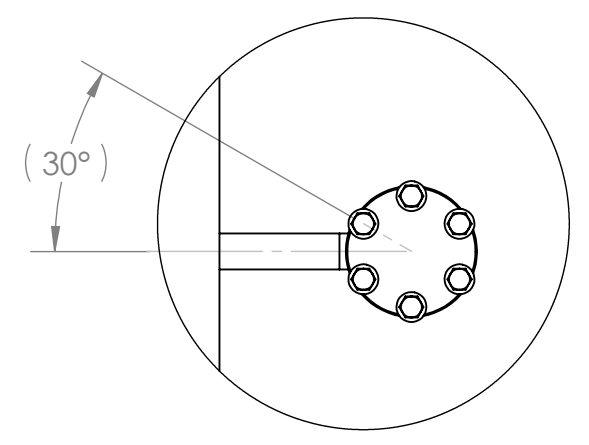
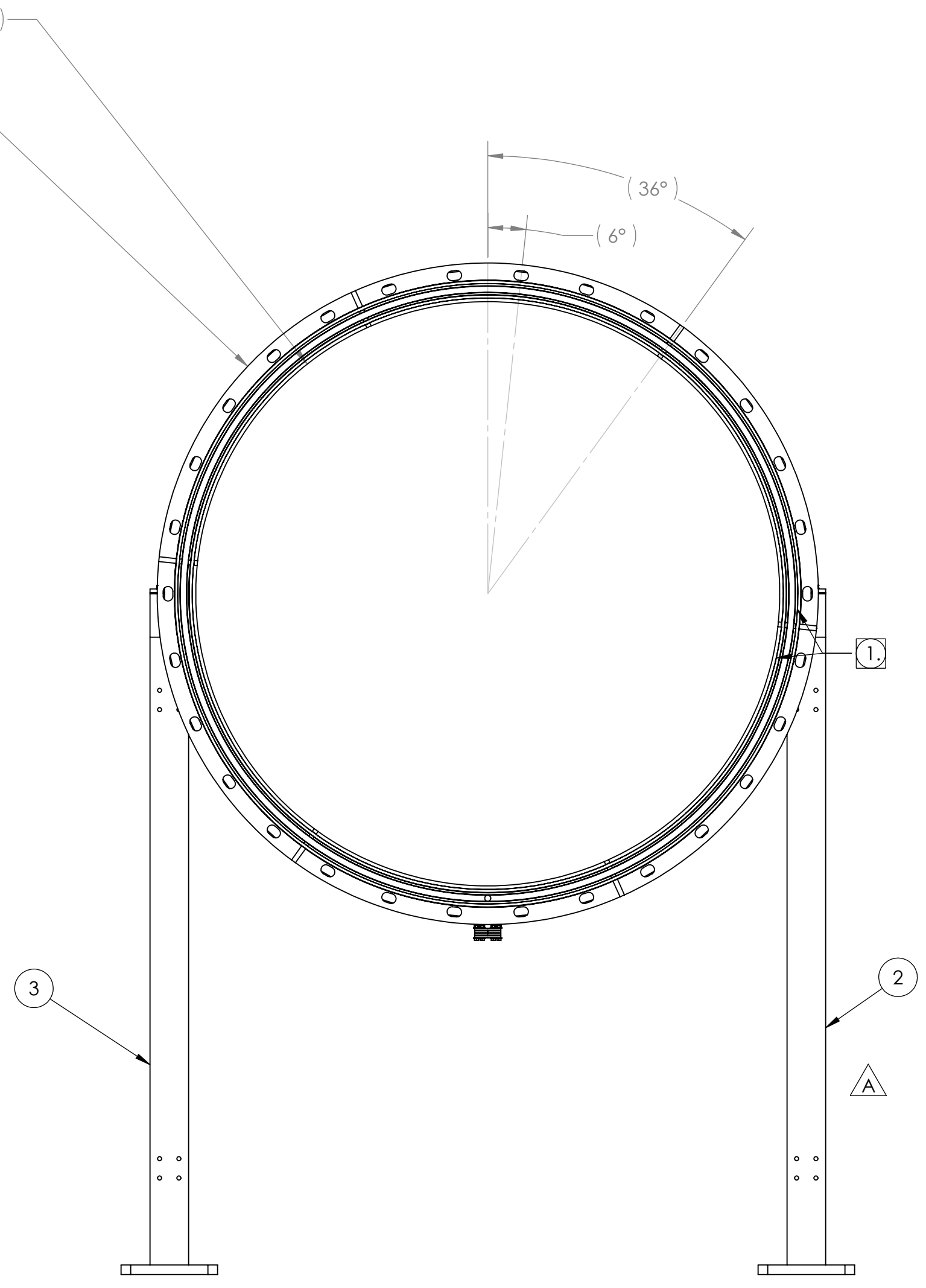
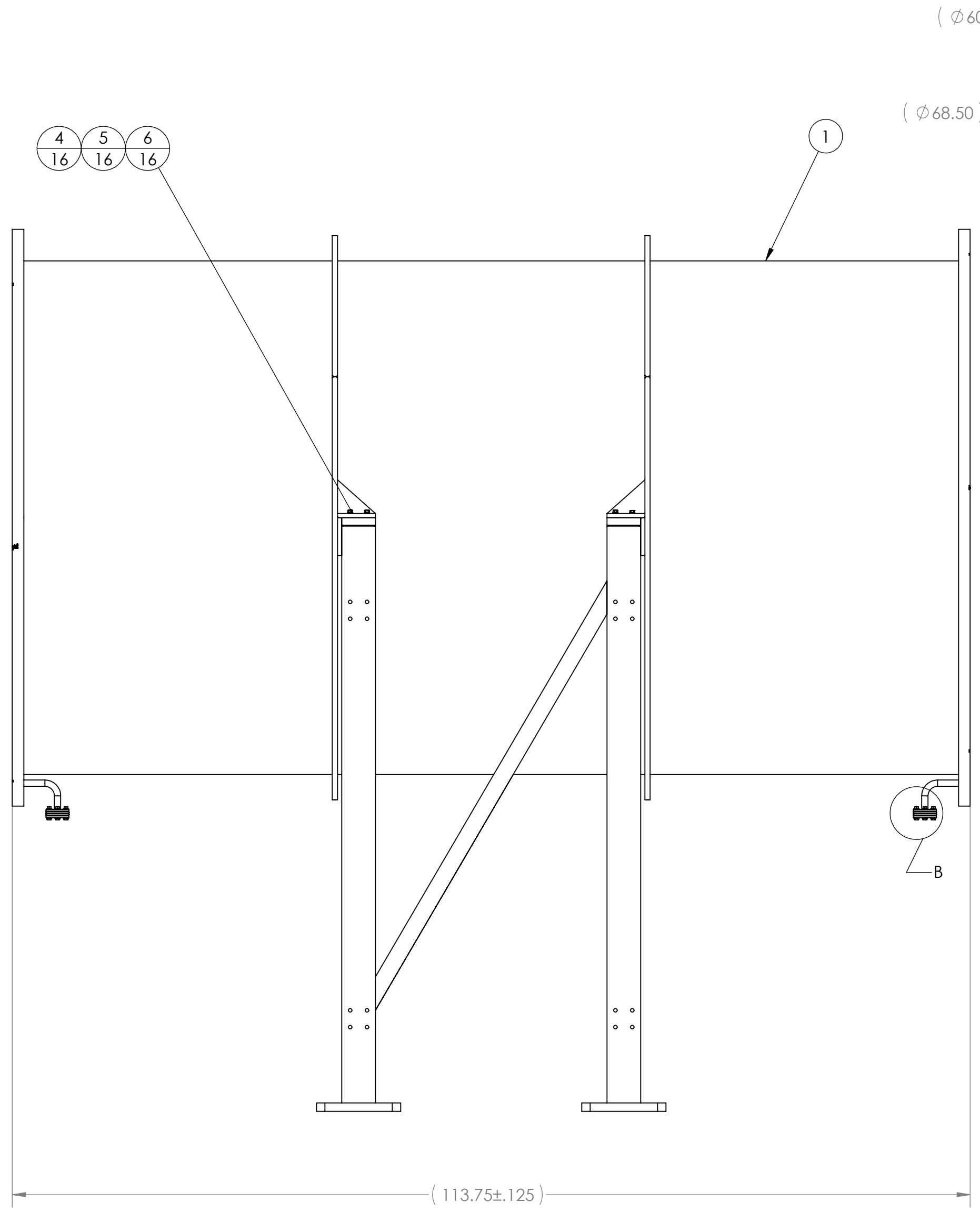
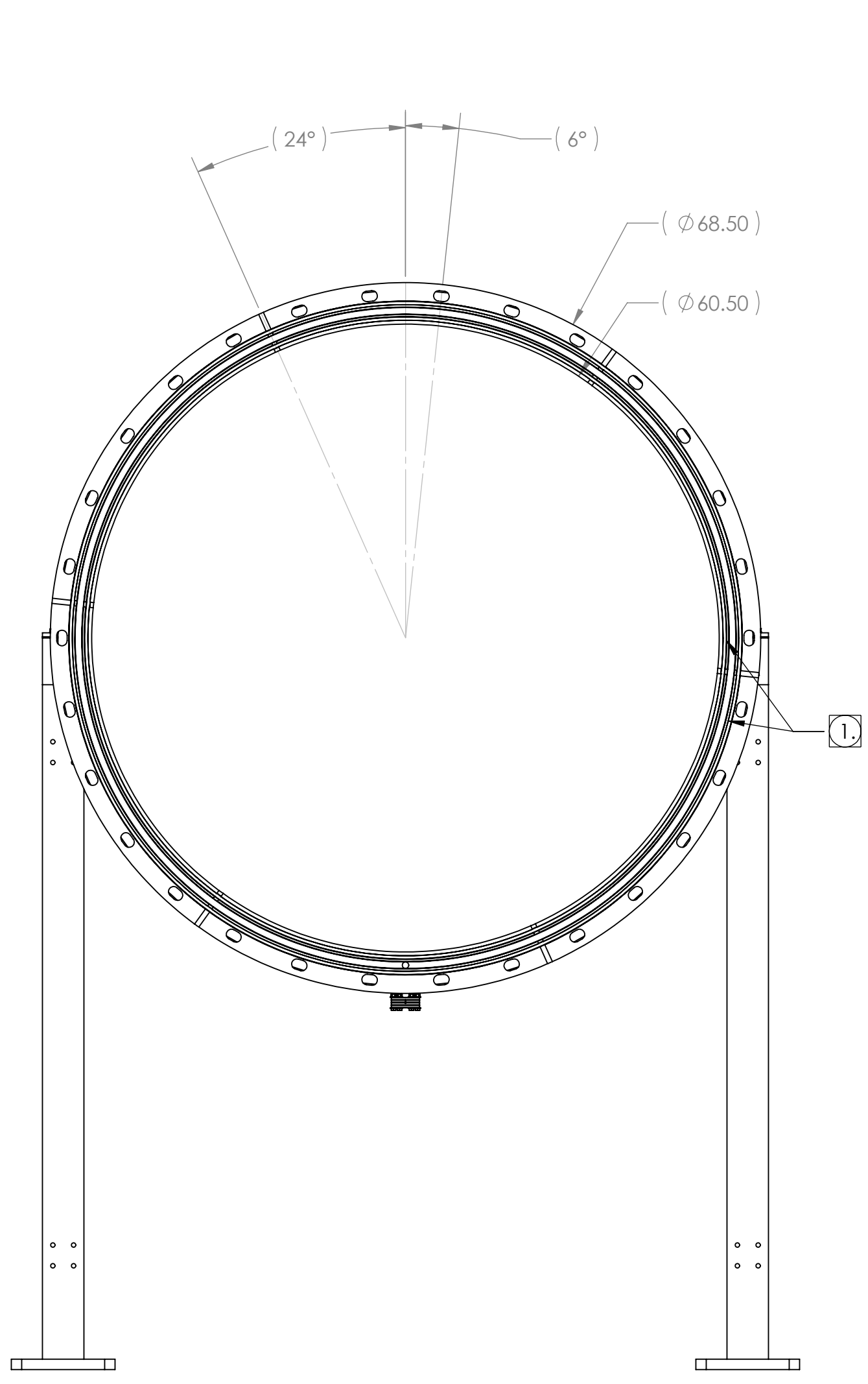
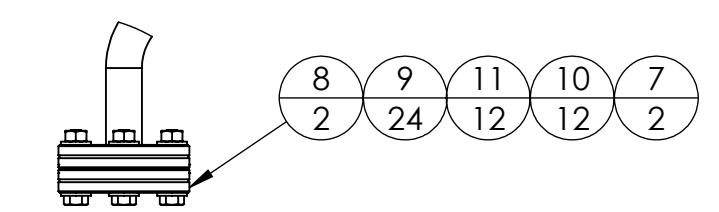


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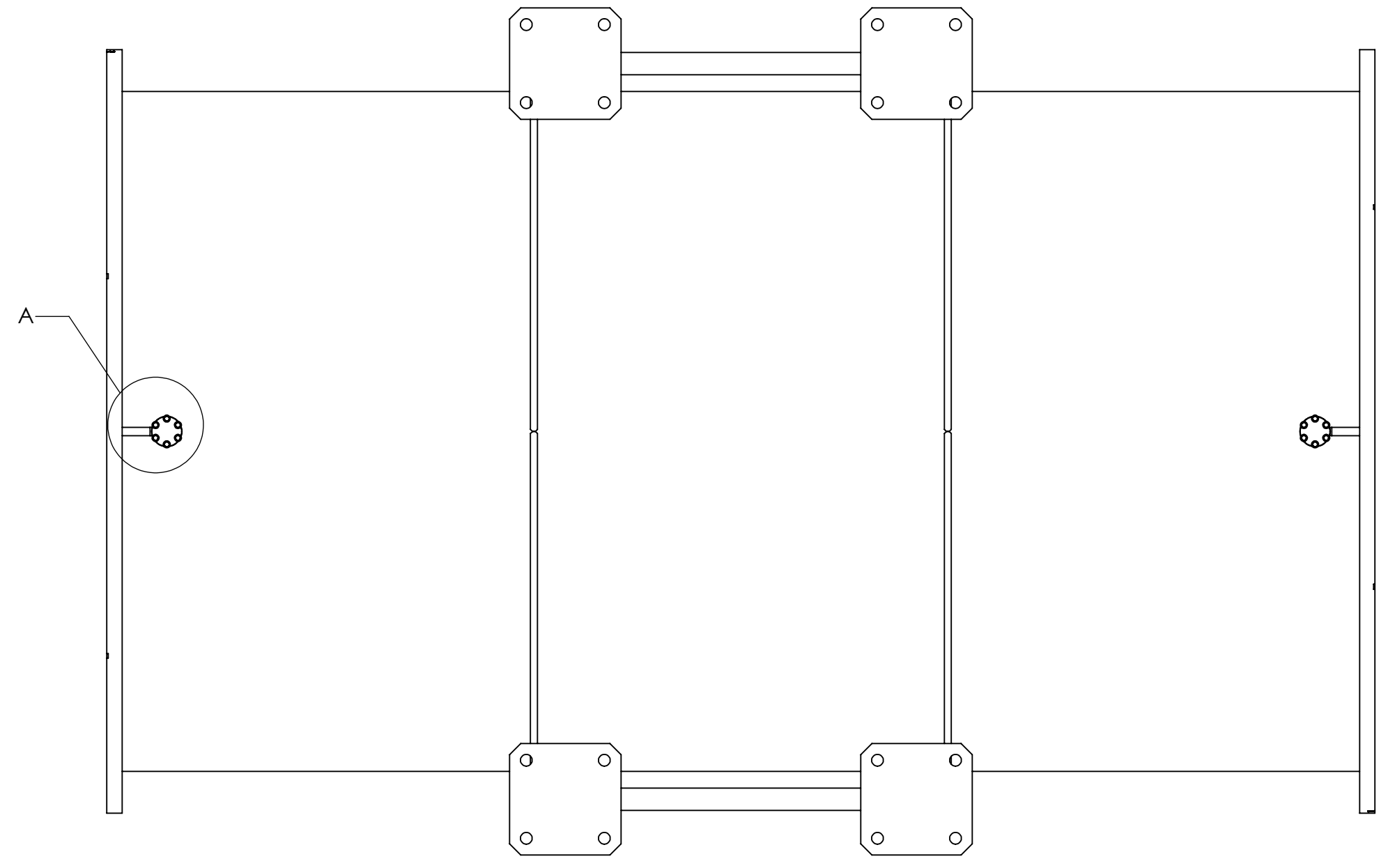
REVISIONS		DATE	APPROVED
ZONE	REV	DESCRIPTION	
	A	REVISED STAND PER NEW INFO FROM CUSTOMER	7/7/2010
	B	ADDED PUMP OUT PORT BLANK AND HARDWARE; RELEASED TO PRODUCTION	8/23/2010



DETAIL A  
SCALE 1 : 4



DETAIL B  
SCALE 1 : 4



- NOTES:
- VACUUM SEALING SURFACE
  - TORQUE ITEM 6 DOWN TO 11 FT-LBS
  - TORQUE ITEM 11 DOWN TO 110 IN-LBS
  - FOLLOW ALL LIGO SPECIFIC PROCEDURES FOR CLEANLINESS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114263-00WS	WELDMENT, FINAL, MIDSTATION SPOOL	1
2	114275-00WM	WELDMENT, STAND	1
3	114275-01WM	WELDMENT, STAND	1
4	91090A110	(MGM) WASHER, FENDER, 5/16 NOM ID, ZINC PLATED	16
5	L0500000S	LOCK WASHER, 5/16 NOM ID, 0.078 THK	16
6	C05C0320S	HHCS, 5/16-18, 2.00 LG	16
7	G-275	(NORCAL) GASKET, COPPER, 2.75" CF	2
8	275-000N	(NORCAL) BLANK, CF, 2.75" OD	2
9	F0400000M	WASHER, 1/4 NOM ID, 0.065 THK	24
10	G04F0000M	HEX NUT, 1/4-28	12
11	C04F0220M	HHCS, 1/4-28, 1.38 LG	12

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240  
 UNLESS OTHERWISE SPECIFIED: WEIGHT: 3056.87 #  
 DIMENSIONS ARE IN INCHES:  
 TOLERANCES: FINISH  
 ANGULAR: ±0°30' ±25'  
 XXX ±.005  
 UNSPECIFIED RADII: R.015  
 BREAK EDGES: .010x45°  
 REMOVE ALL BURRS  
 // ▽ ▽ ▽ WITHIN .03

APPROVALS DATE  
 DRAFTER MKM2 6/11/10  
 CHECKER RW 6/14/10  
 ENGINEER MKM2 6/11/10

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 www.gnbolives.com

TITLE: ASSEMBLY, MIDSTATION SPOOL

DO NOT SCALE DRAWING	D	DWG. NO. 114262-00S	REV B
		SCALE: 1:12	SHEET 1 OF 1