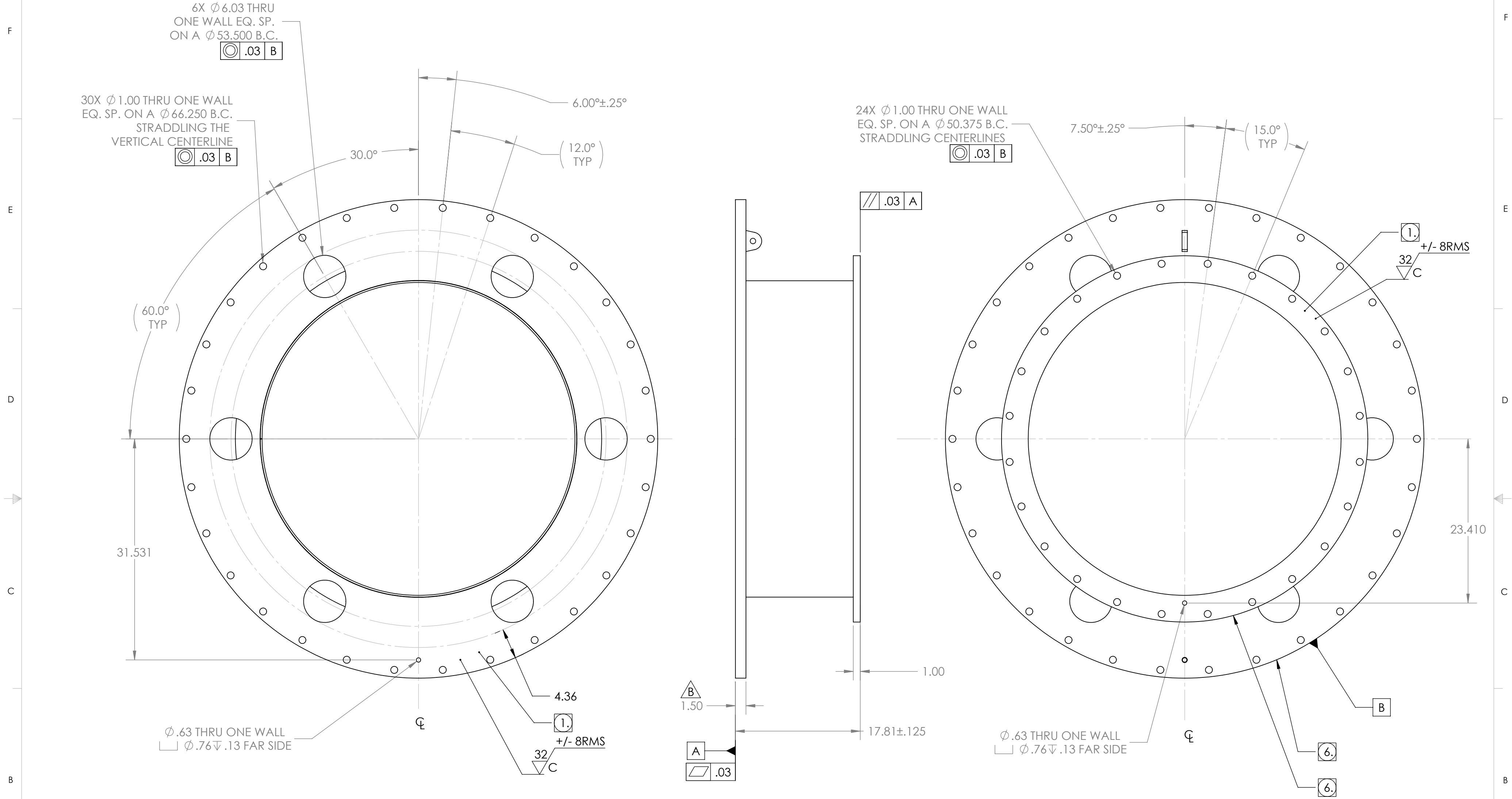


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ENLARGED VIEWS, ADDED SEAL SURFACE CALLOUTS, CLARIFIED SOME CALLOUTS	7/14/2010	MKM2
	B	FLANGE THICKNESS WAS 1.0, NOW 1.5	7/20/2010	MKM2
	C	RELEASED TO PRODUCTION	8/23/2010	MKM2



NOTES:

- VACUUM SEALING SURFACE
- THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
- NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
  - WATER LEACHABLE CHLORIDES: 100PPM
  - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
  - TOTAL SULFUR: 1000PPM
- DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
- MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.
- DO NOT MACHINE OD OF FLANGES. FORGING MANUFACTURER'S NUMBERS TO BE LEFT INTACT.
- ALL SEAL SURFACES SHALL BE MACHINED WITH A CONCENTRIC LAY.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114287-00WS	WELDMENT, INITIAL, ADAPTER A-16	1

MATERIAL: AISI 304/ AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES

TOLERANCES: FINISH

ANGULAR:  $\pm$  0 $^\circ$ 30'

XX  $\pm$  .03

XXX  $\pm$  .005

UNSPECIFIED FILLETS: R.015

BREAK EDGES .010x45 $^\circ$

REMOVE ALL BURRS

//  $\square$   $\perp$  WITHIN .03

THIRD ANGLE PROJECTION

WEIGHT: 1136.48#

APPROVALS	DATE
DRAFTER MKM2	7/11/10
CHECKER RW	7/9/10
ENGINEER MKM2	7/11/10

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TITLE: MACHINING, ADAPTER 1-16

DO NOT SCALE DRAWING

C DWG. NO. 114285-00S REV C

SCALE: 1:10 SHEET 1 OF 1