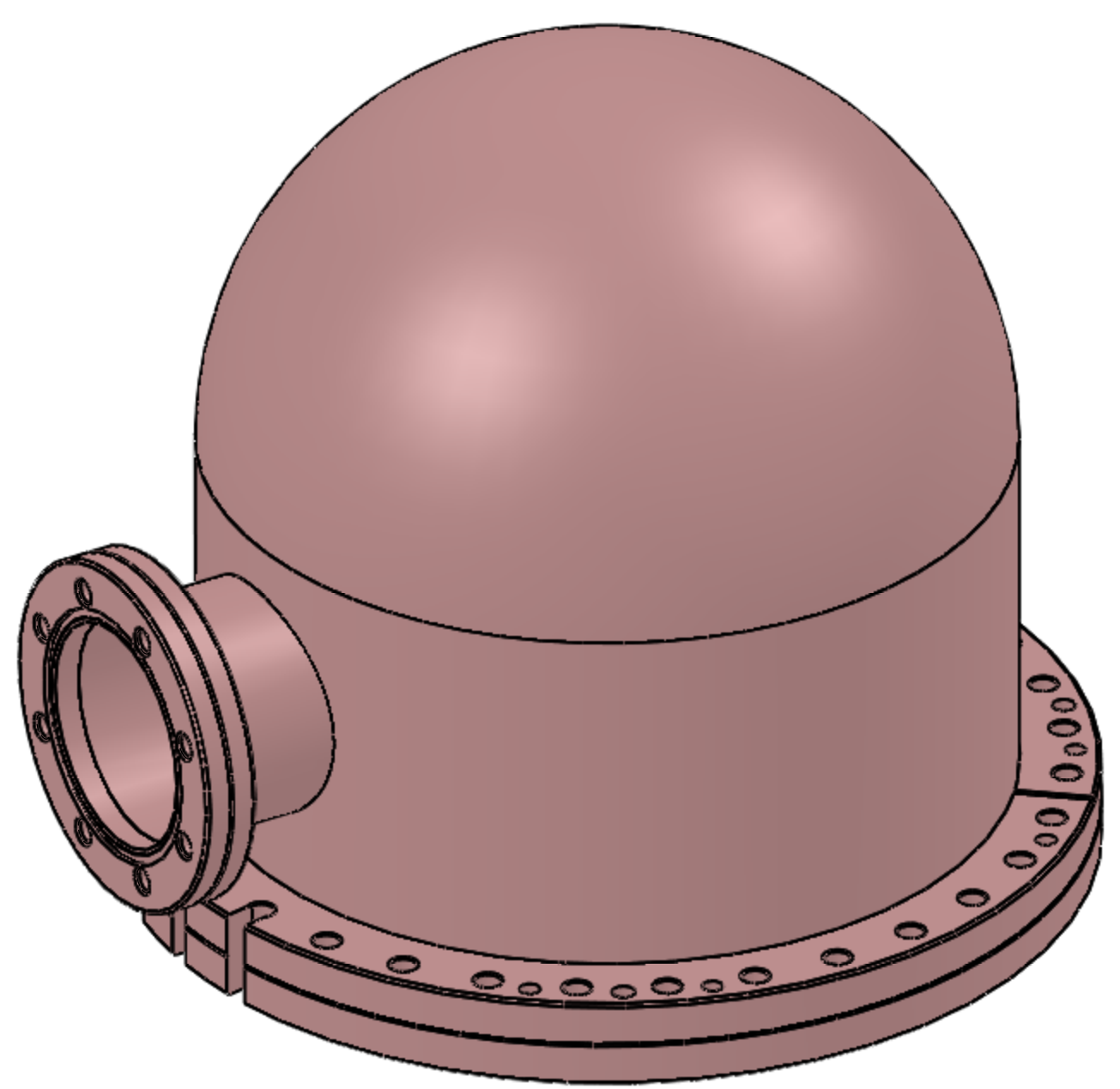
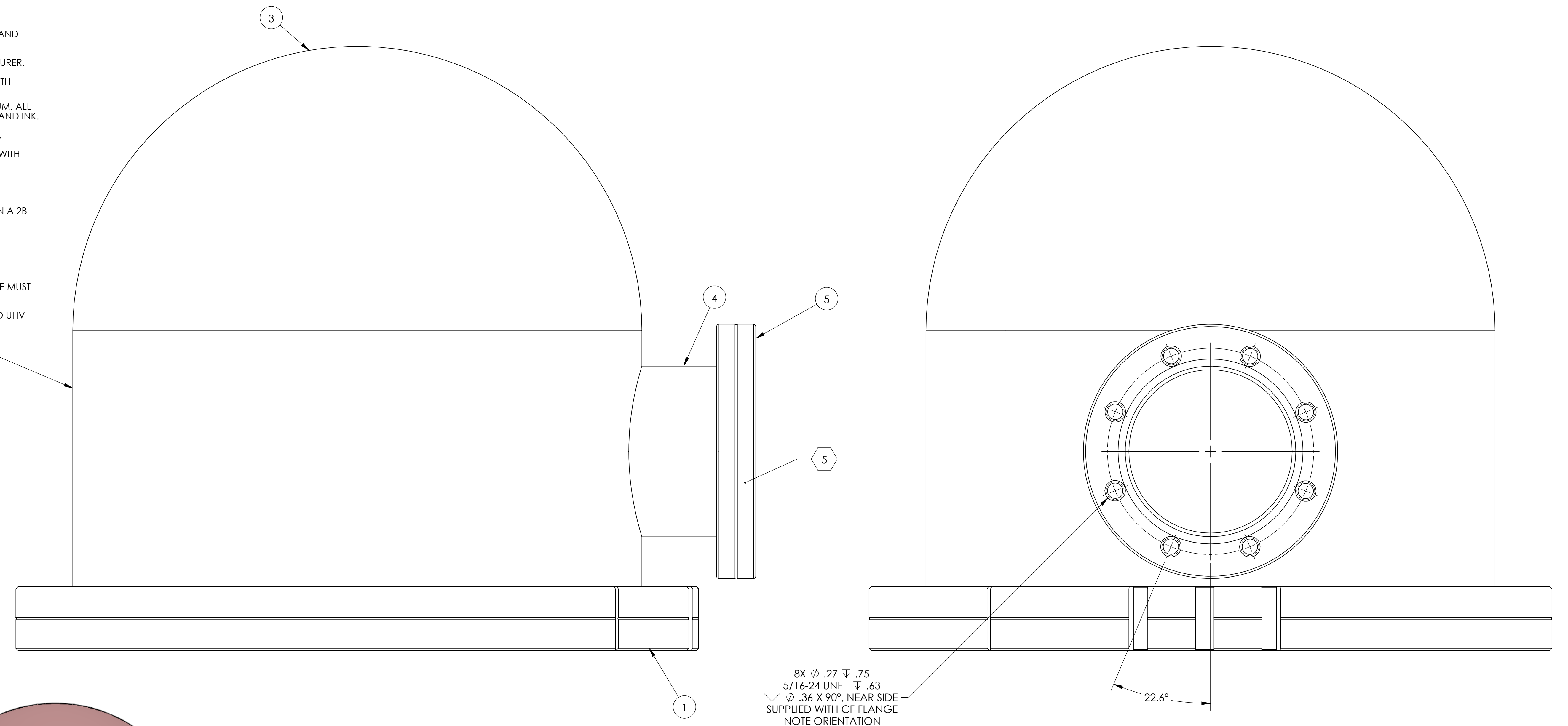


REV.	DATE	DCN #	DRAWING TREE #
v1	26 JAN 2010	E0900443-X0	E1000025
v2	22 MAR 2010	E0900443-V1	E1000025
v3	29 APR 2010	E1000146-V1	E1000025
v4	20 MAY 2010	E1000171-V1	E1000025

- NOTES CONTINUED:**
- ③ 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: DXXXXXX-VY, TYPE-XX, S/N XXX
  - ⚠ WELDS TO BE EXTERNAL FUSION GTAW UHV CONTINUOUS AND FULL PENETRATION.
  - ⚠ JOINT CONFIGURATION TO BE DETERMINED BY MANUFACTURER.
  - ⚠ 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 E0900364.
  - 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 AFTER WELDING PER BEST COMMERCIAL PRACTICE. MASK CF FLANGE GASKET SURFACES.
  - ⚠ PULL PORT CAN BE USED
  - ⚠ TACK WELD CAN BE USED IF NEEDED FOR SET UP. VOLUME MUST VENT TO INSIDE.
  - ⚠ WELDS TO BE CONTINUOUS EXTERNAL FUSION GTAW AND UHV COMPATIBLE.



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
5	Nor-Cal_450-250NT	Nor-Cal CF Flange 4.5"n 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 MACHINED TO SAME DIMENSIONS AND TOLERANCES	304 SSSL	1

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

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

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SEI

NEXT ASSY: D0900648

PART NAME		TRILLIUM 240 POD TOP HAT	
DESIGNER	S. BARNUM	2 Dec. 2009	SIZE DWG. NO.
DRAFTER	M.HILLARD	26 Jan 2010	D D0900649
CHECKER	F.MATCHARD	26 Jan 2010	REV. v4
APPROVAL	K.MASON	26 Jan 2010	SCALE: 1:1 PROJECTION: SHEET 1 OF 2

D0900649\_Trillium\_Pod\_TopHat\_PART.PDM.REV.X.027\_DRAWING.PDM.REV.X.015

