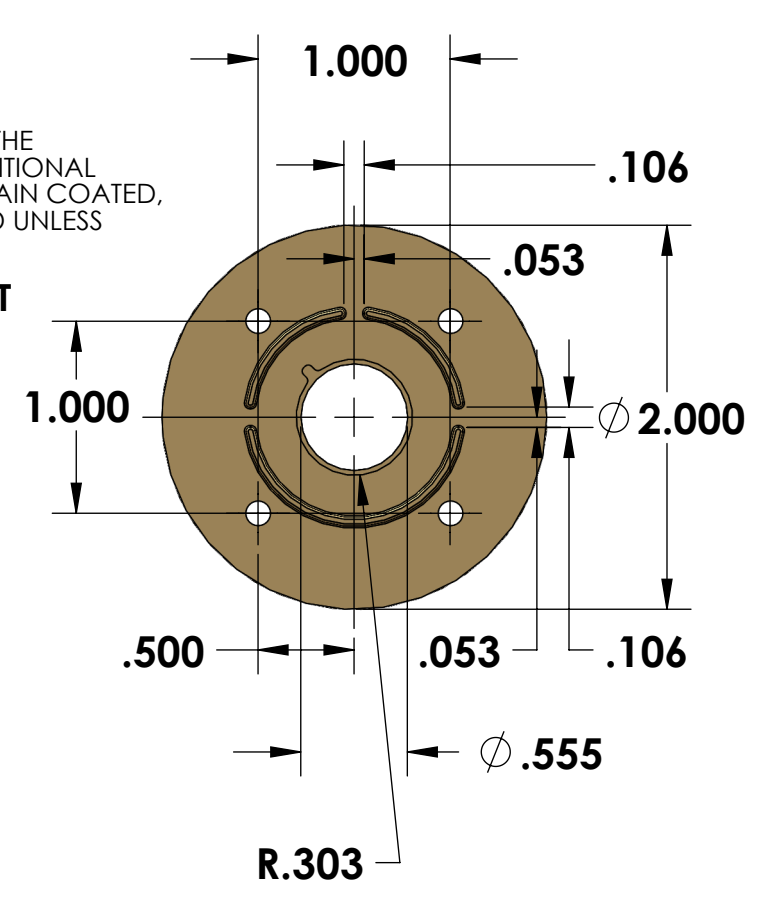


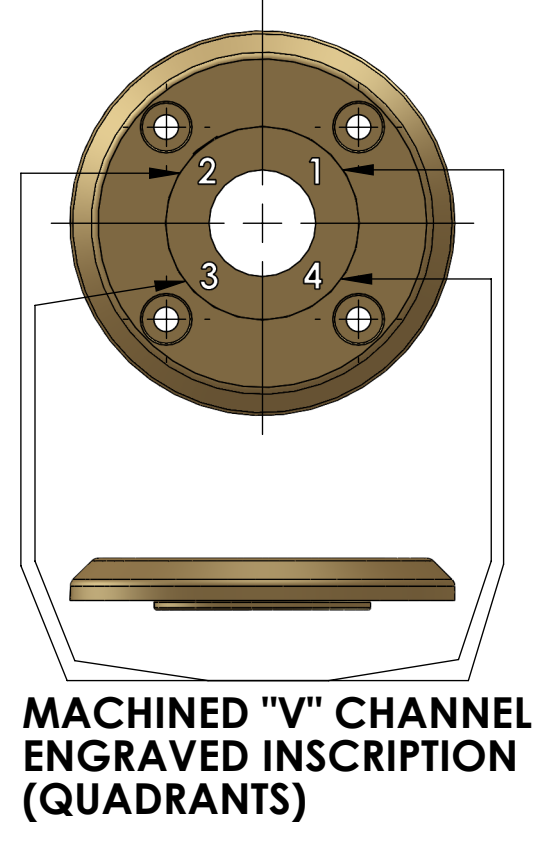
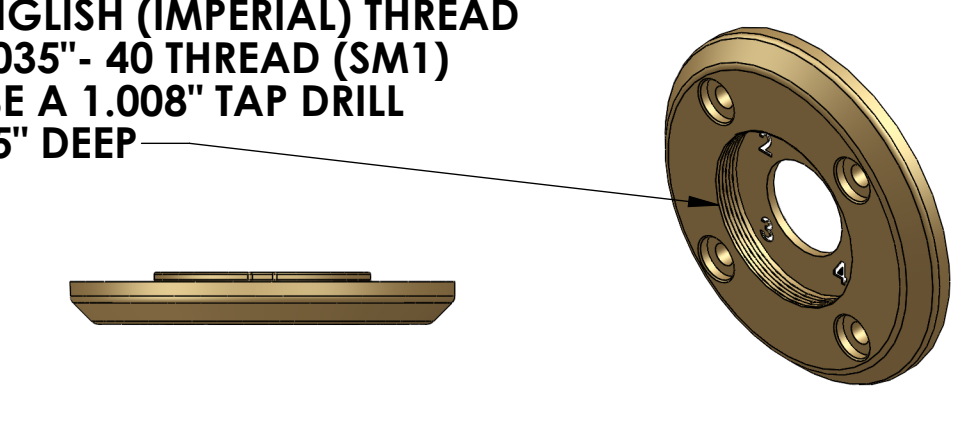
NOTES CONTINUED:  
 3. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.17" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N-XXX

- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-6590364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E090364.
- 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 40 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-6590364.
- 12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E100083 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. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
- 15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK. WHEN FORMING, IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

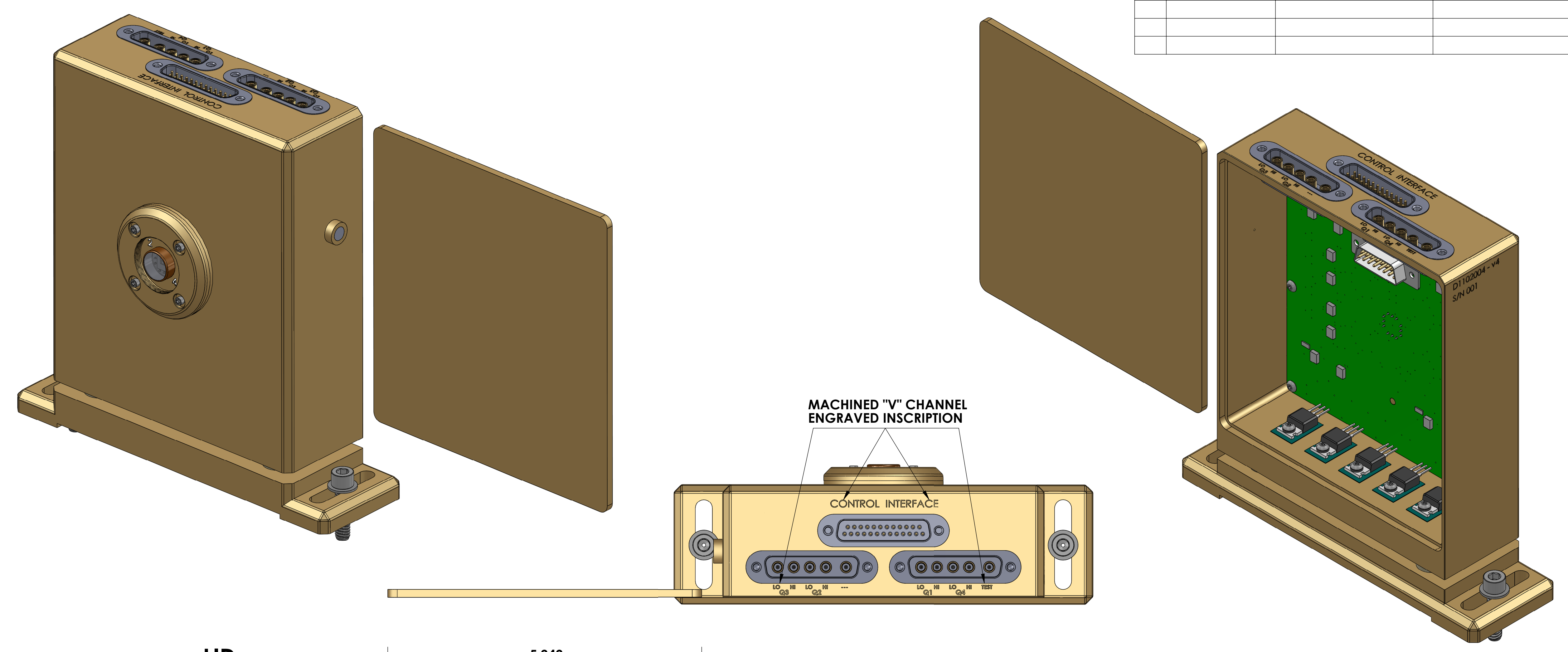
NOTES 9, 10, 13, 14 and 15 DO NOT APPLY TO THIS PART



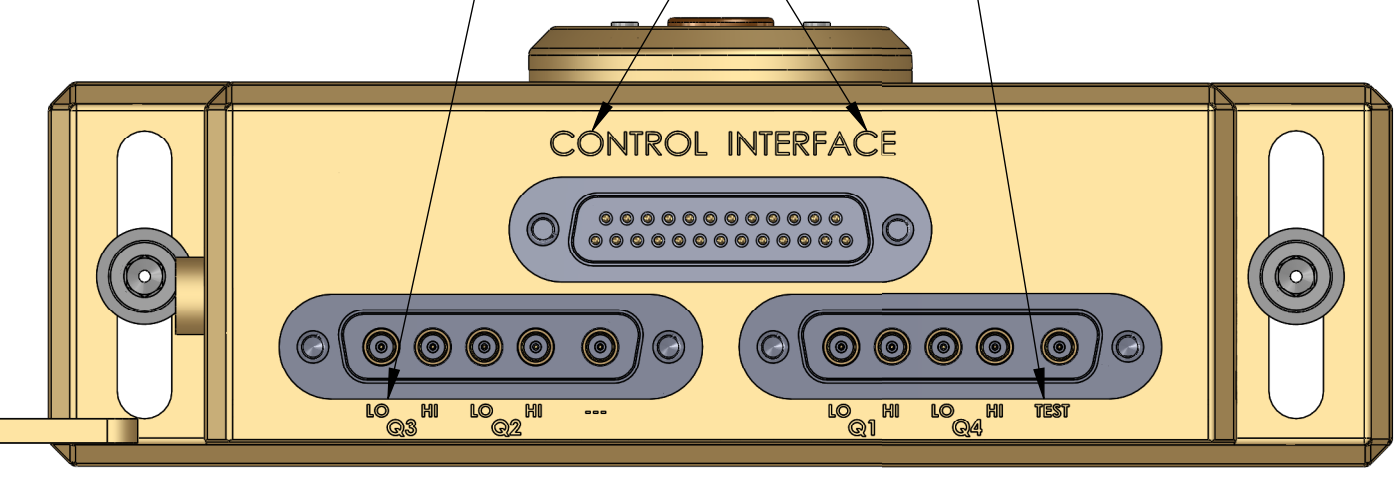
ENGLISH (IMPERIAL) THREAD  
 1.035"- 40 THREAD (SM1)  
 USE A 1.008" TAP DRILL  
 .15" DEEP



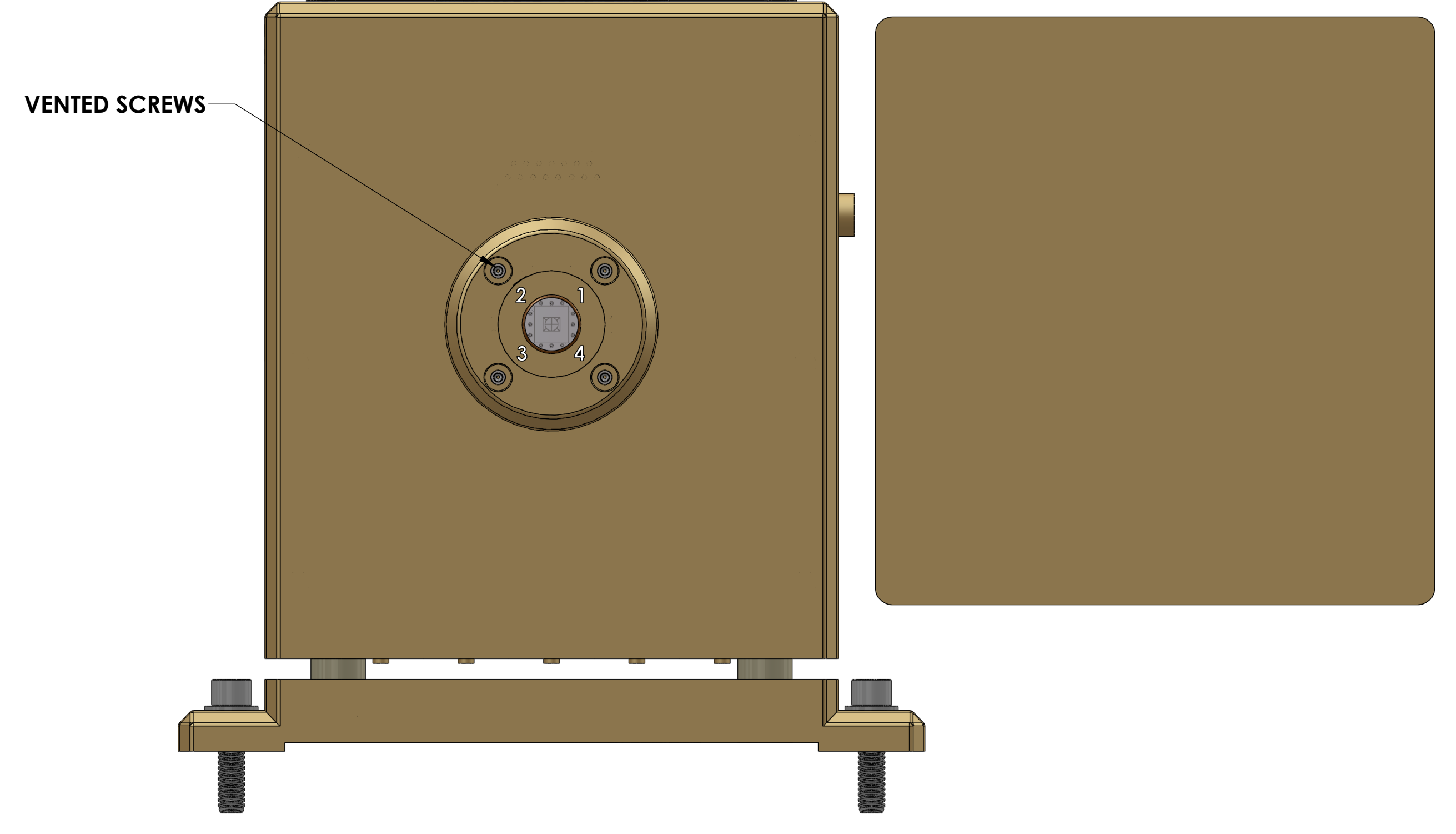
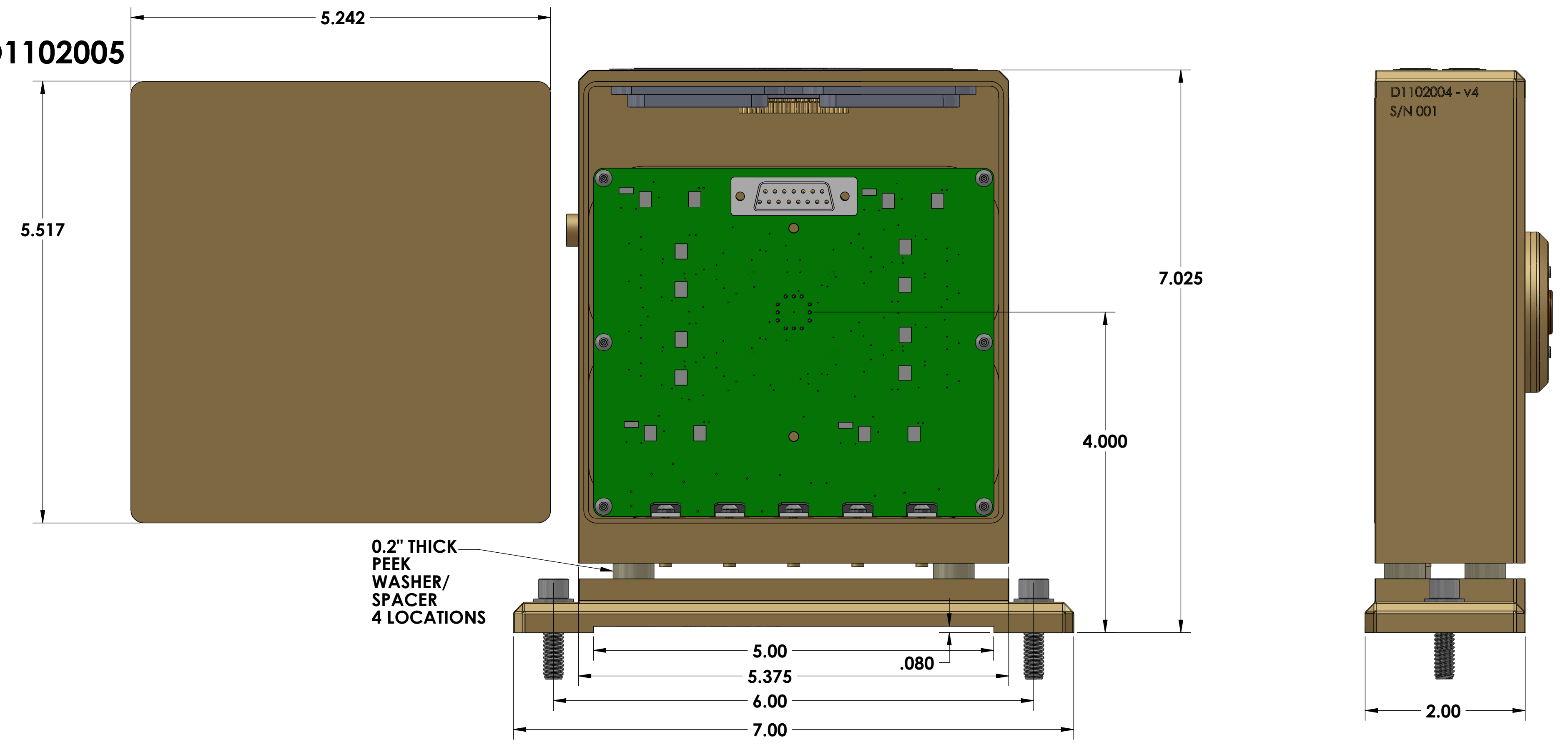
**PHOTO HOOD BRACKET  
 DCC# D1102006**



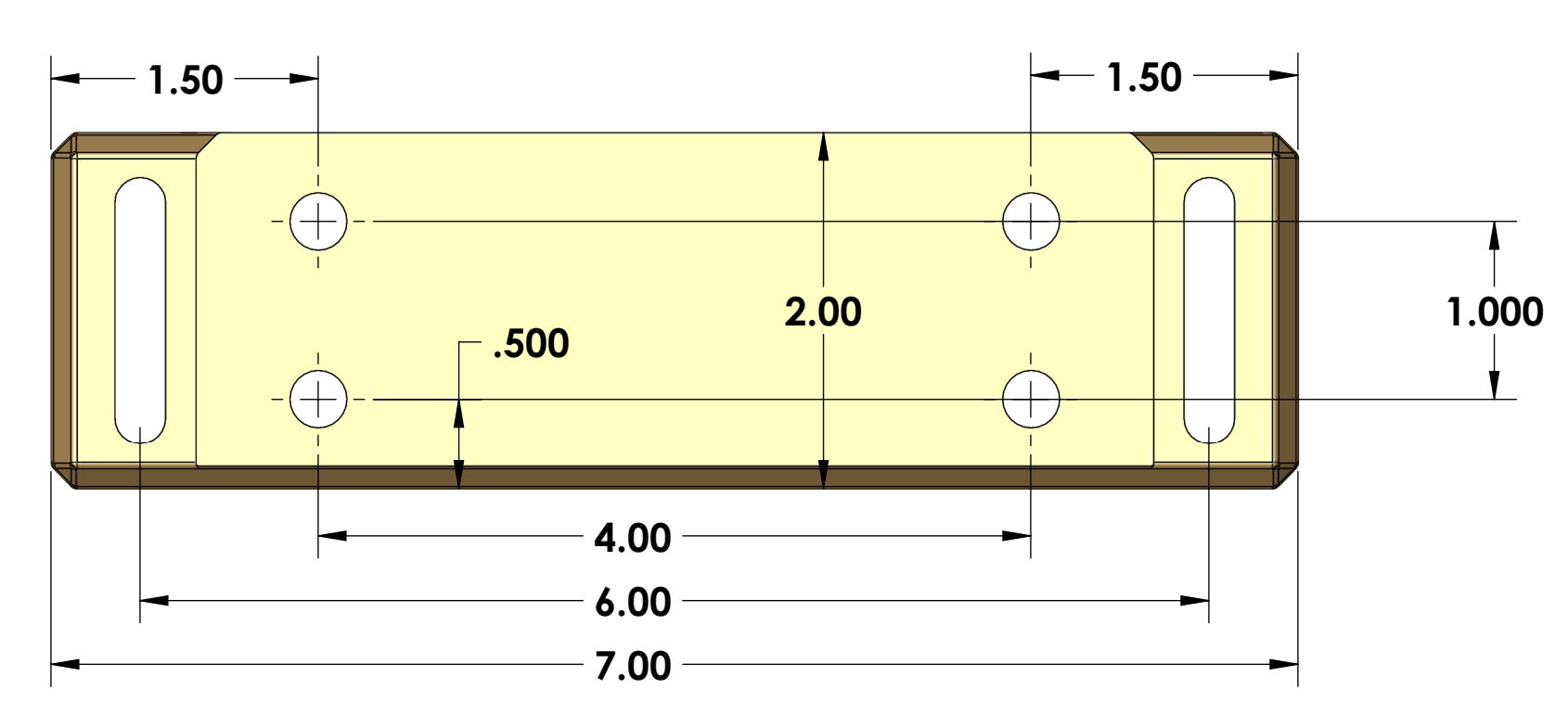
MACHINED "V" CHANNEL  
 ENGRAVED INSCRIPTION



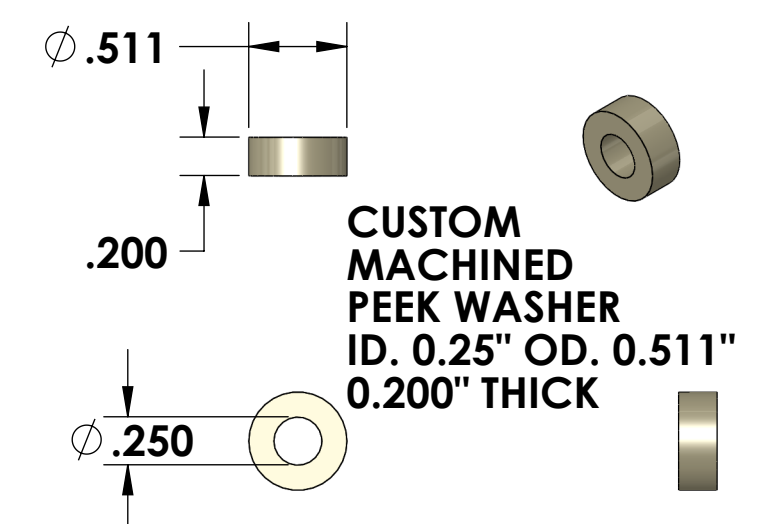
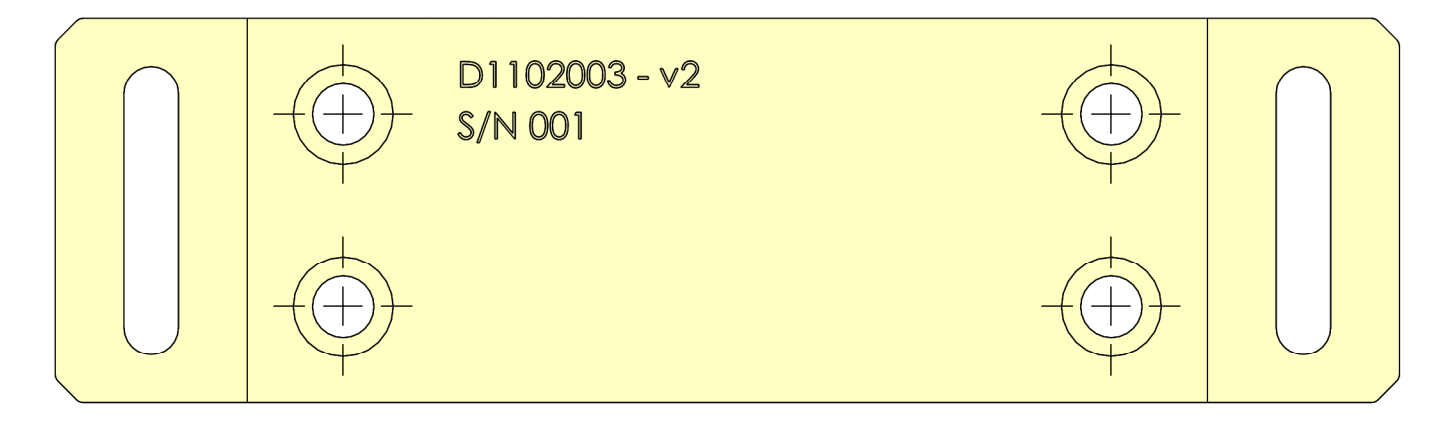
**LID  
 DCC# D1102005**



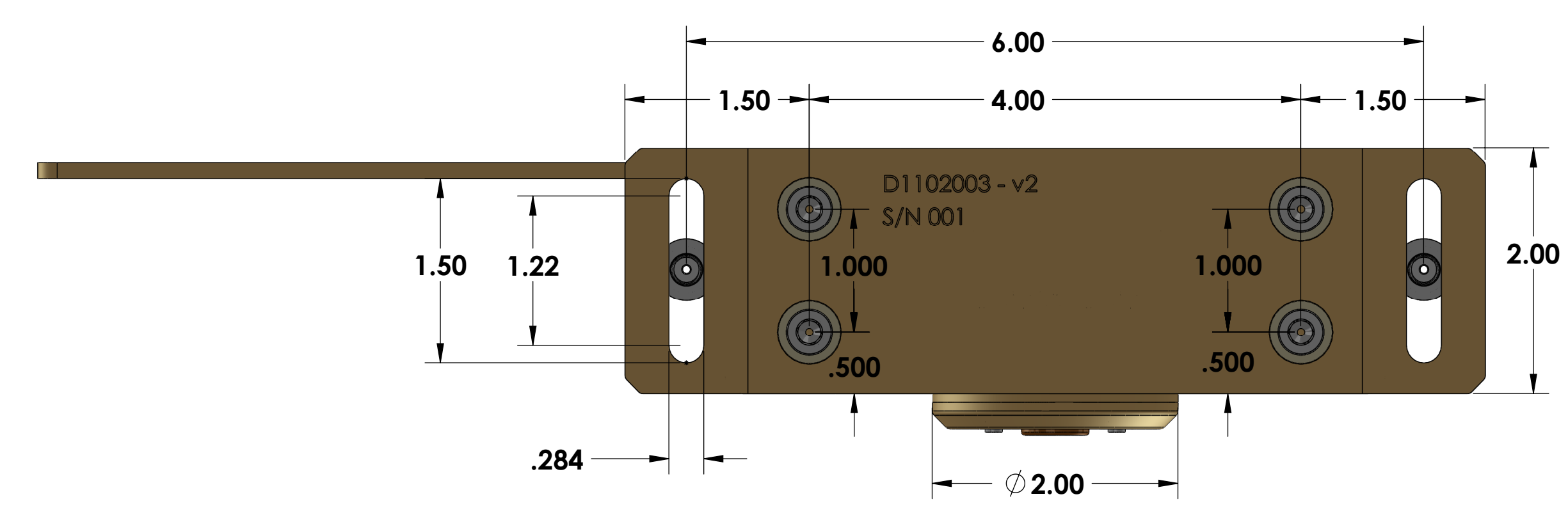
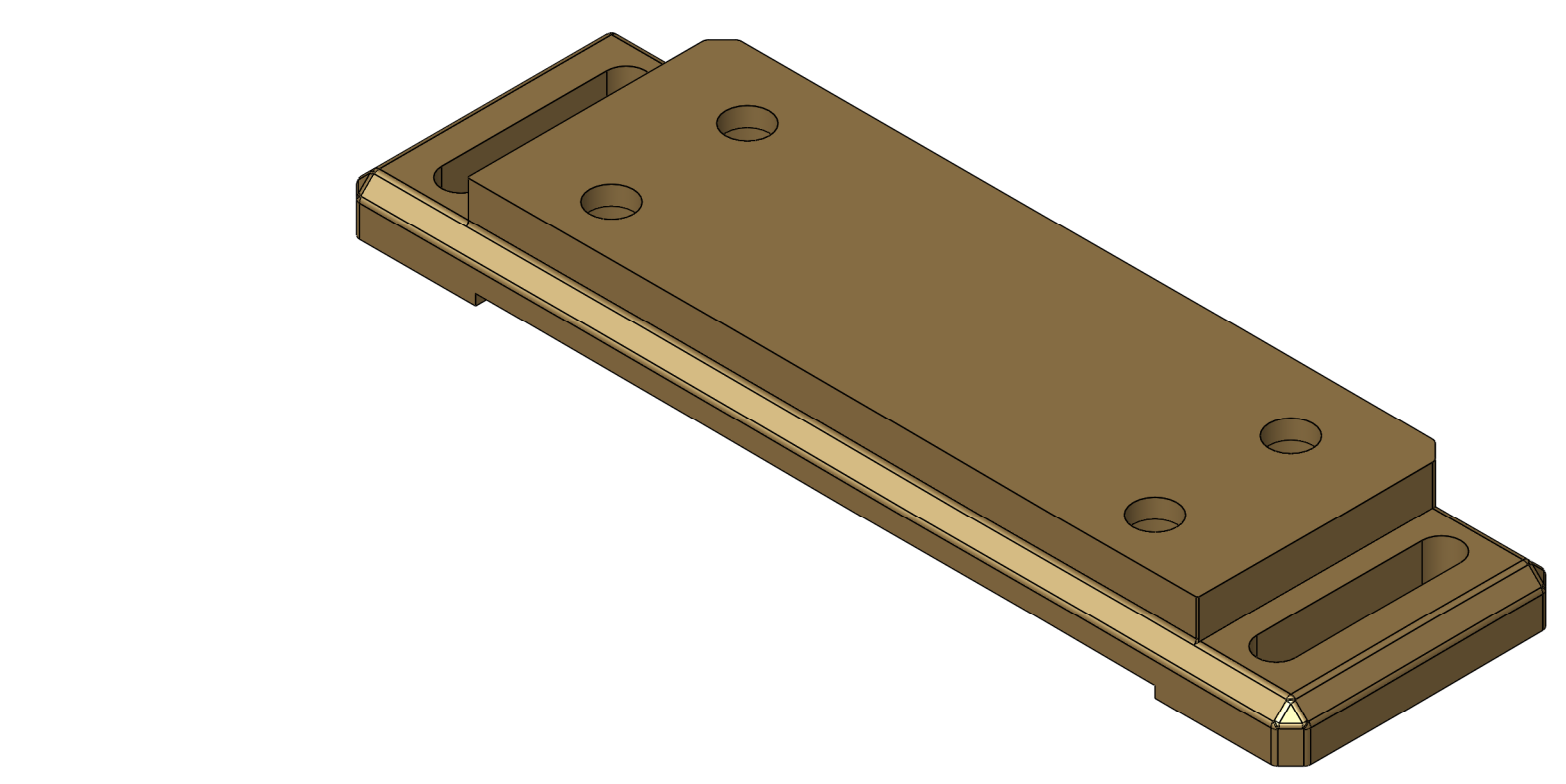
VENTED SCREWS



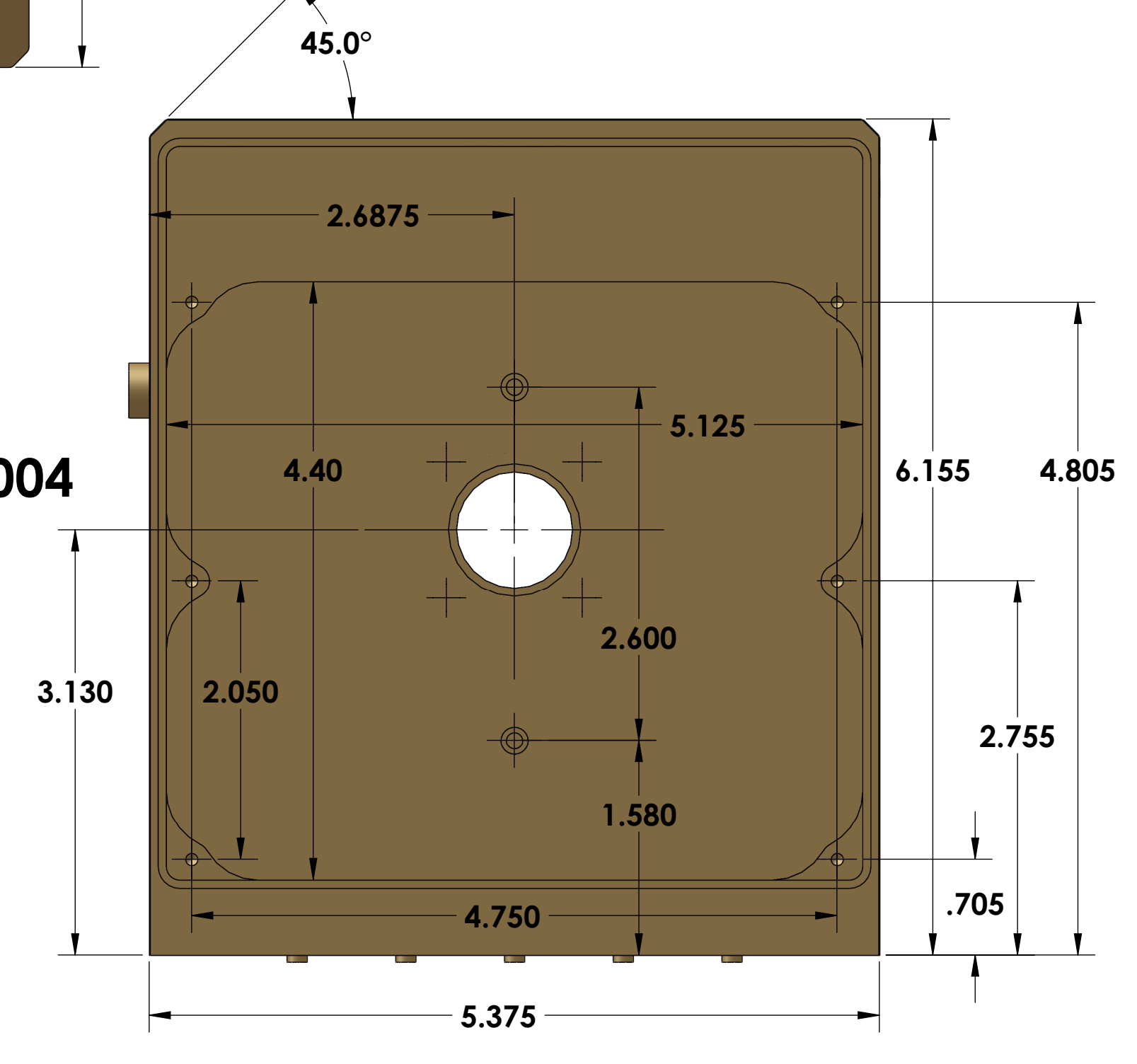
**BASE  
 DCC# D1102003**



**PEEK WASHER/SPACER  
 DCC# D1102010**



**MAIN BODY  
 DCC# D1102004**



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <b>ASC IN-VACUUM ENCLOSURE - TOP ASSEMBLY</b>	
DIMENSIONS ARE IN		SYSTEM	SUB-SYSTEM	DESIGNER	DATE
1. INTERPRET DRAWING PER ASME Y14.5-1994			ISC	R. ABBOTT	MAR/7/2012
2. REMOVE ALL SHARP EDGES. .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.				E. BROWN	MAR/7/2012
3. DO NOT SCALE FROM DRAWING.					
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.					
TOLERANCES: .XX ± .XXX ±					
ANGULAR ± °					
FINISH		NEXT ASSY		CHECKER	
μinch					
SCALE: 1:1		PROJECTION:			

REV.	DATE	DCN #	DRAWING TREE #

D1102003-v2-ASC - VAC Enclosure TOP ASSEMBLY PART FROM REV: 2002, DRAWING FOR REV: 2001