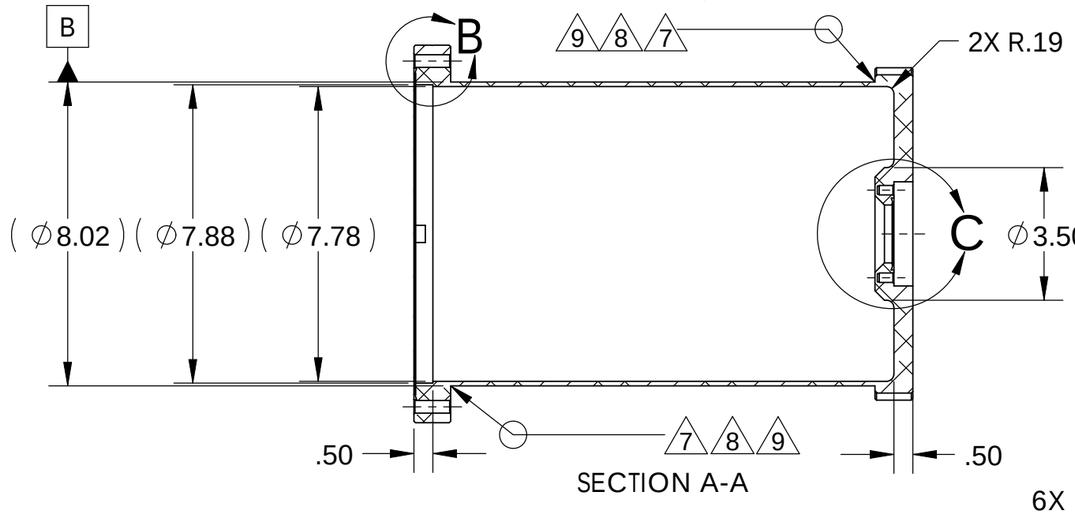
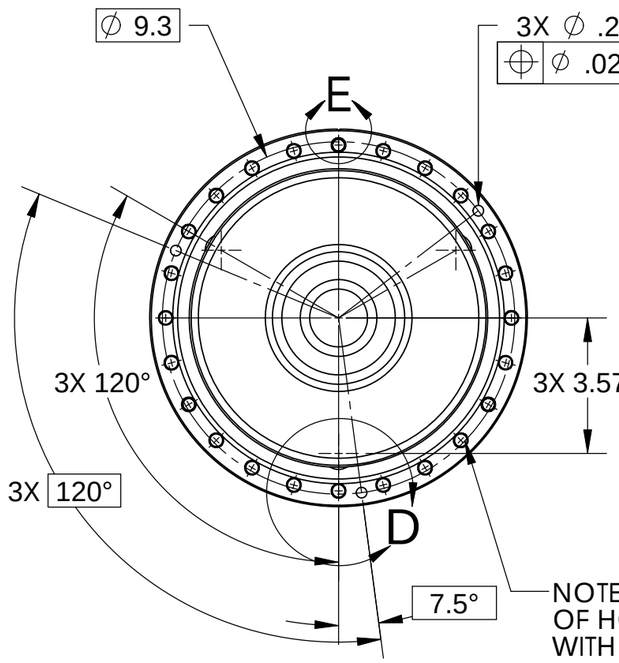
NOTES CONTINUED:

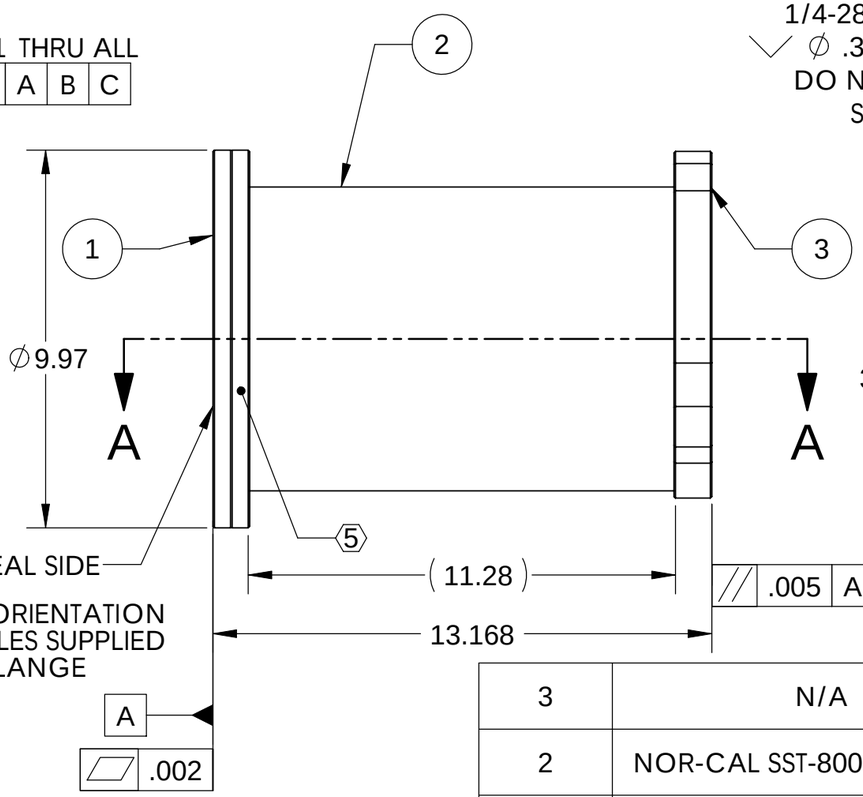
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. 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 REF. NOR-CAL 275-150N.
7. ALL WELDS TO BE EXTERNAL FUSION GTAW UHV WELDS.
8. JOINT CONFIGURATION TO BE DETERMINED BY VENDOR.
9. ALL WELDMENTS MUST BE FABRICATED IN COMPLIANCE WITH SPECIFICATIONS DEFINED IN LIGO DOCUMENT E0900048.
10. EXTERNAL SURFACE OF POD IS EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF: WELD RESIDUE, SCALE, DIRT AND INK.
11. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
12. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
13. APPROXIMATE WEIGHT = 27.3LB.
14. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.
15. ELECTROPOLISH TUBES PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE

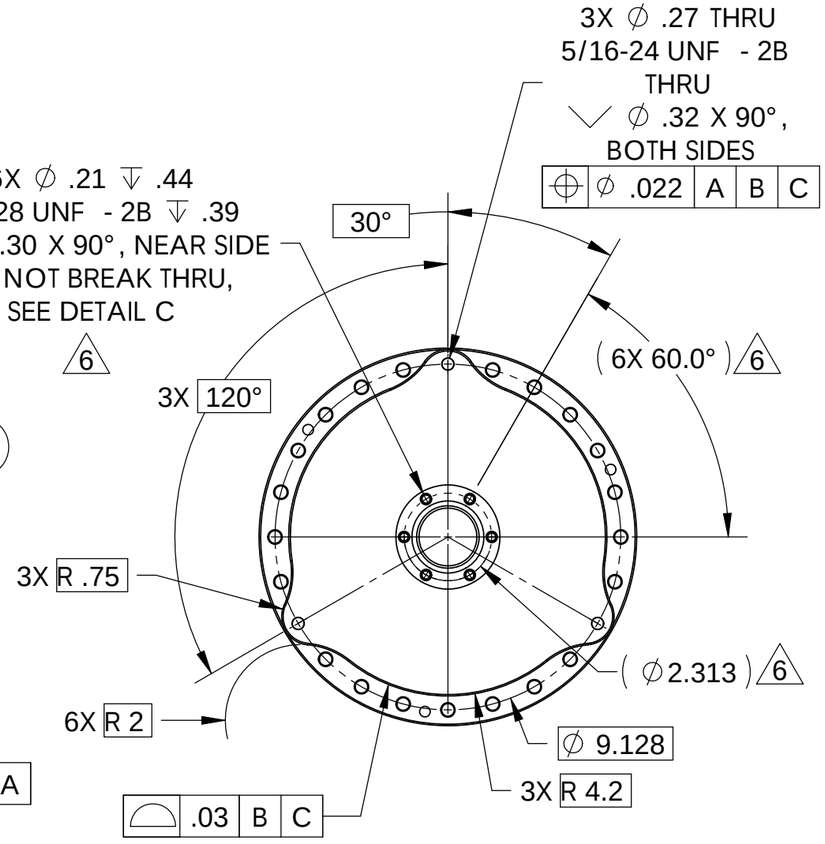
REV.	DATE	DCN #	DRAWING TREE #
v1	4 FEB 2010	E0900444	E1000025

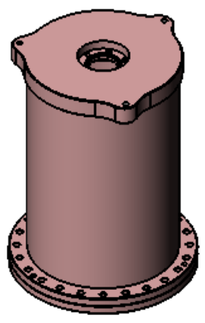


SECTION A-A









ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
3	N/A	10" CF BLANK FLANGE MODIFIED AS NOTED	304 SSTL	1
2	NOR-CAL SST-800 OR EQUIV.	8" OD TUBING CUT TO LENGTH	304 SSTL	1
1	NOR-CAL 1000-800NT OR EQUIV	10" CF FLANGE	304 SSTL	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± 0.1°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
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: 304 SSTL
FINISH: 63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SEI
NEXT ASSY: D0900857

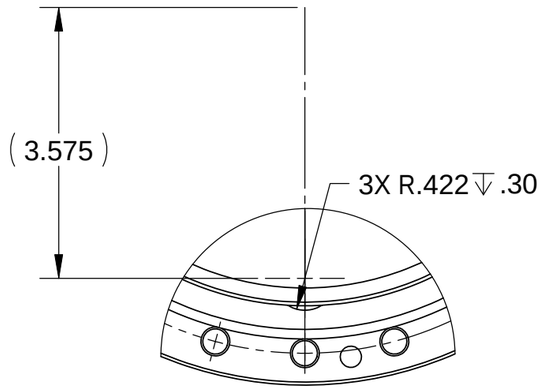
PART NAME: GS13 Pod Top Hat

DESIGNER	S.BARNUM	4 FEB 2010	
DRAFTER	M.HILLARD	4 FEB 2010	
CHECKER	F.Matichard	4 FEB 2010	
APPROVAL	K.MASON	4 FEB 2010	

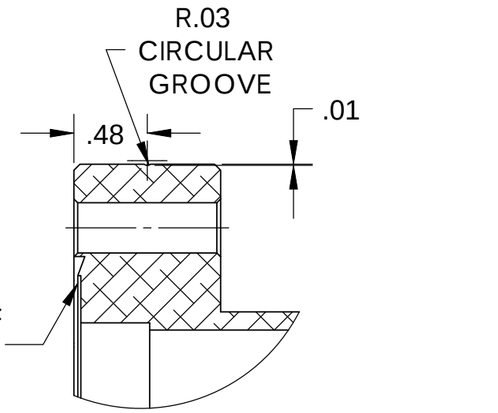
SIZE: B — DWG. NO.: D0900859 — REV.: v1
SCALE: 1:4 — PROJECTION: — SHEET 1 OF 2

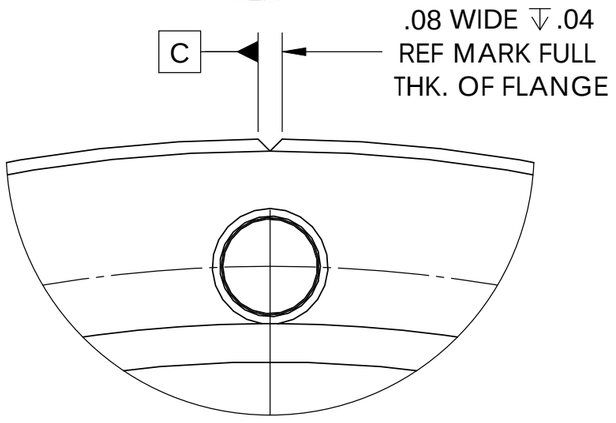
D0900859_GS-13_Pod_TopHat, PART PDM REV: X-016, DRAWING PDM REV: X-007

DETAIL D
SCALE 1 : 2

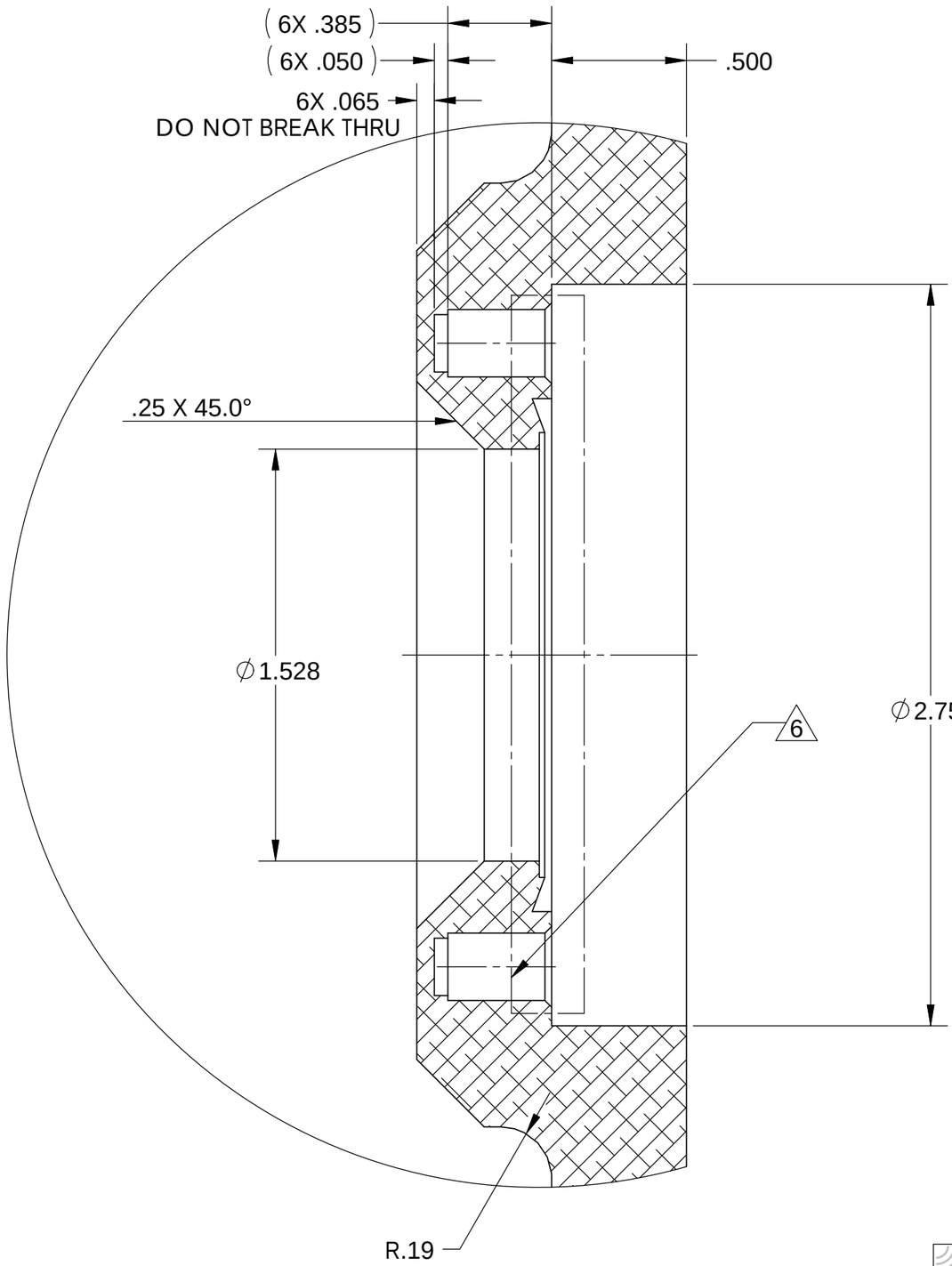


DETAIL B
SCALE 1 : 1





DETAIL E
SCALE 2 : 1



DETAIL C
SCALE 2 : 1

D0900859_GS-13_Pod_TopHat, PART PDM REV: X-016, DRAWING PDM REV: X-007

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D0900859	REV. v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2