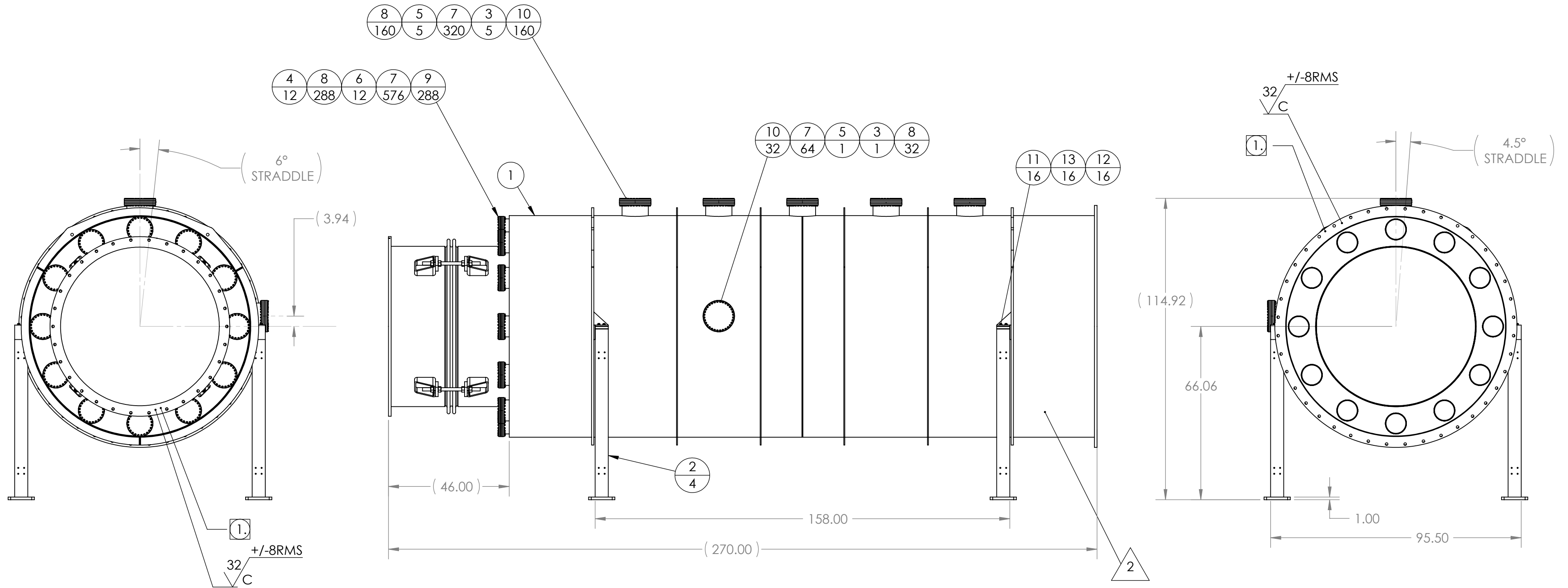


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED HARDWARE TO Zn COATED; RELEASED TO PRODUCTION	8/24/2010	MKM2



NOTES:

- 1. VACUUM SEALING SURFACE
- 2. SCRIBE THE FOLLOWING ON THE INDICATED SURFACE:
 - a. LIGO PART NUMBER,
 - b. SERIAL NUMBER,
 - c. GNB PART NUMBER
- 2. CLEAN PER LIGO SPECIFICATION E0900403
- 3. BAKEOUT PER LIGO SPECIFICATION E0900407
- 4. LEAK CHECK PER LIGO SPECIFICATION E0900404
- 5. KEEP FREE OF CONTAMINATION. ANY CONTAMINATION MUST BE REMOVED WITH A CO2 SPRAY IMMEDIATELY.
- 6. VERIFY CLEANLINESS PER PROCEDURE
- 7. PREPARE FOR SHIPPING PER
- 8. ALL CONFLAT FLANGES ARE NON-ROTATABLE WITH THRU HOLES.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114248-00WS	WELDMENT, MC-A TUBE	1
2	114386-00WM	STAND, MCA, SINGLE SUPPORT	4
3	G-1200	(NORCAL) GASKET, COPPER, 12" CF	6
4	G-1000	(NORCAL) GASKET, COPPER, 10" CF	12
5	1200-000N	(NORCAL) BLANK, CF, 12" OD	6
6	1000-000N	(NORCAL) BLANK, CF, 10" OD	12
7	F0500000Z	WASHER, 5/16 NOM ID, 0.065 THK, Zn COATED	960
8	G05F0000Z	HEX NUT, 5/16-24, Zn COATED	480
9	C05F0400Z	HHCS, 5/16-24, 2.50 LG, Zn COATED	288
10	C05F0440Z	HHCS, 5/16-24, 2.75 LG, Zn COATED	192
11	C08C0360Z	HHCS, 1/2-13, 2.25 LG, Zn COATED	16
12	91525A145	(MCM) WASHER, FENDER, 1/2 NOM ID, 1.5" OD	16
13	L0800000Z	LOCK WASHER, 1/2 NOM ID, 0.125 THK, Zn COATED	16

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240
 WEIGHT: 9192.47#

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: ± 0°30'
 .XX ±.06
 .XXX ±.005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

APPROVALS: DATE
 DRAFTER MKM2 6/11/10
 CHECKER RW 6/15/10
 ENGINEER MKM2 6/11/10

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

SCALE: 1:30

TITLE: ASSEMBLY, MC-A TUBE
 WAMCA#1/LAMCA#1

DWG. NO. 114247-00S
 SHEET 1 OF 1

REV A

TORQUE TABLE		
ITEM	TORQUE VALUE	UNITS
14	110	IN-LB
12, 15, 16, 19	190	IN-LB
18, 27	345	IN-LB