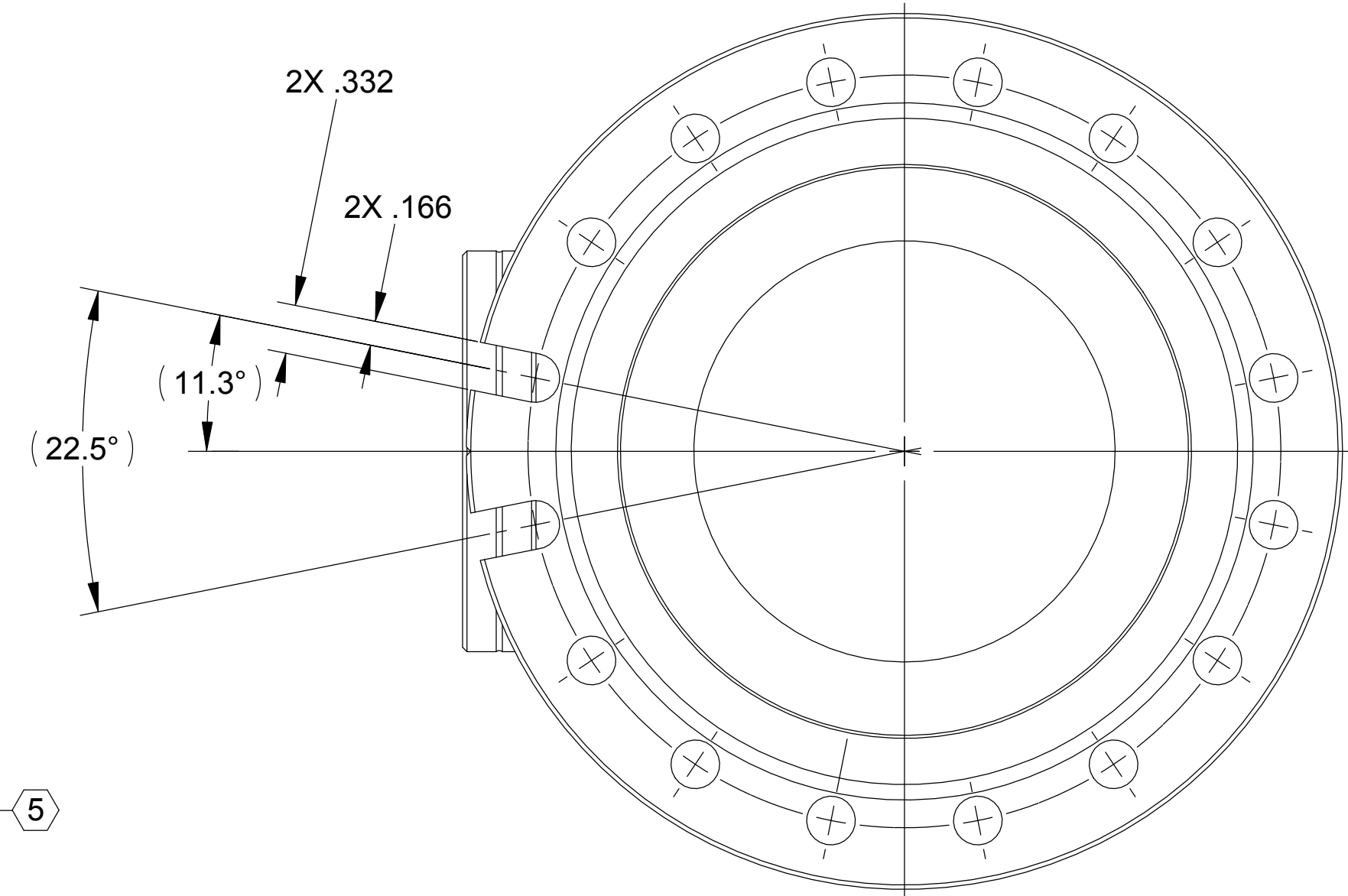
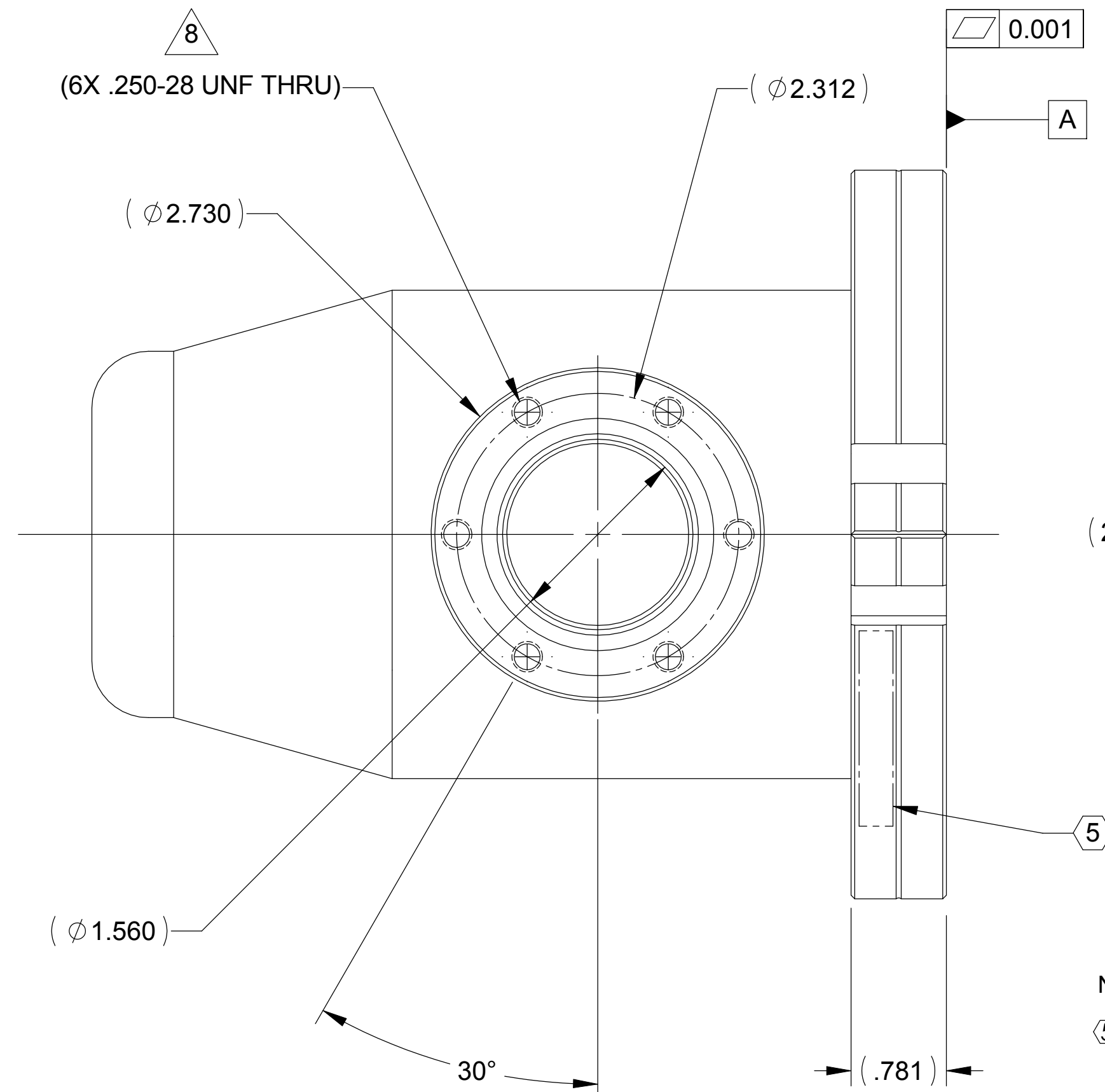
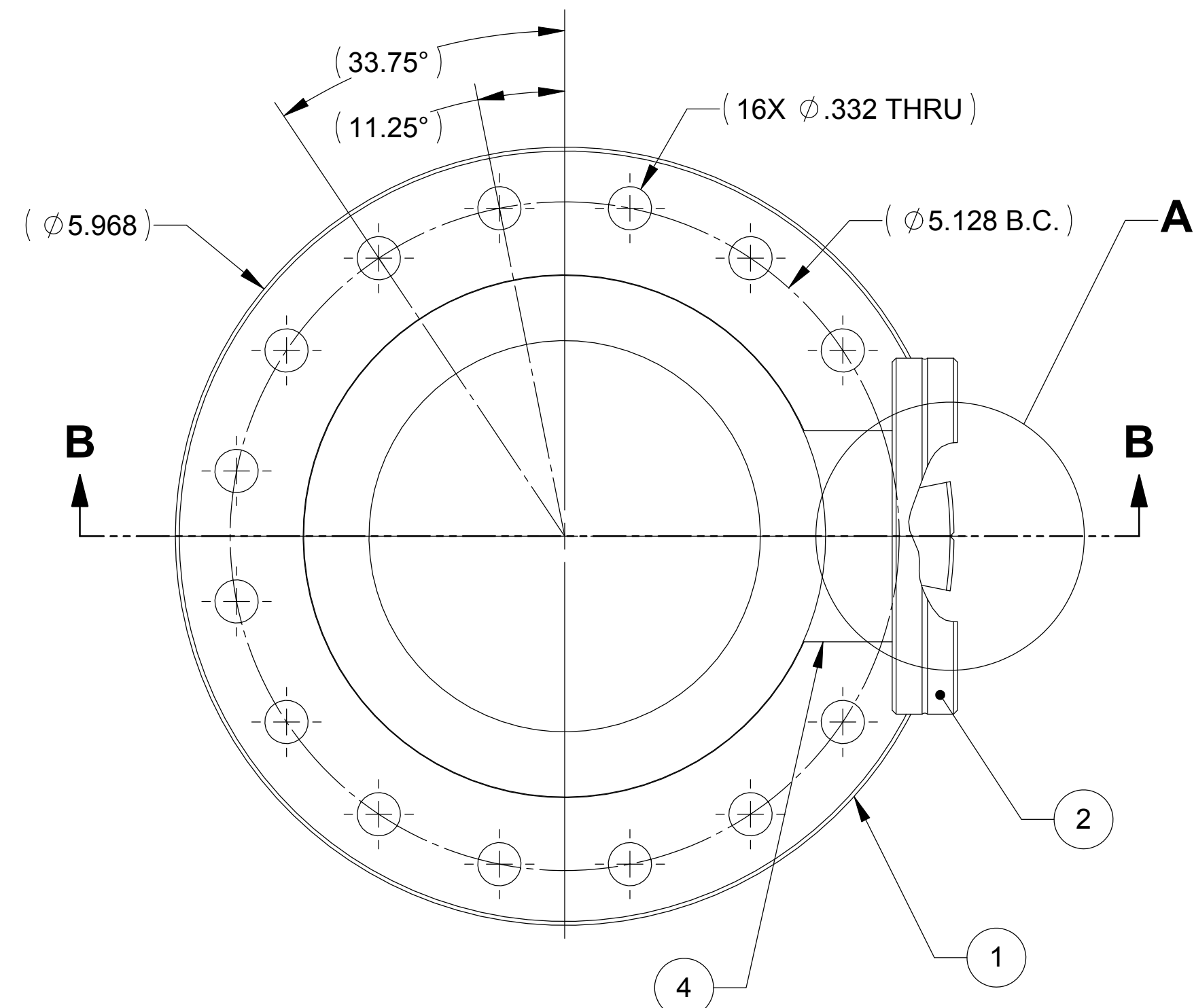
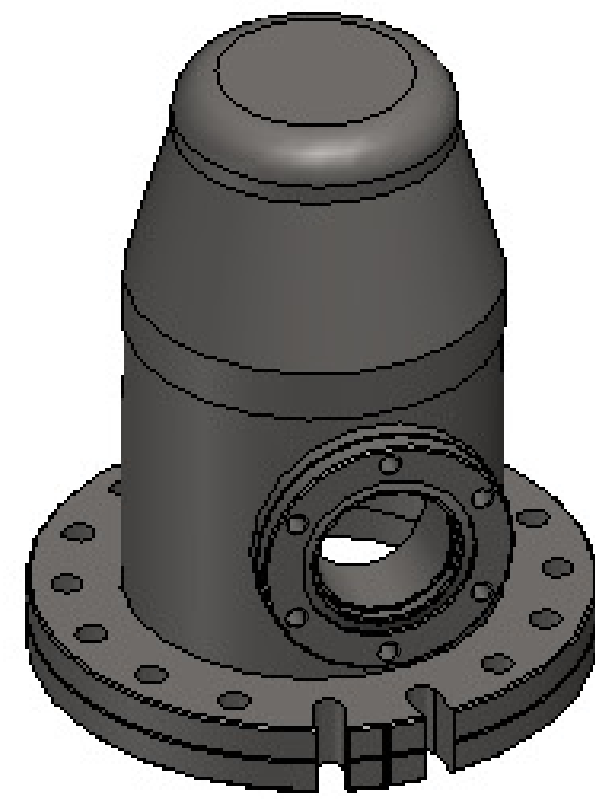
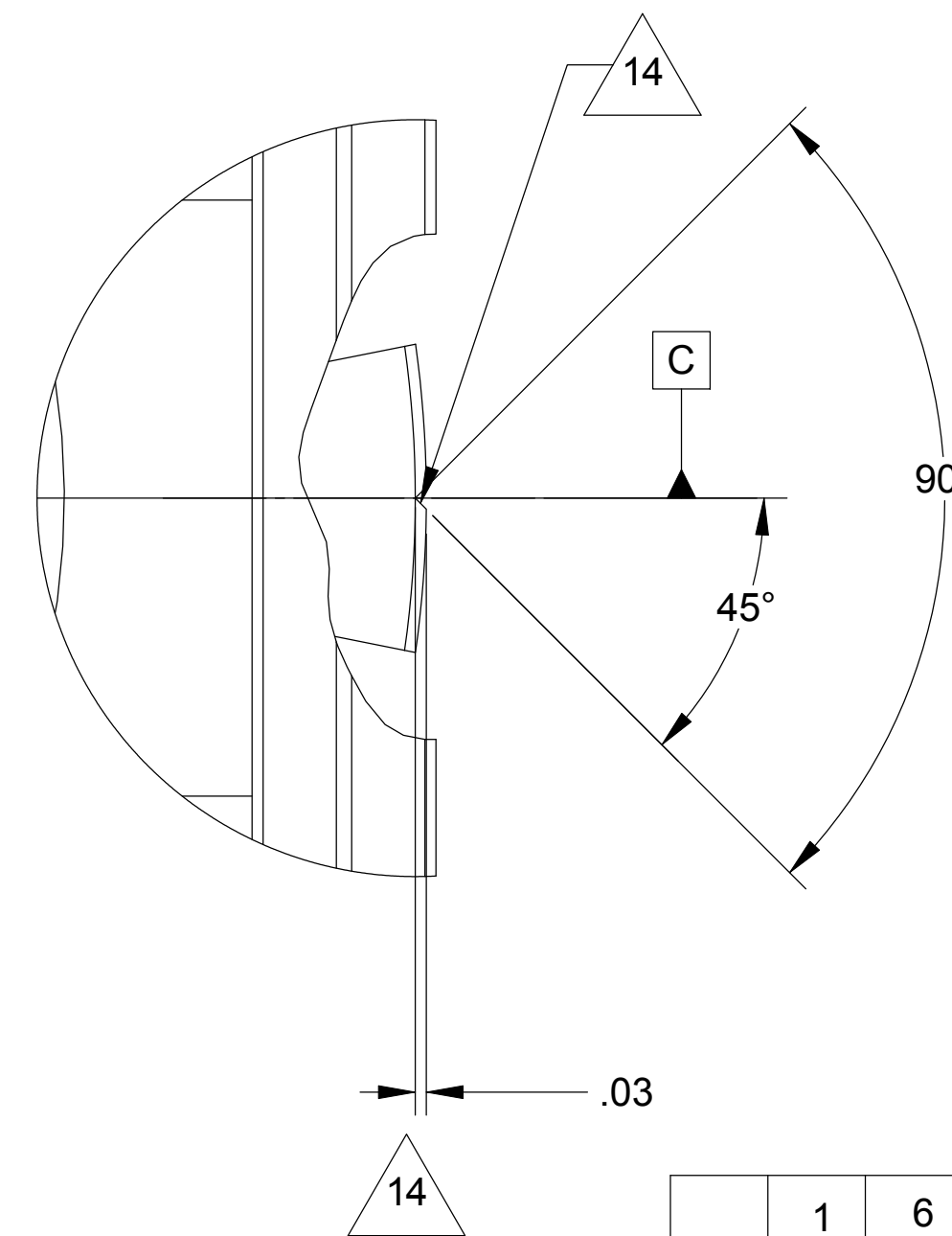
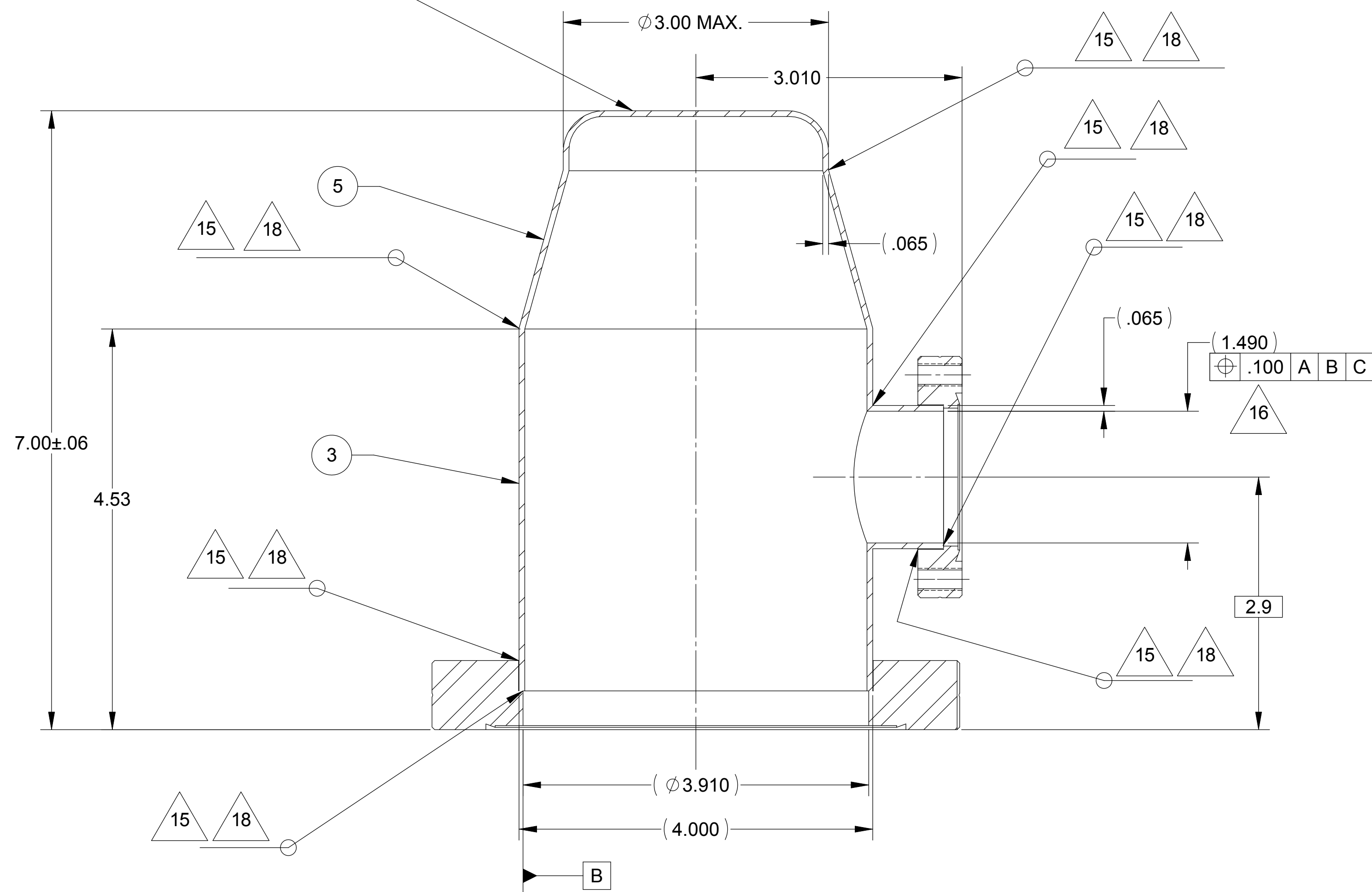


REV.	DATE	DCN #	DRAWING TREE #
V1	02 DEC 2004	-	-
V2	10 JUN 2009	-	-
V3	26 JAN 2010	E0900436	T0900600
V4	20 FEB 2010	E1000048	T0900600



NOTES:

- SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
- ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
- MACHINE FILLET RADII .003-.015.
- THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
- COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
- COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- FEATURES THAT ARE REFERENCED OR UNDEMENTIONED SHALL CONFORM TO THE APPROPRIATE NOR-CAL PRODUCTS PART NUMBERS LISTED IN THE PARTS LIST.
- REFERENCE MATING PART DRAWING D047822.
- ELECTROPOLISH TUBES PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE.
- PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- ALL WELDS TO BE EXTERNAL FUSION GTAW UHV WELDS.
- APPLIES PRIOR TO WELDING.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION LIGO-E0900364 AND WELDMENTS SPECIFICATION LIGO-E0900048.
- JOINT CONFIGURATION TO BE DETERMINED BY VENDOR.
- NOTE ON BILL OF MATERIALS: VENDOR REFERENCES ARE PROVIDED AS EXAMPLE OF PARTS MEETING ALL SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.



DETAIL A  
SCALE 4:1

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1	6			D047823-106	CAP, END	G-2W-300	(CRES 304)	
1	5			D047823-105	REDUCER, Ø4.00 TO Ø 2.50 X .065 WALL	B-31W-400-250	(CRES 304)	
1	4			D047823-104	TUBE, Ø 1.62 X .065 WALL	SST-162	(CRES 304)	
1	3			D047823-103	TUBE, Ø 4.00 X .083 WALL	SST-400	(CRES 304)	
1	2			D047823-102	PORT, CF FLANGE Ø 2.75	275-162N	(CRES 304)	
1	1			D047823-101	BASE, CF FLANGE Ø 6.00	600-400N	(CRES 304)	

SECTION B-B

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
.XX ± .015  
.XXX ± .005  
ANGULAR ± 0.5°

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.

MATERIAL: AISI 304  
FINISH: 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO  
SUB-SYSTEM: SEI  
NEXT ASSY: D047820

PART NAME: L4C Vacuum Chamber top

DESIGNER: ASI	10 Nov. 2009	SIZE: D	DWG. NO. D047823	REV. V4
DRAFTER: F. MATICHARD	26 Dec. 2010			
CHECKER: S.BARNUM	26 Dec. 2010			
APPROVAL: K.MASON	26 Dec. 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D047823 L4C Vacuum Chamber top, PART PDM REV: V3, DRAWING PDM REV: V3-000