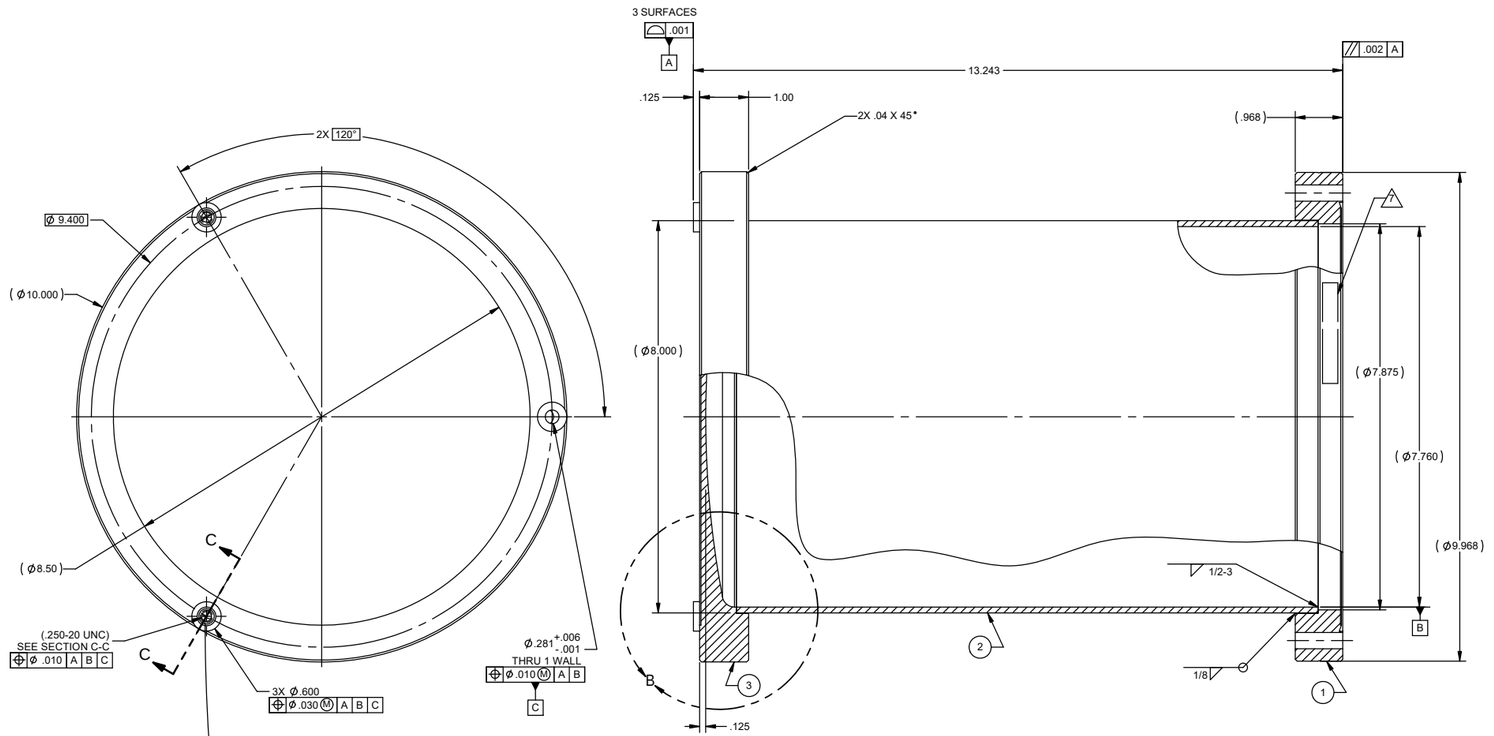
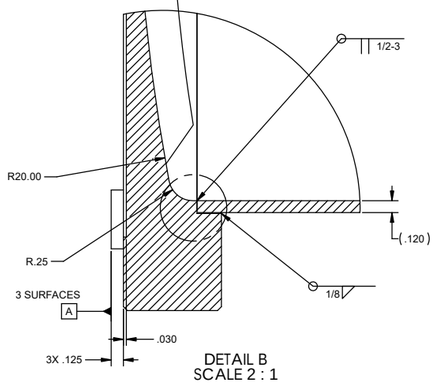
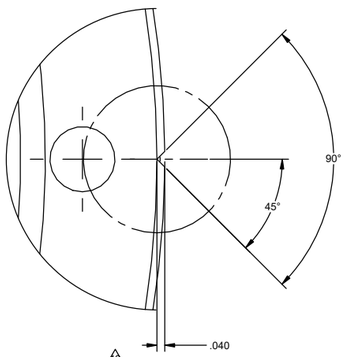
REVISIONS												
LTR	ZONE	DESCRIPTION	DWN	CHK	P-ENG	CONFG	ME	STRS	MATL	PROJ	QA	RELEASE DATE
A		INITIAL RELEASE										
v3		UPDATED NOTES TO LIGO SPECS	KM									3/28/19

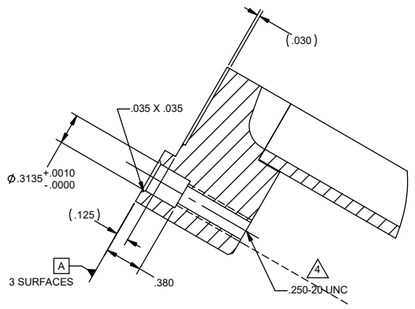




DETAIL B
SCALE 2 : 1



10
DETAIL A
SCALE 4 : 1



SECTION C-C
SCALE 2 : 1
TYPICAL 2 PLACES

NOTES: UNLESS OTHERWISE SPECIFIED.

1. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364 AND E0900048.
2. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
3. MACHINE FILLET RADII .003-.015.
4. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
5. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
6. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
7. WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: LIGO P/N-REVISION-TYPE, FOLLOWED ON THE NEXT LINE BY "S/N-" AND A THREE DIGIT SERIAL NUMBER, STARTING AT 100, AND PROCEEDING CONSECUTIVELY. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER. D047813-C-1 S/N-100 (EXAMPLE)
8. FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 1000-000NT.
9. REFERENCE MATING PART DRAWING 20007812.
10. PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURER'S OPTION BUT SHALL BE LOCATED AS SPECIFIED.
11. CONFIGURATION OF KNIFE EDGE, GASKET RELIEF AREAS, AND THEIR RELATIONSHIP TO THE SURROUNDING BOLT PATTERN AND MATING FLANGE AREA SHALL CONFORM TO A 2.75 CF FLANGE SUCH AS A 275-150N.
12. EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF WELD RESIDUE, SCALE, DIRT, AND INK.
13. TACK WELD CAN BE USED IF NEEDED FOR SETUP, VOLUME MUST VENT TO THE INSIDE.
14. ELECTROPOLISH AFTER WELDING PER BEST COMMERCIAL PRACTICE. MASK CF FLANGE GASKET SURFACE.

QTY REQD	ITEM NO	REF DES	CAGE NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE
1	3			20007812-103	TOP		CRES 304 PER ASTM A167	
1	2			20007812-102	TUBING, .120 WALL Ø8.00	SST-800	(CRES 304)	
1	1			20007812-1	BASE, CF FLANGE 10.00	1000-800N	(CRES 304)	

PARTS LIST

CONTRACT NO

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS .XX ±.03 .XXX ±.010
ANGLES ±1/2°
MACHINE FINISH 125
DO NOT SCALE DRAWING
INTERPRET DWG PER ASME Y14.5M - 1994

MATERIAL
SEE PARTS LIST

THIS DRAWING IS PRELIMINARY AND NOT UNDER CONFIGURATION CONTROL UNLESS A RED RELEASED STAMP APPEARS HERE.

DWN R.D.BILLING 02/23/04
PROJ ENGR
CHK
CONFG
ME
STRS
MATL
PROJ
QA

ALLIANCE SPACESYSTEMS, INC.
1250 Lincoln Ave., Suite 100
Pasadena, CA 91103

CHAMBER, TOP MOUNT
GS-13 SEISMOMETER
LIGO-D047812-A

20007810	1388
NEXT ASSEMBLY	PROJECT CODE
APPLICATION	

FILE ATTACHMENTS

LIGO D047812

SIZE	CAGE CODE		REV
E	1KNU9	20007812	v3
SCALE 1:1	UNCLASSIFIED	SHEET 1 OF 1	

REV 7.04

THIS DOCUMENT MAY CONTAIN ITAR CONTROLLED INFORMATION AND/OR COMMERCE CONTROLLED INFORMATION EXPORT RESTRICTIONS MAY APPLY