NOTES CONTINUED:

Ⓢ 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: DXXXXXXX-YY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = X.XXX LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. *REFER TO LIGO-E0900364*
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. *REFER TO LIGO-E0900364.*
12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
14. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

REV.	DATE	DCN #	DRAWING TREE #
v5	JUL 2012	E1200710-V1	-
-	-	-	-
v6	JAN 2013	E1200710-V2	-

D7

LOCATED ON THE TOP OF THE CHAMBER

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D7		BLANK			-- BLANK (FULL FLANGE) --

SPARE.

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D6-1C1	-1	C	25D-1	SUS	SUS - TRIPLE
D6-1C2	-1	C	25D-2	SUS	SUS - TRIPLE
D6-2C1	-2	C	25D-1	SUS	SUS - TRIPLE
D6-2C2	-2	C	25D-2	SUS	SUS - TRIPLE
D6-3C1	-3	C	25D-1	ISC	ISC - ~~QUAD DIODE - ASC POB~~ PICOMOTORS
D6-3C2	-3	C	25D-2	ISC	ISC - PICOMOTORS

SPARE.

D6

D5

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D5		BLANK			-- BLANK (FULL FLANGE) --

D4

TOP

AS VIEWED FROM THE AIR SIDE

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D4-1A1	-1	A	BNC-1	SEI	SEI - CAP POS SENS
D4-1A2	-1	A	BNC-2	SEI	SEI - CAP POS SENS
D4-2B1	-2	B	3PWR-1	SEI	SEI - ISI COILS
D4-2B2	-2	B	3PWR-2	SEI	SEI - ISI COILS
D4-3C1	-3	C	25D-1	SEI	SEI - GS-13
D4-3C2	-3	C	25D-2		-- NOT ASSIGNED --

L1 HAM 3

AS VIEWED FROM ABOVE PLAN VIEW

D1

TOP

AS VIEWED FROM THE AIR SIDE

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D1-1A1	-1	A	BNC-1	SEI	SEI - CAP POS SENS
D1-1A2	-1	A	BNC-2	SEI	SEI - CAP POS SENS
D1-2B1	-2	B	3PWR-1	SEI	SEI - ISI COILS
D1-2B2	-2	B	3PWR-2	SEI	SEI - ISI COILS
D1-3C1	-3	C	25D-1	SEI	SEI - GS-13
D1-3C2	-3	C	25D-2	I/O	I/O QUAD DIODE CT.

D2

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D2-1A1	-1	A	BNC-1	SEI	SEI - CAP POS SENS
D2-1A2	-1	A	BNC-2	SEI	SEI - CAP POS SENS
D2-2B1	-2	B	3PWR-1	SEI	SEI - ISI COILS
D2-2B2	-2	B	3PWR-2	SEI	SEI - ISI COILS
D2-3C1	-3	C	25D-1	SEI	SEI - GS-13
D2-3C2	-3	C	25D-2		-- NOT ASSIGNED --

D3

BELLOWS SIDE OF THE CHAMBER

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D3-1C1	-1	C	25D-1	SUS	SUS - TRIPLE
D3-1C2	-1	C	25D-2	SUS	SUS - TRIPLE
D3-2C1	-2	C	25D-1	SUS	SUS - TRIPLE
D3-2C2	-2	C	25D-2	SUS	SUS - TRIPLE
D3-3C1	-3	C	25D-1	I/O / ISC	I/O / ISC PICOMOTORS CT.
D3-3C2	-3	C	25D-2	ISC	ISC - QUAD DIODE (SINGLE)

REMOVE CT.

D8

LOCATED ON THE TOP OF THE CHAMBER

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
D8		BLANK			-- BLANK (FULL FLANGE) --

* SUBFLANGE TYPE >	A	B	C	D	E	F	G	BLANK
CONNECTORS >	BNC	3PWR	25D	5 WAY COAX (2 PER FLANGE)	5 WAY COAX (1 PER FLANGE)	25PIN FULL FLANGE	TRI-AXIAL	BLANK
SUBSYSTEMS v								
SEI (ISI)	6	6	3					
SUS			8					
ISC			3					
I/O			1					
I/O / ISC			1					
TCS								
PSL								
AOS								
NOT ASSIGNED			2					
TOTALS (CONNECTORS)	6	6	18	0	0	0	0	0
TOTALS (FLANGES)	3	3	9	0	0	0	0	0

*** FOR A COMPLETE EXPLANATION OF FLANGE DESIGNATORS, FLANGE NAMING CONVENTIONS AND SUBFLANGE TYPES SEE DCC# D1101775**

CALUM ISMAIL
JAN 2013

DIMENSIONS ARE IN

TOLERANCES:
.XX ±
.XXX ±

ANGULAR ± °

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
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: N/A
FINISH: N/A µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM | SUB-SYSTEM: ALL
NEXT ASSY

PART NAME: **FLANGE LAYOUT L1 HAM CHAMBER 3 (HAM 3)**

DESIGNER		
DRAFTER	E. BROWN	MAR/29/2012
CHECKER		
APPROVAL		

SIZE: D | DWG. NO.: D1002886 | REV.: v5

SCALE: 1:16 | PROJECTION: | SHEET 1 OF 1

D1002886 V6