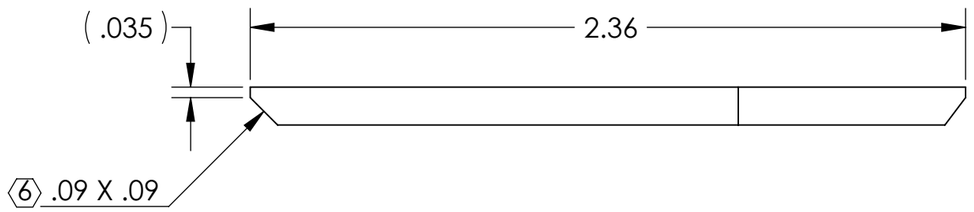
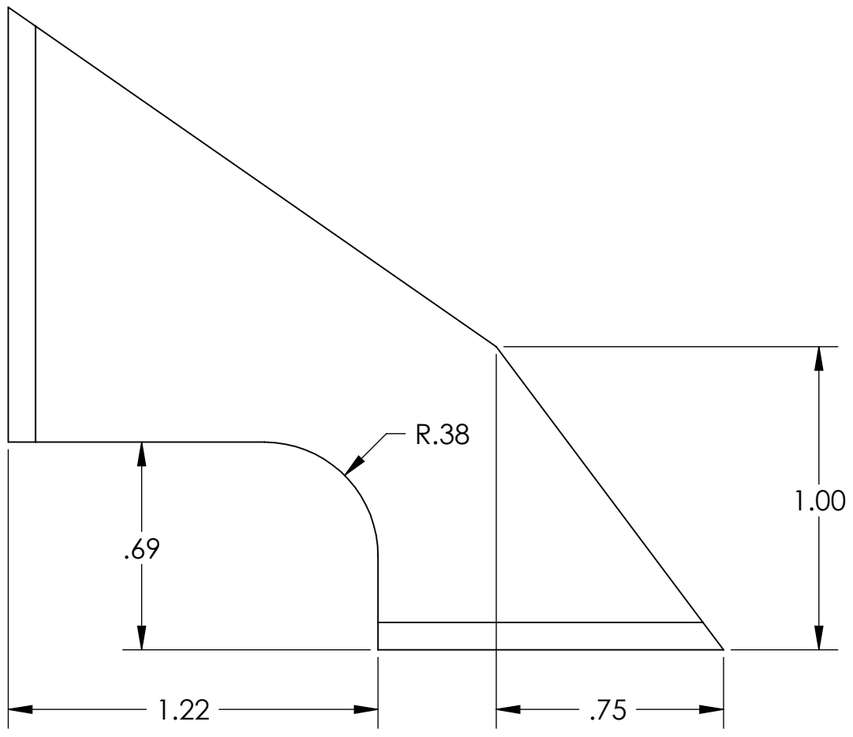
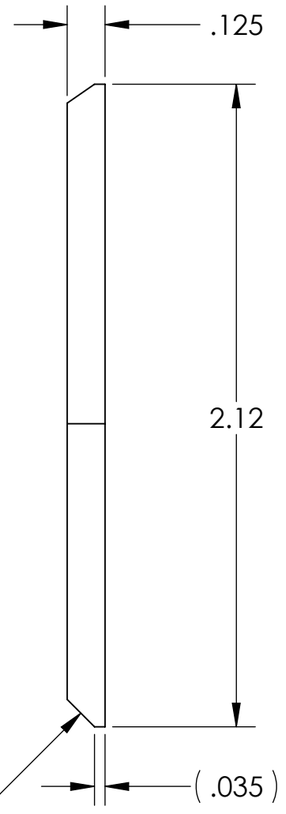
NOTES CONTINUED:

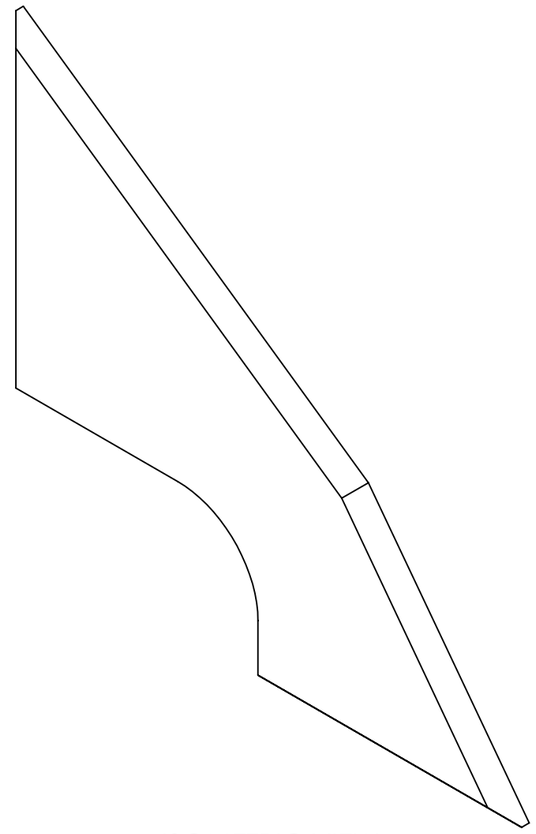
5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
6. ⟨6⟩ HALF OF ALL SIDE GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-









ISOMETRIC VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: SIDE GUSSET				
	MATERIAL: 304 OR 304L SSTL	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	DESIGNER: D. BRIDGES 29 AUG 2010	SIZE: B	DWG. NO.: D070577	REV.: v2	
			NEXT ASSY: STRUCTURAL WELDMENT, HLTS		DRAFTER: D. BRIDGES 29 AUG 2010				
					CHECKER: M. MEYER 30 AUG 2010				
					APPROVAL:	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1	

D070577_Advanced_LIGO_SUS_HLTS_Structure_Side_Gusset, PART PDM REV: V1-004, DRAWING PDM REV: V1-000