

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. 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.

7. FOR SURFACE ROUGHNESS REFER TO E1900024.

8. GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.

9. FLANGES WILL BE USED IN UHV SERVICE.

10. NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.

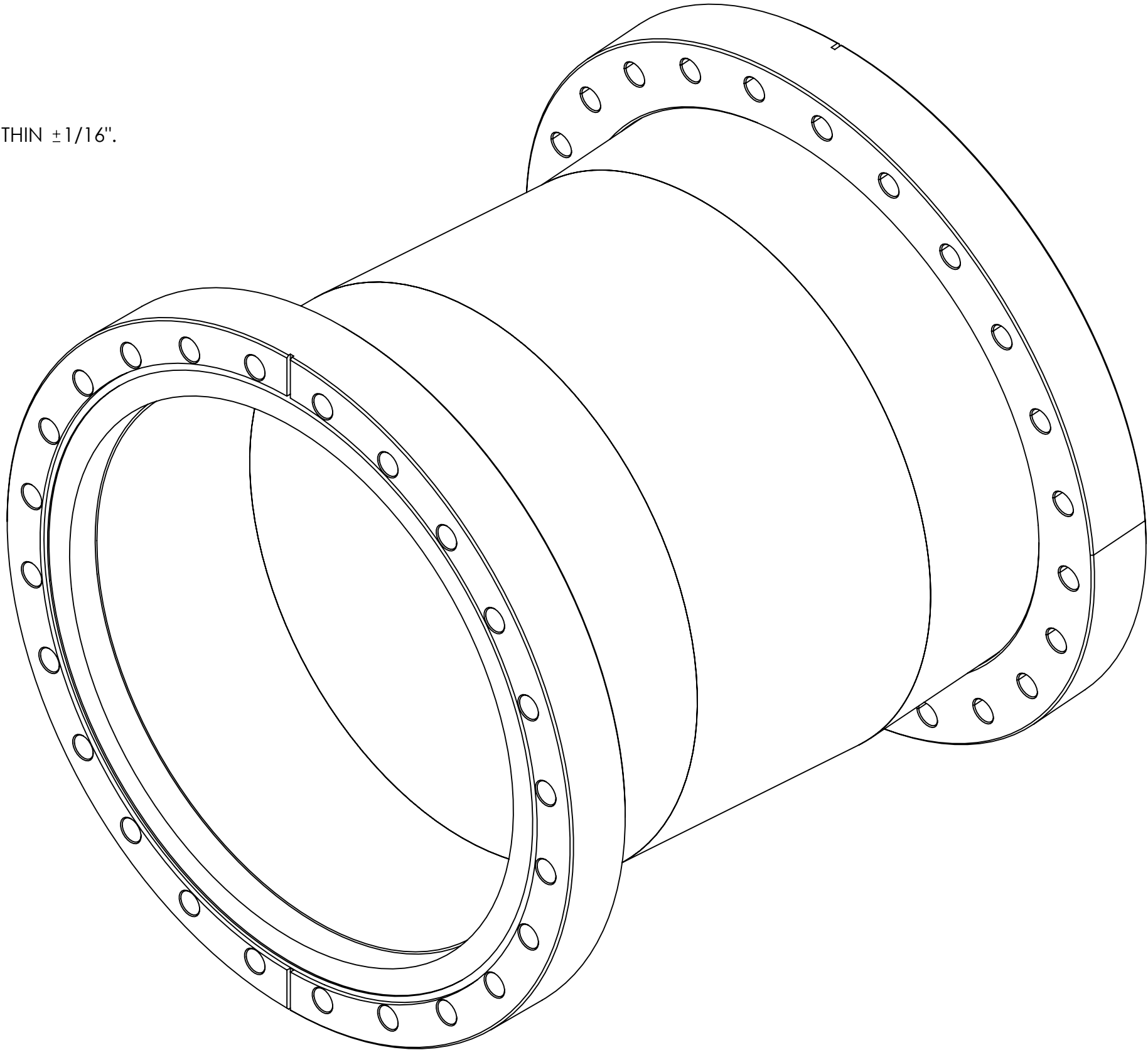
11. NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS MAY BE USED.

12) FOR WELDING AND HELIUM LEAK TEST SPECIFICATIONS REFER TO LIGO E0900408 & E0900404

13. CONFLAT FLANGES ARE TO BE PROTECTED WITH RIGID COVERS AT ALL TIMES DURING AND AFTER MANUFACTURING.

14. PACKAGE, HANDLE, AND SHIP IN SUCH A MANNER S TO MAINTAIN SPECIFIED SURFACE FINISHED AND FLATNESS TOLERANCES.

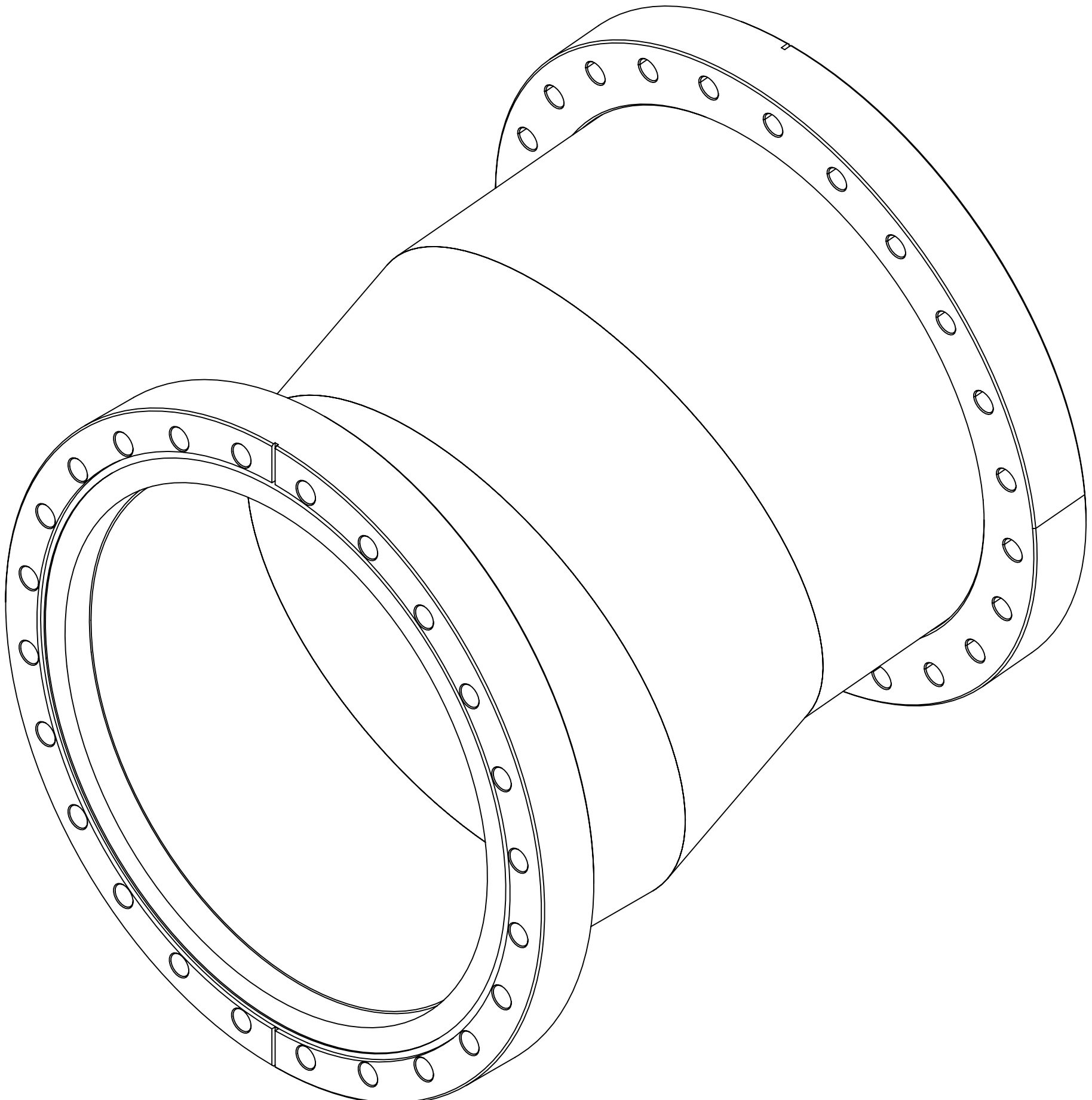
15) FLANGE LEAK PORTS SHALL BE CENTERED AT 12 AND 6 O'CLOCK POSITIONS, WITHIN $\pm 1/16"$.



ISO VIEW

-01 (LHO)

(SEE PG. 2 FOR WELDMENT)

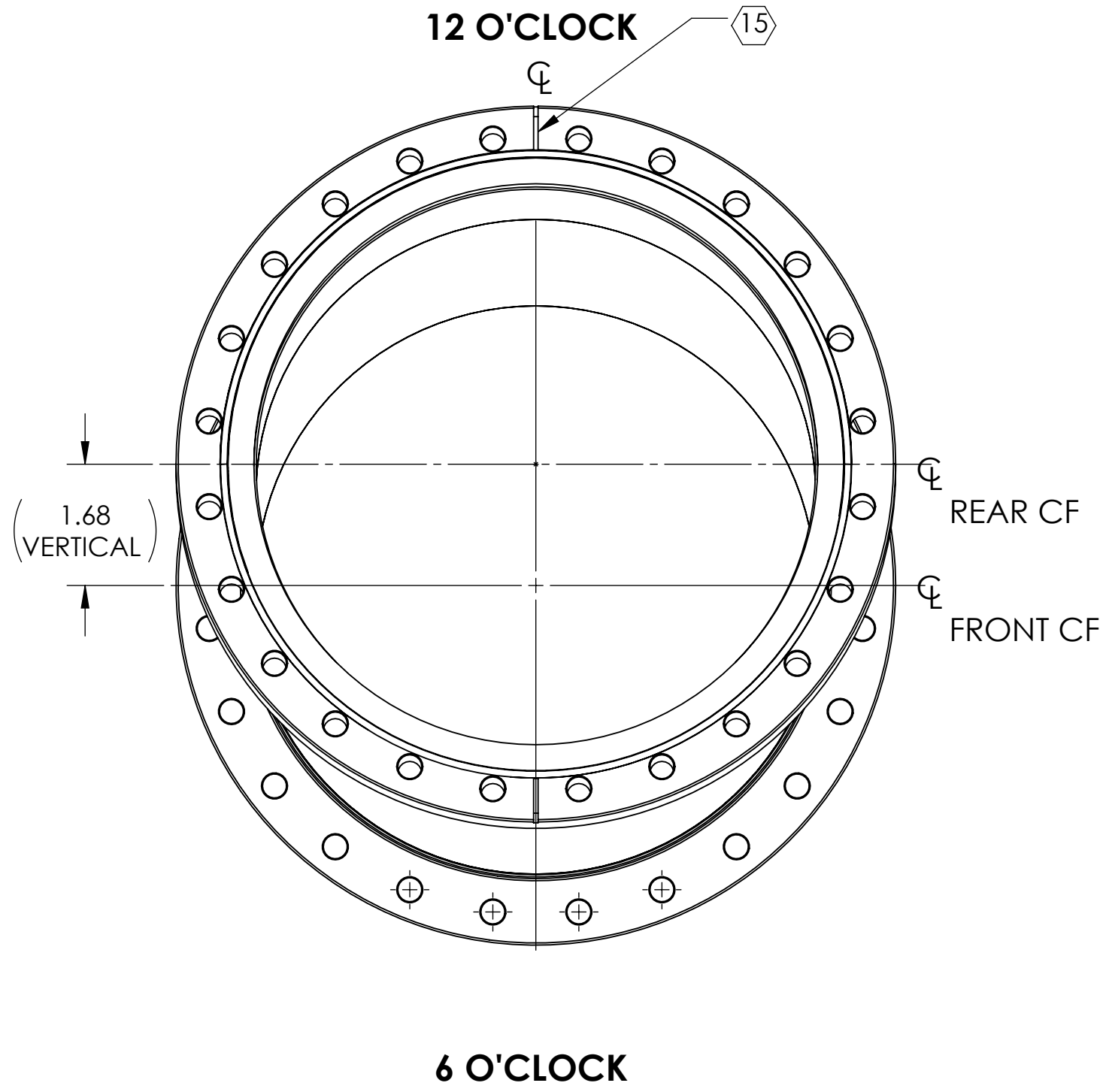
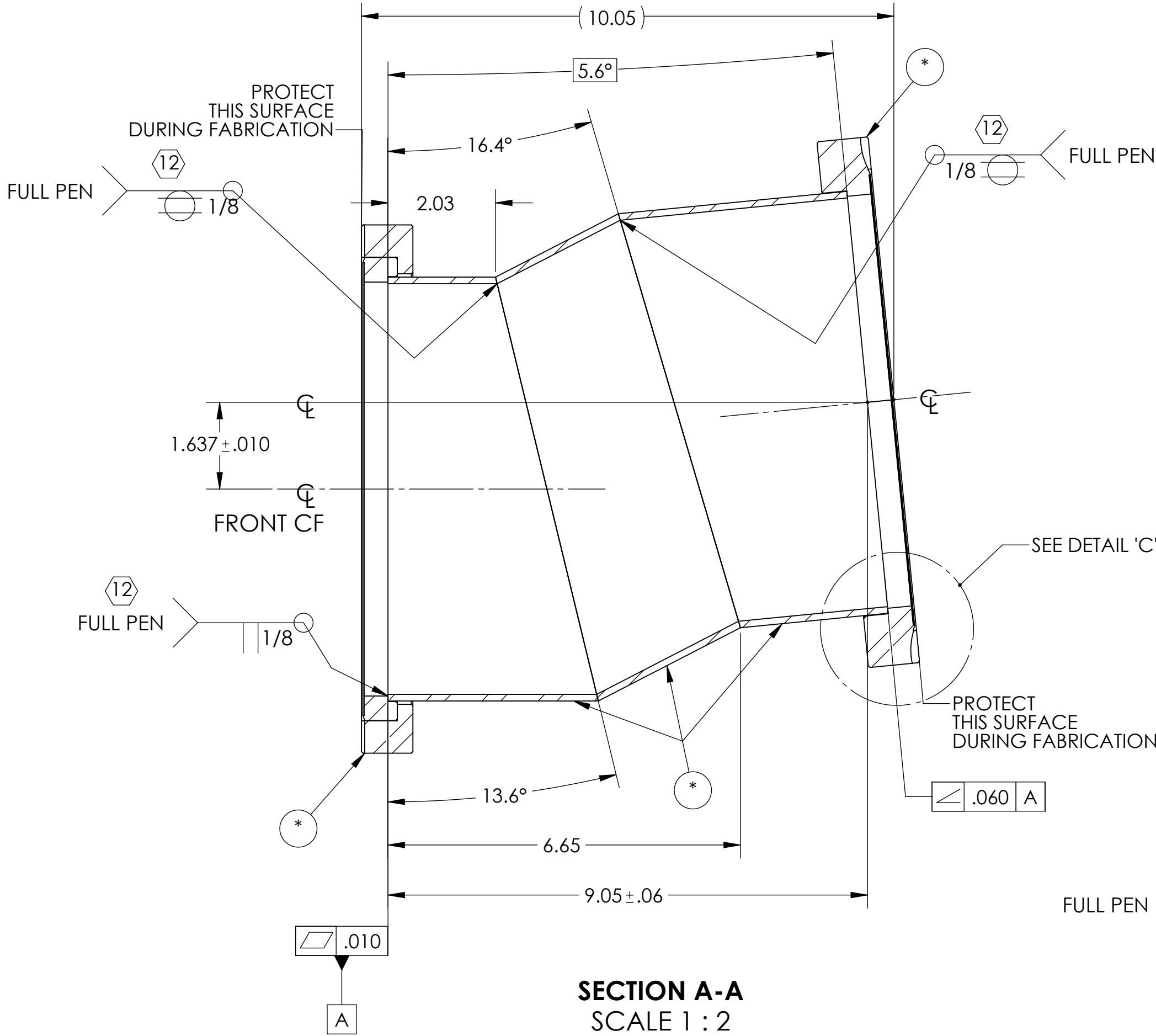
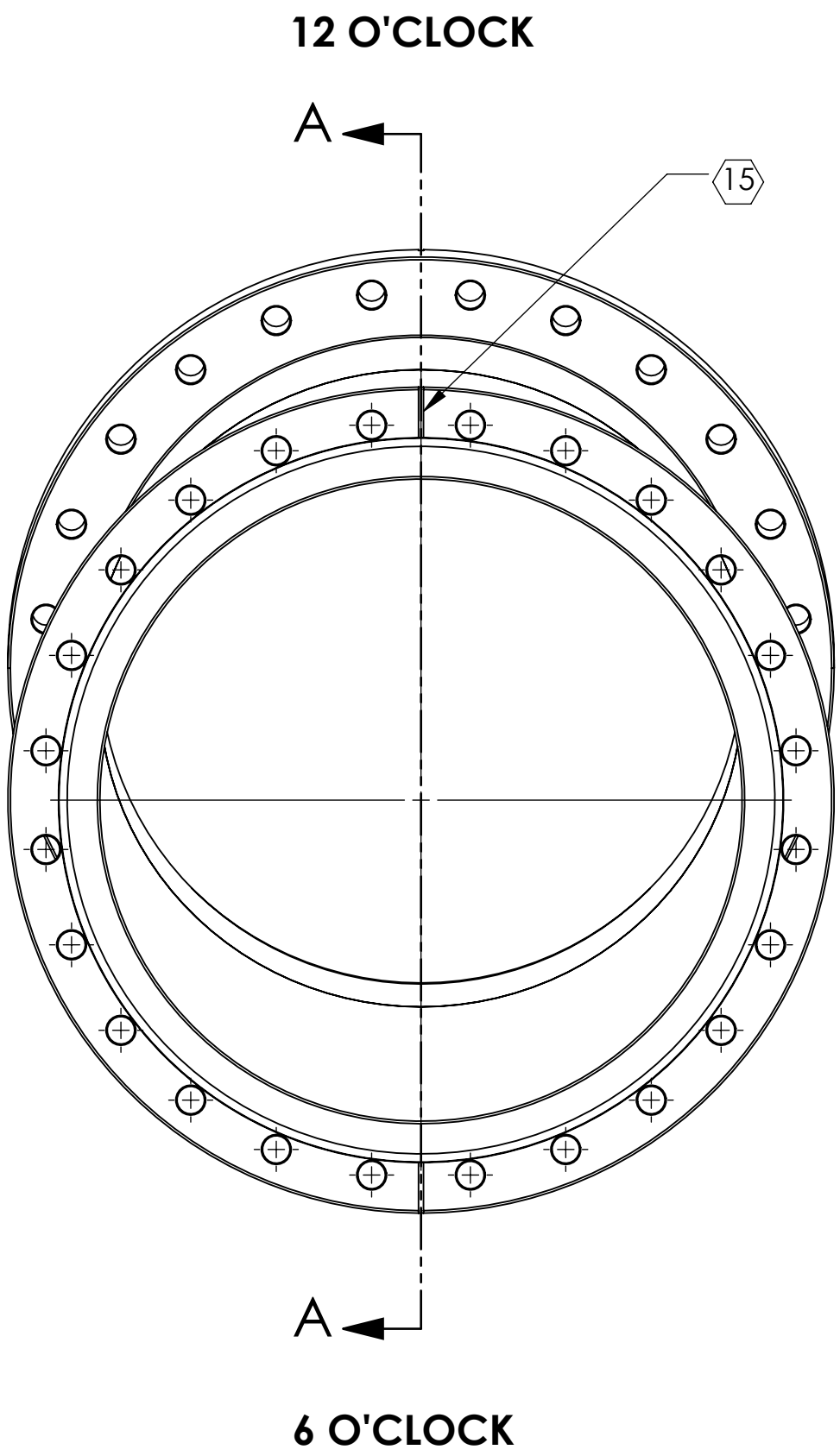


ISO VIEW

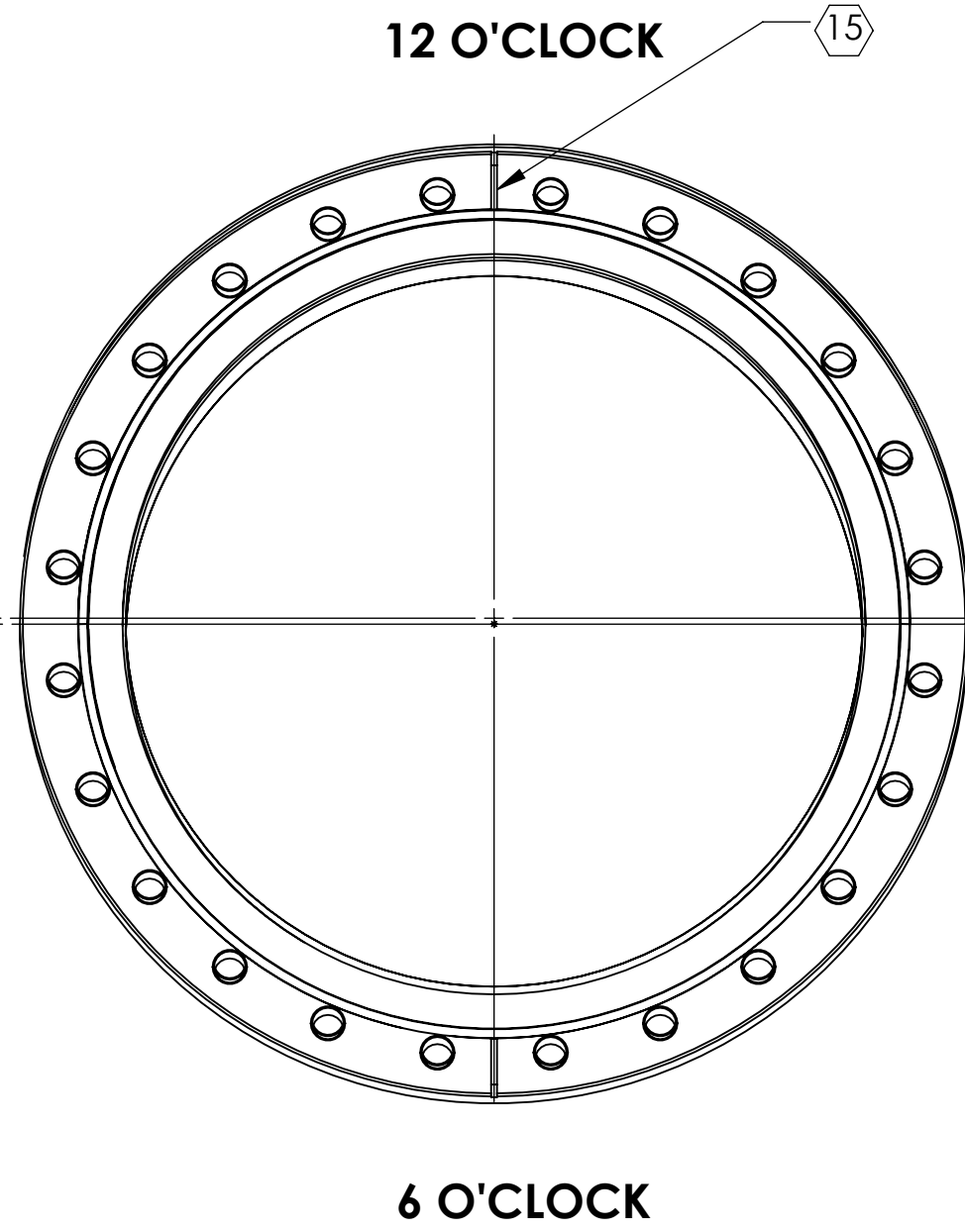
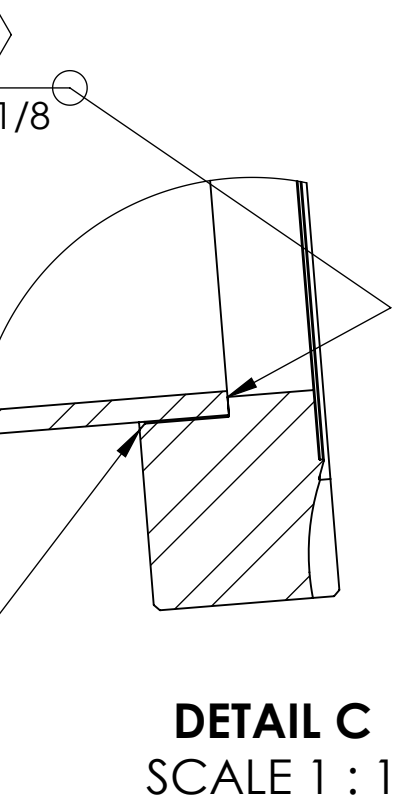
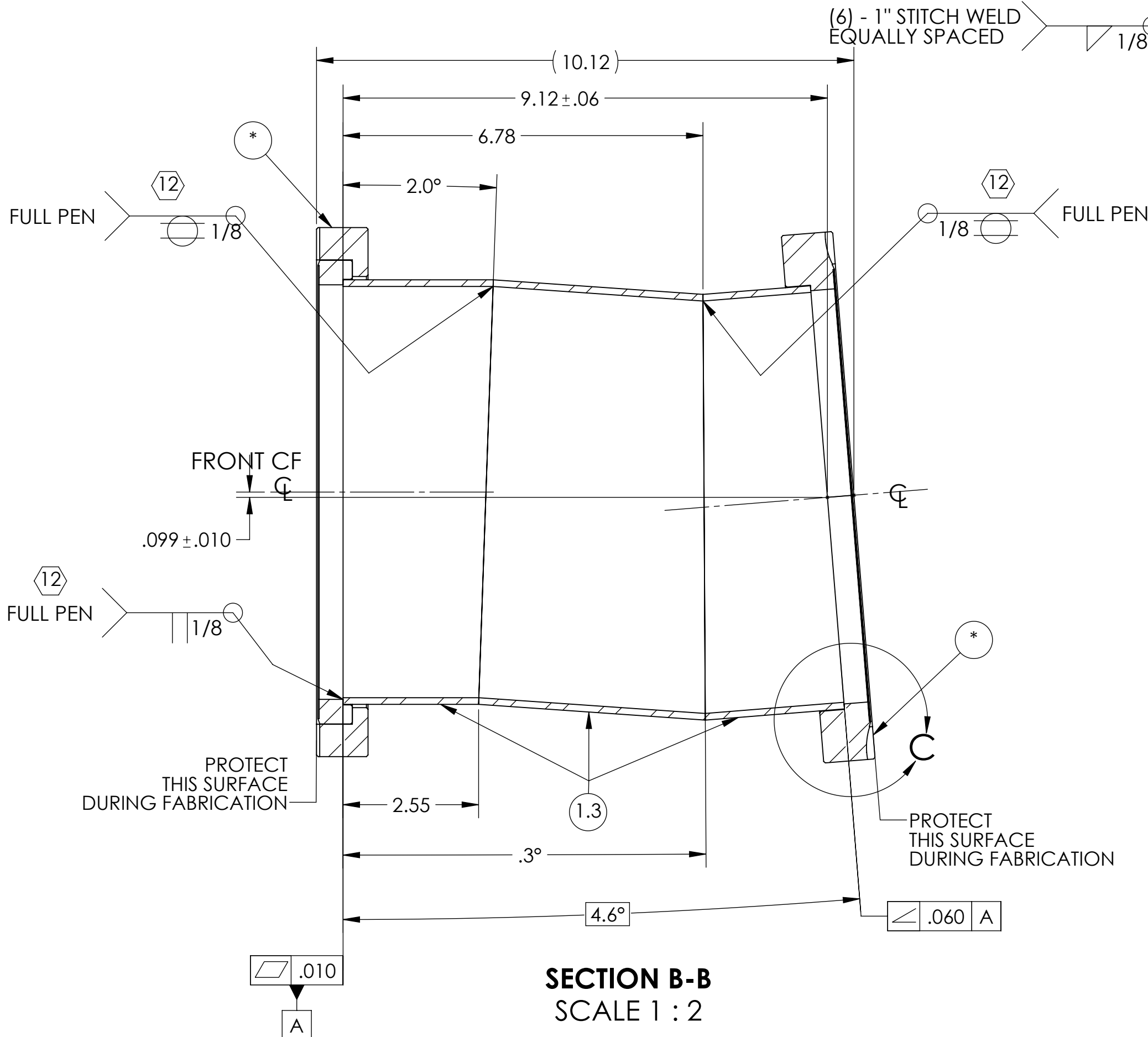
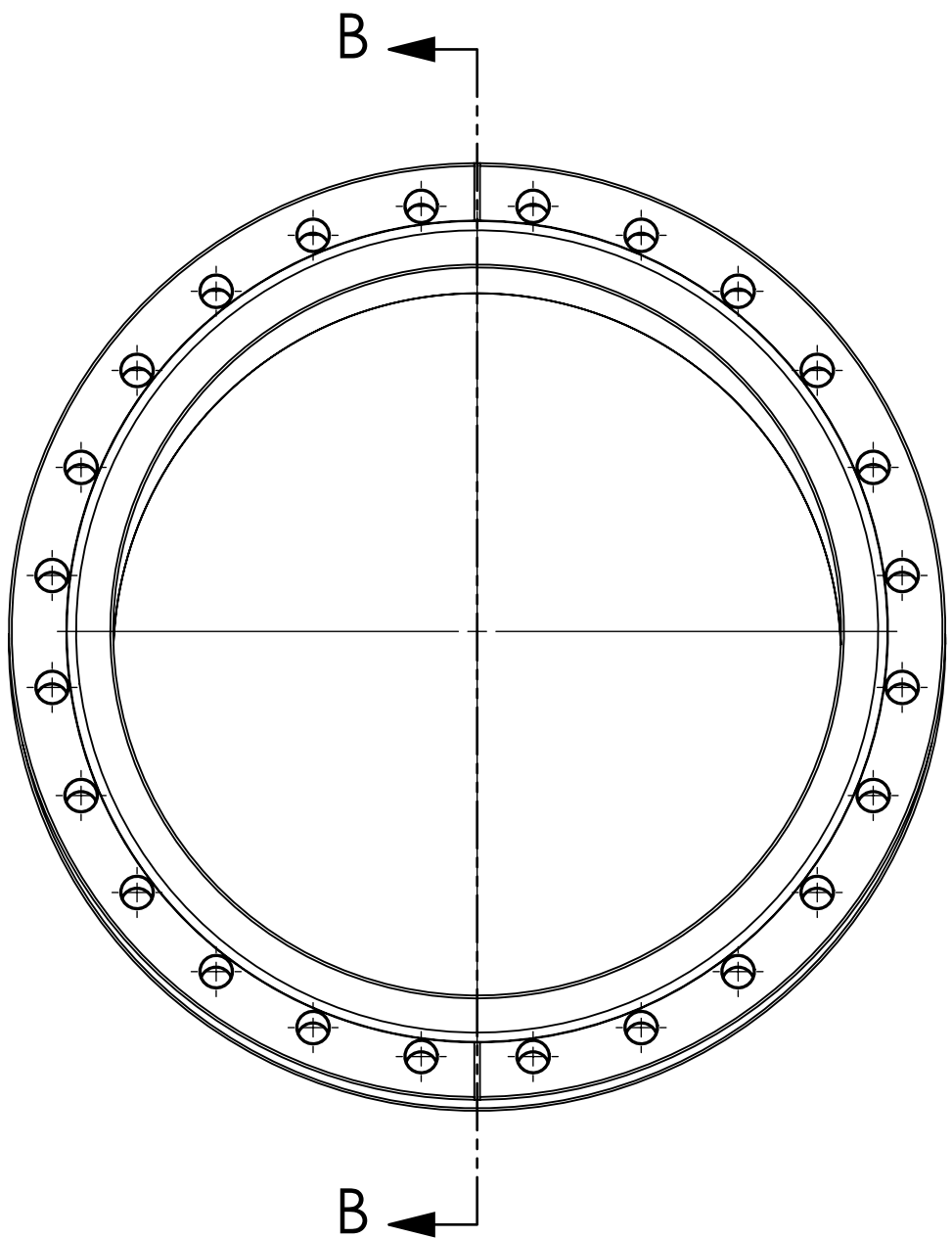
REV.	DATE	DCN #	DRAWING TREE #
v1	08 FEB 2021	E2100061-x0	-
-	-	-	-
-	-	-	-

		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME								
DIMENSIONS ARE IN INCHES		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.		SYSTEM		SUB-SYSTEM		A+, VAC, Custom Spool, 8" tube OD x 10" CF (TYPE A)						
TOLERANCES: .XX ± .03 .XXX ± .010				A+		VE		DESIGNER	E.SANCHEZ	06 JAN 2021	SIZE	DWG. NO.		REV.
								DRAFTER	E.SANCHEZ	05 FEB 2021	D	D2100053		v2
								CHECKER	SEE DCC	SEE DCC				
ANGULAR ± 0.5°		MATERIAL		FINISH		NEXT ASSY		APPROVAL	SEE DCC	SEE DCC	SCALE: NTS	PROJECTION:		SHEET 1 OF 2
		304 SSTL		SEE NOTE 7		D1800238, D1800241								


-01 (LHO)



-02 (LLO)



1.3	BY VENDOR	TUBE, 8" OD X .12 WALL	AIISI 304	A/R
1.2	110033 MDC OR EQ.	CF FLANGE, 10" X 8", NON-ROTATABLE	AIISI 304	1
1.1	100033 MDC OR EQ.	CF FLANGE, 10" X 8", ROTATABLE	AIISI 304	1
1	D2100053-01	A+, VAC. Custom Spool, 8in tube OD x 10in CF (TYPE A), H1	AIISI 304	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
PARTS LIST				



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SIZE	DWG. NO.	REV.
D	D2100053	v2
SCALE: 1:1.5	PROJECTION:	SHEET 2 OF 2