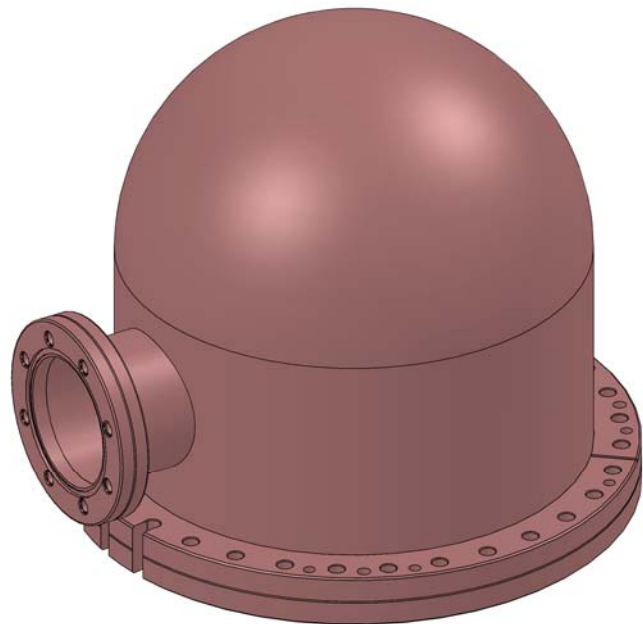
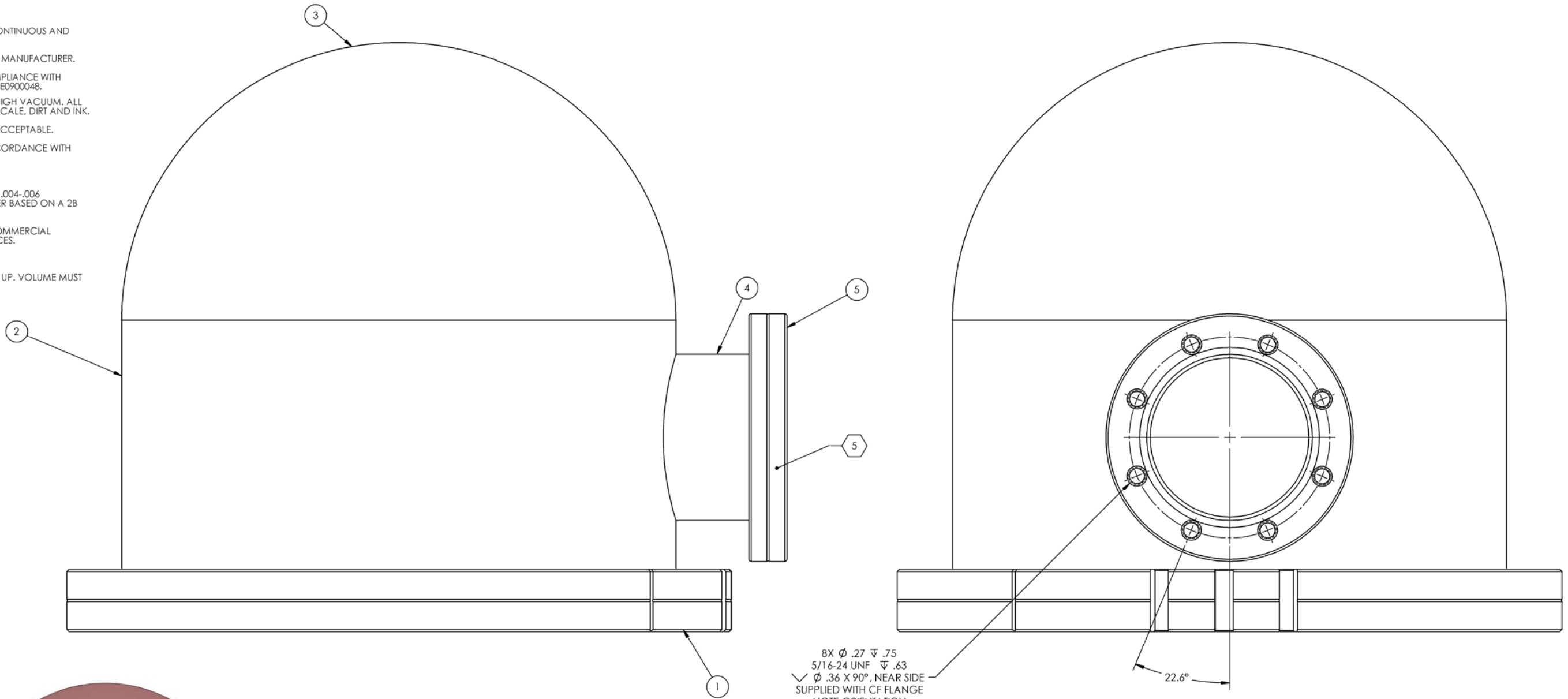


REV.	DATE	DCN #	DRAWING TREE #
v1	26 JAN 2010	E0900443-X0	E1000025
v2	22 MAR 2010	E0900443-V1	E1000025
v3	29 APR 2010	E1000146-V1	E1000025

NOTES CONTINUED:

- ② SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- ⚠ WELDS TO BE EXTERNAL FUSION GTAW UHV CONTINUOUS AND FULL PENETRATION.
- ⚠ JOINT CONFIGURATION TO BE DETERMINED BY MANUFACTURER.
- ⚠ ALL WELDMENTS MUST BE FABRICATED IN COMPLIANCE WITH SPECIFICATIONS DEFINED IN LIGO DOCUMENT E0900048.
- 9. EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF: WELD RESIDUE, SCALE, DIRT AND INK.
- 10. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
- 11. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 12. APPROXIMATE WEIGHT = 23LB.
- 13. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
- 14. ELECTROPOLISH AFTER WELDING PER BEST COMMERCIAL PRACTICE. MASK CF FLANGE GASKET SURFACES.
- ⚠ PULL PORT CAN BE USED
- ⚠ TACK WELD CAN BE USED IF NEEDED FOR SET UP. VOLUME MUST VENT TO INSIDE.



8X Ø .27 ± .005
 5/16-24 UNF ± .005
 ✓ Ø .36 X 90°, NEAR SIDE
 SUPPLIED WITH CF FLANGE
 NOTE ORIENTATION

22.6°

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
5	Nor-Cal_450-250NT	Nor-Cal CF Flange 4.5"n Nom. OD or Equiv. Modified as Noted	304 SSSL	1
4	Nor-Cal_SST-300	Nor-Cal 3" OD Tubing Modified or Equiv.	304 SSSL	1
3	Nor-Cal_R-HS-00010D	Nor-Cal 10" OD Dome or Equiv.	304 SSSL	1
2	Nor-Cal_SST-1000	Nor-Cal 10" OD Tubing Cut to Length or Equiv.	304 SSSL	1
1	Nor-Cal_1200-1000NT	NOR-CAL CF FLANGE 12" NOM. OD OR MACHINED TO SAME DIMENSIONS AND TOLERANCES	304 SSSL	1

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .010 .XXX ± .005 ANGULAR ± 0.1°		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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME TRILLIUM 240 POD TOP HAT	
MATERIAL 304 SSSL		FINISH 63 μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
NEXT ASSY D0900648		DESIGNER S. BARNUM 2 Dec. 2009		SIZE D		DWG. NO. D0900649	
CHECKER F.MATICHARD 26 Jan 2010		APPROVAL K.MASON 26 Jan 2010		SCALE: 1:1		PROJECTION:	
				SHEET 1 OF 2		REV. v3	

D0900649_Trillium_Pod_Chamber_TopHat_PART FROM REV: X.027, DRAWING FROM REV: X.012

