

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 2.32 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 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	21-AUG-13	-	E1300255-v1
v2	24-SEPT-13	E1300279-x0	E1300255-v2
v3	31-OCT-13	E1300607-x0	E1300813-v1

D

C

B

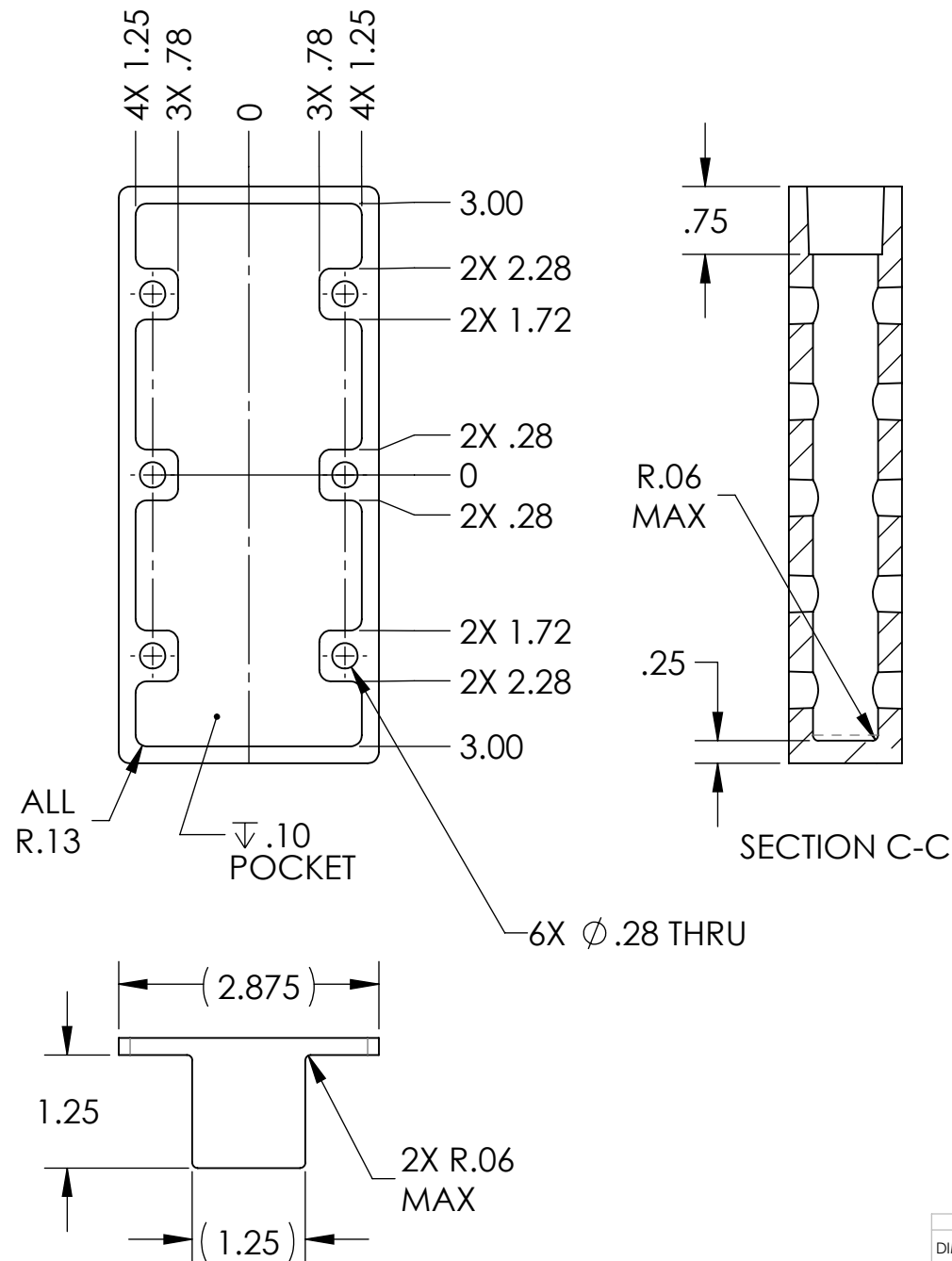
A

D

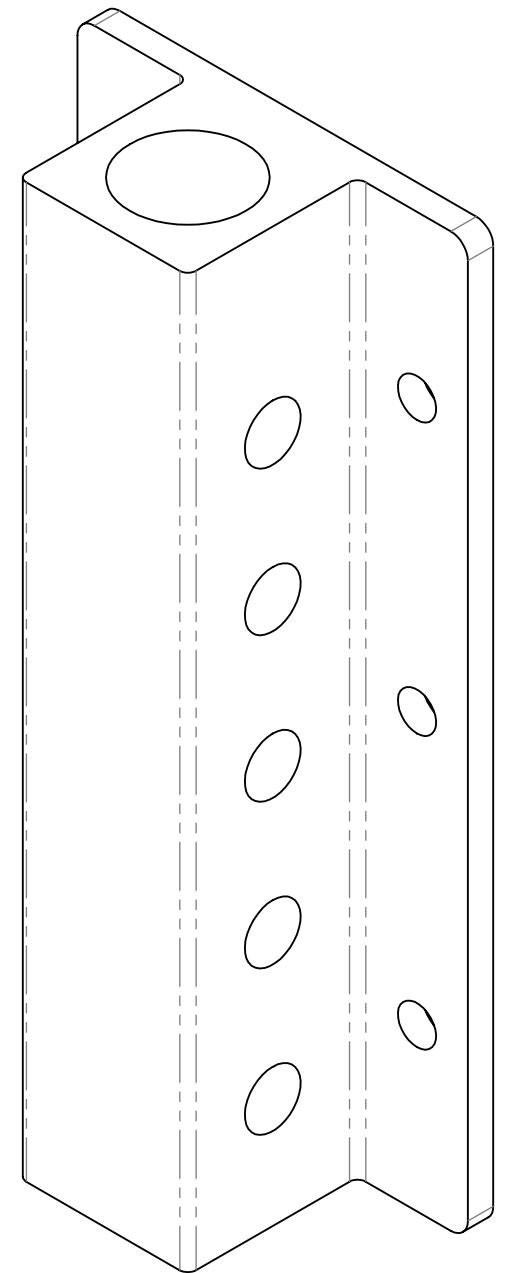
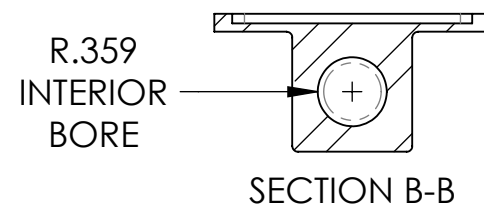
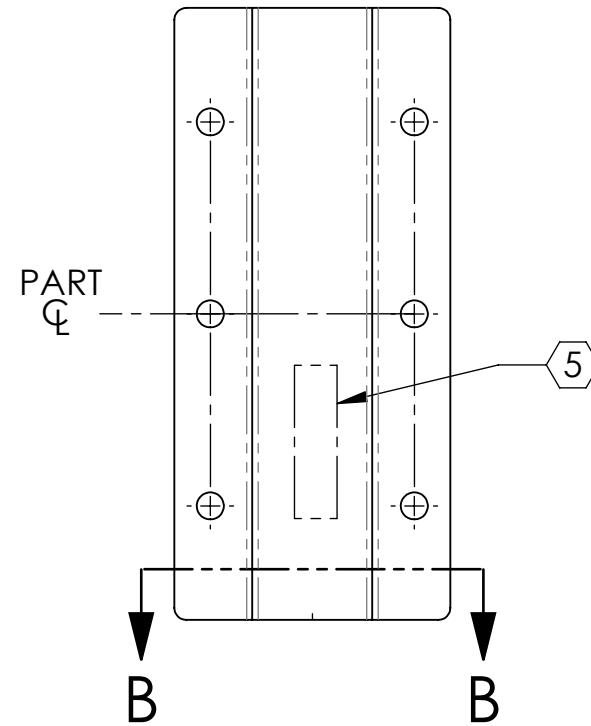
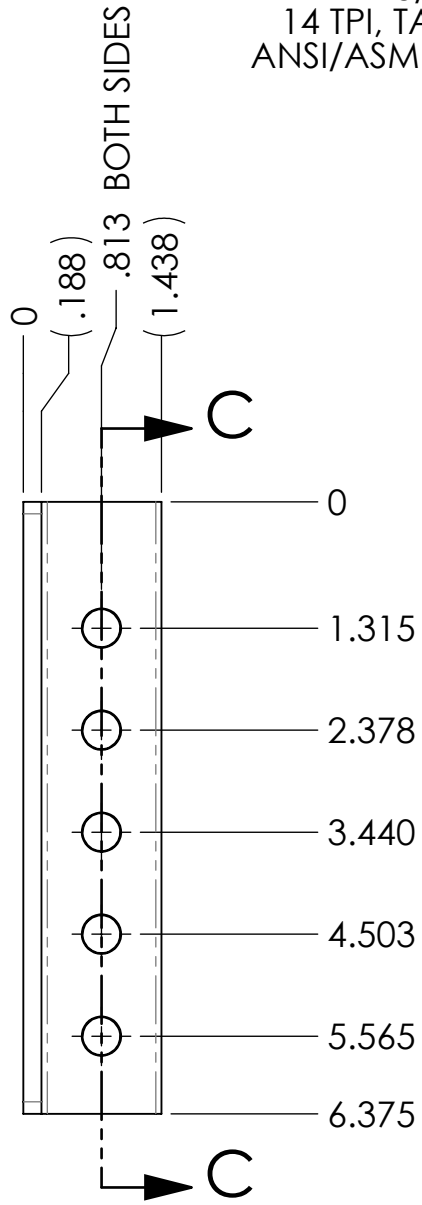
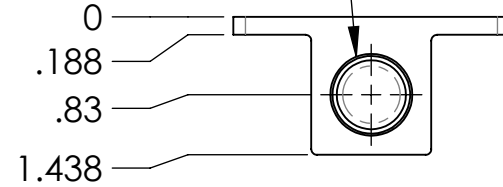
C

B

A



1/2 NPT  
23/32 DRILL  
14 TPI, TAPER PER  
ANSI/ASME B1.20.1



ISO VIEW  
SCALE 1:1

D1300677\_dLIGO TCS CO2P MANIFOLD, PART PDM REV: X-009, DRAWING PDM REV: X-013

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± °				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.02 FOR MACHINED 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.		aLIGO TCS CO2P MANIFOLD	
MATERIAL		FINISH		NEXT ASSY		DESIGNER	
AISI 316 SS BAR		63 μinch		D1300294		M. JACOBSON	
						DRFTER	
						M. JACOBSON	
						CHECKER	
						J. LEWIS	
						APPROVAL	
						HEPTONSTALL	
				SYSTEM		SUB-SYSTEM	
				ADVANCED LIGO		AOS	
				DATE		SIZE DWG. NO.	
				08-AUG-13		B	
				21-AUG-13		D1300677	
				01-NOV-13		REV.	
				01-NOV-13		v3	
				SCALE: 1:2		PROJECTION:	
				FIRST ANGLE		SHEET 1 OF 1	