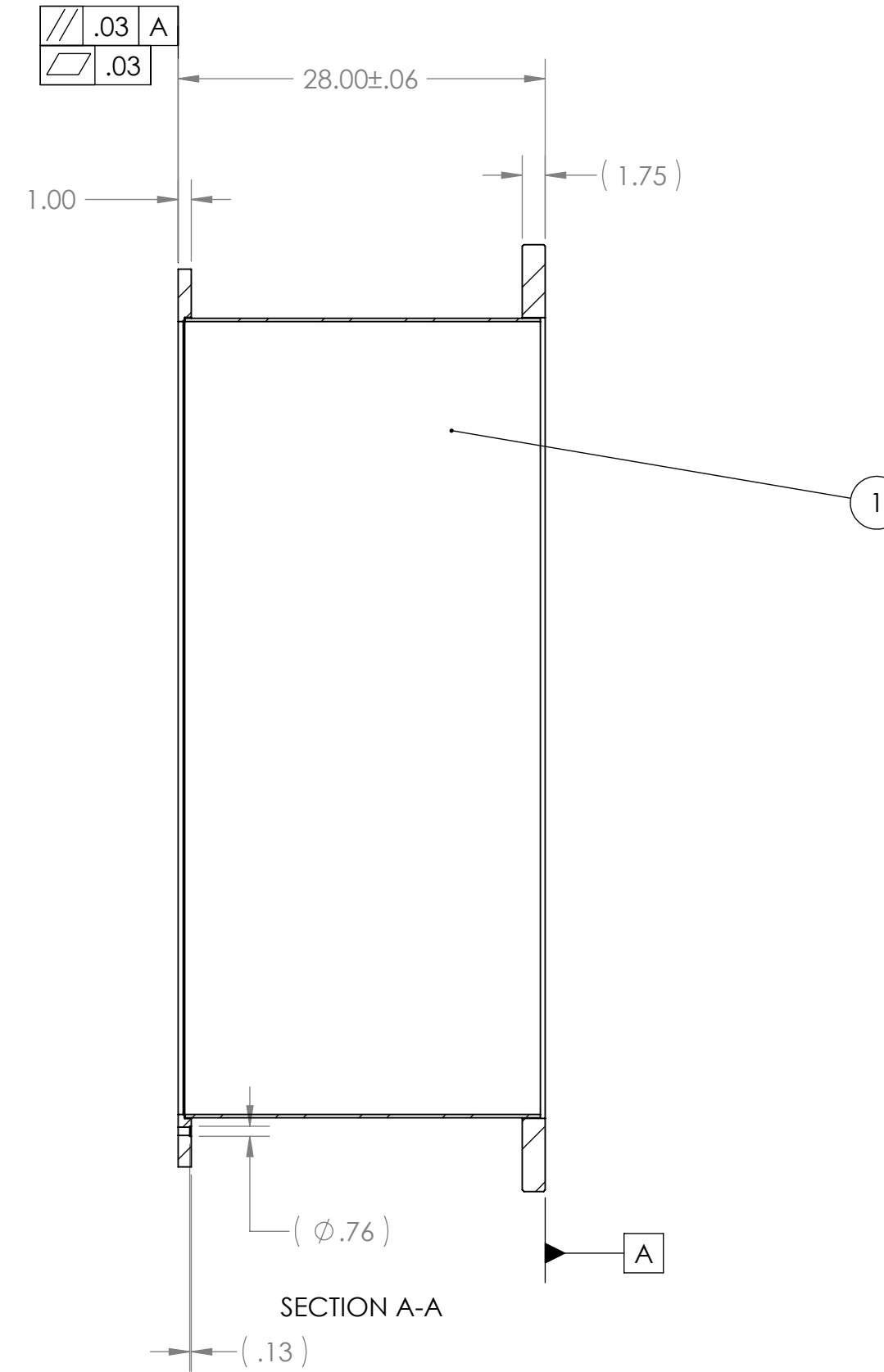
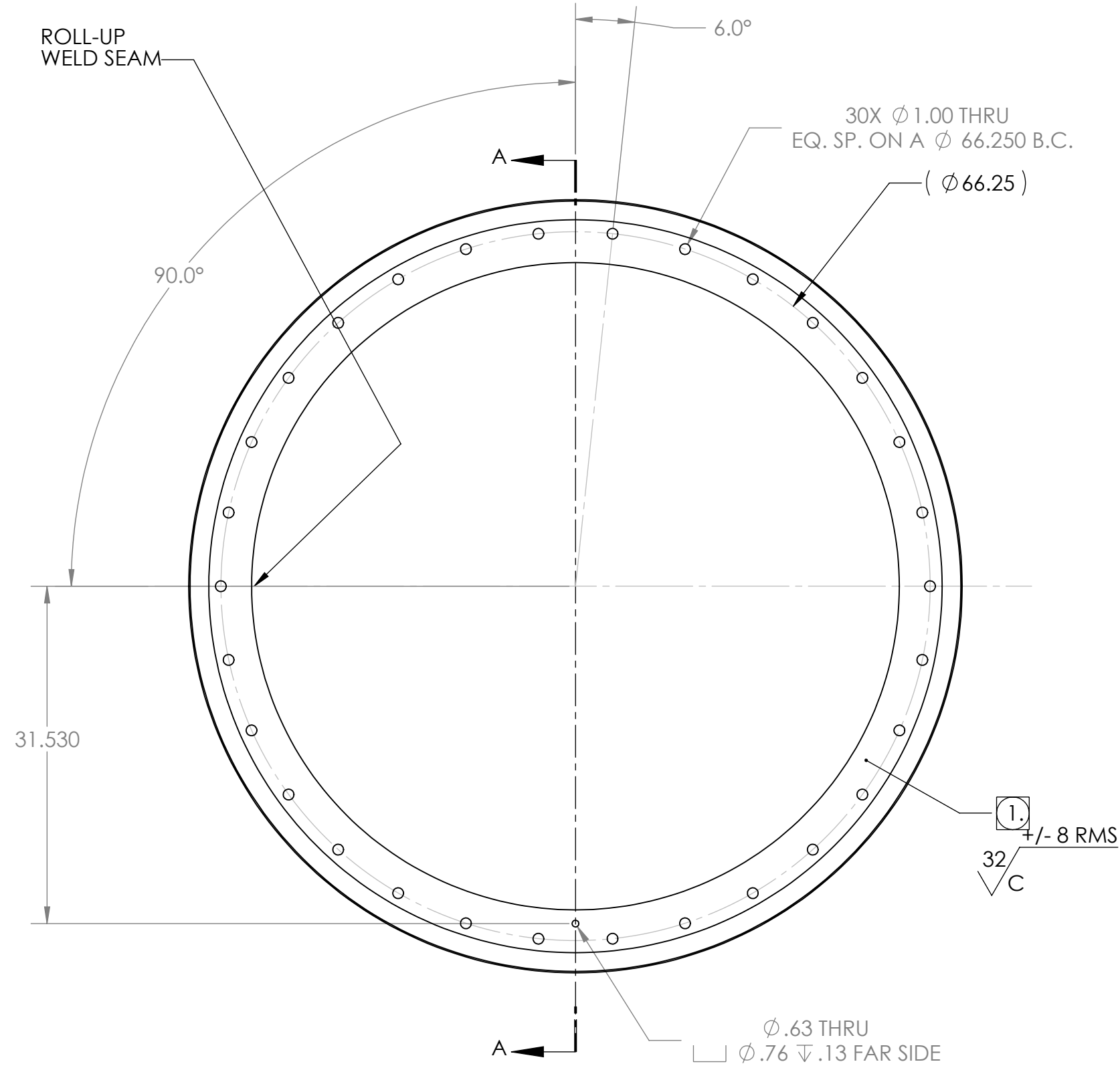


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	RELEASED TO PRODUCTION	8/23/2010	MKM2



NOTES:

1. VACUUM SEALING SURFACE
2. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
3. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - a. WATER LEACHABLE CHLORIDES: 100PPM
 - b. TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - c. TOTAL SULFUR: 1000PPM
4. DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
5. MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114315-00WS	WELDMENT, SMALLER, ADAPTER A-18	1
MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FINISH		WEIGHT: 1181.85#	
ANGULAR: \pm 0°30'		APPROVALS	
.XX \pm .03		DATE	
.XXX \pm .005		6/28/10	
UNSPECIFIED FILLETS: R.015		DRAFTER MKM2	
BREAK EDGES .010x45°		CHECKER RW	
REMOVE ALL BURRS		7/9/10	
// \square \perp WITHIN .03		ENGINEER MKM2	
		6/28/10	
TITLE: SUB NIPPLE, ADAPTER, A-18			
THIRD ANGLE PROJECTION		DO NOT SCALE DRAWING	
C		DWG. NO. 114314-00S	
SCALE: 1:12		REV A	
SHEET 1 OF 1			

