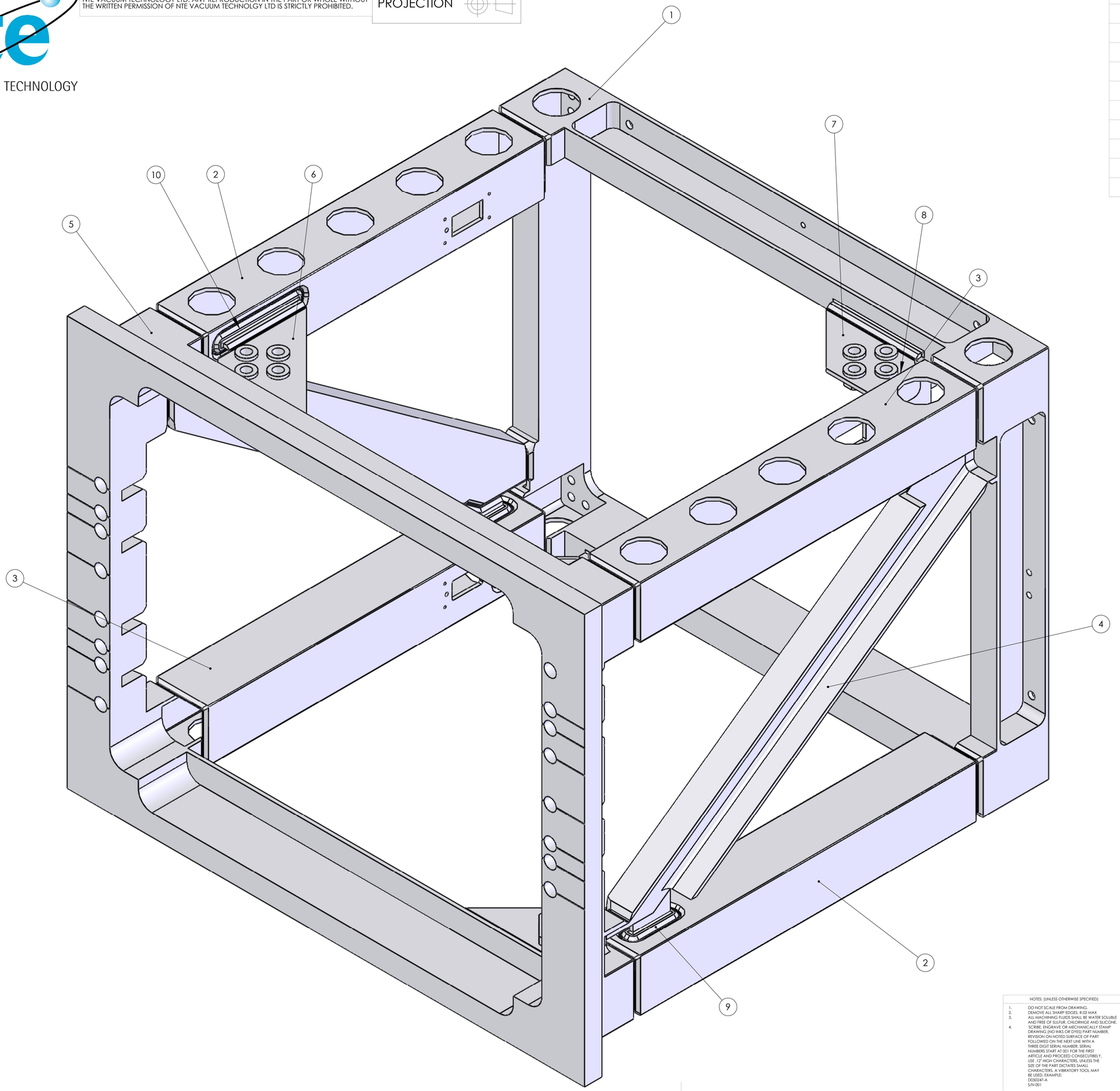
PROJECTION

VACUUM TECHNOLOGY



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D060494-00-K	BOTTOM RING	1
2	D060496-00-K	VERTICAL BOX No1	2
3	D060497-00-K	VERTICAL BOX No2	2
4	D060499-00-K	WELDED TRUSS MEMBER No1	2
5	D060493-00-K	TOP RING	1
6	D060500-00-K	FULL GUSSET	2
7	D060501-00-K	SHORT GUSSET	2
8	D060499-02_02	SHORT GUSSET SUPPORT	2
9	D060499-02_03	WELDED TRUSS MEMBER SUPPORT	4
10	D060499-02_01	FULL GUSSET SUPPORT	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, CHLORINGE AND SILICONE.
4. SCRIBE, 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 CONSECUTIBELY. USE .12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: D050247-A S/N 001

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN MILLIMETERS
SURFACE FINISH:
TOLERANCES:
LINEAR: .XX ±0.01mm
.XX ±0.005mm
ANGULAR: ±0.5°

FINISH: CLEAN to LIGO SPEC

DEBUR AND BREAK SHARP EDGES

	NAME	DATE
DRAWN	TOMASZ RAK	12.06.2008
CHK'D		
APP'V'D		
MFG		
Q.A		

MATERIAL: Aluminium Alloy 6082

WEIGHT:

DO NOT SCALE DRAWING

REVISION B

PARTS LIST

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP

TITLE:

UPPER STRUCTURE ASSEMBLY

DWG NO. D060492-00-K

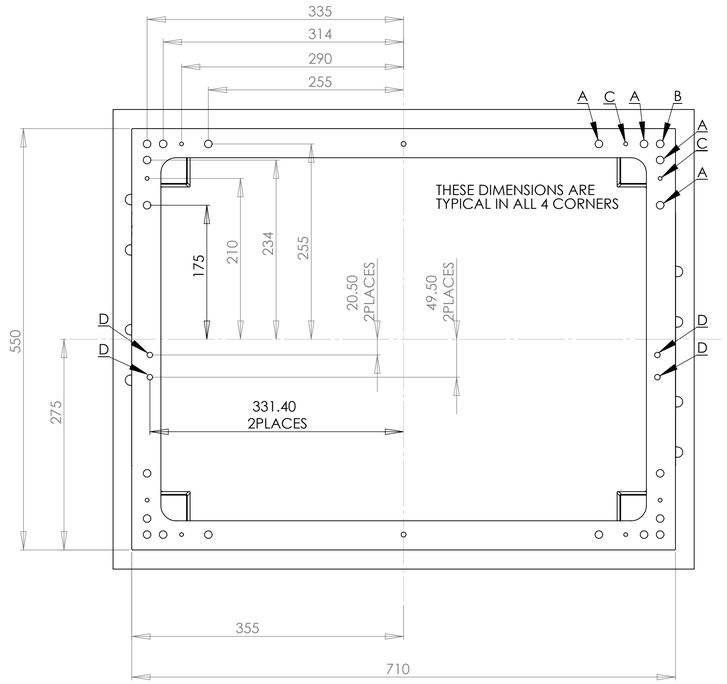
A1

SCALE:1:3

SHEET 1 OF 3

PROJECTION

VACUUM TECHNOLOGY



NOTE

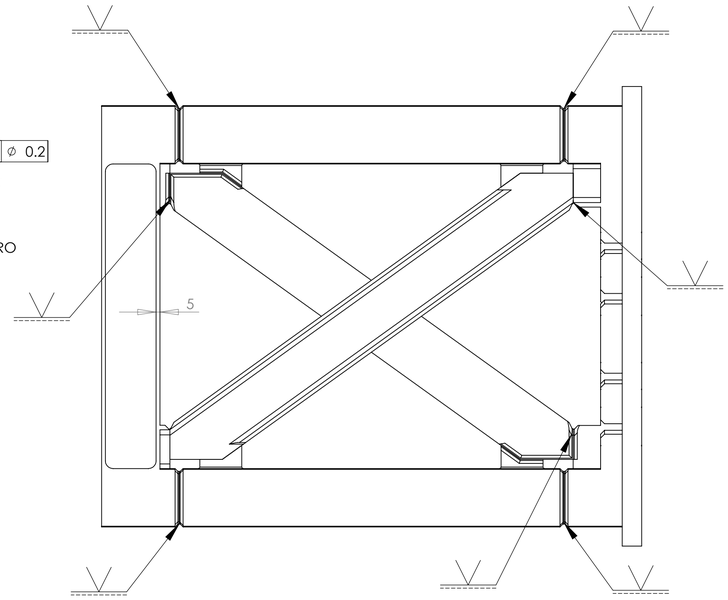
16 HOLES MARKED "A" ∅10.4mm THRO FIRST FACE ONLY

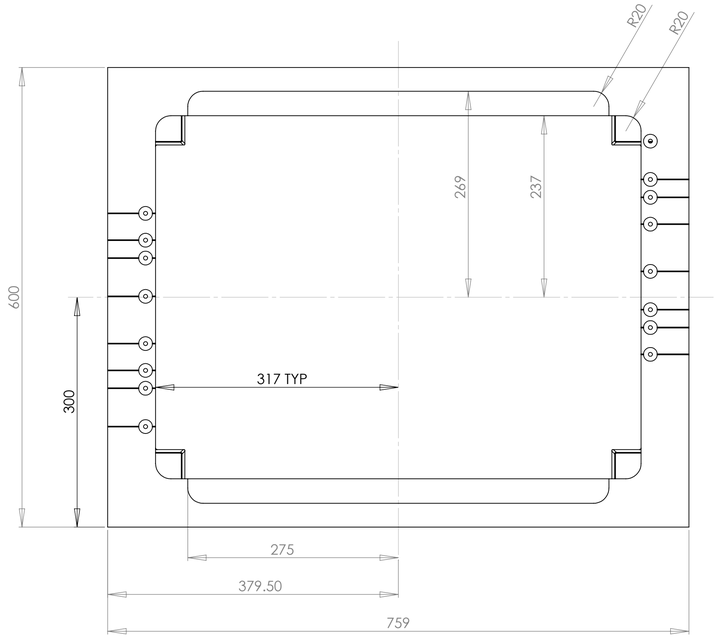
4 HOLES MARKED "B" ∅8.2 - 8.3 ⌖ ∅ 0.2

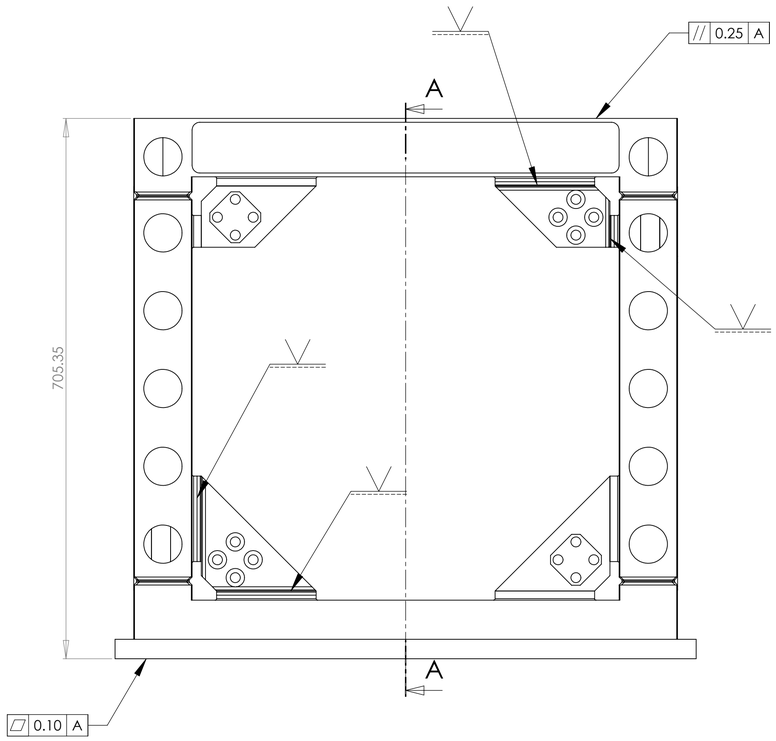
10 HOLES MARKED "C" 1/4-20 UNC HELICOILS THRO FIRST FACE ONLY

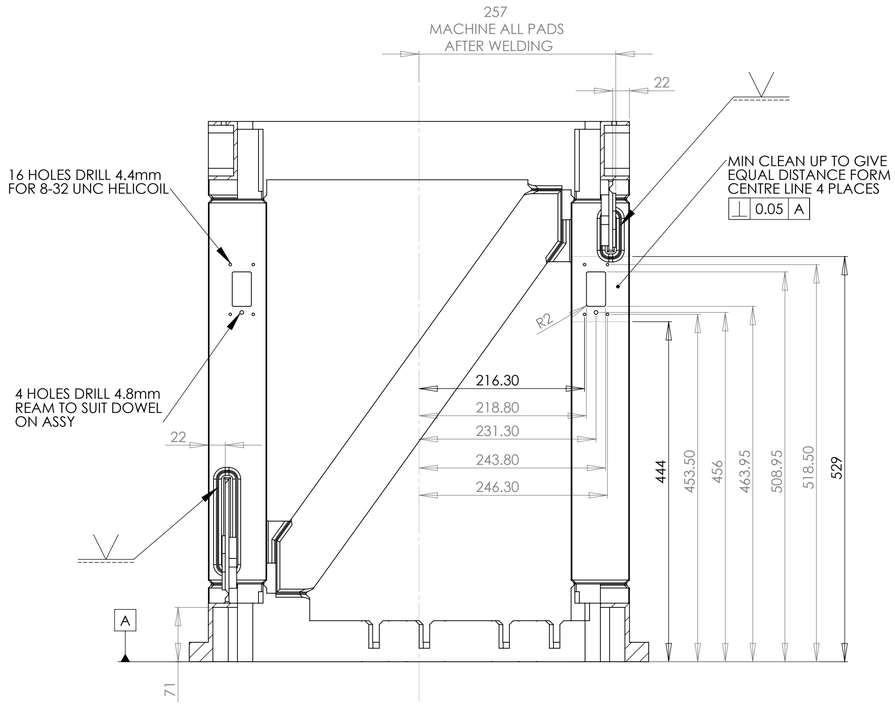
⌖ ∅ 0.25

4 HOLES MARKED "D" ∅7.2mm THRO BOTH FALCES OF BOTTOM RING









SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

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UNLESS OTHERWISE SPECIFIED:
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SURFACE FINISH:
TOLERANCES:
LINEAR: .XX ±0.01mm
.XX ±0.005mm
ANGULAR: ±0.5°

FINISH: CLEAN to LIGO SPEC

DEBUR AND BREAK SHARP EDGES

	NAME	DATE
DRAWN	TOMASZ RAK	12.06.2008
CHK'D		
APP'V'D		
MFG		
Q.A		

MATERIAL: Aluminium Alloy 6082

WEIGHT:

DO NOT SCALE DRAWING

REVISION B

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP

TITLE: UPPER STRUCTURE ASSEMBLY

DWG NO. D060492-00-K

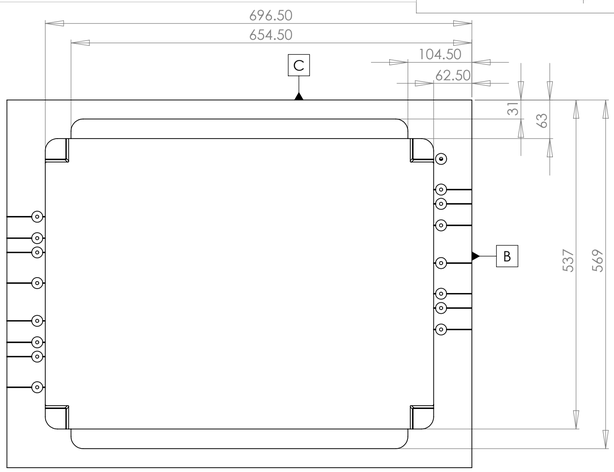
A1

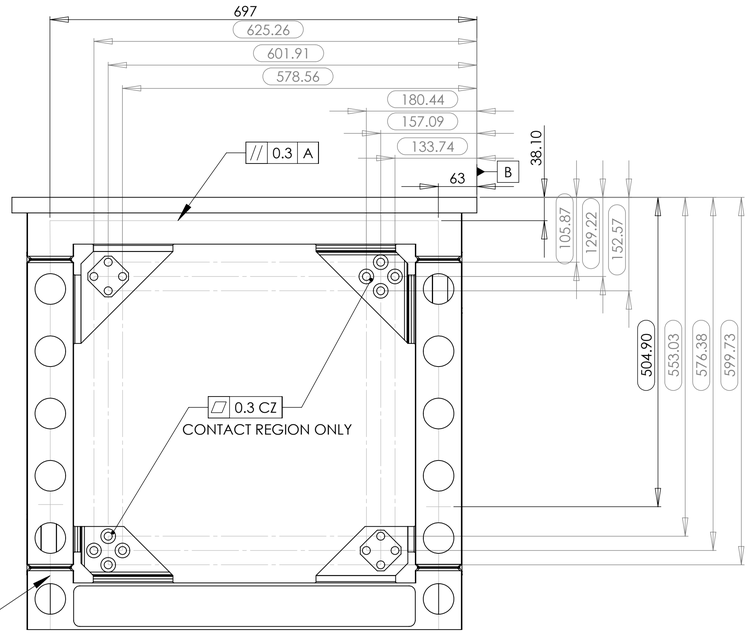
SCALE:1:4

SHEET 2 OF 3

VACUUM TECHNOLOGY

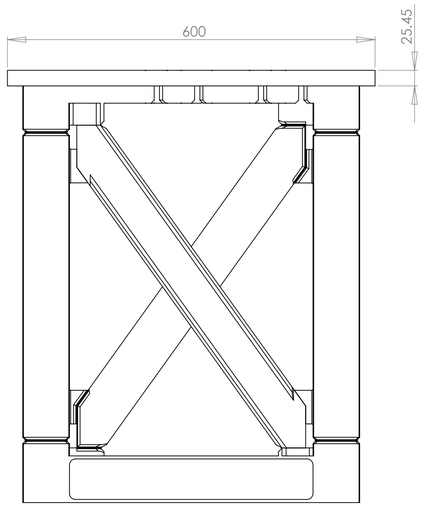
PROJECTION

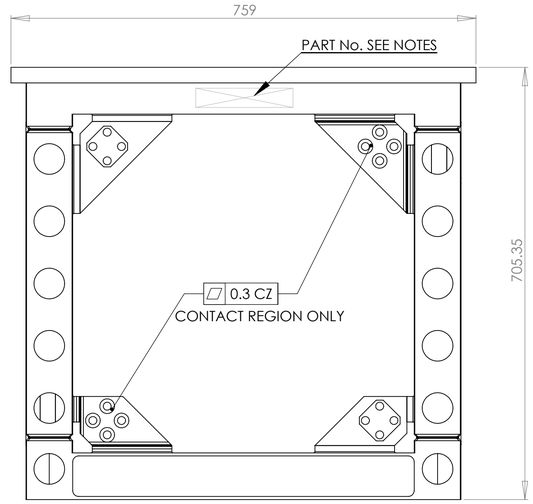




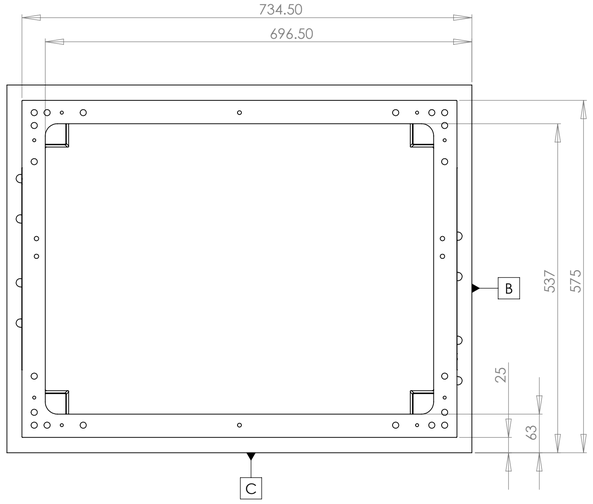
ENGRAVED LINES AS DETAIL A

⊥ ⌀ 0.3 A





TAP ALL HOLES DIMENSIONED ON THIS VEIW
3/8-16 UNC THRO 0.005" OBERSIZE ⌖ ⌀ 0.3 B A



DRAWING SHOWING FULL UPPER STRUCTURE WELDMENT
DRAWING NOT INTENDED FOR MANUFACTURE
DETAIL OF WELD PREPS, TOOLING RADS, FAB STEPS EXCLUDED

SHEET 1 SHOWS ASSEMBYLY
SHEET 2,3 & 4 SHOW FULL WELDMENT DETAIL

NOTES: (UNLESS OTHERWISE SPECIFIED)

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DEBUR AND BREAK SHARP EDGES

	NAME	DATE
DRAWN	TOMASZ RAK	12.06.2008
CHK'D		
APPV'D		
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Q.A		

MATERIAL: Aluminium Alloy 6082

WEIGHT:

DO NOT SCALE DRAWING | REVISION B

PARTS LIST

LIGO

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP

TITLE: UPPER STRUCTURE WELDMENT

DWG NO. D060492-00-K

A1

SCALE:1:3

SHEET 3 OF 3