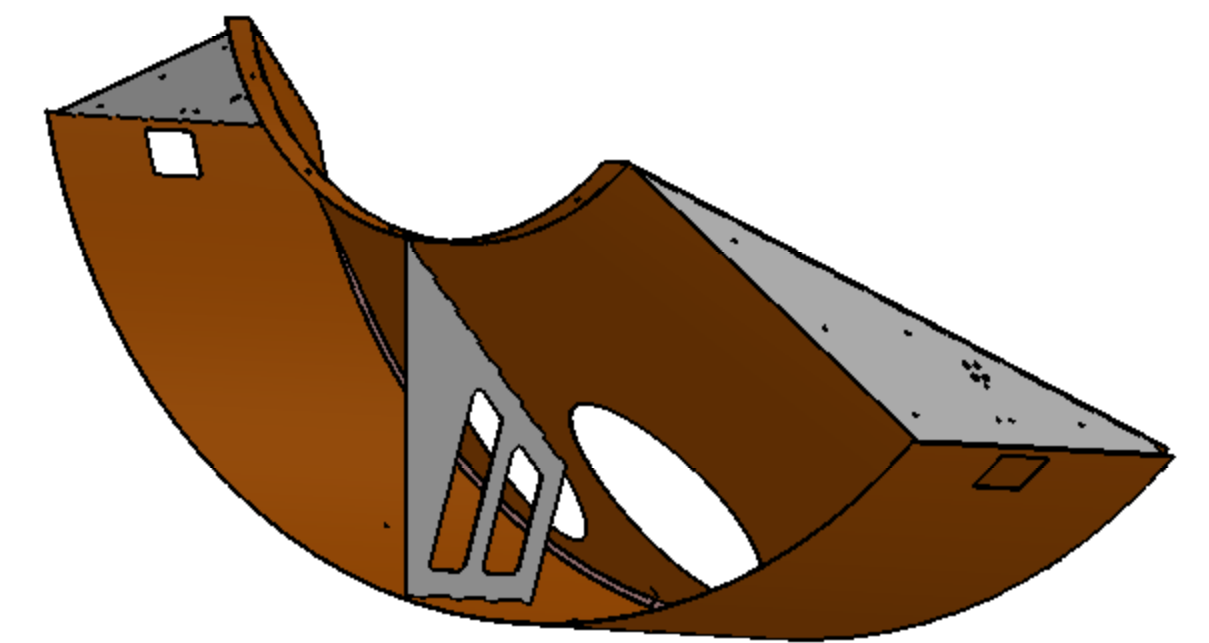
SECTION E-E



REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUL 2011	E1000360-v2	-
-	-	-	-
-	-	-	-



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18GA A424 TYPE I STEEL	1		1
1	D1003230	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMY H1, BOTTOM	18GA A424 TYPE I STEEL	1		1

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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES:	
.X ± .1	
.XX ± .06	
.XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	A424 TYPE I STEEL
FINISH	N/A

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

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

NEXT ASSY: **D1003227**

PART NAME: **MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMY H1, BOTTOM**

DESIGNER: TQ, NGUYEN 16 DEC 2010
 DRAFTER: TQ, NGUYEN 29 JUL 2011
 CHECKER: M. SMITH
 APPROVAL: D. COYNE

SIZE: **D** DWG. NO.: **D1003229** REV.: **v1**

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

D1003229.dwg_Monolithic_Cryo_Baffle_Segment_Subassembly_Weldment_ETMY_H1_Bottom_PARR PDM REV: X-005 DRAWING PDM REV: X-001