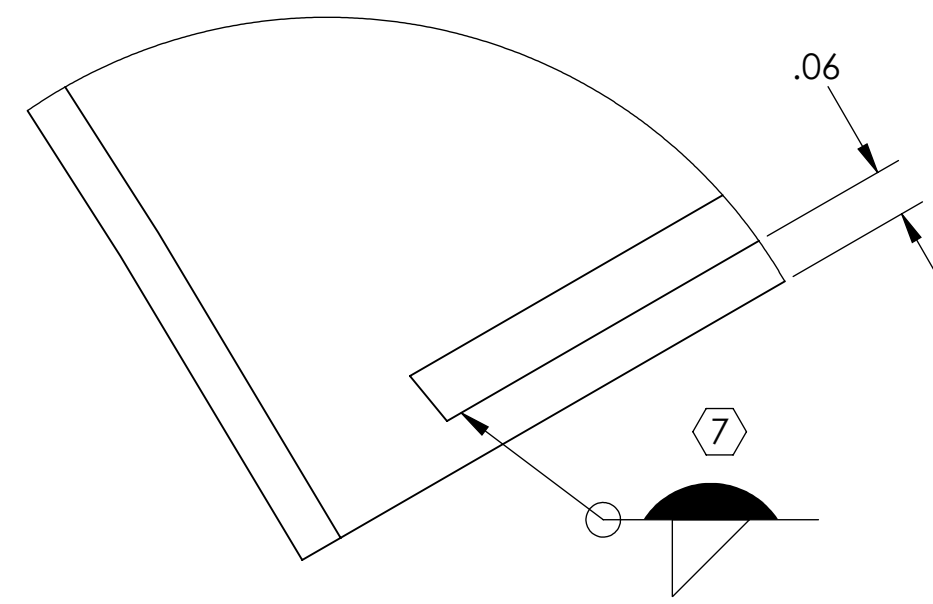
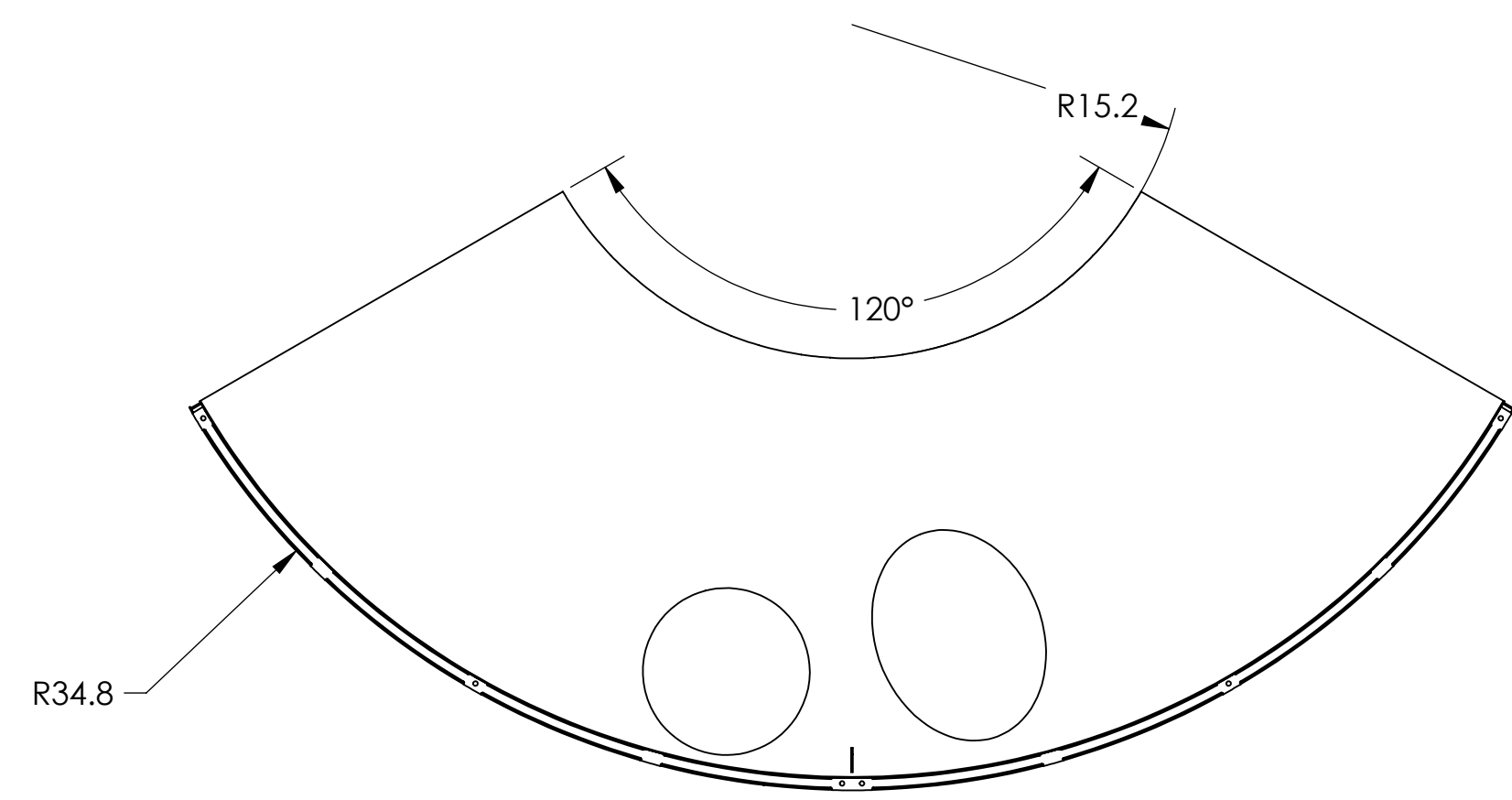
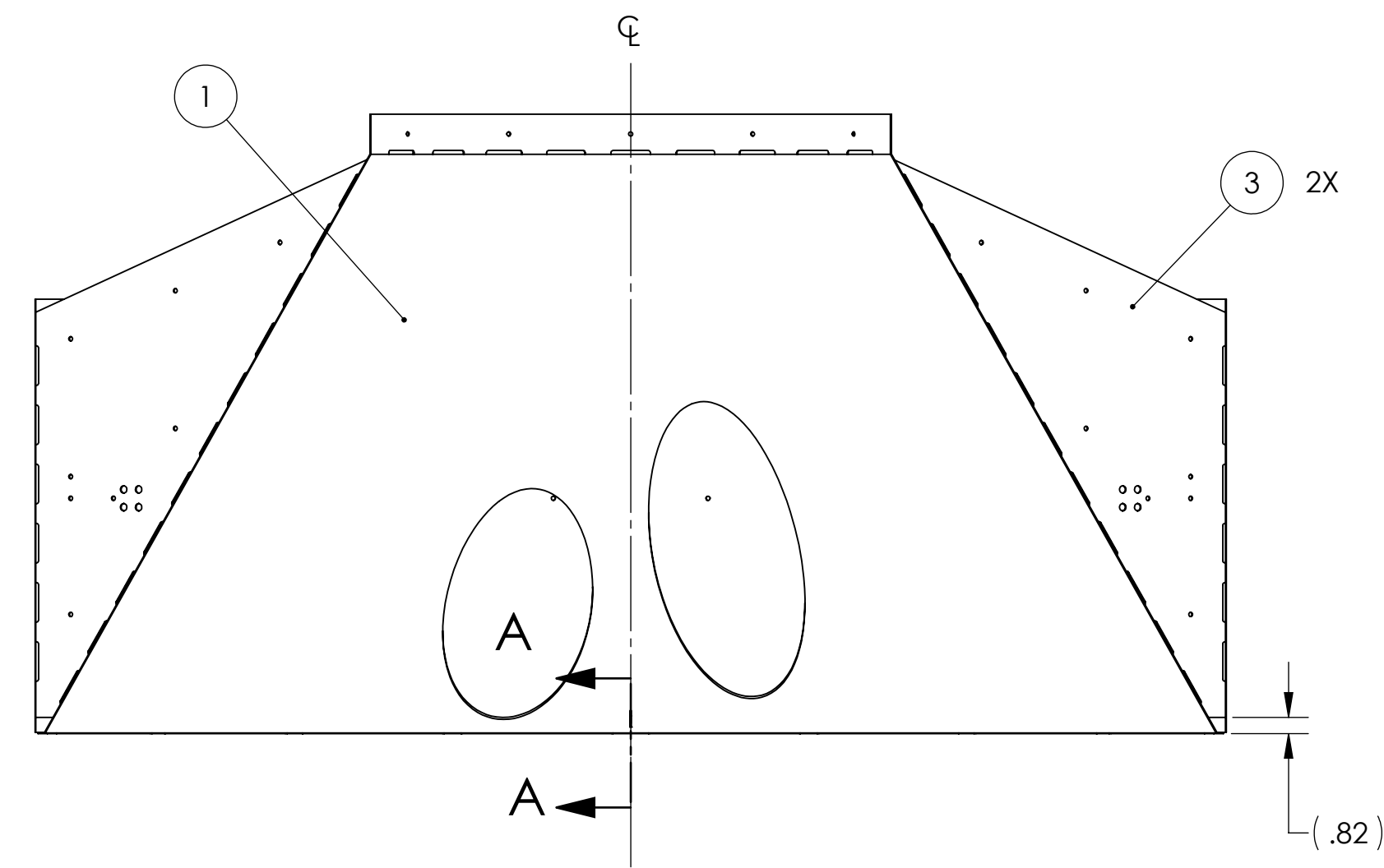
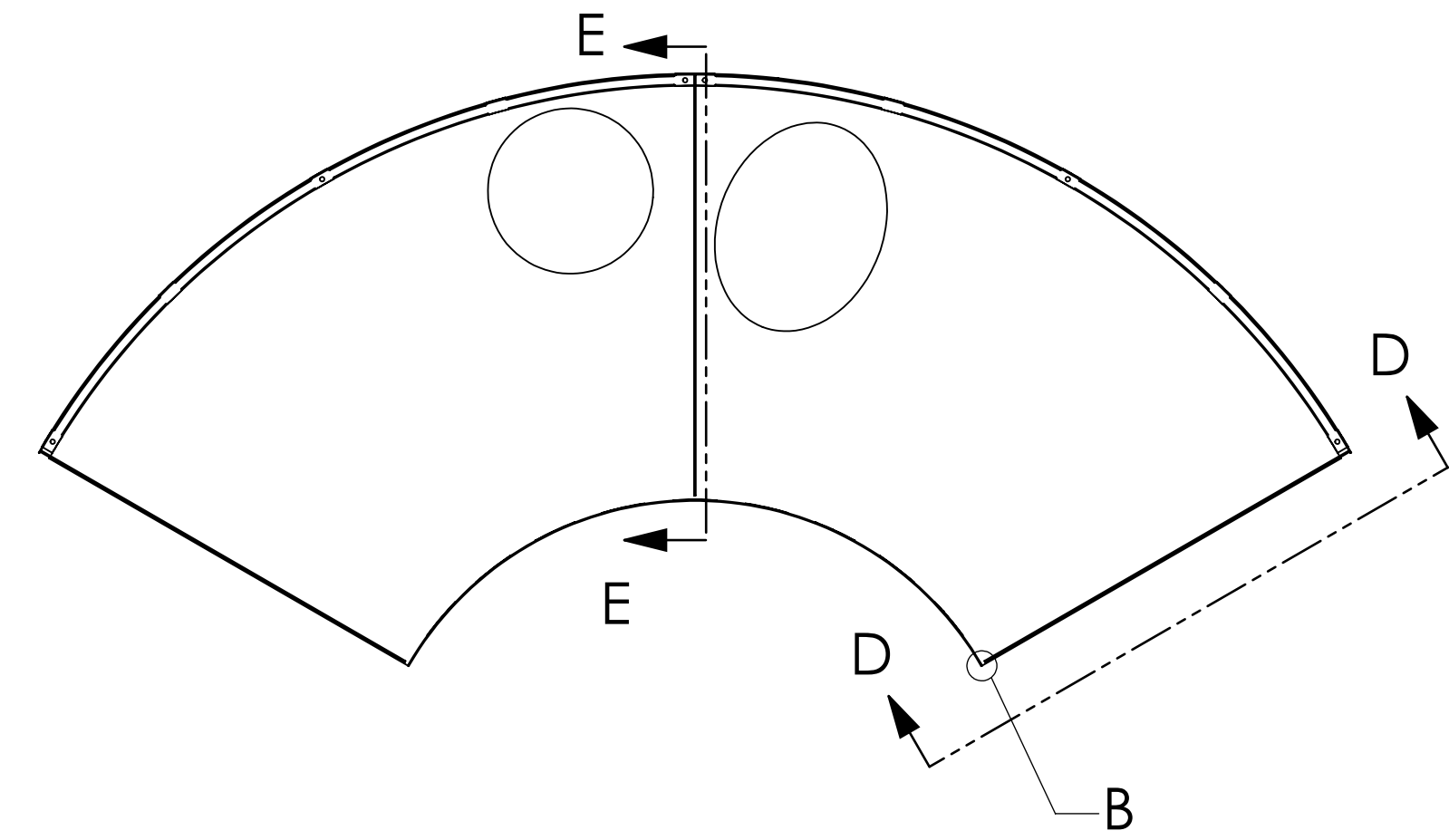


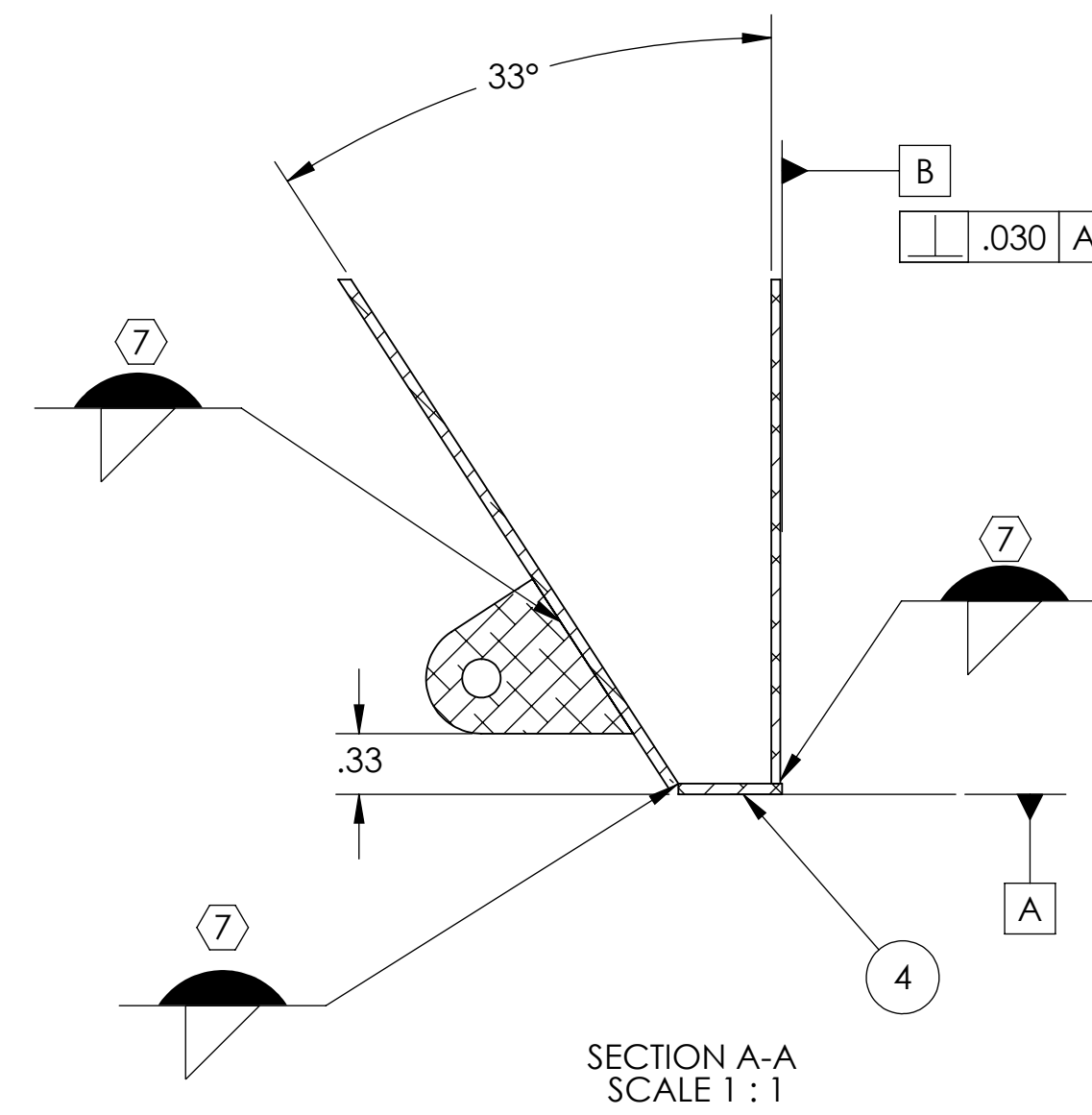
NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), DO NOT STAMP OR LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR 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.

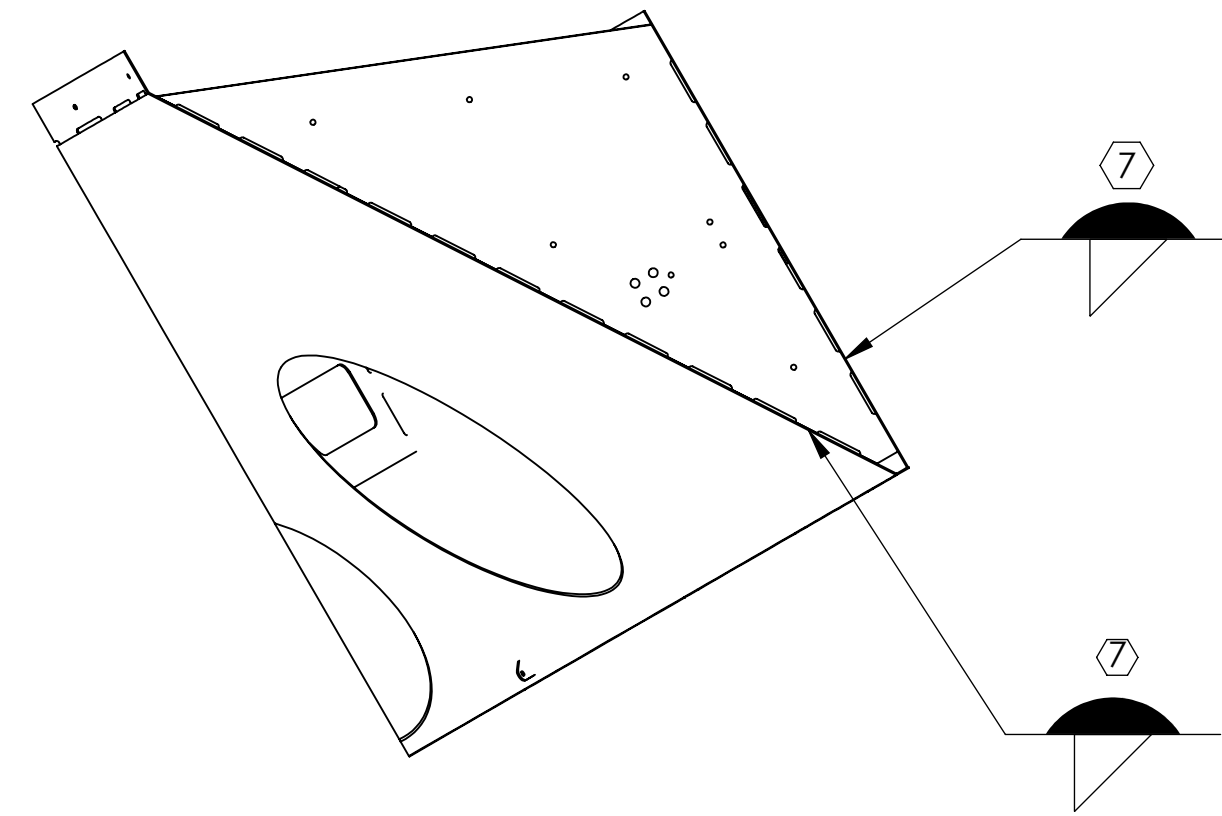
7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, 2 & 3, 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



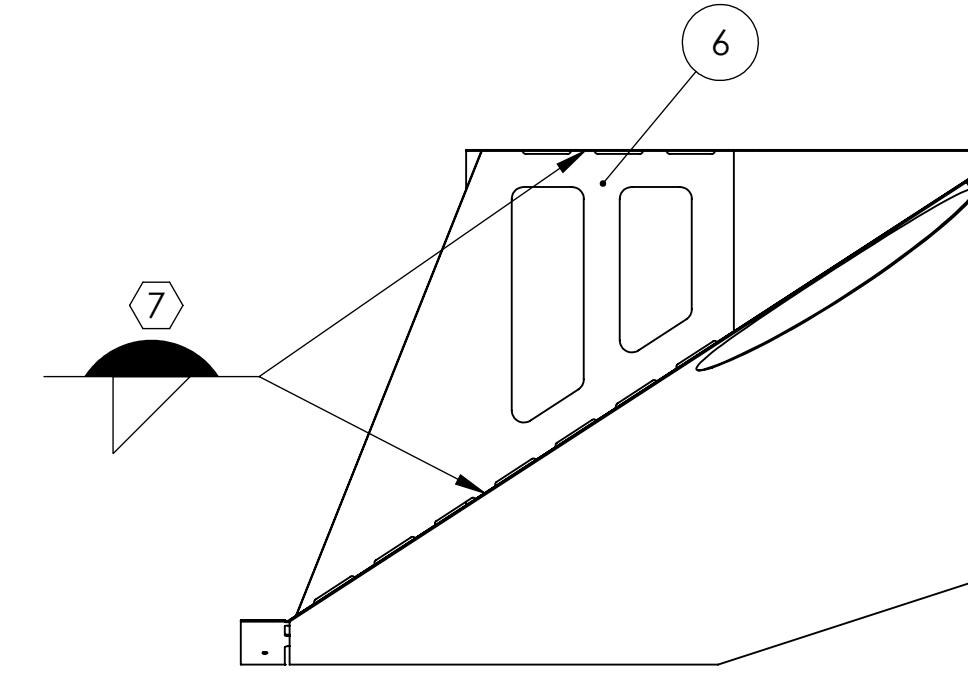
DETAIL B  
SCALE 4 : 1



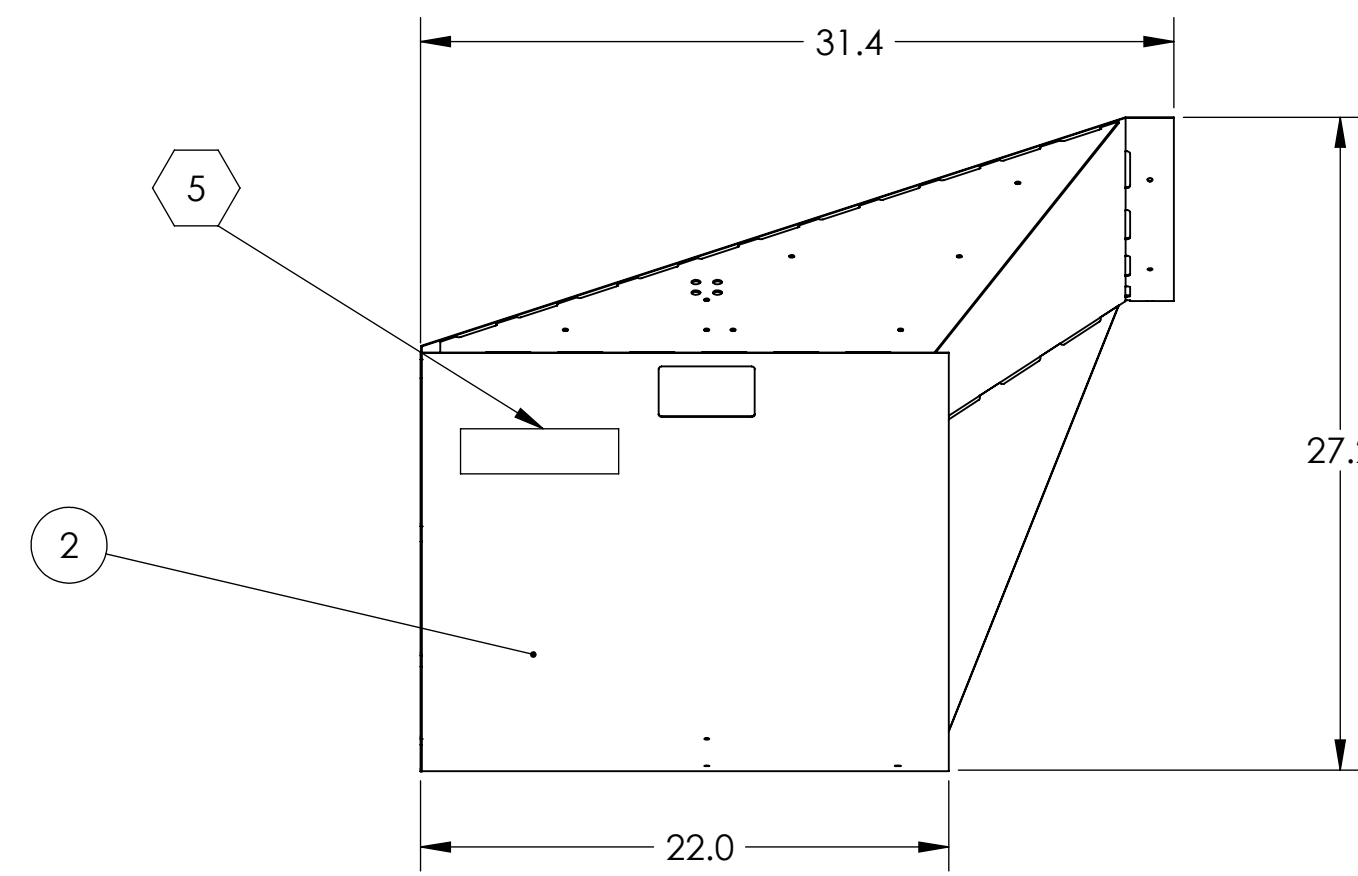
SECTION A-A  
SCALE 1 : 1



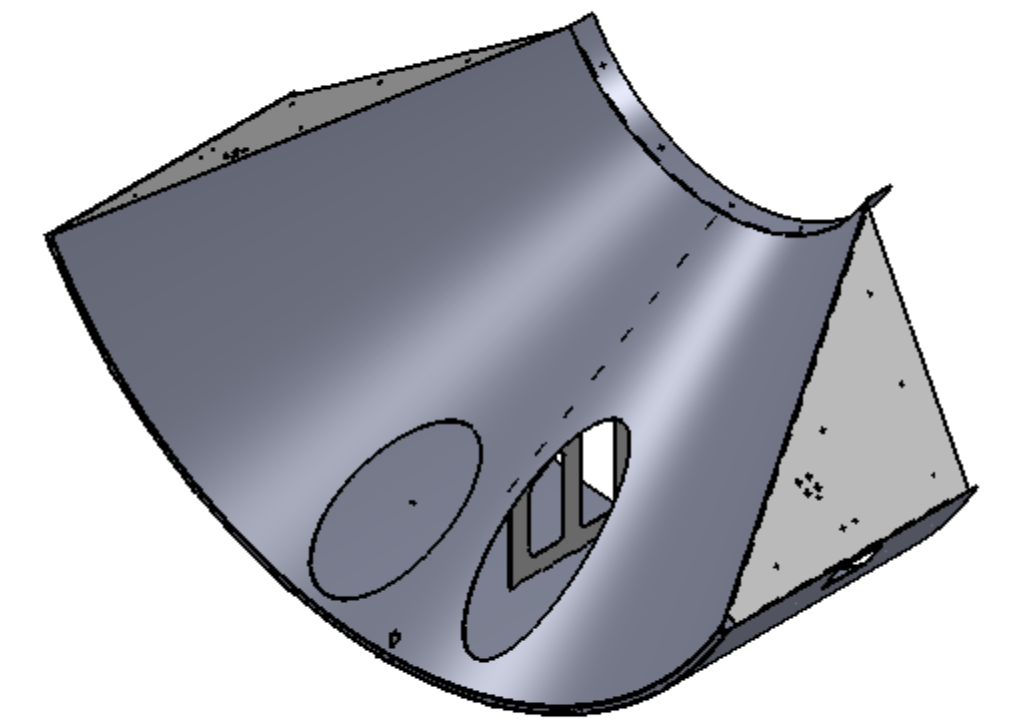
SECTION D-D



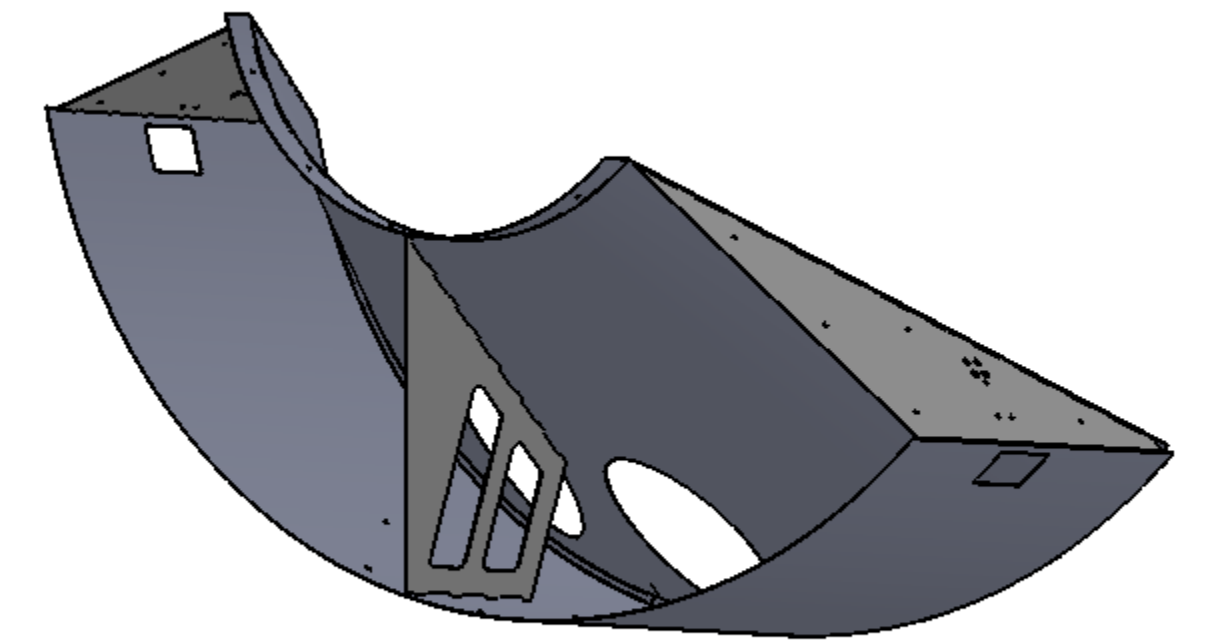
SECTION E-E



REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUL 2011	E1000360-v2	-
v2	17 OCT 2011	E1000360-v3	-
-	-	-	-



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSSL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18 GAUGE 304 SSSL	1		1
1	D1003230	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMY H1, BOTTOM	18 GAUGE 304 SSSL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D1003227

PART NAME		MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ETMY H1, BOTTOM	
DESIGNER	TQ. NGUYEN	16 DEC 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	29 JUL 2011	D
CHECKER	M. SMITH		D1003229
APPROVAL	D. COYNE		REV. v2
SCALE: 1:8		PROJECTION:	SHEET 1 OF 1

D1003229\_dLIGO\_Manifold\_Cryo\_Baffle\_Segment\_Subassembly\_Weldment\_ETMY\_H1\_Bottom\_PARRPDM\_REV-K013\_DRAWING\_PDM\_REV-X003