

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .25" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: D080462-v2, S/N 001.

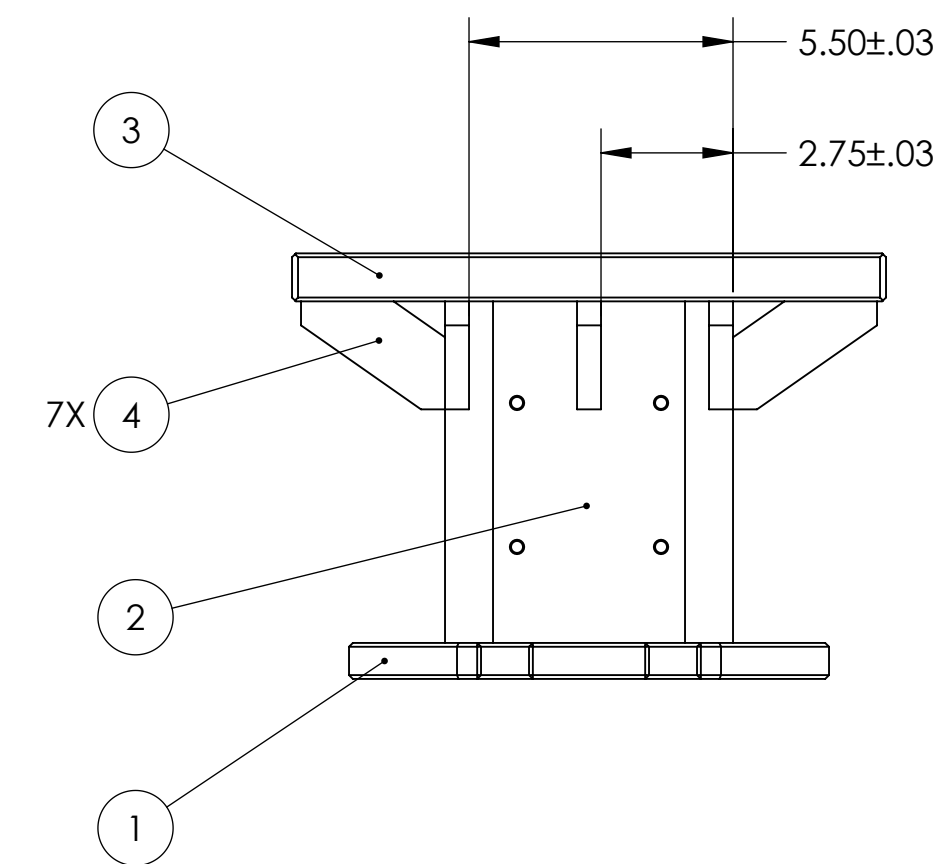
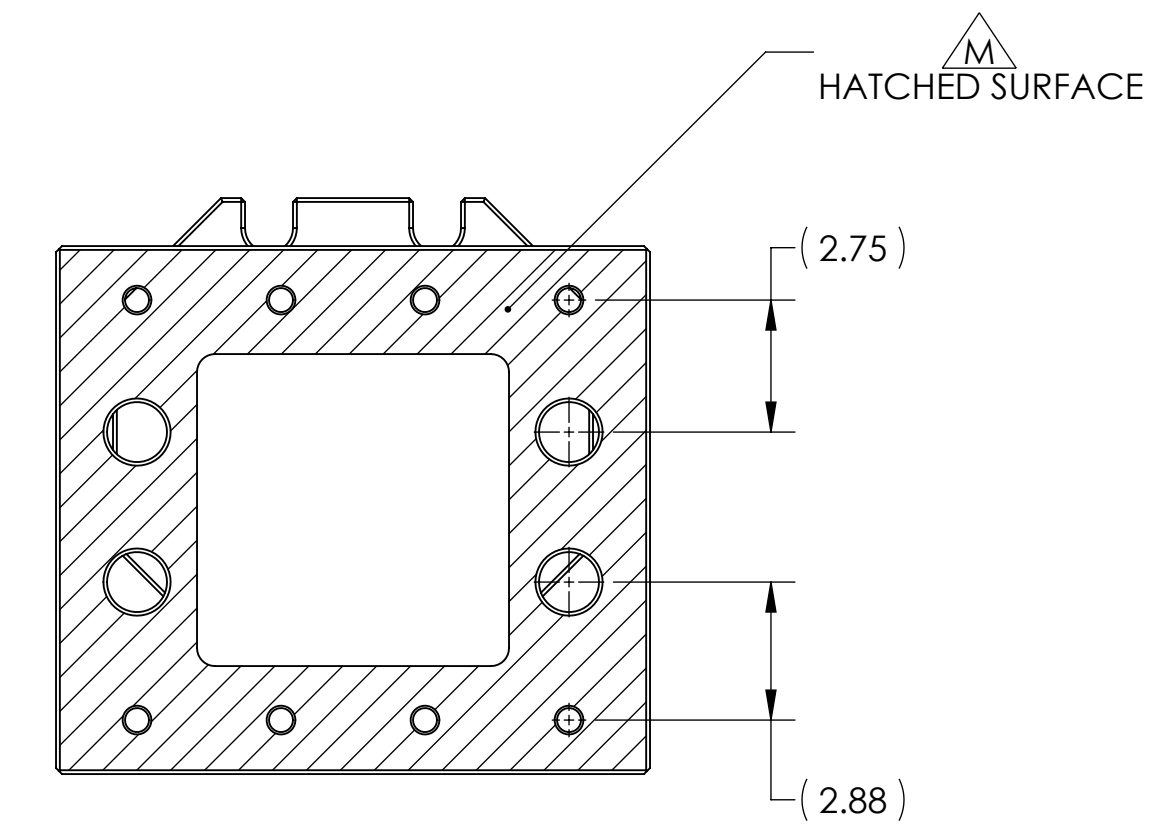
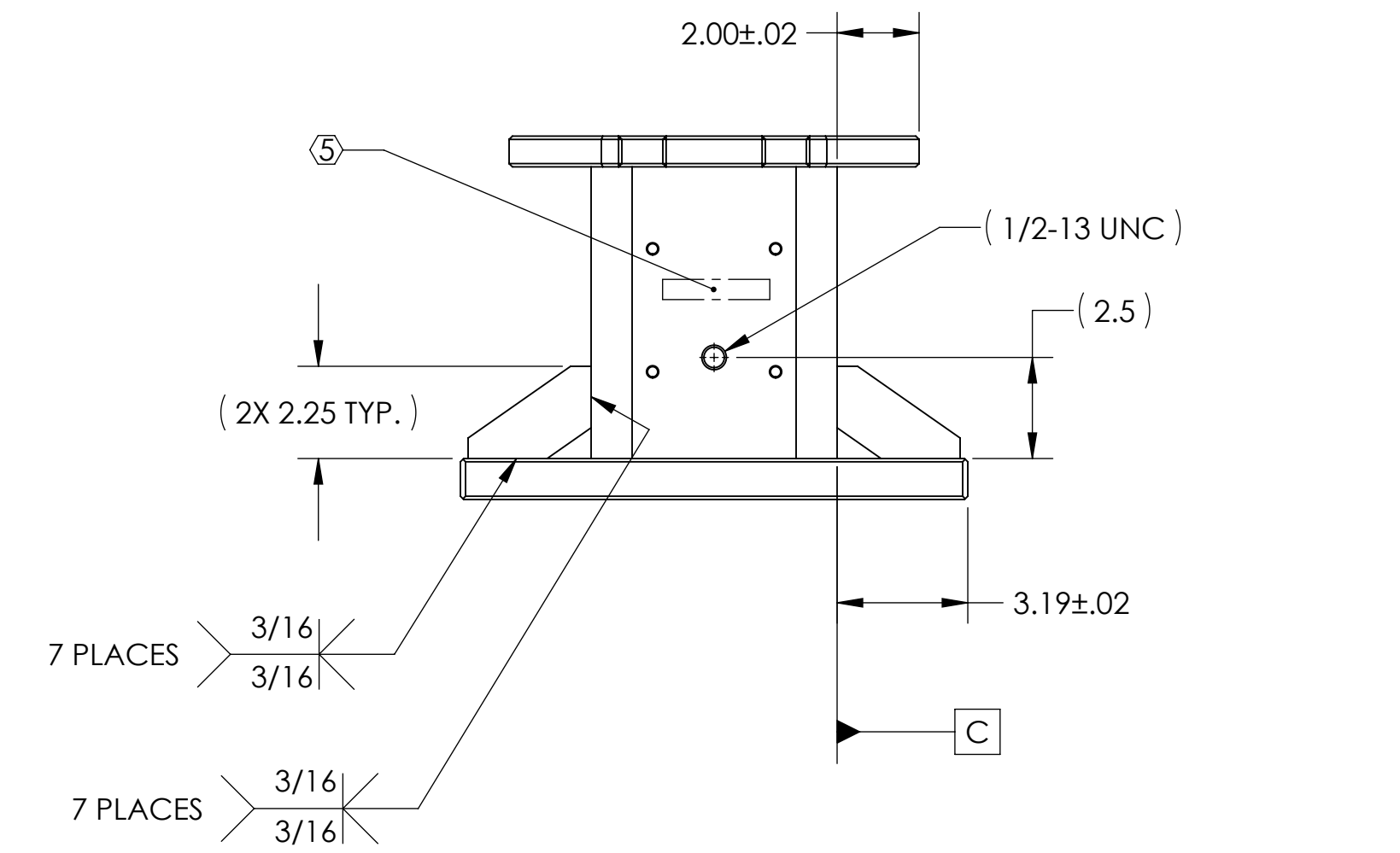
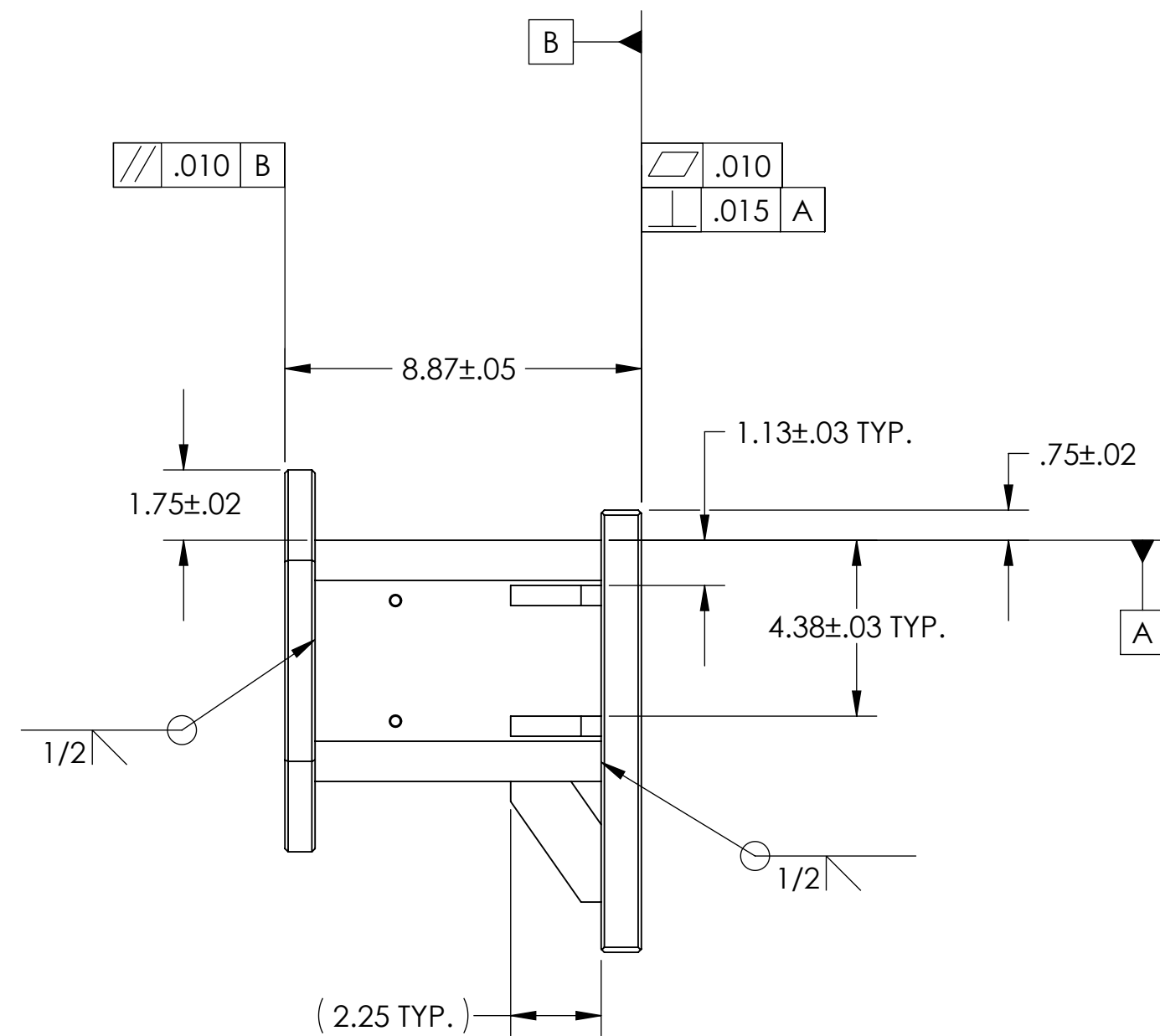
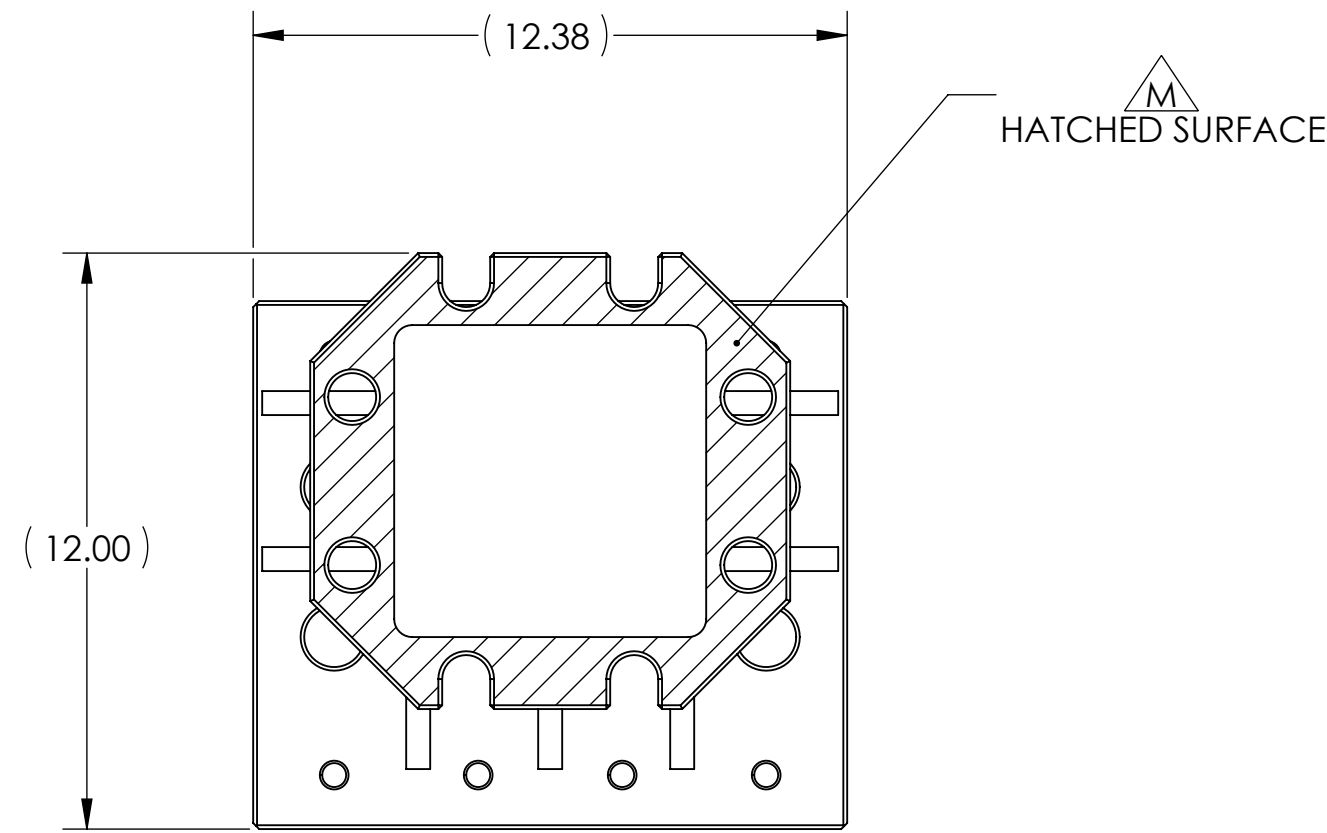
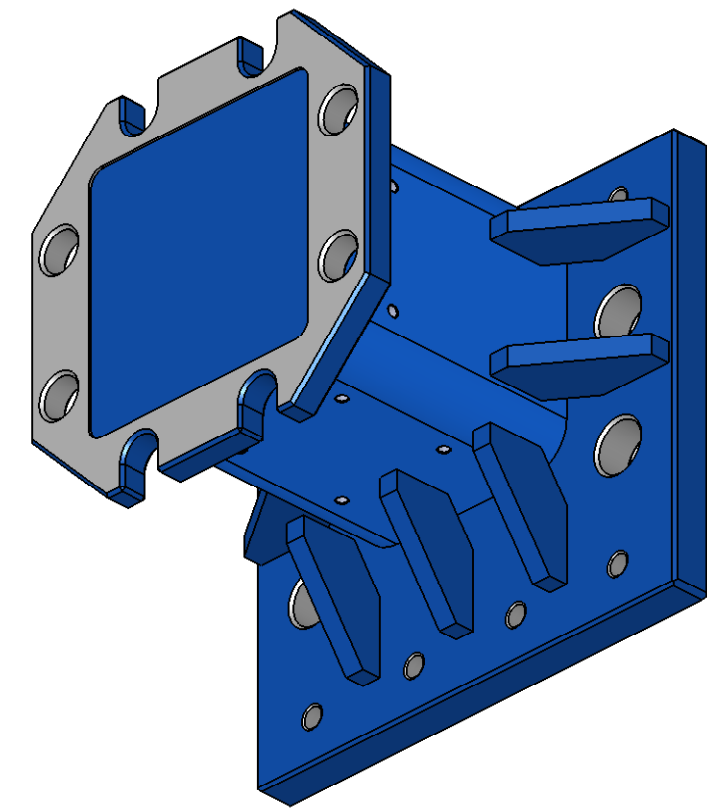
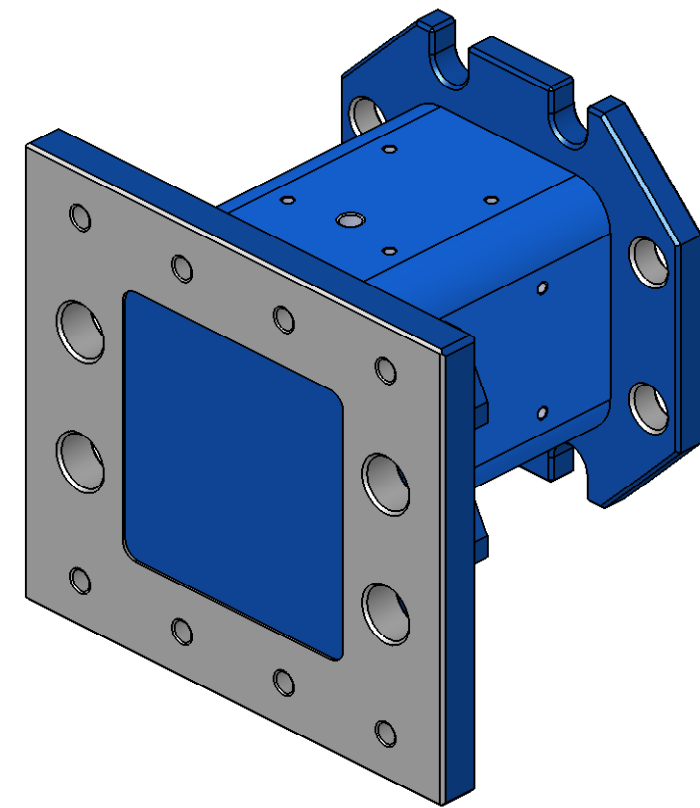
6. STRUCTURE MUST SATISFY STATED TOLERANCES AFTER WELDING. IF NECESSARY, SURFACES ON PLATES MAY BE MACHINED AFTER WELDING.

7. PLUG ALL SCREW HOLES, BOTH TAPPED AND THRU.

8. PAINT ALL SURFACES, EXCEPT WHERE INDICATED BY Δ . USE MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL). PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2.

9. APPLY "OXISOLV RUST INHIBITOR" TO ALL UNPAINTED SURFACES, PER MFG INSTRUCTIONS. REMOVE PLUGS FROM ALL HOLES.

REV.	DATE	DCN #	DRAWING TREE #
v1 / 01	05 Aug 2008	Initial release for LASTI prototype.	
v2	28 Aug 2009	E0900261	



Total Weight: 82 lbs

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
4	D080461	HAM Crossbeam Connector Gusset	ASTM A36 Steel	7
3	D080460	HAM Crossbeam Connector Mount Plate	ASTM A36 Steel	1
2	D080458	HAM Crossbeam Connector Tube	A500 Grade B Steel	1
1	D080459	HAM Crossbeam Connector HEPI Plate	ASTM A36 Steel	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		SYSTEM ADVANCED LIGO SUB-SYSTEM SEI		HAM Crossbeam Connector Weldment			
MATERIAL		FINISH		NEXT ASSY		DESIGNER		DRAFTER		CHECKER	
See BOM		See Notes		HAM SUPPORT STRUCTURE		A. Stein		A. Stein		-	
						K. Mason		28 Aug 2009		SCALE: 1:4	
										PROJECTION:	
										SHEET 1 OF 1	

D080462-HAM_Crossbeam_Connector_Weldment_PART PDM REV: X-010 DRAWING PDM REV: X-011