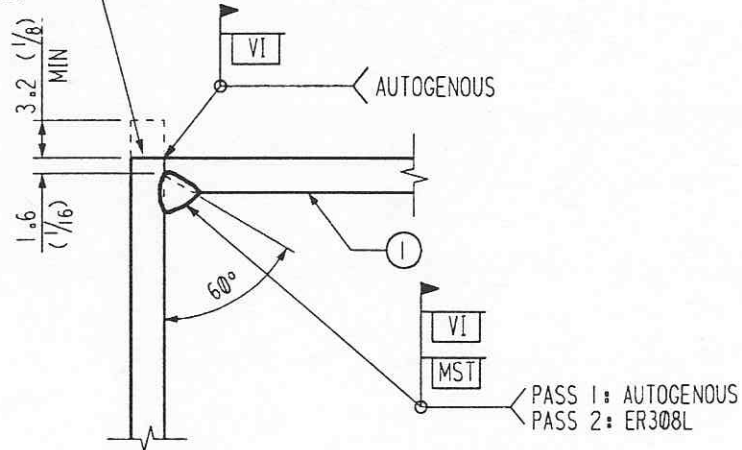
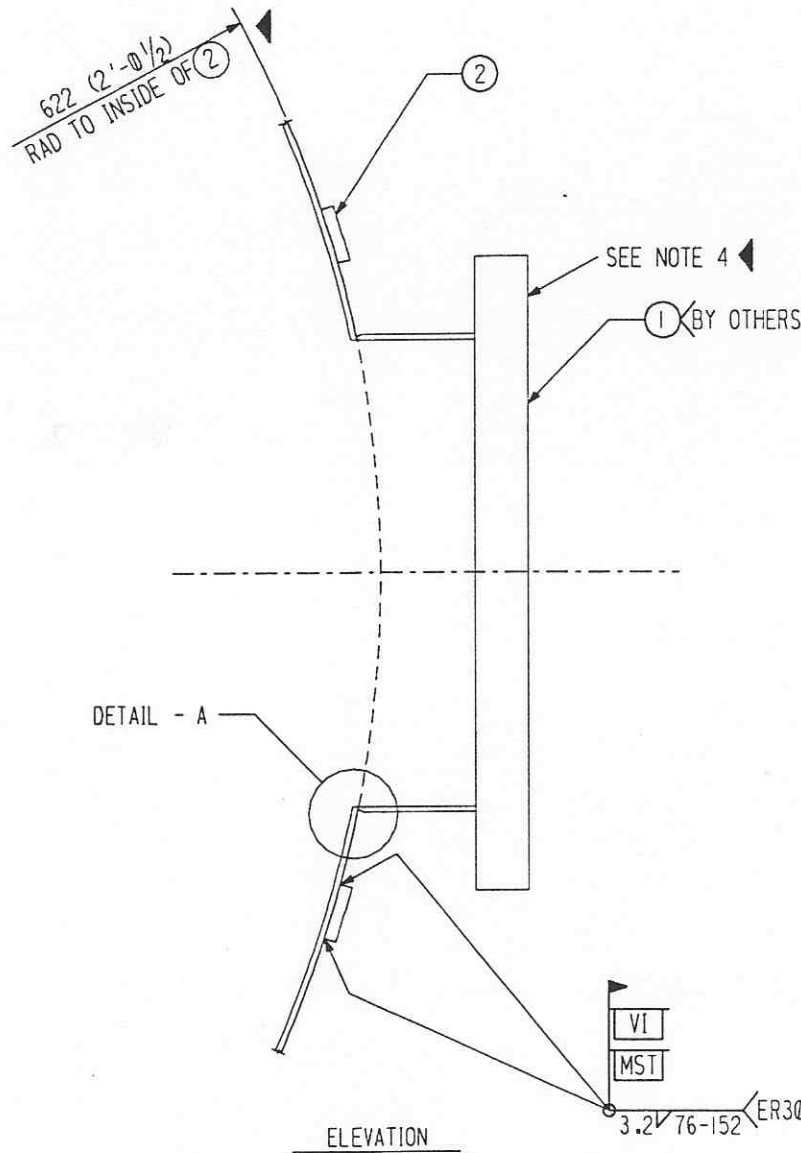


GRIND FLUSH
AFTER WELDING

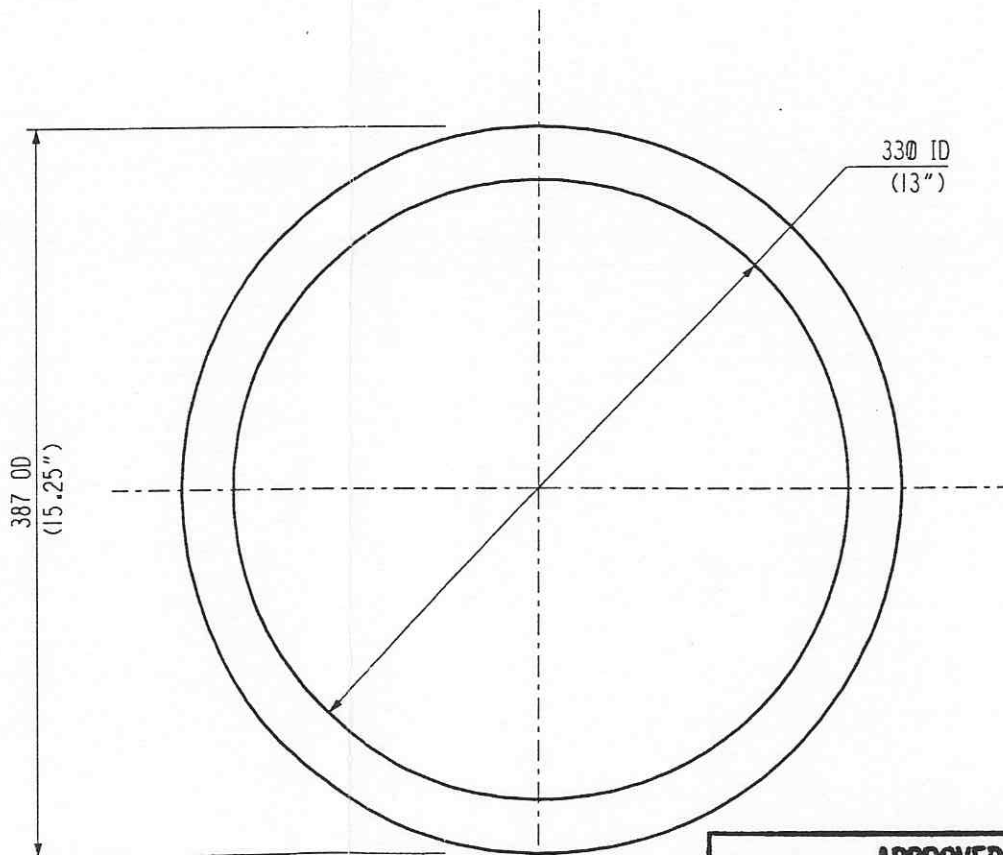


DETAIL - A



DETAIL - A

ELEVATION



SEE NOTE 3

SHP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
72	13-1		CONFLAT FLANGE OR EQUAL 13 1/4" OD W/ PIPE 254 OD X 3.05 THK (10 OD X 0.12 THK)	63 (2 1/2)	M5	Ac
72	13-2		PL 387 OD X 6.35 X 330 ID (1'-3 1/4 X 1/4 X 1'-1 ID)		M6	A
			M5 = SEE SPEC C-PORT-OP (SA240-TP304L)			
			M6 = SEE SPEC C-PORTPAD-1 (SA240-TP304L)			

SHOP:

REFER TO FABRICATION SPECIFICATION FOR INSTRUCTIONS.

NOTES:

- PUMP PORTS TO BE INSTALLED ON THE HORIZONTAL ϕ OF THE BEAM TUBE.
- WORK THIS DRAWING WITH DRAWING #4, SHEETS 1-7.
- CONFLAT IS A REGISTERED TRADE MARK OF VARIAN VACUUM PRODUCTS
- FLANGE BOLT HOLES TO STRADDLE VERTICAL CENTERLINE.

APPROVED	
<i>M. Tellalian</i>	8-12-96
CBI	DATE
<i>J. Jones</i>	8-23-96
CALTECH	DATE

CBI		SUPPLIER'S / PURCHASER'S NO	
LIGO BEAM TUBE HANFORD, WA & LIVINGSTON, LA PUMP PORT DETAILS			
CUSTOMER'S NO		CONTRACT NO	
BY KJR CHKD DET DATE 3-15-94		953571	
M.J. TELLALIAN		DWG 13	REV
ENGINEERING ASSIGNED		SHT	3
LIGO-D950039-03-B			

INDICATES CHANGE FROM PREVIOUS ISSUE