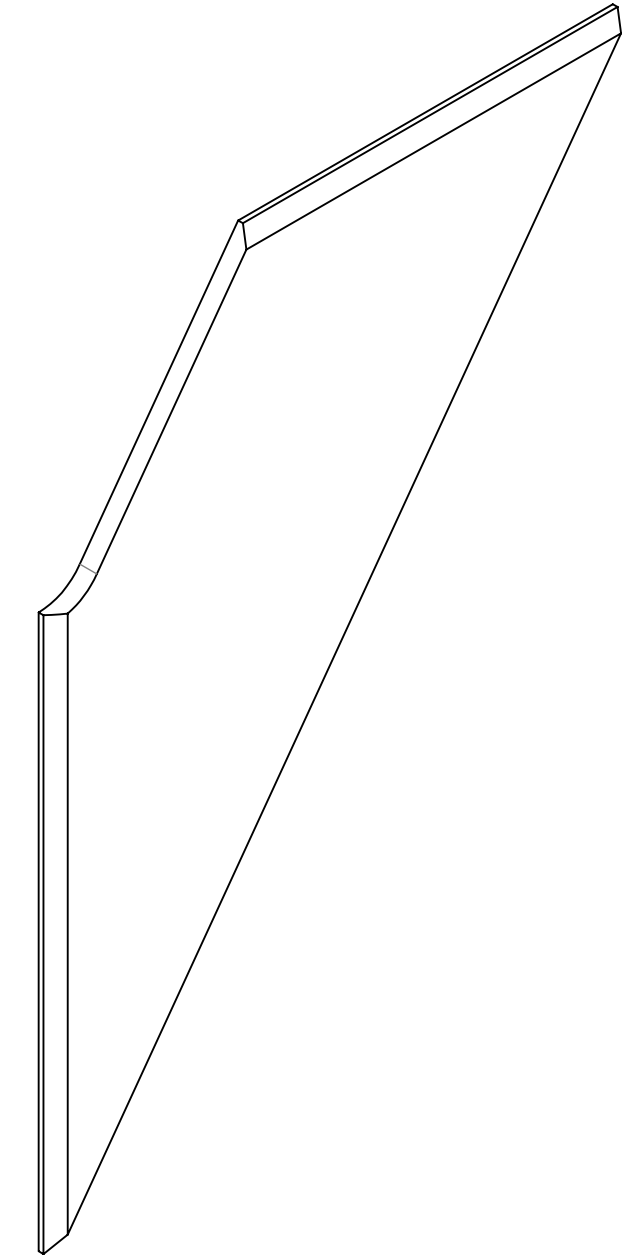
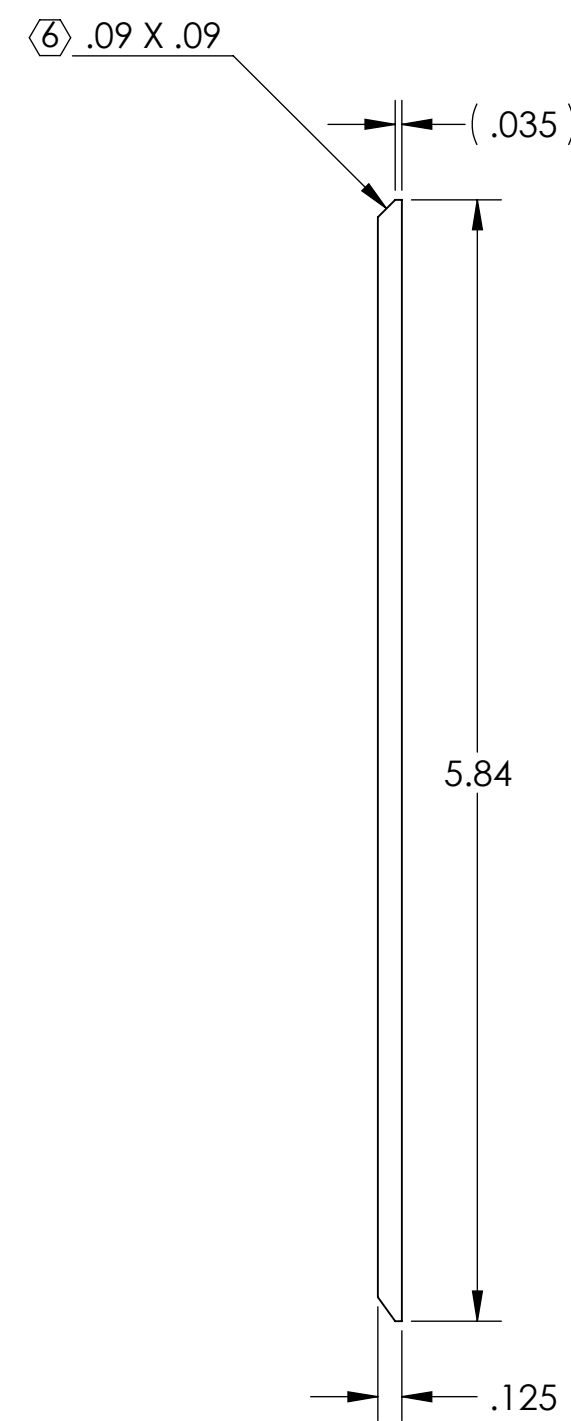
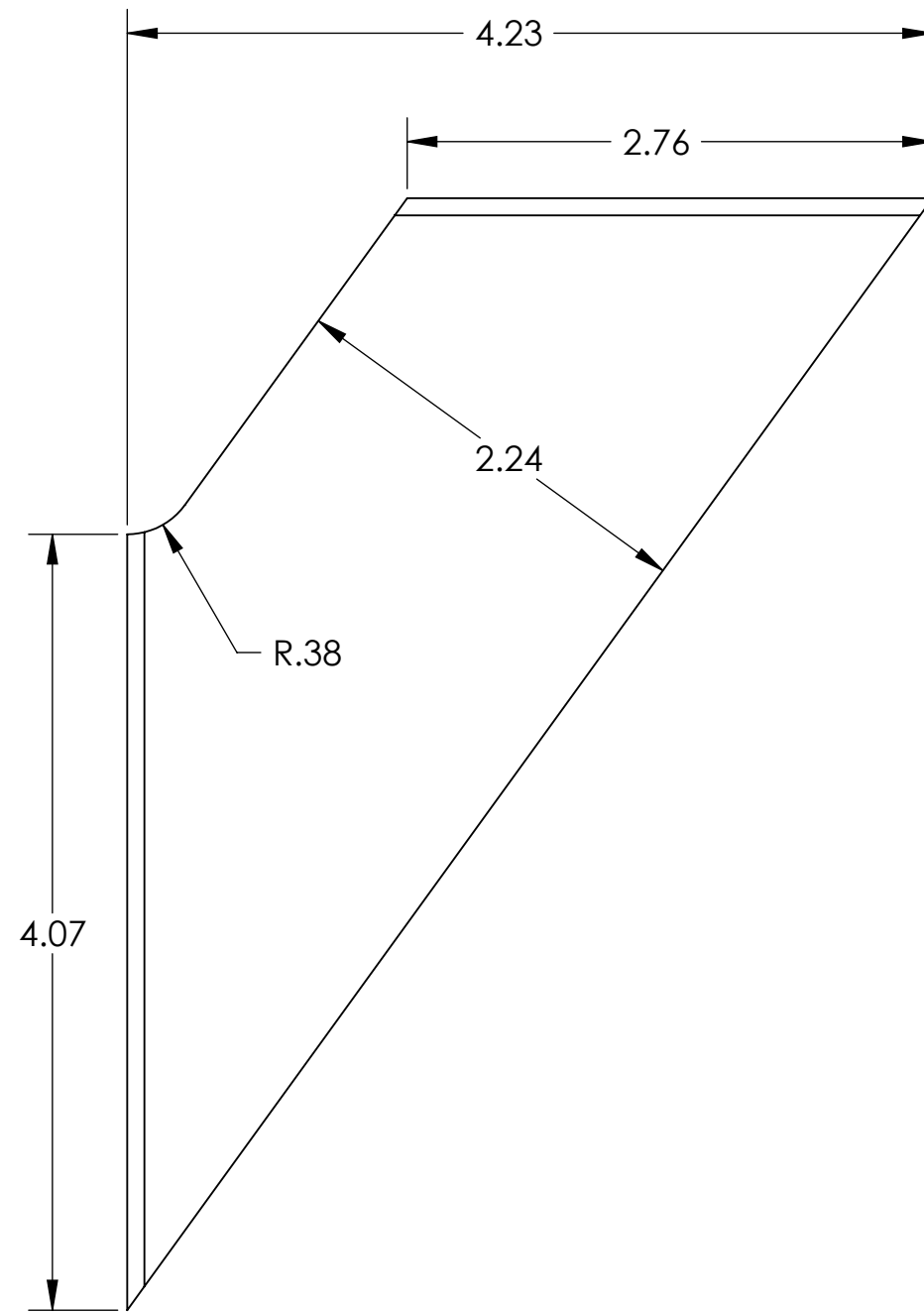
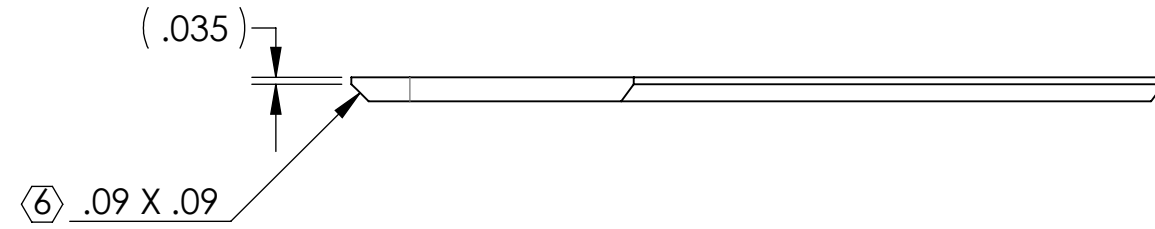


**NOTES CONTINUED:**  
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.  
 6. HALF OF ALL UPPER FRONT 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 E090364.

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



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

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.

**MATERIAL** 304 OR 304L SSSL  
**FINISH** 63 μinch



**SYSTEM** ADVANCED LIGO **SUB-SYSTEM** SUS

**NEXT ASSY** STRUCTURAL WELDMENT, HLTS

<b>PART NAME</b>			<b>UPPER FRONT GUSSET</b>		
<b>DESIGNER</b>	D. BRIDGES	29 AUG 2010	<b>SIZE</b>	<b>DWG. NO.</b>	<b>REV.</b>
<b>DRAFTER</b>	D. BRIDGES	29 AUG 2010	c	D070579	v2
<b>CHECKER</b>	M. MEYER	30 AUG 2010			
<b>APPROVAL</b>			<b>SCALE:</b> 1:1	<b>PROJECTION:</b>	SHEET 1 OF 1