

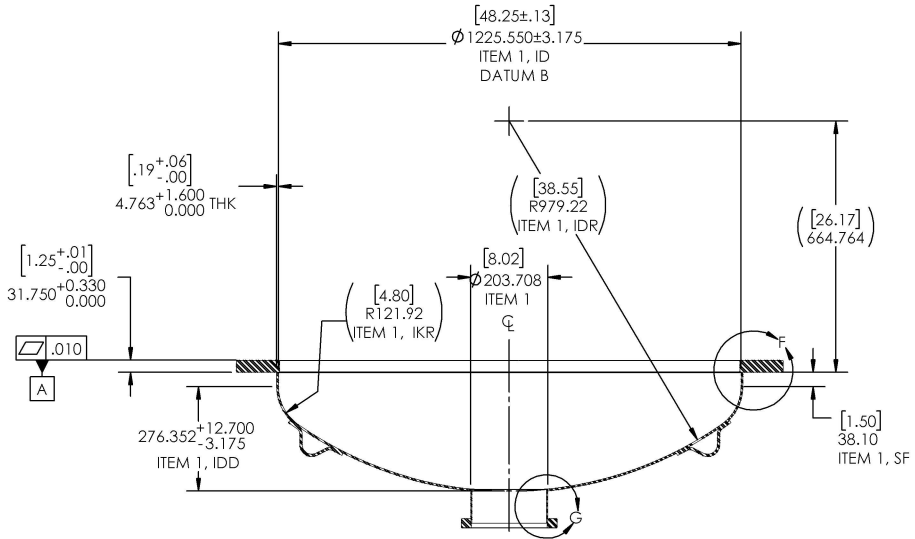
5) SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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. APPROXIMATE WEIGHT = 400.77 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
REFER TO LIGO SPECIFICATION E0900364.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL.
AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
11. 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 SPECIFICATION E0900364.
12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION, THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
14. REFER TO LIGO E0900408 & E0900404 FOR WELDING AND HELIUM LEAK TESTING SPECIFICATIONS.
15. FLANGES MUST BE PACKAGED, HANDLED AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.

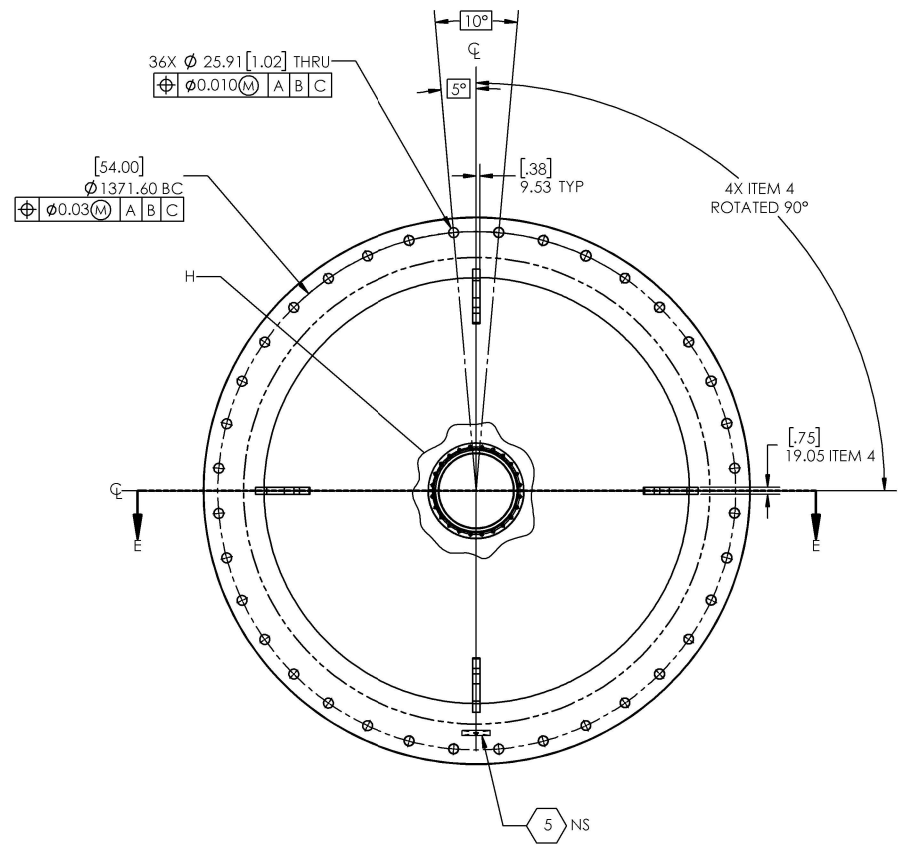
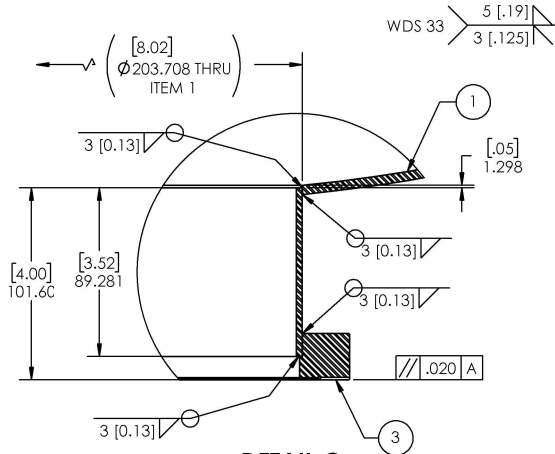


4	D2600123-04	4	LIFTING LUG, .75" X .25" THK, 304 SST	304 SS		
3	DN200CF-TBD	1	FLANGE,UHV,CS/304,BLANK,FXD, (10.00 in / 254.00 mm OD)	CSTL/304L SS	KJ LESKER CO	
2	D2600123-02	1	FLANGE, MAIN, 57"OD X 48"ID X 1" THK	CARBON STL		
1	D2600123-01	1	TORISPHERICAL HEAD, ASME 80-10, 48" OD	CARBON STL		
ITEM NO.	PART NUMBER	QTY.	DESCRIPTION	MATERIAL	SUPPLIER	
D2600123 WELDMENT						
INSTITUTE OF TECHNOLOGY INSTITUTE OF TECHNOLOGY		PART NAME ENDCAP WELDMENT, CEBEX				
	SUB-SYSTEM VE	DESIGNER	E SHANKLE	06/06/2026	SIZE DWG. NO. D2600123	REV. v1
		DRAFTER	E. SHANKLE	06/06/2026		
		CHECKER	CEBEX TEAM	06/07/2026		
		APPROVAL				
0234				SCALE: 1:10	PROJECTION: 	SHEET 1 OF 2

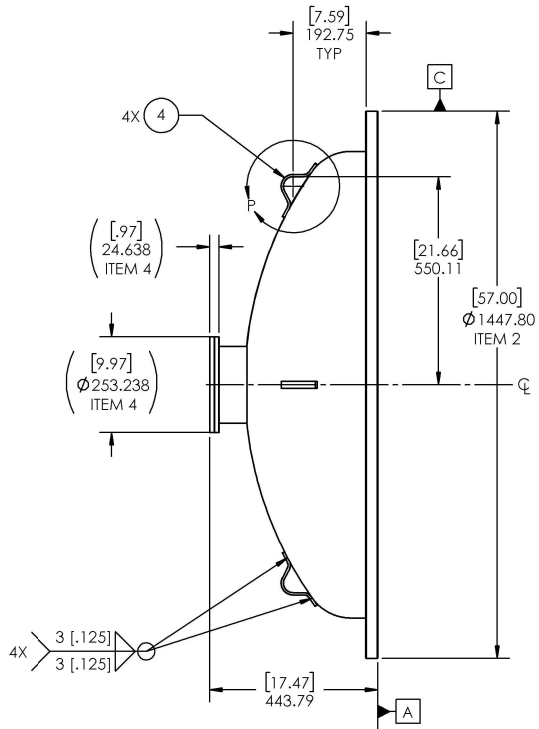
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		<div><div>CEBEX</div><div>CALIFORNIA INSTITUTE OF TECHNOLOGY</div><div>MASSACHUSETTS INSTITUTE OF TECHNOLOGY</div></div>		PART NAME								
DIMENSIONS ARE IN INCHES [MM]				ENDCAP WELDMENT, CEBEX								
TOLERANCES: .XX ± .03 .XXX ± .006		SYSTEM		SUB-SYSTEM		DESIGNER	E SHANKLE	06/06/2026	SIZE	DWG. NO.	REV.	
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.		LIGO		VE		DRAFTER	E. SHANKLE	06/06/2026	D	D2600123	v1	
ANGULAR ± 0.5°		MATERIAL		FINISH		NEXT ASSY		CHECKER	CEBEX TEAM	06/07/2026	APPROVAL	
AISI 304		63 μinch		D2600234				SCALE: 1:10		PROJECTION:		SHEET 1 OF 2



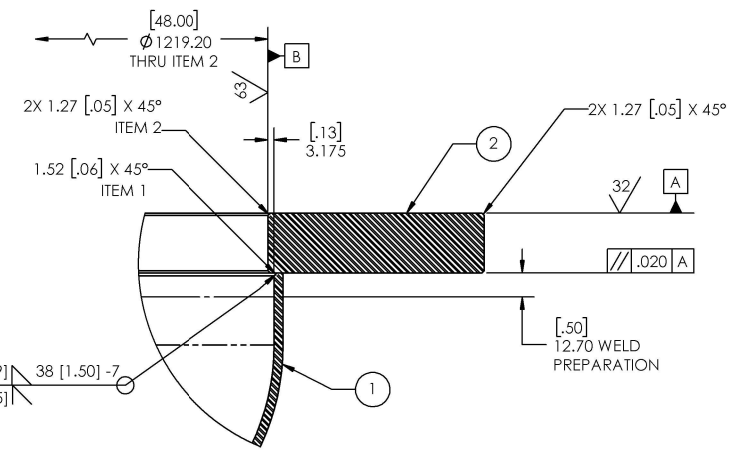
SECTION E-E



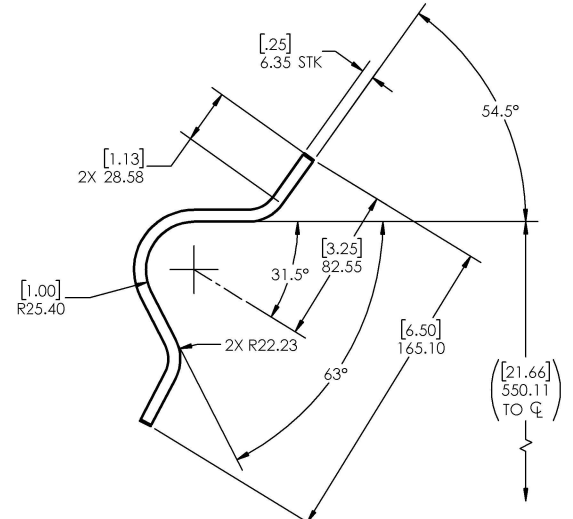
DETAIL G
SCALE 1 : 2



DETAIL H
SCALE 1 : 2



DETAIL F
SCALE 1 : 2



DETAIL P
ITEM 4, 4 PLACES
SCALE 1 : 2

PRELIMINARY

CEBEX		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE	DWG. NO.	REV.	
D	D2600123	v1	
SCALE: 1:10	PROJECTION:	SHEET 2 OF 2	