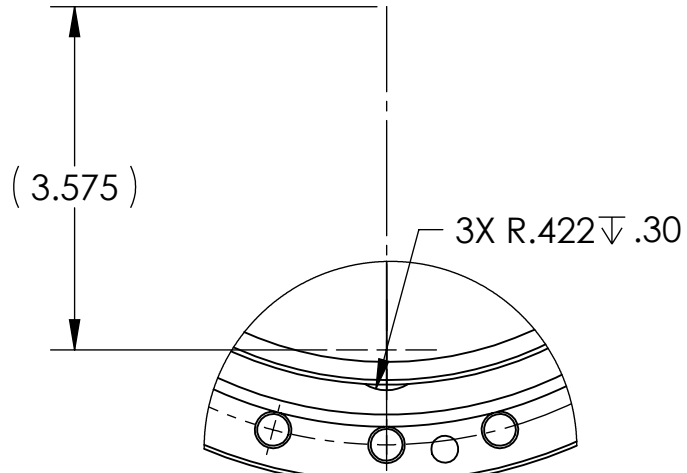
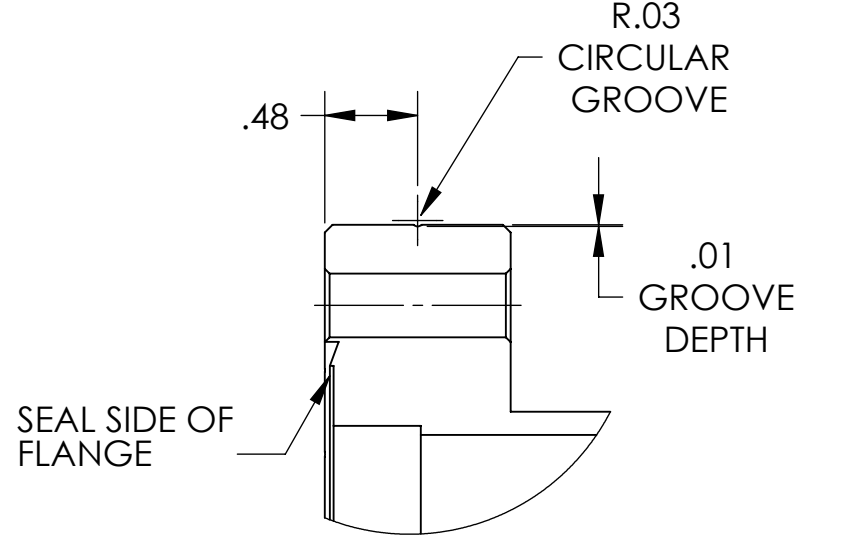


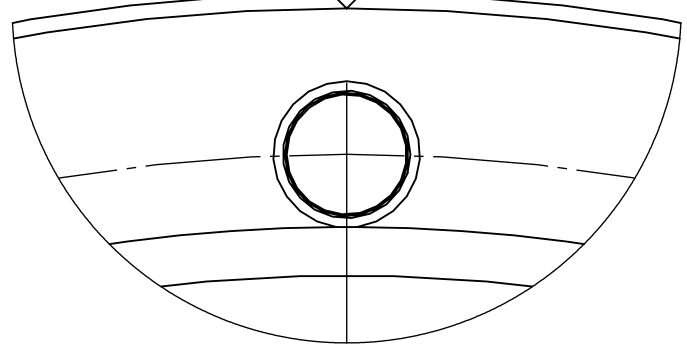
DETAIL D
SCALE 1 : 2



DETAIL B
SCALE 1 : 1



.08 WIDE ∇ .04
REF MARK FULL
THK. OF FLANGE



DETAIL E
SCALE 2 : 1

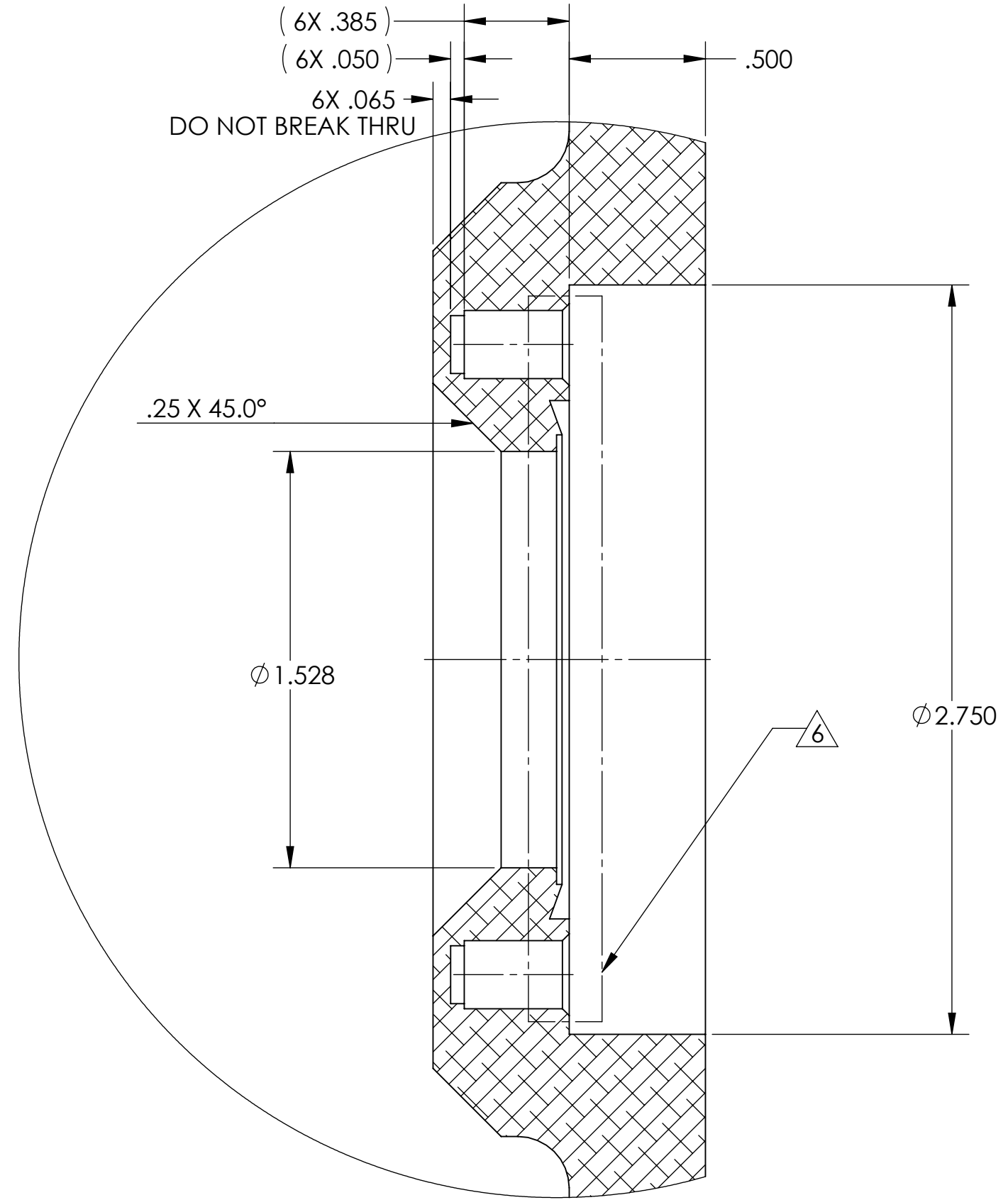
(6X .385)

(6X .050)

6X .065

DO NOT BREAK THRU

.500



DETAIL C
SCALE 2 : 1

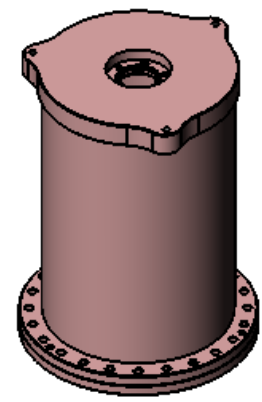
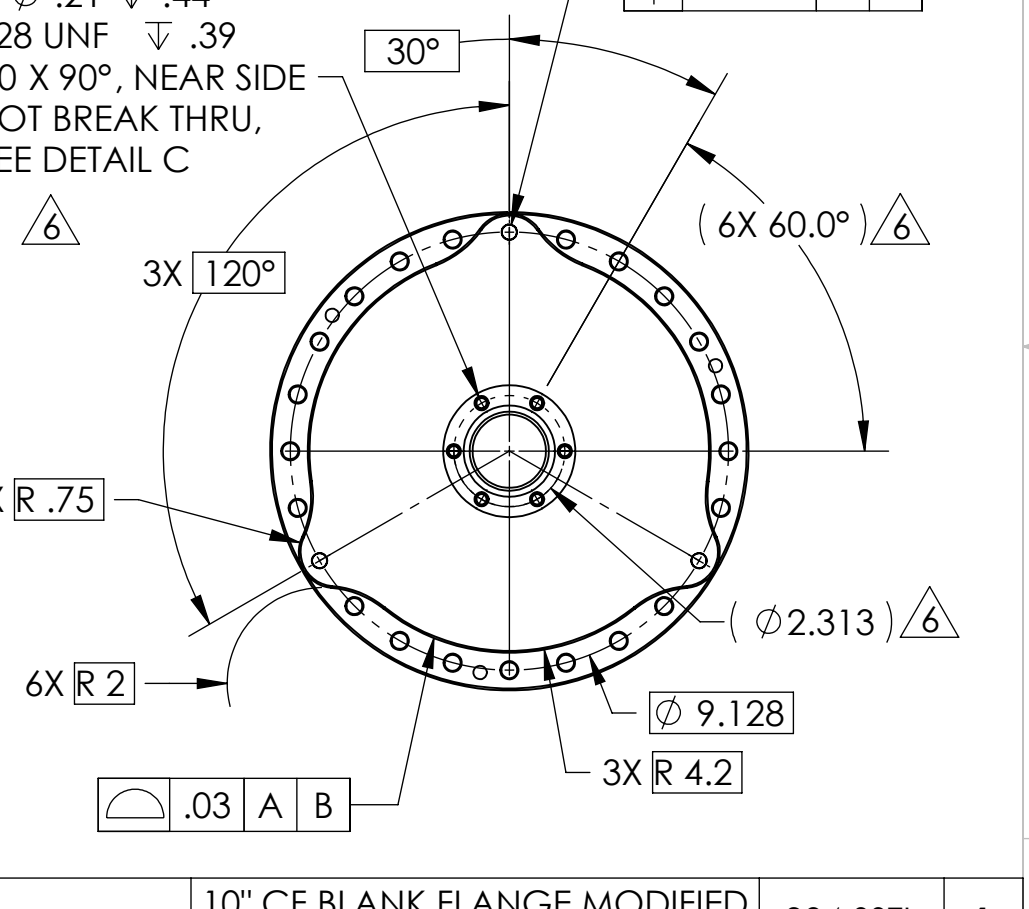
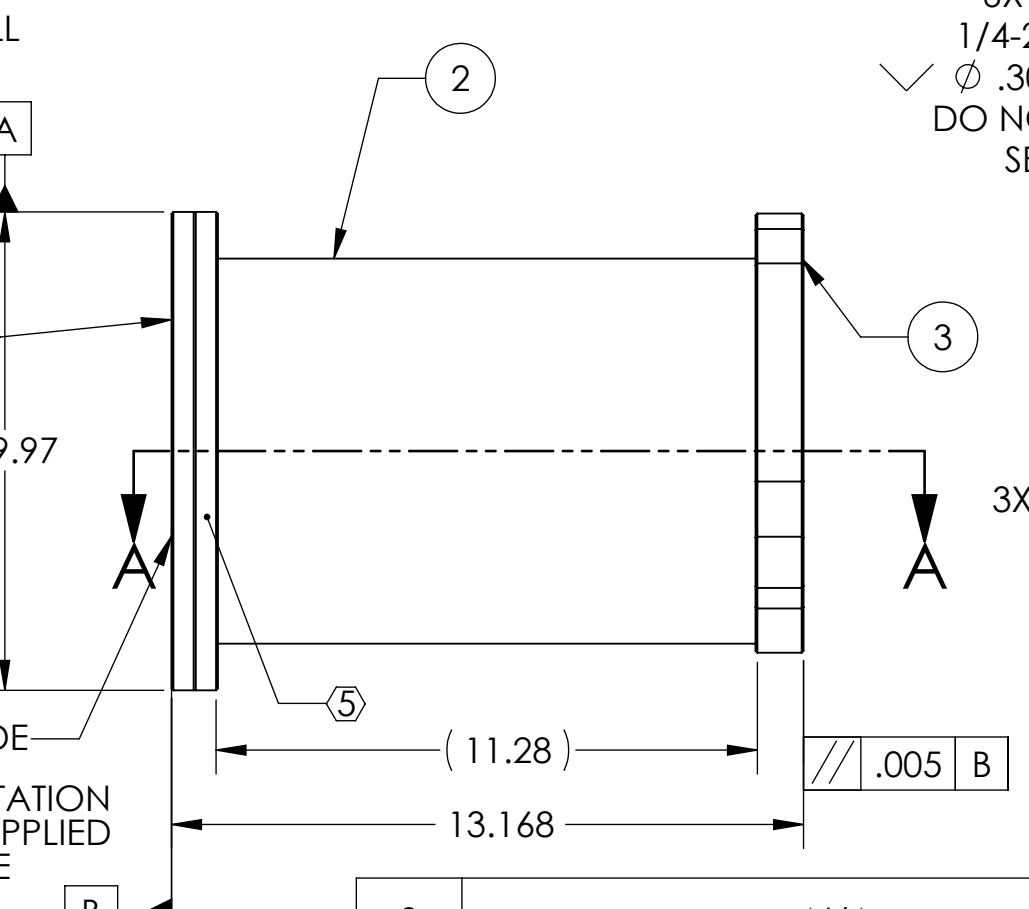
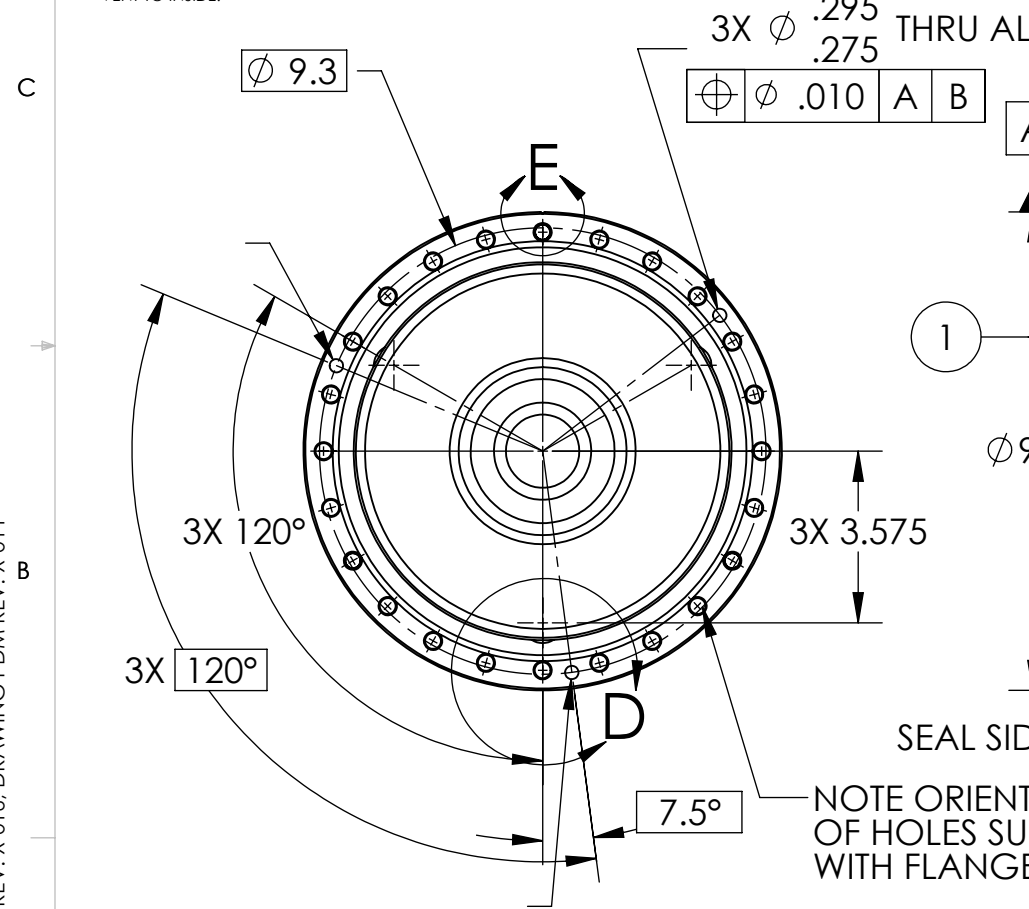
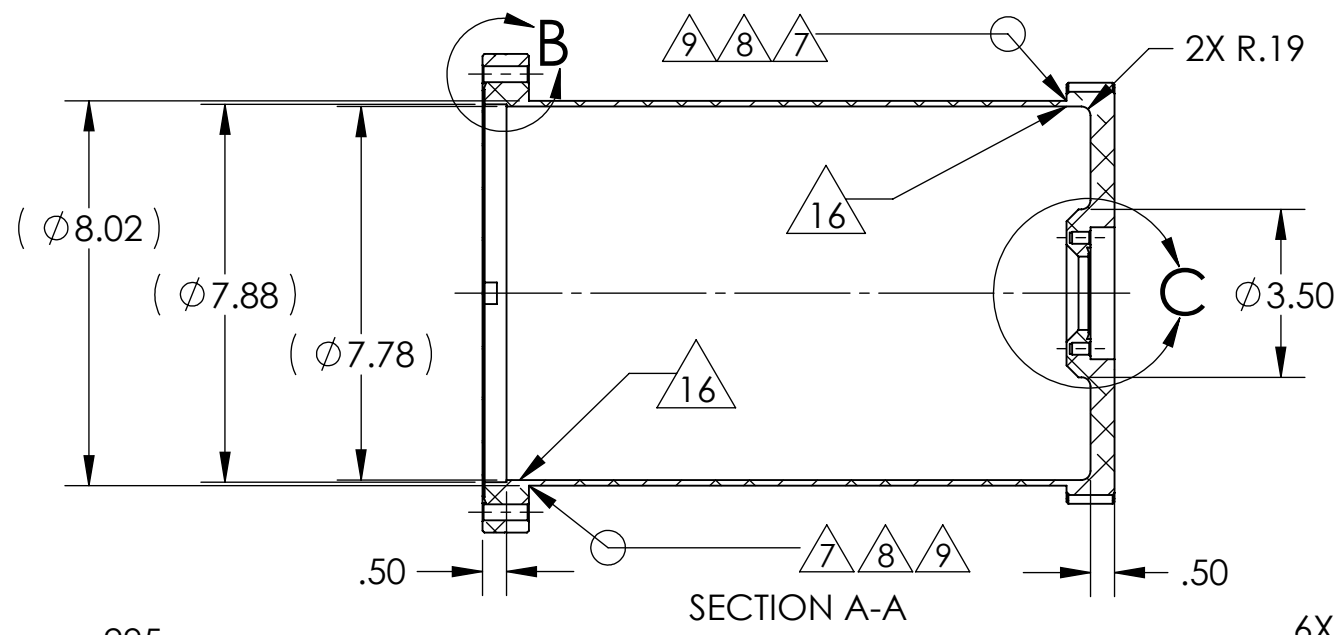
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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0900859	v4
SCALE: 1:4		PROJECTION:
		SHEET 1 OF 2

D0900859_GS-13_Pod_TopHat, PART PDM REV: X-016, DRAWING PDM REV: X-011

- NOTES CONTINUED:**
- 5. 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
 - 6. CONFIGURATION OF KNIFE EDGE GASKET RELIEF AREAS AND THEIR RELATIONSHIP TO THE SURROUNDING BOLT PATTERN AND MATING FLANGE AREA SHALL CONFORM TO A 2.75" CF FLANGE REF. NOR-CAL 275-150N.
 - 7. WELDS TO BE CONTINUOUS EXTERNAL FUSION GTAW FOR UHV. ALSO, FULL PENETRATION IF: TUBING TO TUBING, OR TUBING TO THIN WALL.
 - 8. JOINT CONFIGURATION TO BE DETERMINED BY VENDOR.
 - 9. ALL WELDMENTS MUST BE FABRICATED IN COMPLIANCE WITH SPECIFICATIONS DEFINED IN LIGO DOCUMENT E0900048.
 - 10. EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF: WELD RESIDUE, SCALE, DIRT AND INK.
 - 11. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
 - 12. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 13. APPROXIMATE WEIGHT = 27.3LB.
 - 14. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
 - 15. ELECTROPOLISH AFTER WELDING PER BEST COMMERCIAL PRACTICE. MASK CF FLANGE GASKET SURFACES.
 - 16. TACK WELD CAN BE USED IF NEEDED FOR SET UP. VOLUME MUST VENT TO INSIDE.

REV.	DATE	DCN #	DRAWING TREE #
V1	4 FEB 2010	E0900444-X0	E1000025
V2	23 MAR 2010	E0900444-V1	E1000025
V3	29 APR 2010	E1000148-V1	E1000025
V4	20 MAY 2010	E1000171-V1	E1000025



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
3	N/A	10" CF BLANK FLANGE MODIFIED AS NOTED	304 SSSL	1
2	NOR-CAL SST-800 OR EQUIV.	8" OD TUBING CUT TO LENGTH	304 SSSL	1
1	NOR-CAL 1000-800NT OR MACHINED TO SAME DIMENSIONS AND TOLERANCES	10" CF FLANGE	304 SSSL	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

TOLERANCES:
 .XX ± .015
 .XXX ± .005
 ANGULAR ± 0.1°

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ADVANCED LIGO SUB-SYSTEM SEI

GS13 Pod Top Hat

DESIGNER S.BARNUM 4 FEB 2010 **SIZE DWG. NO.** B **D0900859** **REV.** v4
DRAFTER M.HILLARD 4 FEB 2010
CHECKER F.Matichard 4 FEB 2010
APPROVAL K.MASON 4 FEB 2010

MATERIAL 304 SSSL **FINISH** 63 μinch **NEXT ASSY** D0900857

SCALE: 1:4 **PROJECTION:** **SHEET 2 OF 2**