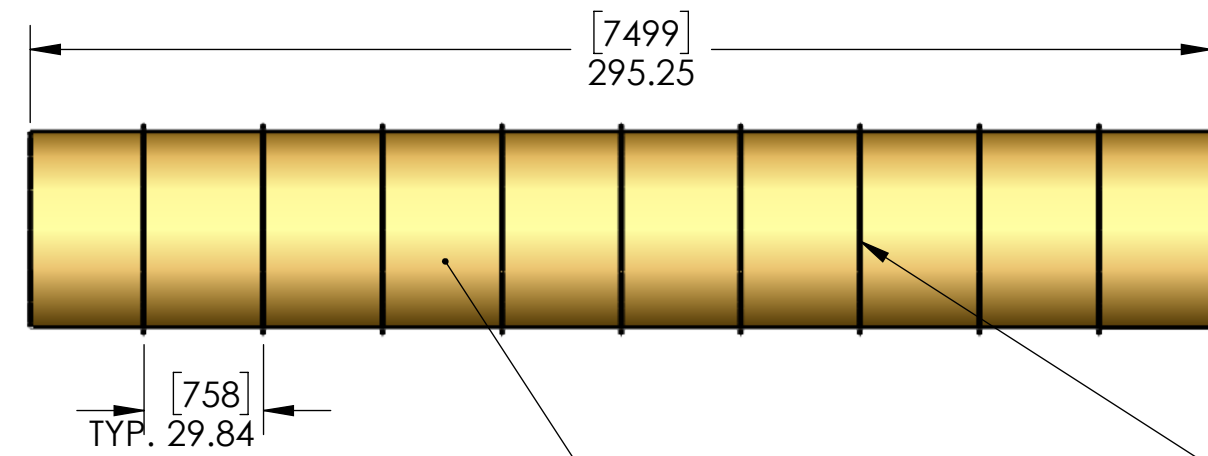
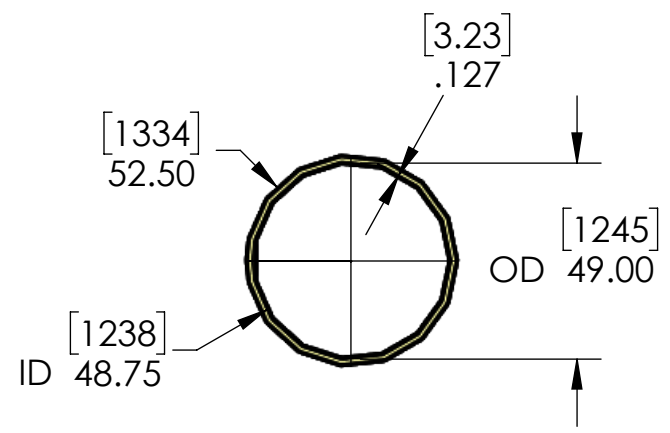
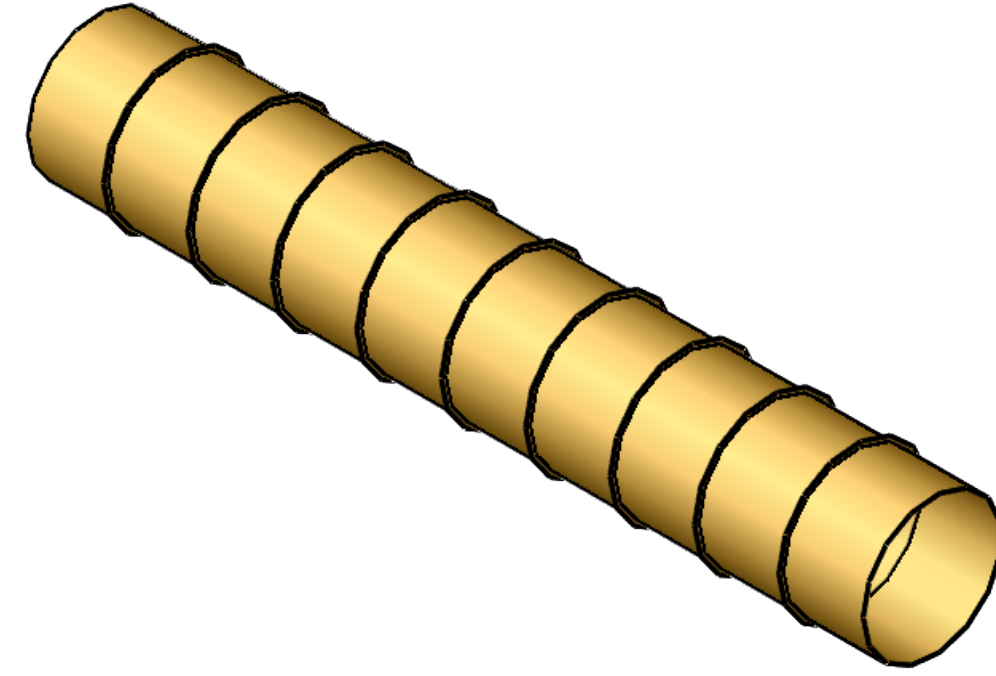


- NOTES CONTINUED:**
- 5. APPROXIMATE WEIGHT = X.XXX LB.
  - 6. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  - 7. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - 8. Processed per CBI Beam Tube specifications:
    - a. UNS S30203 low carbon "304L"
    - b. Air-oxidation firing @440C for 36 hrs
    - c. Clean with Mirachem 500, DI water (no hydrocarbon solvents)
    - d. 150C, ~30 day bakeout confirmed with mass spectrometry

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



D950040 VACUUM STIFFENERS

DERIVED FROM D950034, SUB-ASSEMBLY B

D1900102 LTREX beam tube w/ flanges (derived D950034 subassy B, D950040 stiffener), PART PDM REV.: , DRAWING PDM REV.:

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN TOLERANCES: .XX .XXX ANGULAR		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.		LTREX beam tube segment without flanges	
MATERIAL 304L Stainless Steel FINISH μinch		SYSTEM Vacuum SUB-SYSTEM NEXT ASSY		DESIGNER DRAFTER CHECKER APPROVAL	
		SIZE DWG. NO. B D1900102		REV.	
		SCALE: 1:48 PROJECTION:		SHEET 1 OF 1	