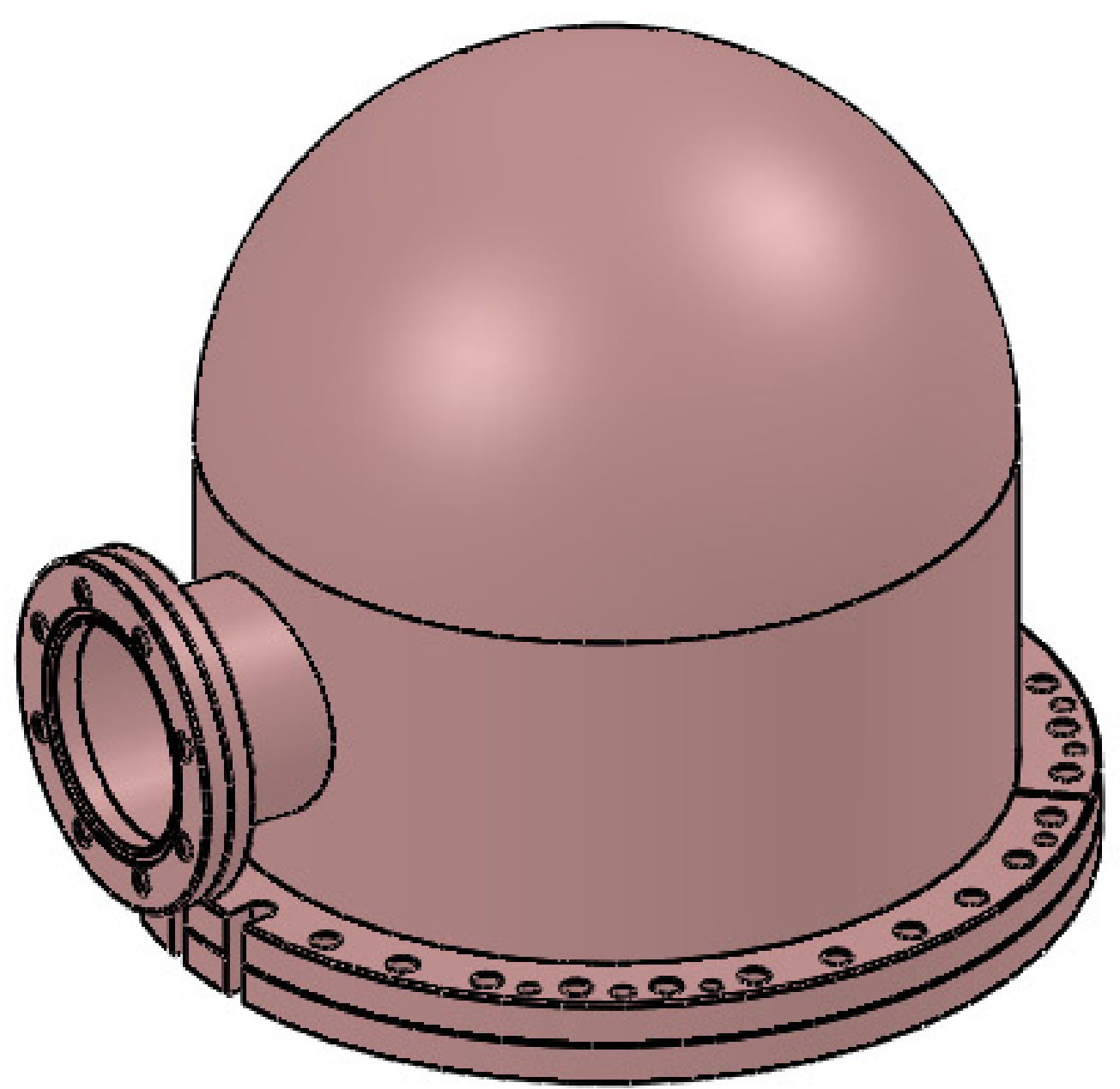
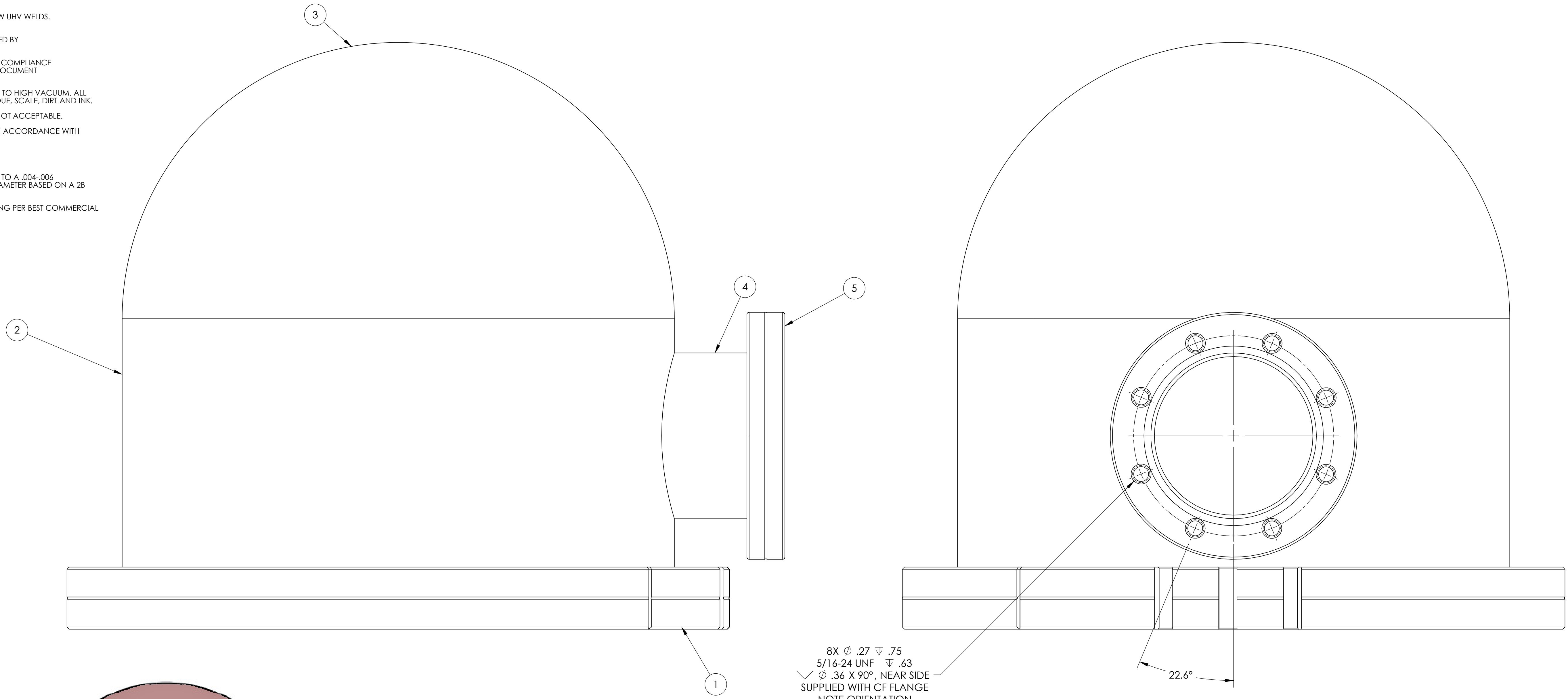


REV.	DATE	DCN #	DRAWING TREE #
v1	26 JAN 2010	E0900443	T0900600

- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE 07 HIGH CHARACTERS. EXAMPLE: DXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
  - 6. ALL WELDS TO BE EXTERNAL FUSION GTAW UHV WELDS.
  - 7. JOINT CONFIGURATION TO BE DETERMINED BY MANUFACTURER.
  - 8. ALL WELDMENTS MUST BE FABRICATED IN COMPLIANCE WITH SPECIFICATIONS DEFINED IN LIGO DOCUMENT E0900048.
  - 9. EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF: WELD RESIDUE, SCALE, DIRT AND INK.
  - 10. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
  - 11. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
  - 12. APPROXIMATE WEIGHT = 23LB.
  - 13. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
  - 14. ELECTROPOLISH TUBES PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .010 .XXX ± .005	
ANGULAR ± 0.1°	
MATERIAL	FINISH
304 SSSL	63 $\mu$ inch

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

SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: SEI  
 NEXT ASSY: D0900648

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
5	Nor-Cal_450-250NT	Nor-Cal CF Flange 4.5" Nom. OD or Equiv. Modified as Noted	304 SSSL	1
4	Nor-Cal_SST-300	Nor-Cal 3" OD Tubing Modified or Equiv.	304 SSSL	1
3	Nor-Cal_R-HS-00010D	Nor-Cal 10" OD Dome or Equiv.	304 SSSL	1
2	Nor-Cal_SST-1000	Nor-Cal 10" OD Tubing Cut to Length or Equiv.	304 SSSL	1
1	Nor-Cal_1200-1000NT	Nor-Cal CF Flange 12" Nom. OD or Equiv. Modified as Noted	304 SSSL	1

PART NAME: Trillium 240 Pod Tophat		DESIGNER: S. BARNUM	DATE: 2 Dec. 2009	SIZE: D	DWG. NO.: D0900649	REV.: v1
DRAFTER: M.HILLARD	DATE: 26 Jan 2010	CHECKER: F.MATCHARD	DATE: 26 Jan 2010	APPROVAL: K.MASON	DATE: 26 Jan 2010	SCALE: 1:1
PROJECTION:		SHEET 1 OF 2				

D0900649\_Trillium\_Pod\_Chamber\_TopHat\_PDF\_REV\_X.027\_DRAWING\_PDM\_REV\_X.009

