



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 CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELD MUST BE PER SPECIFICATION E900048.

⑦ SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

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.

REV.	DATE	DCN #	DRAWING TREE #
V1	1 SEP 2010	E1000360	E1000091
V2	17 OCT 2011	E1000360-v3	-
v4	22 FEB 2013	-	-

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	
TOLERANCES: .XX ± .03 .XXX ± .010	
ANGULAR ±0.5°	
MATERIAL	FINISH
18 GAUGE 304 SSSL	⑦ SUPER #8

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D1003231	

PART NAME				MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ETMY H1, RIGHT			
DESIGNER	TQ. NGUYEN	16 DEC 2010	SIZE	DWG. NO.	REV.		
DRAFTER	TQ. NGUYEN	17 AUG 2010	D	D1003232	v4		
CHECKER	M. SMITH		SCALE: 1:8	PROJECTION:	SHEET 1 OF 1		
APPROVAL	D. COYNE						