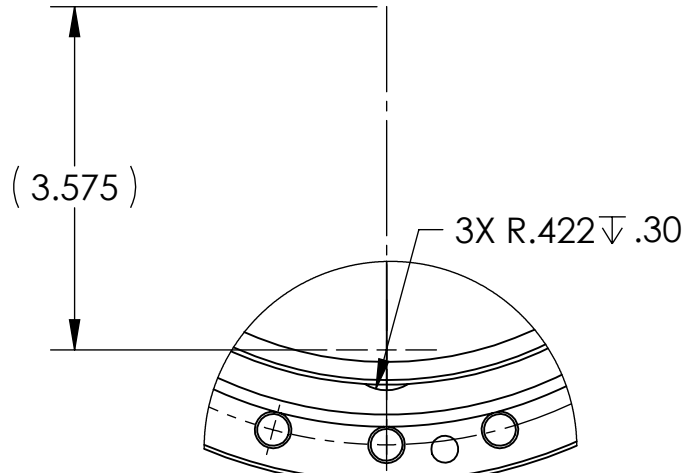
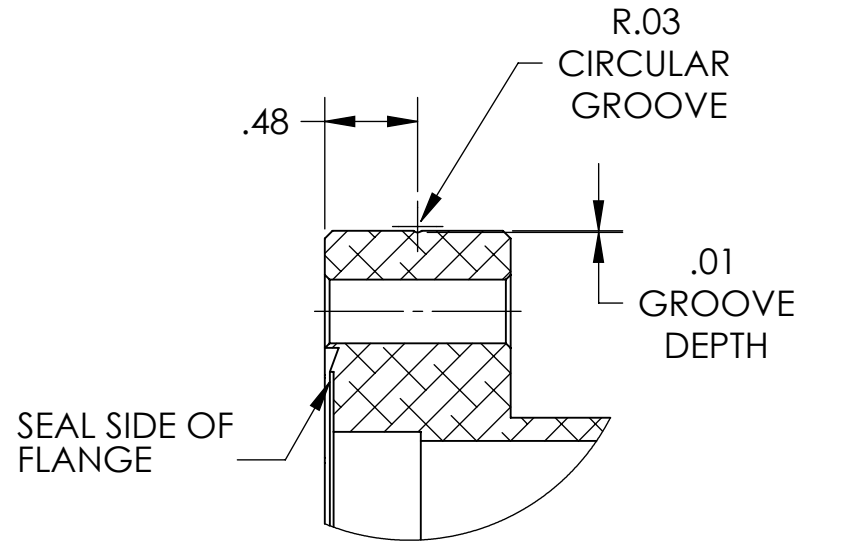


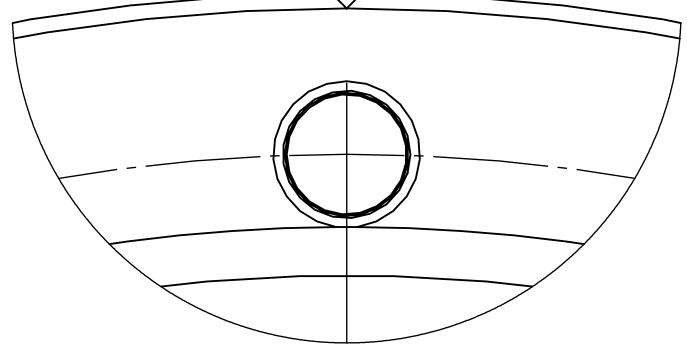
DETAIL D  
SCALE 1 : 2



DETAIL B  
SCALE 1 : 1

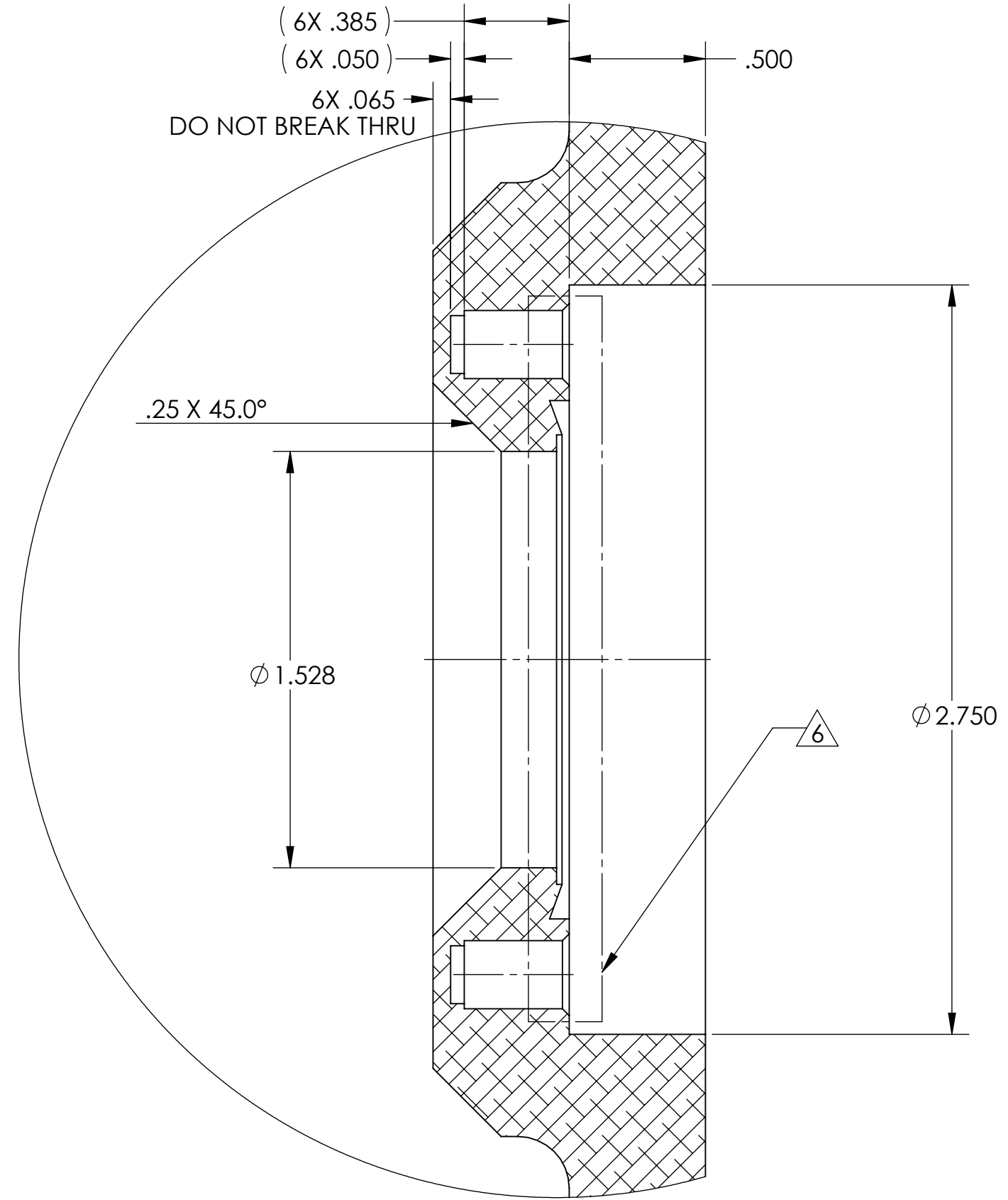


.08 WIDE  $\nabla$  .04  
REF MARK FULL  
THK. OF FLANGE



DETAIL E  
SCALE 2 : 1

( 6X .385 )  
 ( 6X .050 )  
 6X .065  
 DO NOT BREAK THRU



DETAIL C  
SCALE 2 : 1

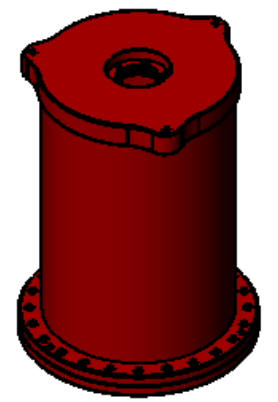
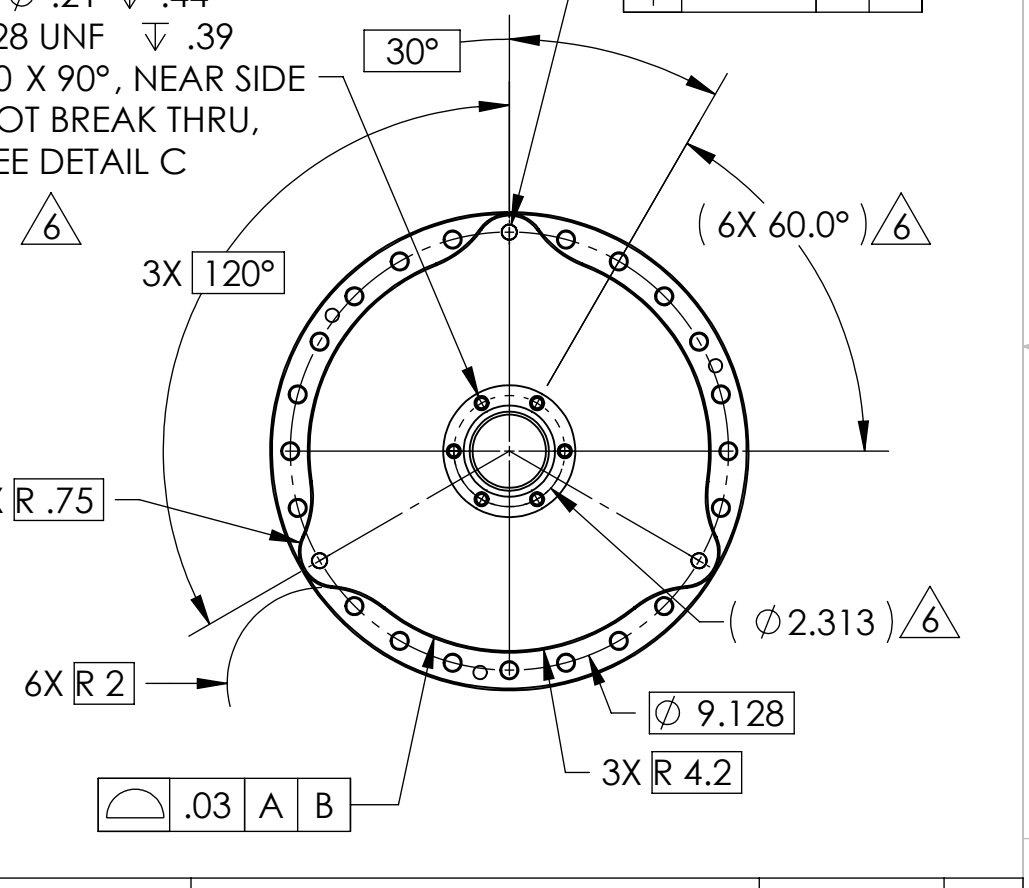
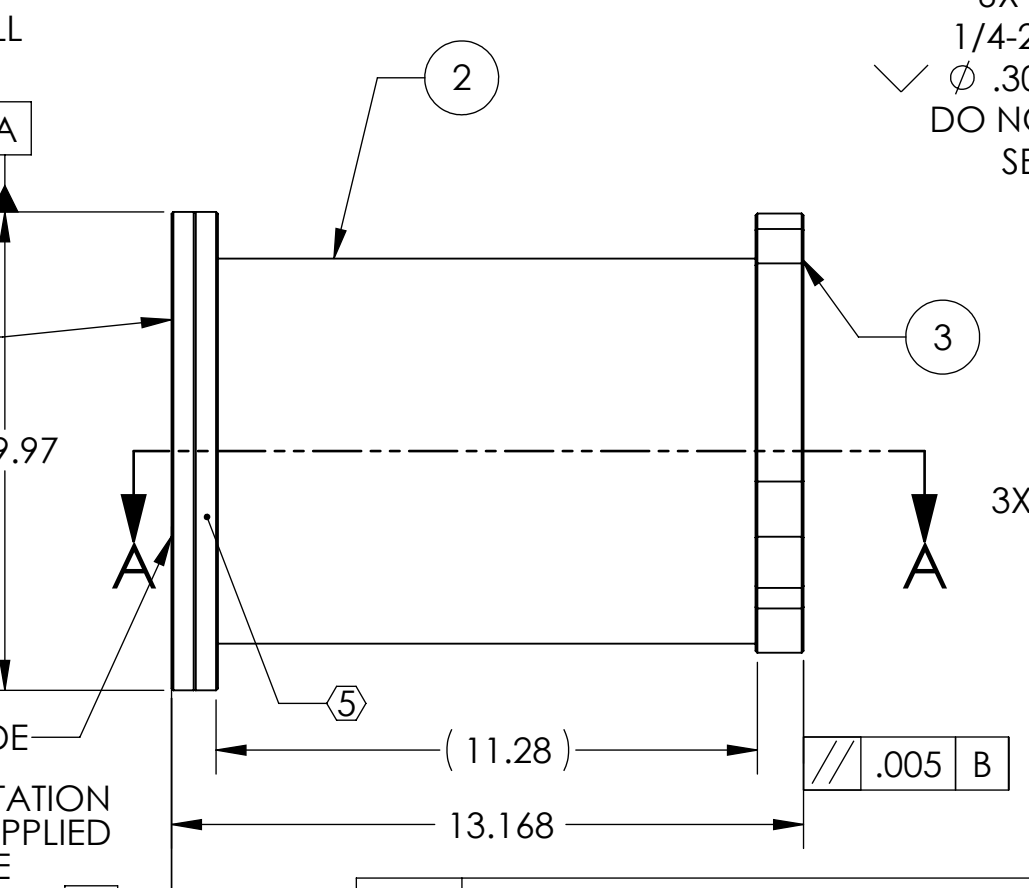
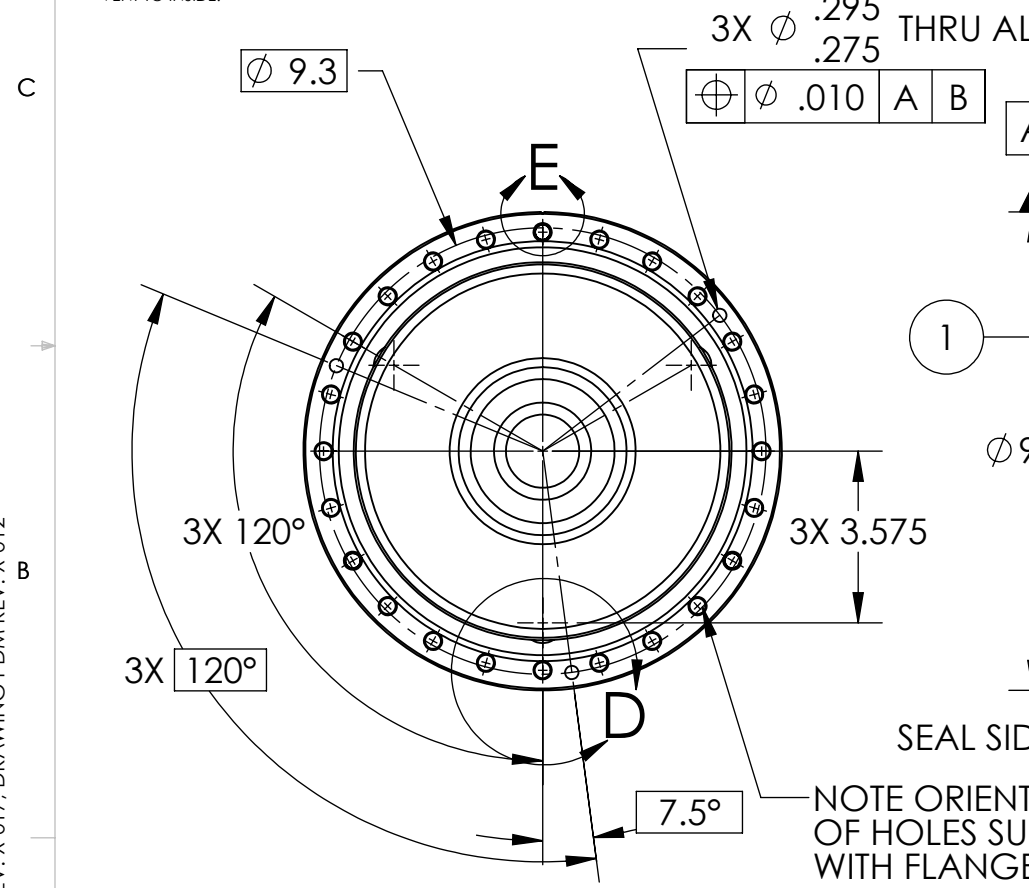
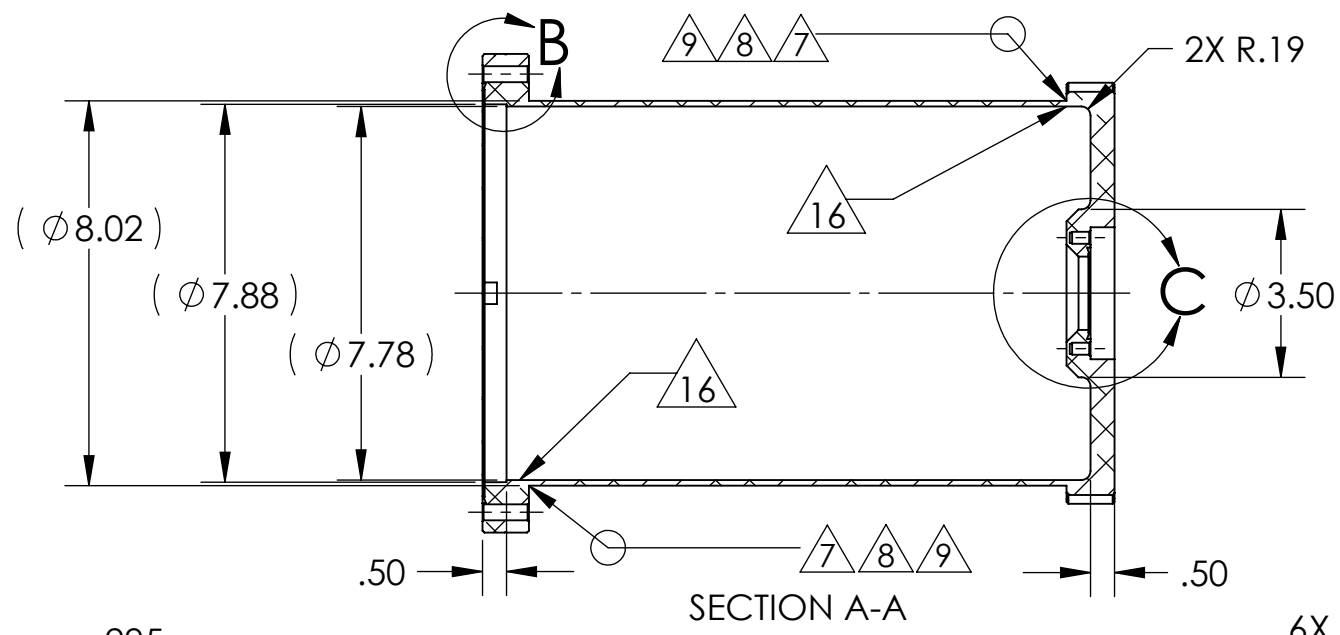
**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0900859	v5
SCALE: 1:4		PROJECTION:
		SHEET 1 OF 2

D0900859\_GS-13\_Pod\_TopHat, PART PDM REV: X-017, DRAWING PDM REV: X-012

- 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 1000-800N 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.

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .015  
 .XXX ± .005  
 ANGULAR ± 0.1°

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

**ADVANCED LIGO** SUB-SYSTEM SEI

**GS13 Pod Top Hat**

DESIGNER	S.BARNUM	4 FEB 2010	SIZE	DWG. NO.	REV.
DRAFTER	M.HILLARD	4 FEB 2010	B	D0900859	v5
CHECKER	F.Matichard	4 FEB 2010	SCALE	1:4	PROJECTION:
APPROVAL	K.MASON	4 FEB 2010	SHEET	2 OF 2	