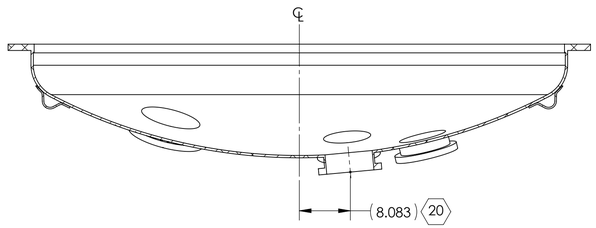
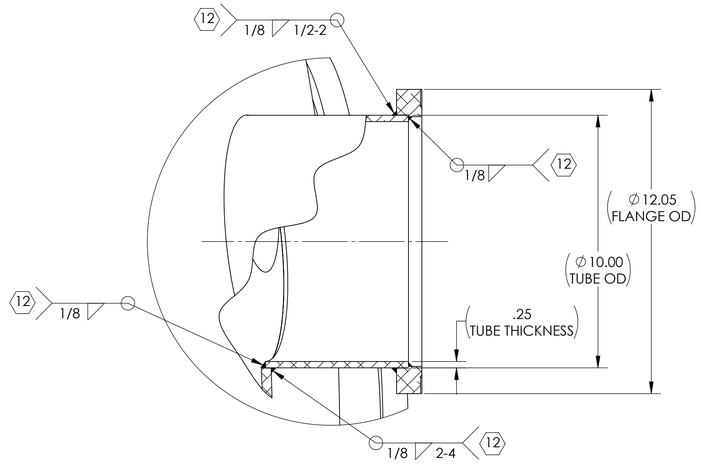
REV.	DATE	DCN #	DRAWING TREE #
v3	28 MAR 2019	E1900228	-
-	-	-	-
-	-	-	-

NOTES CONTINUED:

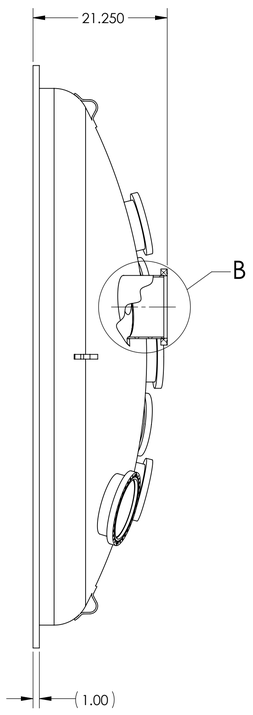
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO SPECIFICATION E0900364
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
8. 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 SPECIFICATION E0900364
9. APPROXIMATE WEIGHT = 1176 LB.
10. MACHINING VENDOR TO USE CENTER PUNCH MARK LOCATED AT 0° ON EACH HEAD AS THE STARTING POINT FOR THE NATURAL CENTERLINE BOLT PATTERN.
11. ALL FORGING MFG NUMBERS TO BE LEFT INTACT.
12. FOR WELDING AND HELIUM LEAK TEST SPECIFICATIONS REFER TO LIGO SPECIFICATION E1900079.
13. IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
14. CONFLAT FLANGES ARE TO BE PROTECTED WITH RIDGID COVERS AT ALL TIMES DURING AND AFTER MACHINING.
15. MATERIAL: MAKE FROM D970427.
16. HEADS ARE ASME F&D
17. STEAM CLEAN & WRAP IN POLYETHELENE TO PREVENT CONTAMINATION DURING SHIPPING.
18. FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.
19. FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE.
20. PORT LOCATIONS, DIMENSIONS TAKEN FROM CENTER OF OUTER FLANGE SURFACE.

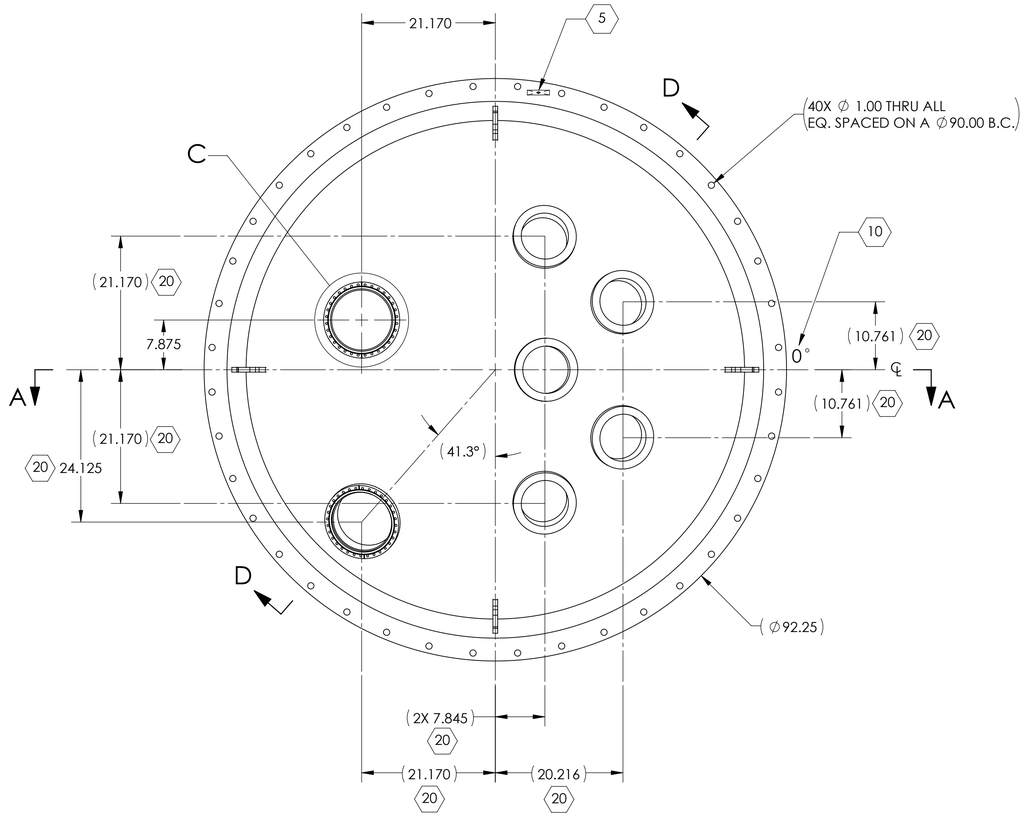


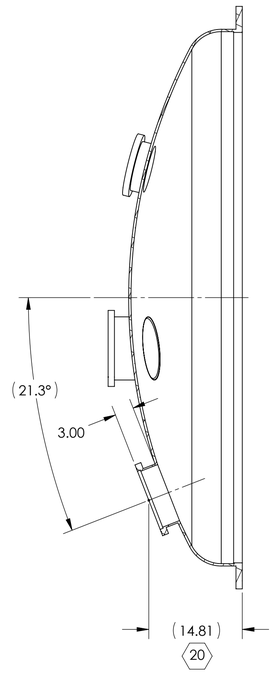
SECTION A-A



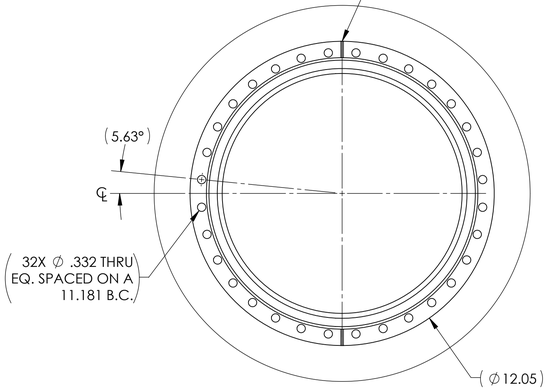
DETAIL B
SCALE 1 : 3
TYPICAL 2 PLACES







SECTION D-D
SCALE 1 : 12
ROTATED ◠ 41.3°



DETAIL C
SCALE 1 : 3
TYPICAL 2 PLACES

PRELIMINARY
NOT FOR PRODUCTION

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .015 ANGULAR ± 1.0°	**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)** 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. **MATERIAL** 304 SSTL (15) **FINISH** NA

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	A+	**SUB-SYSTEM**	VE	**PART NAME**	A+ HAM8 84in COVER		
NEXT ASSY	D1900066			**DESIGNER**			
				DRAFTER	D. GRIFFITH	13 MAR 2019	
				CHECKER	SEE DCC	SEE DCC	
				APPROVAL			

SIZE D **DWG. NO.** D1900066 **REV.** v3
SCALE: 1:12 **PROJECTION:** SHEET 1 OF 1

PART PDM VERSION: y-012
DWG PDM VERSION: y-006
D1900066 A+ HAM8 84in Cover