

NOTES CONTINUED:

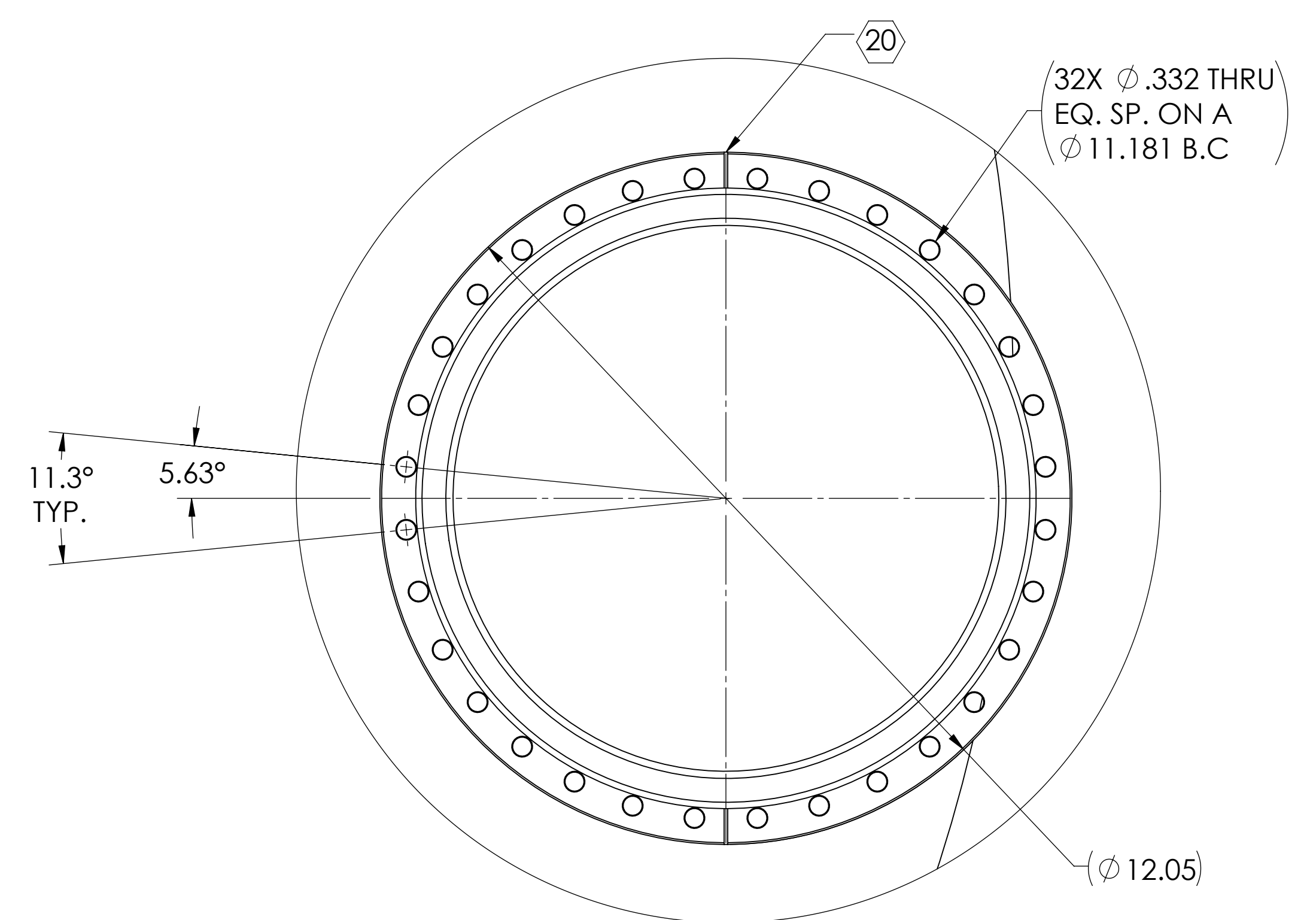
(5) SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXXX

- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
- 9. 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. LIGO SPECIFICATION E0900364
- 11. ALL MATERIAL TO BE 304L STAINLESS STEEL.
- 12. HEADS ARE ASME F&D.
- (13) PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII OF ITEM NO. 1.1

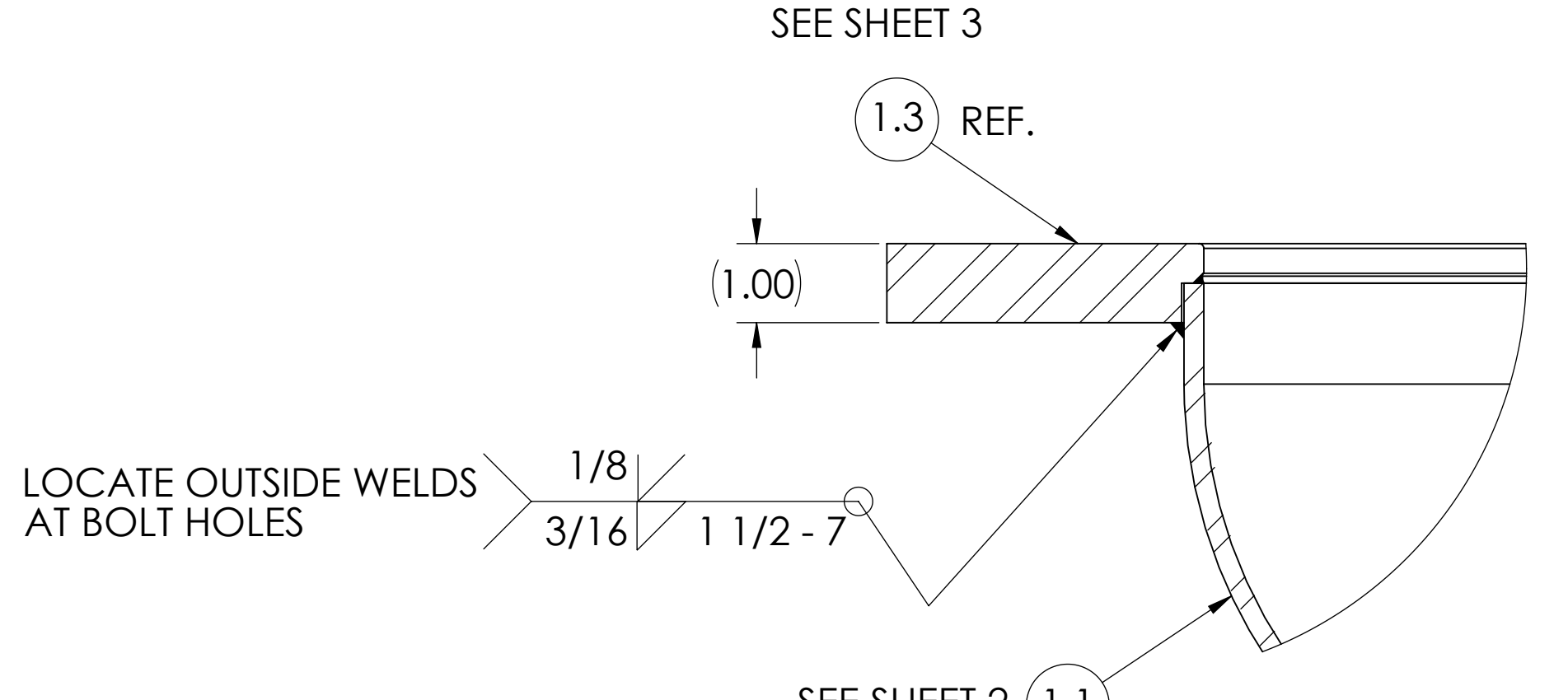
- 14. GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
- 15. MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH.
- 16. FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL UNLESS NOTED.
- 17. FLANGE WILL BE USED IN UHV SERVICE.
- (18) DO NOT MACHINE FLANGE OD.
- 19. WELD HEAD (ITEM 1.1) TO FLANGE (ITEM 1.2) PRIOR TO MACHINING (ITEM 1.1).
- 20. NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.
- 21. NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS MAY BE USED.
- (22) IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
- (20) FLANGE LEAK PORTS SHALL BE CENTERED AT 12 AND 6 O'CLOCK POSITIONS.
- (24) FOR WELDING AND HELIUM LEAK TEST SPECIFICATIONS REFER TO LIGO E0900408 & E0900404.
- 25. CONFLAT FLANGES ARE TO BE PROTECTED WITH RIGID COVERS AT ALL TIMES DURING AND AFTER MANUFACTURING.
- 26. PACKAGE, HANDLE, AND SHIP IN SUCH A MANNER S TO MAINTAIN SPECIFIED SURFACE FINISH AND FLATNESS TOLERANCES.

# +Y DOOR

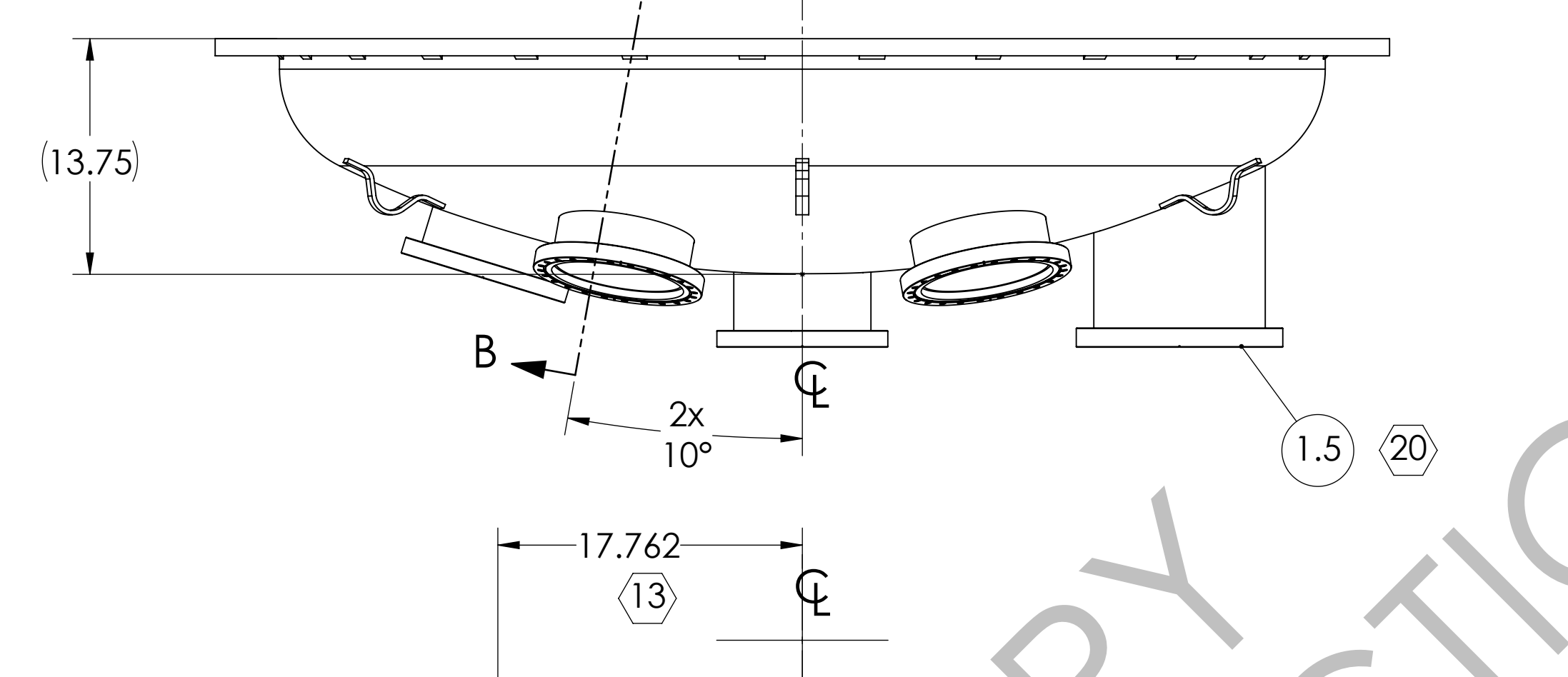
REV.	DATE	DCN #	DRAWING TREE #
v1	16 APR 2019	-	-
v2	17 APR 2019	-	-
v3	20 MAY 2019	E1900228	-



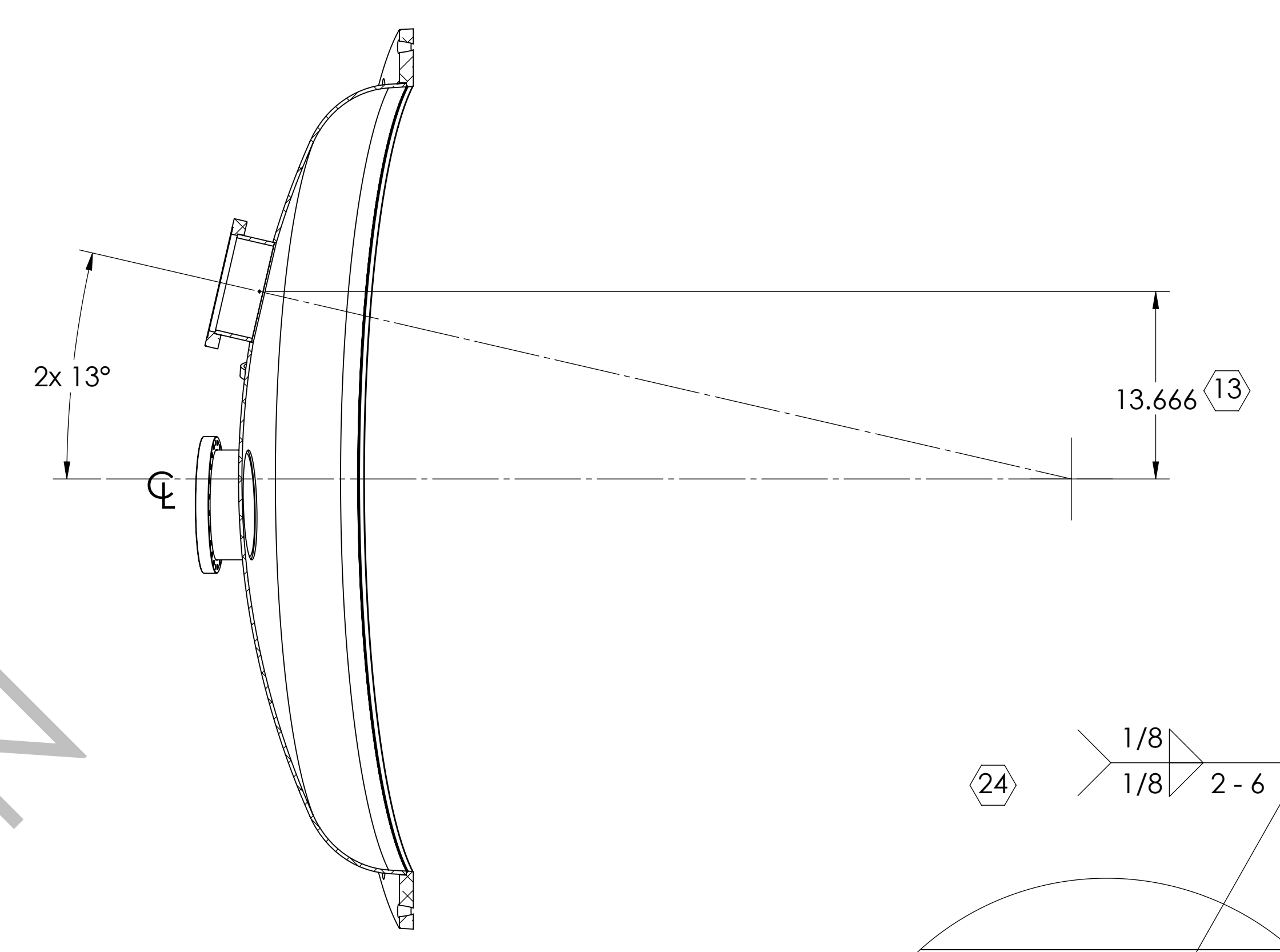
**DETAIL E**  
SCALE 1 : 2  
2 PL.



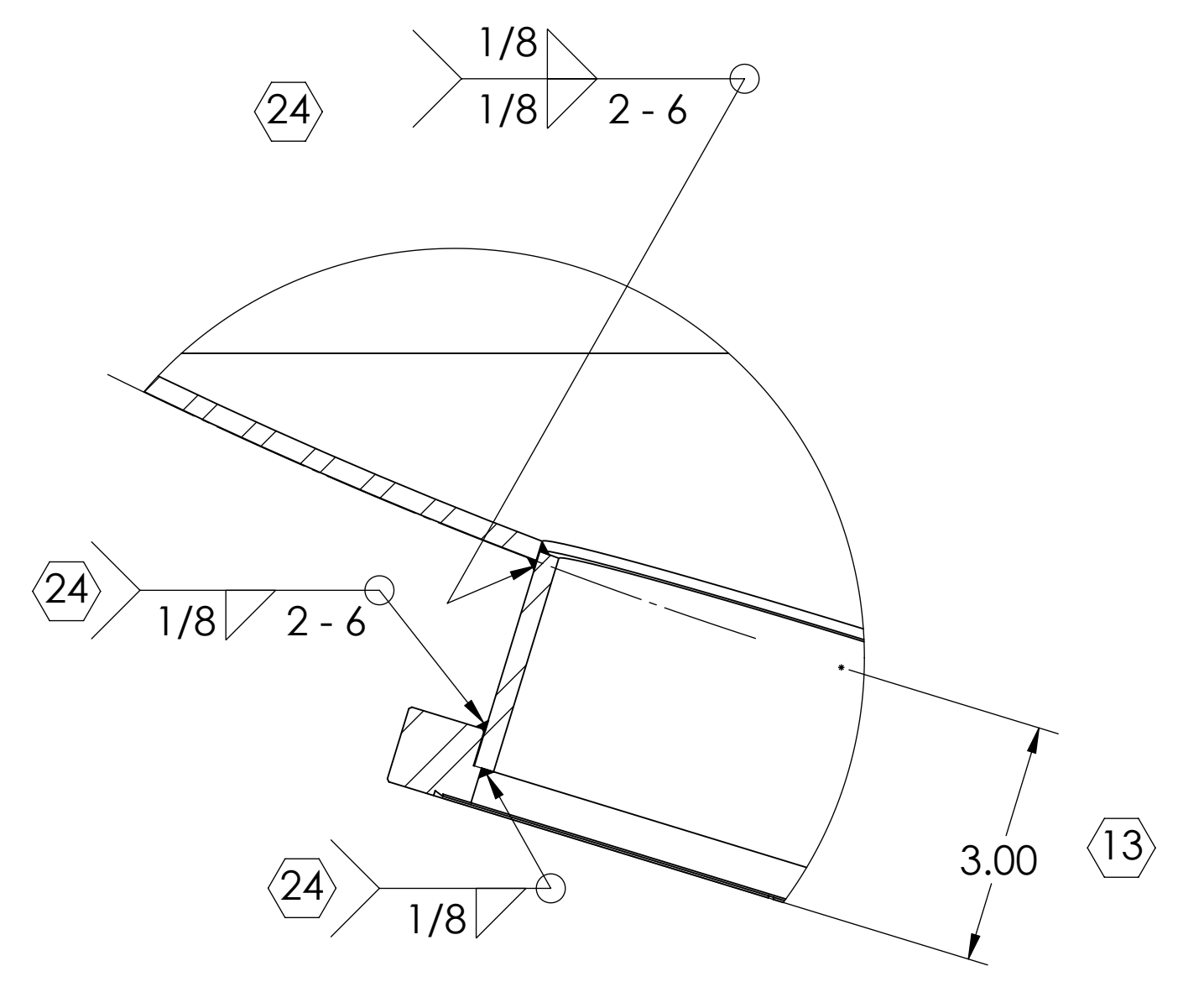
**DETAIL C**  
SCALE 1 : 2



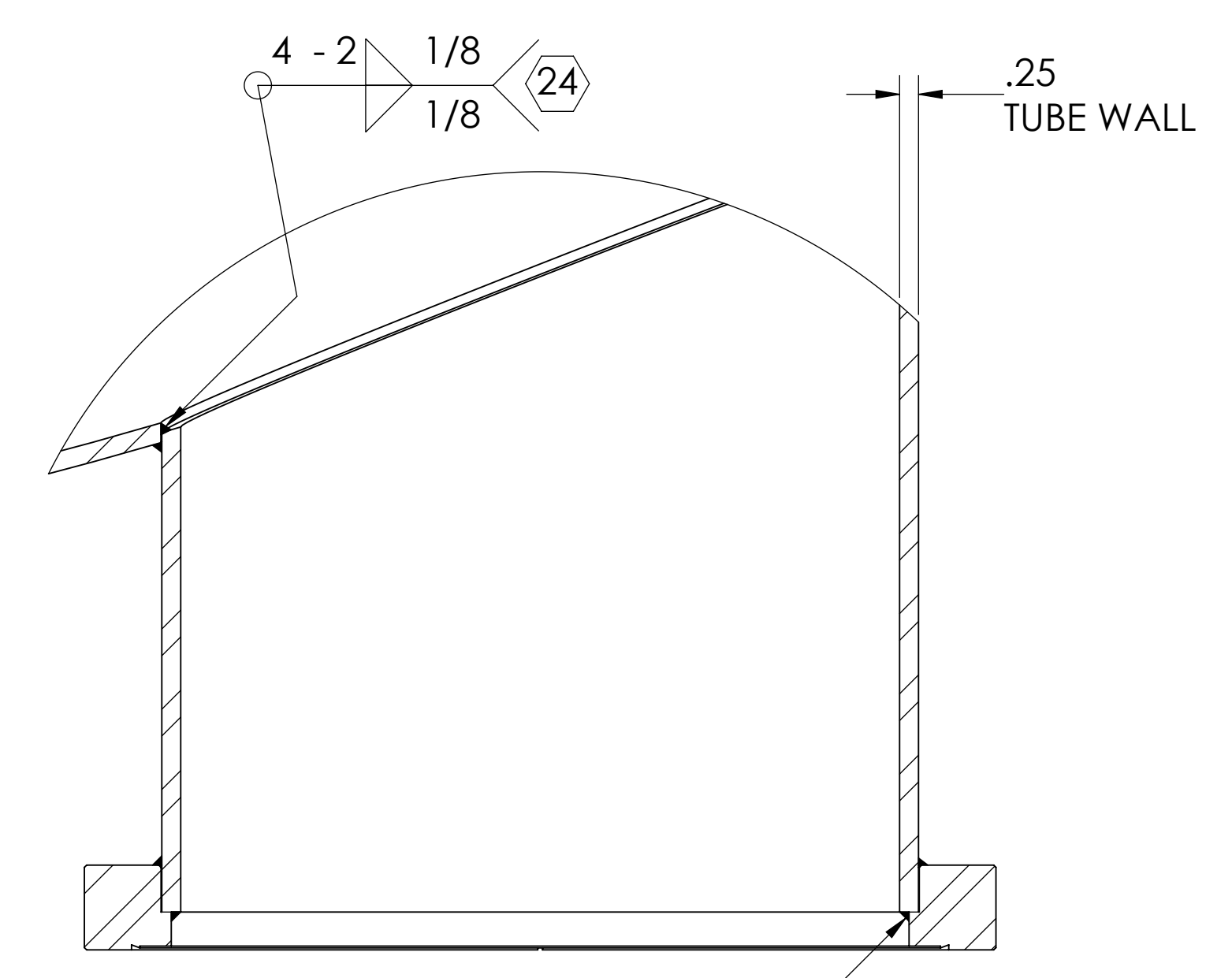
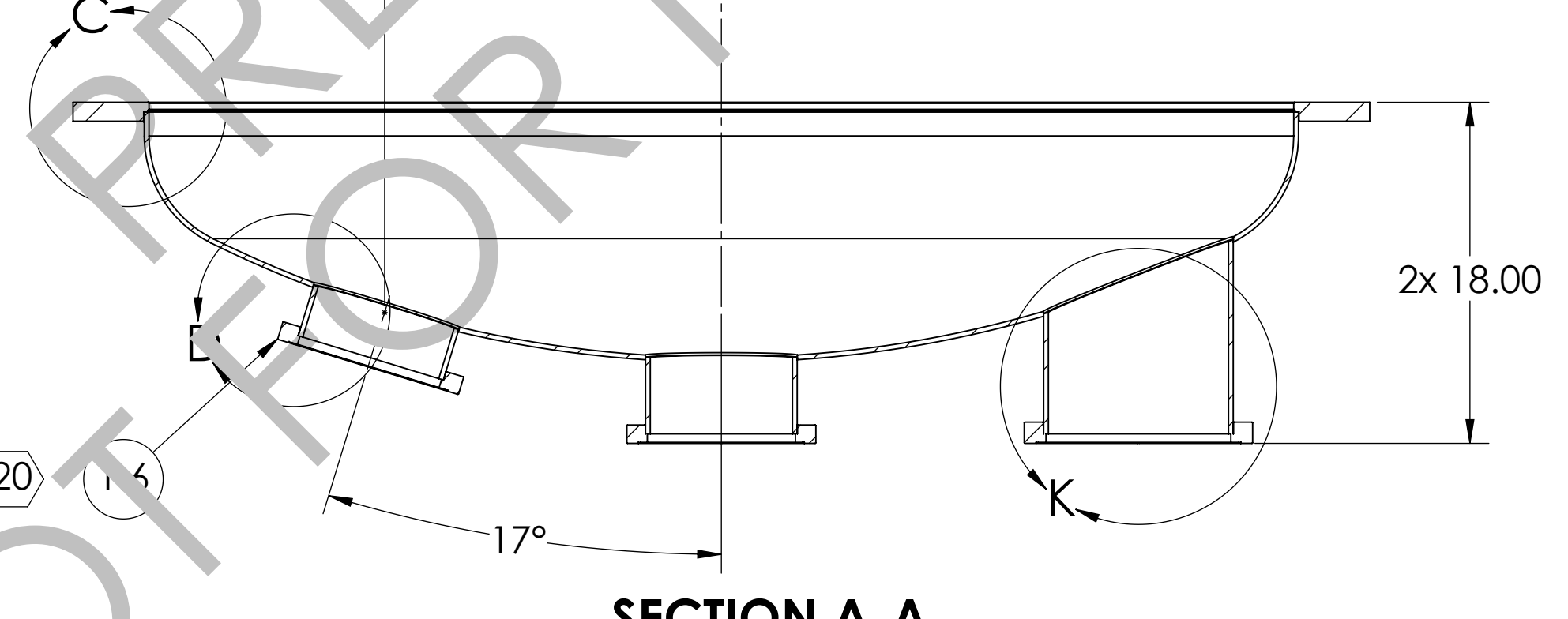
**SECTION A-A**



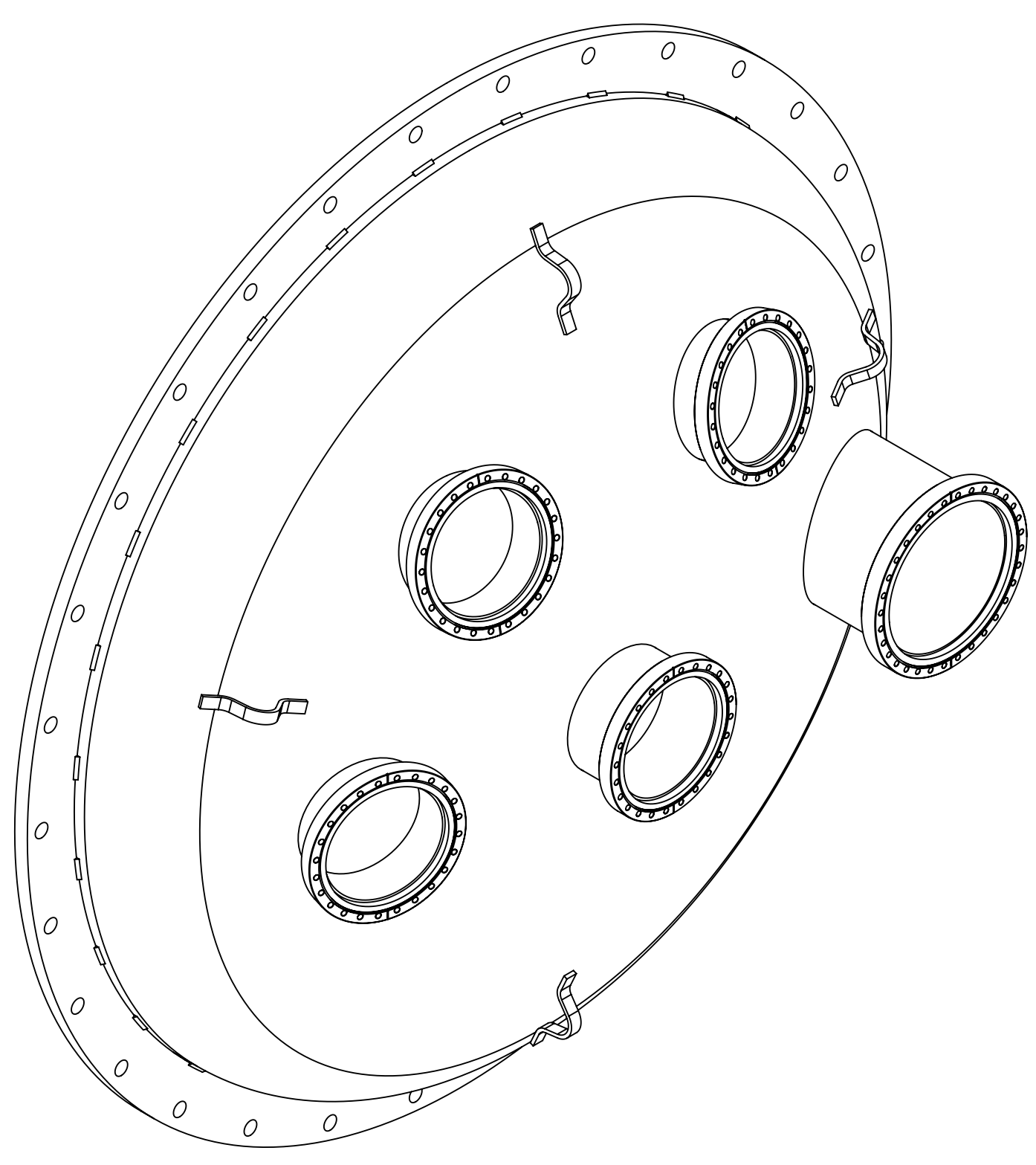
**SECTION B-B**  
(ROTATED 80.0° CW)



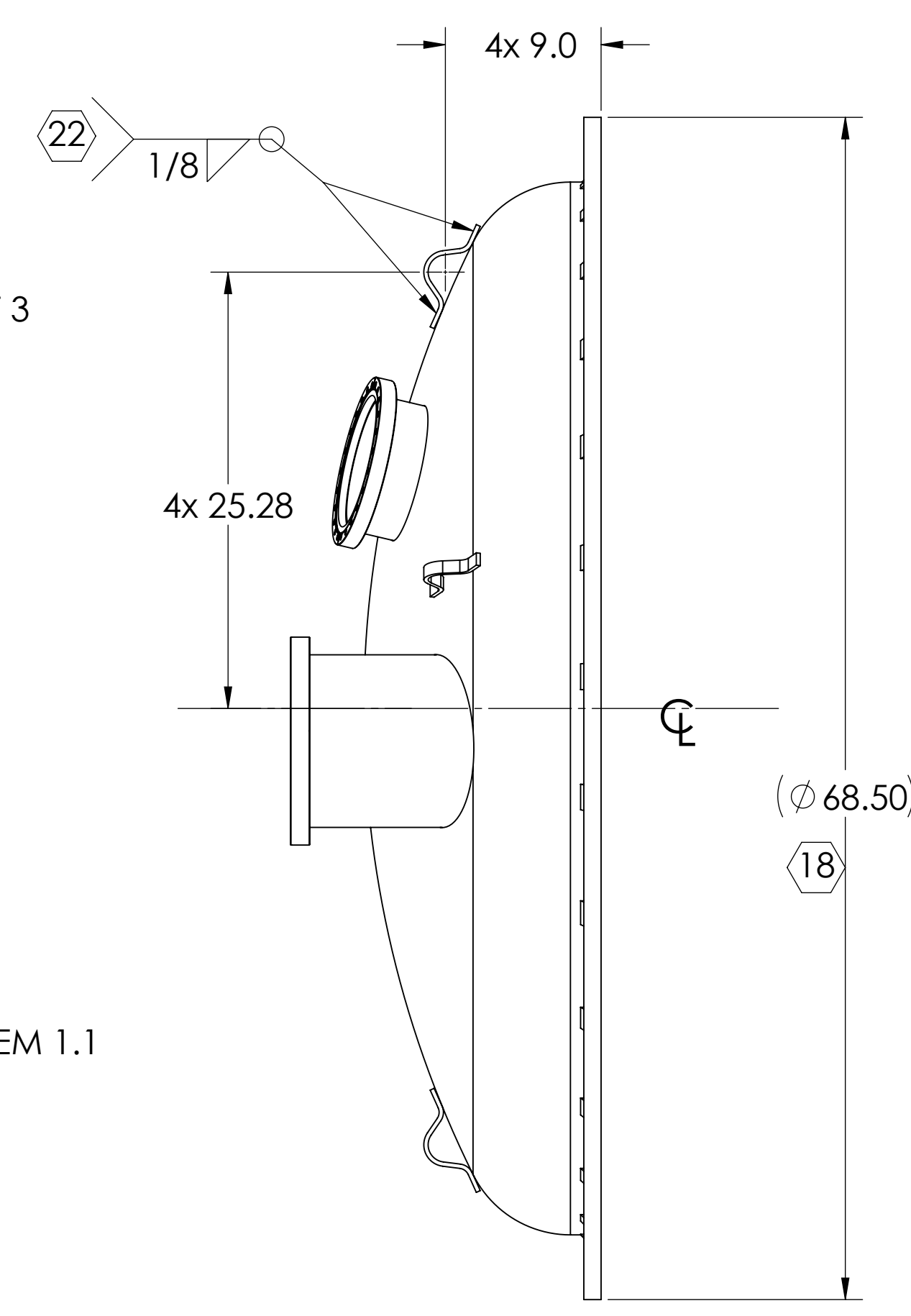
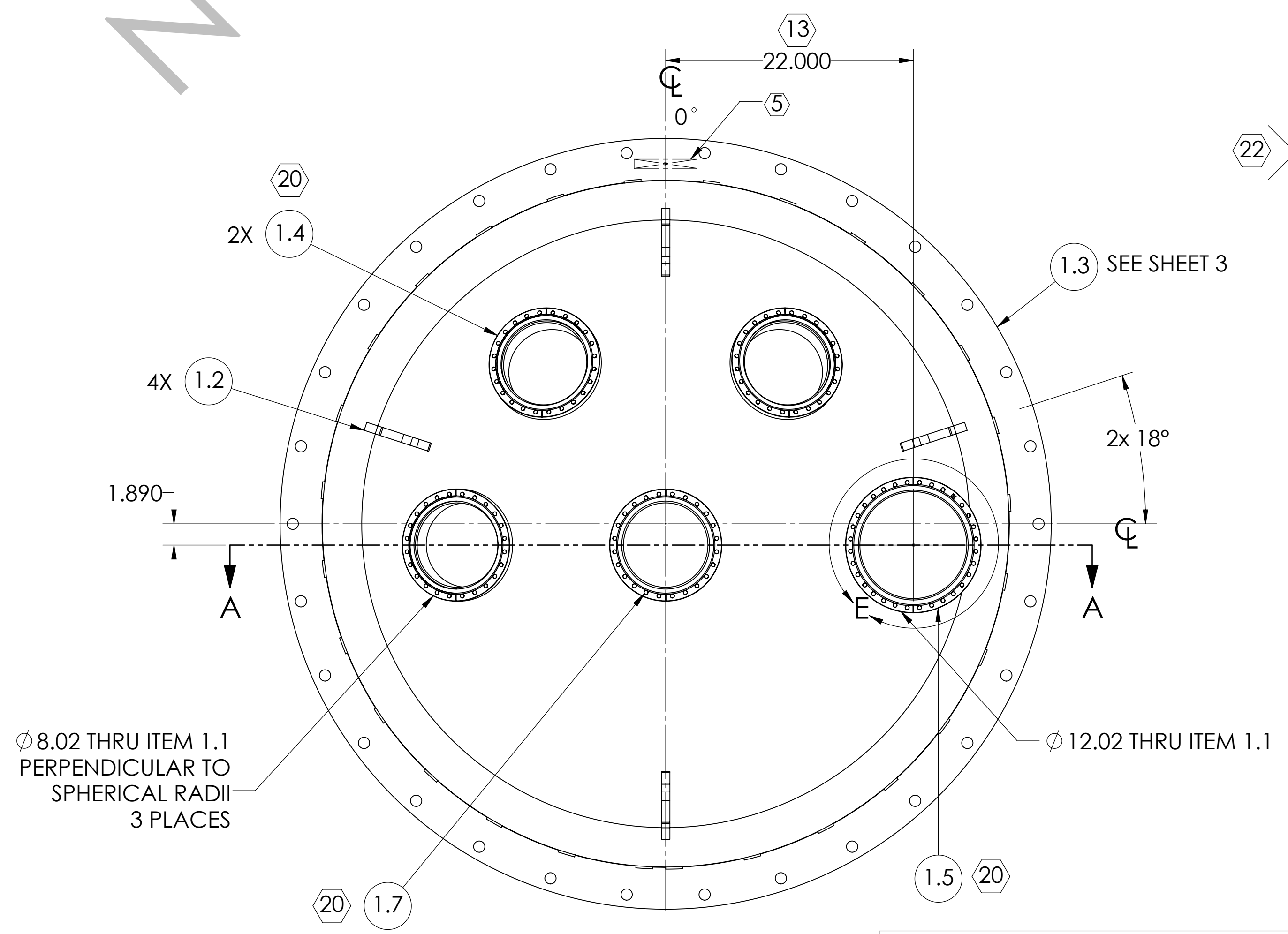
**DETAIL D**  
SCALE 1 : 2  
3 PL.



**DETAIL K**  
SCALE 1 : 2



**ISO VIEW**



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
1.7	TBD	8in HALF NIPPLE X .25 WALL, 10" CF (SPARE)	304L SSSL	1
1.6	TBD	8in HALF NIPPLE X .25 WALL, 10" CF (SPARE)	304L SSSL	1
1.5	TBD	10in HALF NIPPLE X .25 WALL, 12" CF (A+)	304L SSSL	1
1.4	TBD	8in HALF NIPPLE X .25 WALL, 10" CF (SPARE)	304L SSSL	2
1.3	D1900118-103	A+, 68.5in FLANGE, (FLAT FACED)	304L SSSL	1
1.2	D1900118-102	A+, LIFTING LUG	304 SSSL	4
1.1	D1900118-101	A+, TORISPHERICAL VESSEL HEAD (KLOPPER)	304L SSSL	1
1	D1900118	A+, BSC3, 68.5in DOOR (TYPE II)	304L SSSL	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

TOLERANCES:  
.XX ± .03  
.XXX ± .010  
ANGULAR ± 0.5°

MATERIAL: 304L SSSL  
FINISH: AS NOTED μinch  
D0900493, D0901147

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ADVANCED LIGO VE  
D0900493, D0901147

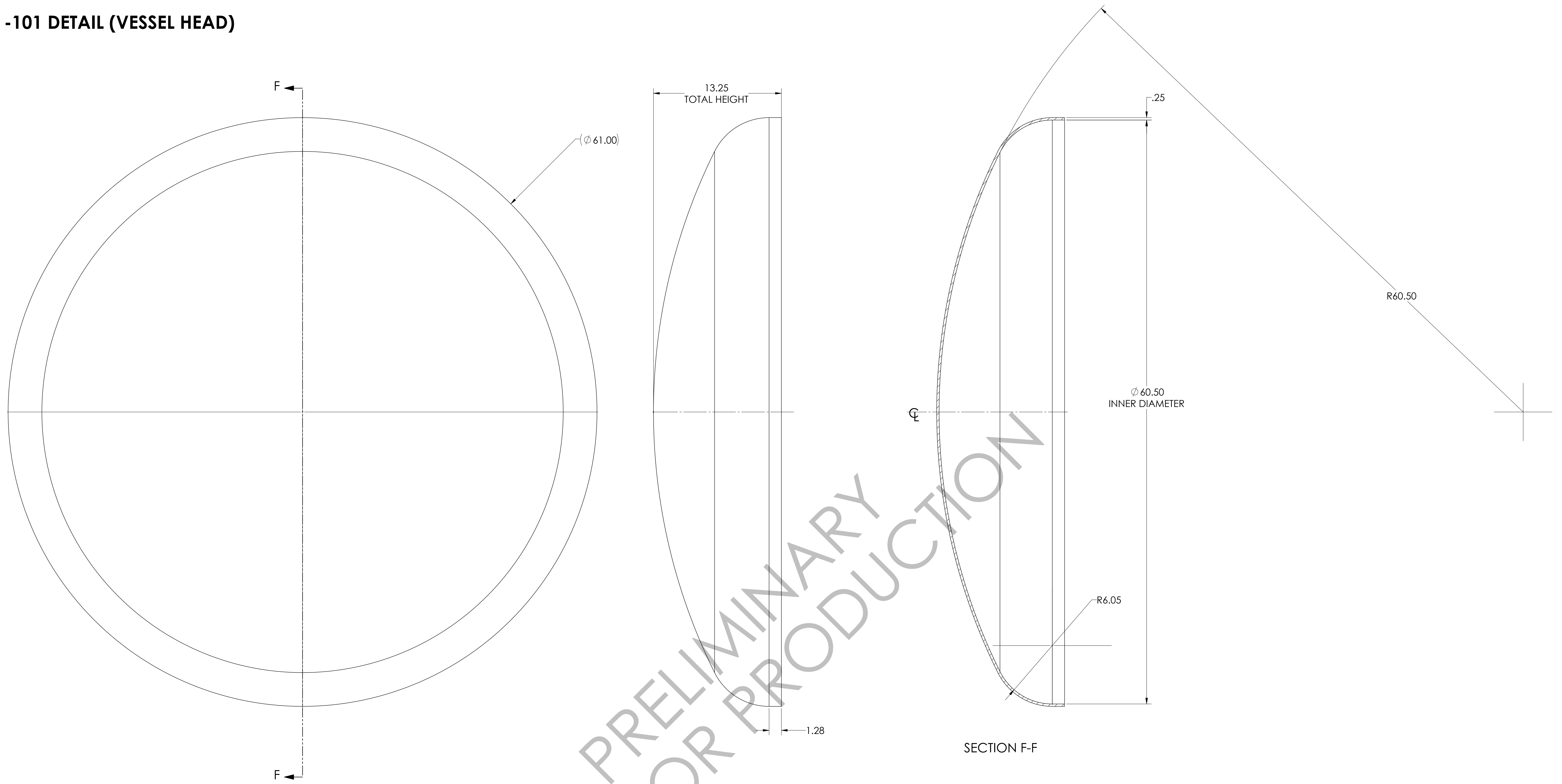
PART NAME: A+, BSC3, 68.5in DOOR (TYPE II)  
DRAWN: E.SANCHEZ  
CHECKER: SEE DCC  
APPROVAL: SEE DCC

SIZE DWG. NO.: E  
SCALE: 1:8  
PROJECTION:

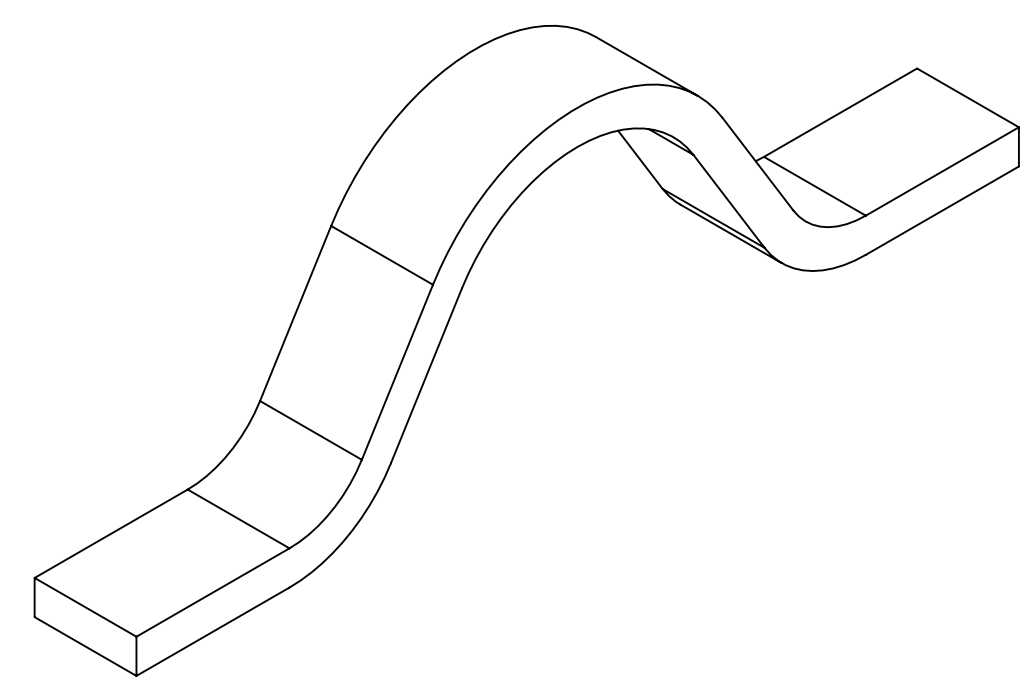
REV. v3

SHEET 1 OF 3

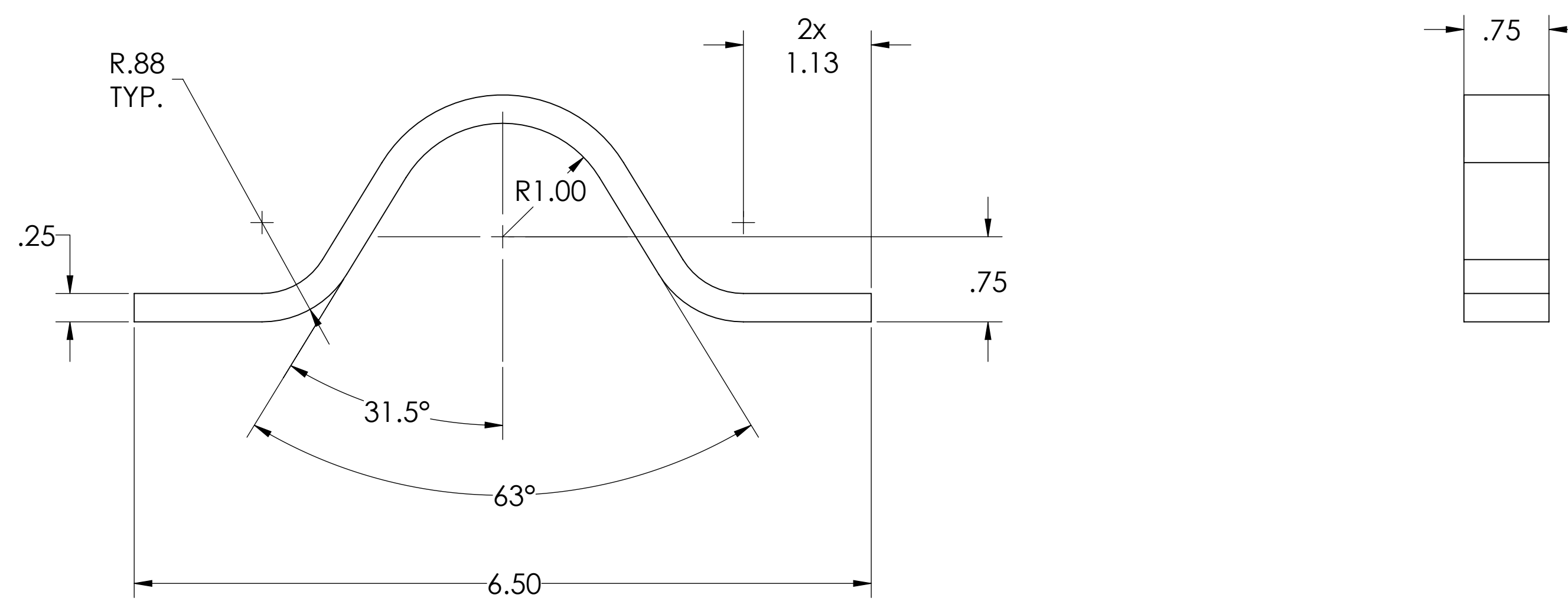
**-101 DETAIL (VESSEL HEAD)**



**-102 DETAIL (LIFTING LUG)**

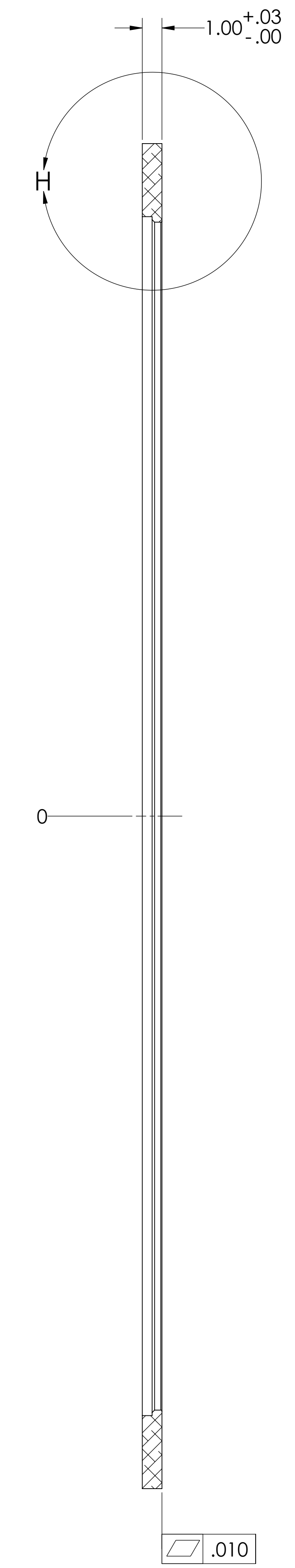
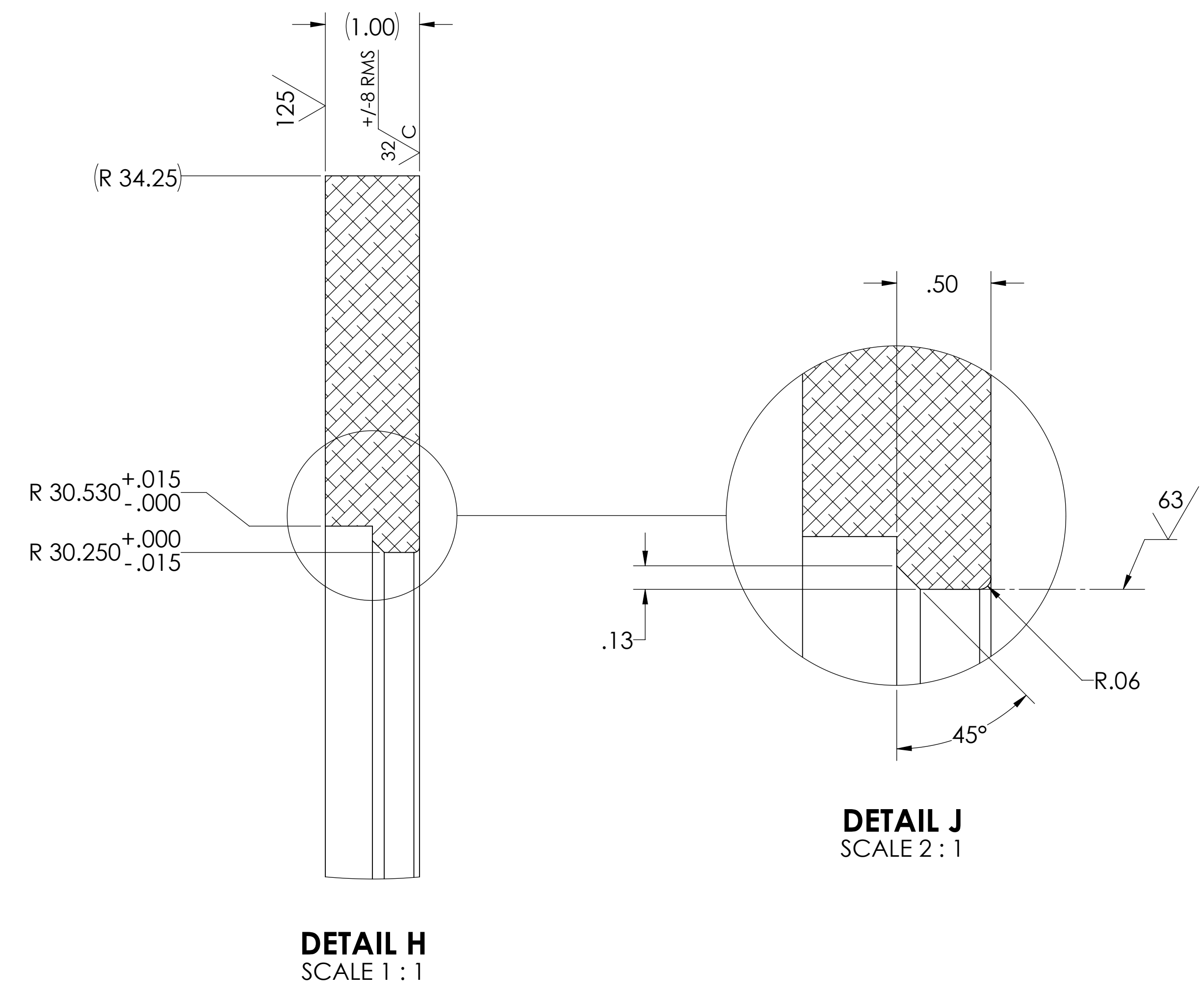
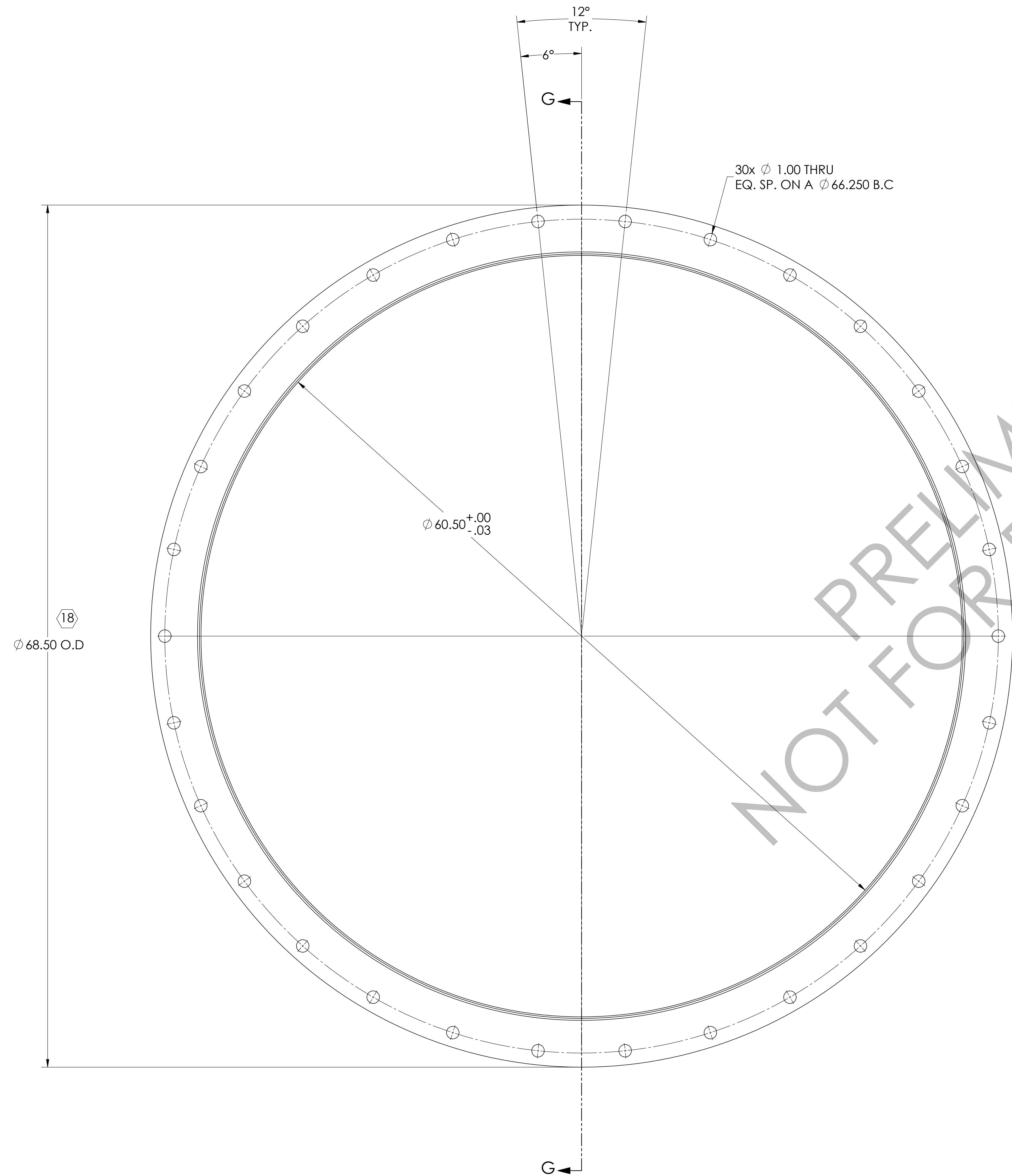


**ISO VIEW**



MATERIAL: 304 SSSL., 3/4" WIDE X 1/4" THICK FLAT BAR, ASTM A479  
QTY. 4

**-103 DETAIL (FLANGE)**



**SECTION G-G**

PRELIMINARY  
NOT FOR PRODUCTION