



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	BOTTOM RING	D060494-00-K	1
2	VERTICAL BOX No 1	D060496-00-K	1
3	VERTICAL BOX No 2	D060497-00-K	2
4	VERTICAL BOX No 3	D060498-00-A	1
5	TOP RING	D060493-00-K	1
6	WELDED TRUSS MEMBER	D060499-00-K	2
7	SHORT GUSSET	D060501-00-K	2
8	FULL GUSSET	D060500-00-K	2

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. DO NOT SCALE FROM DRAWING.
 2. REMOVE ALL SHARP EDGES: R.02 MAX.
 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.

FINISH: ENGRAVE OR MECHANICALLY STAMP DRAWING (NO INKS OR DYES) PART NUMBER, REVISION, 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 12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: D 0 5 0 2 4 7 -A S/N 001

MATERIAL: Aluminum Alloy 6082

FINISH: CLEAN TO LIGO SPEC

DATE: 26-10-16

DRW: AKB
 CHECKED: []
 APPROVED: []

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 XX ± 0.01
 XXX ± 0.005
 ANGULAR ± 0.1°

SCALE: 1:3 PROJECTION: [] SHEET OF: []

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 IGR, GLASGOW UNIVERSITY GEO 605 GROUP

SYSTEM: []
 SUB-SYSTEM: []
 NEXT ASSY: []

UPPER STRUCTURE ASSEMBLY

DWG. NO.: [] REV: []