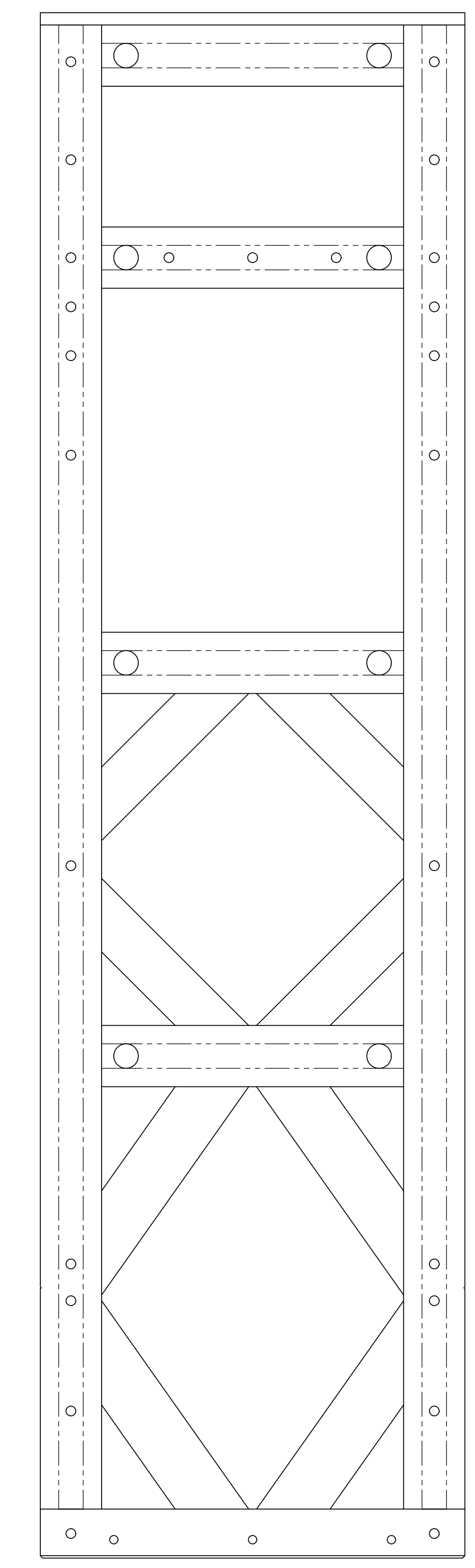
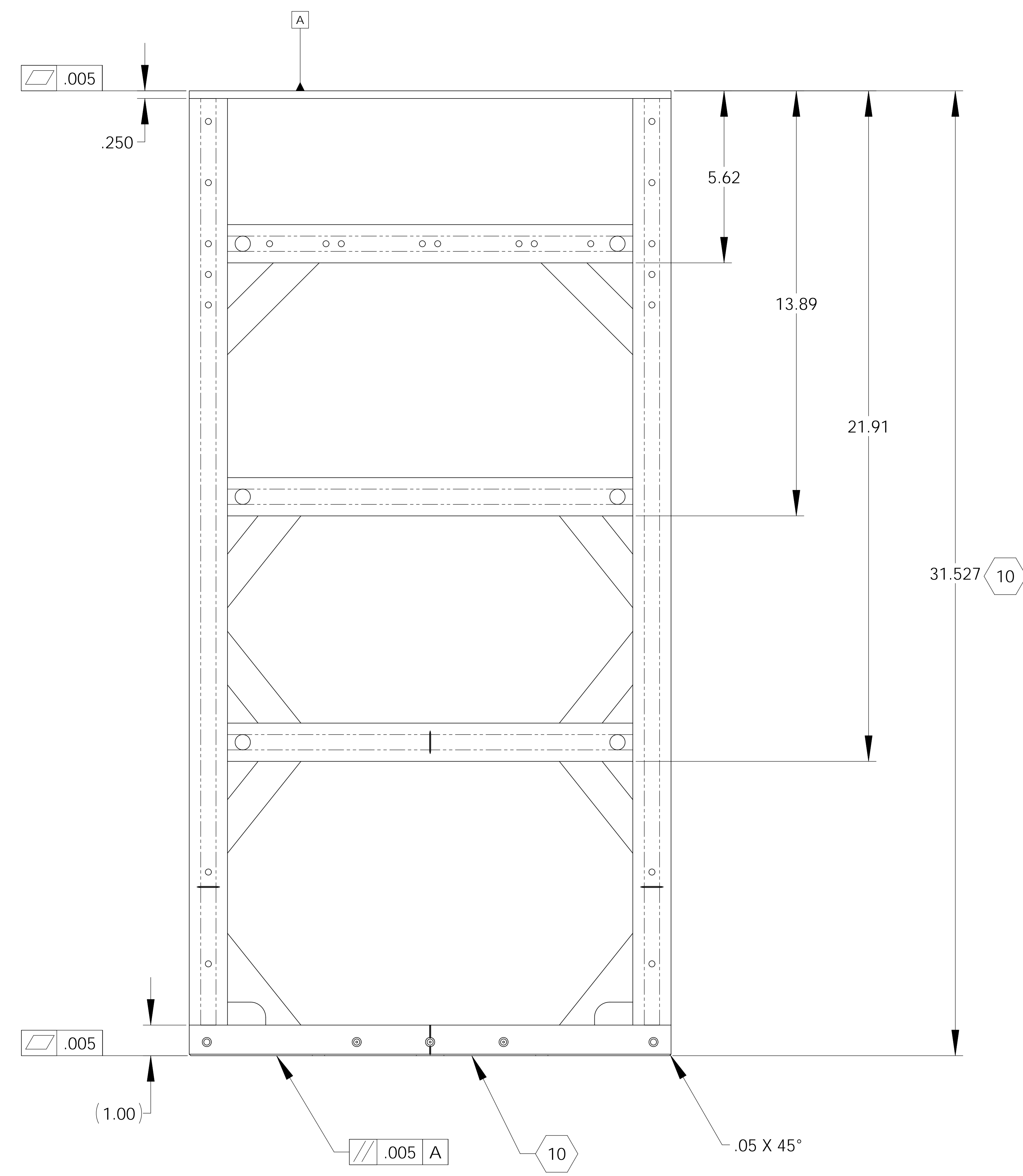
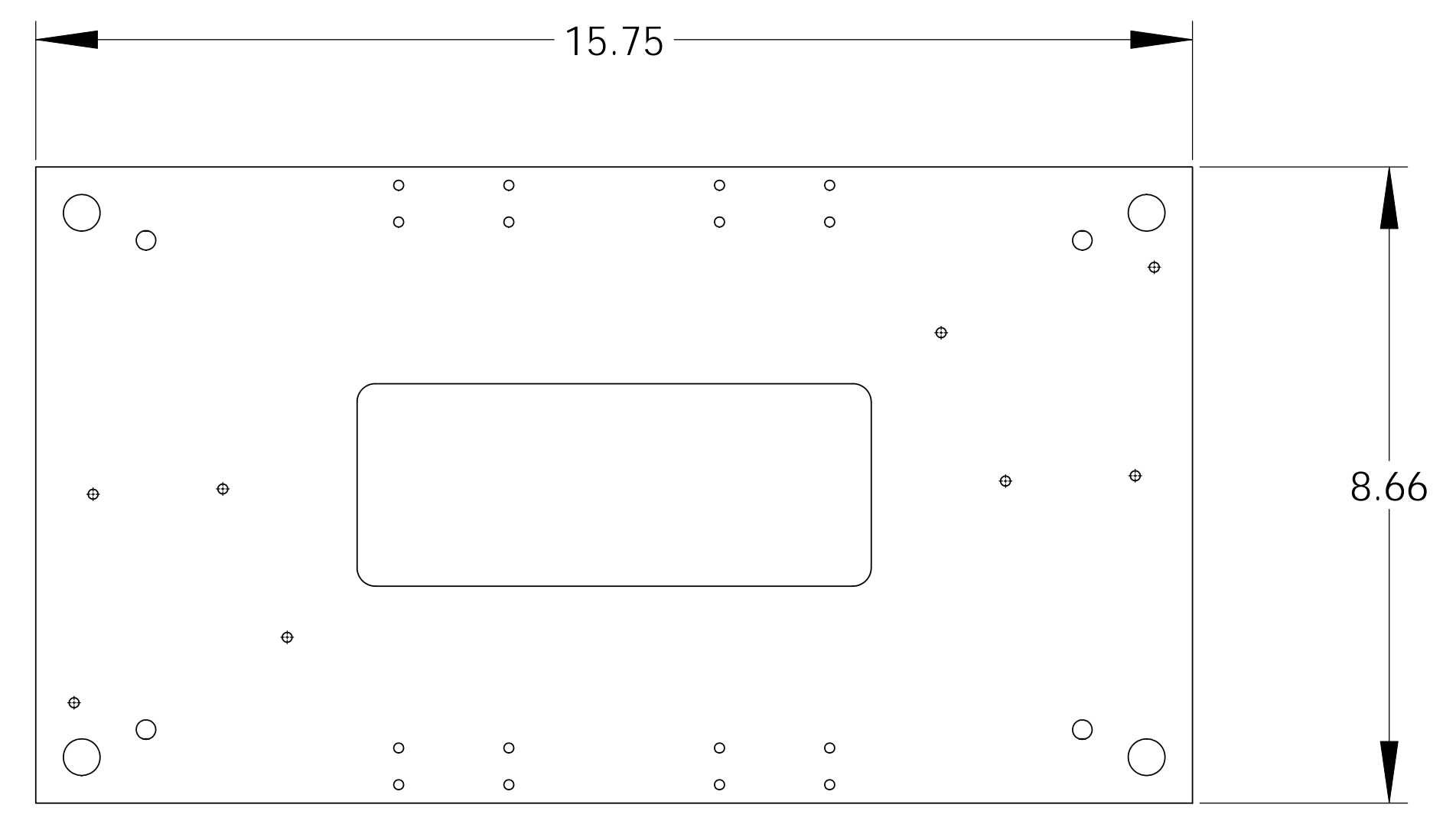
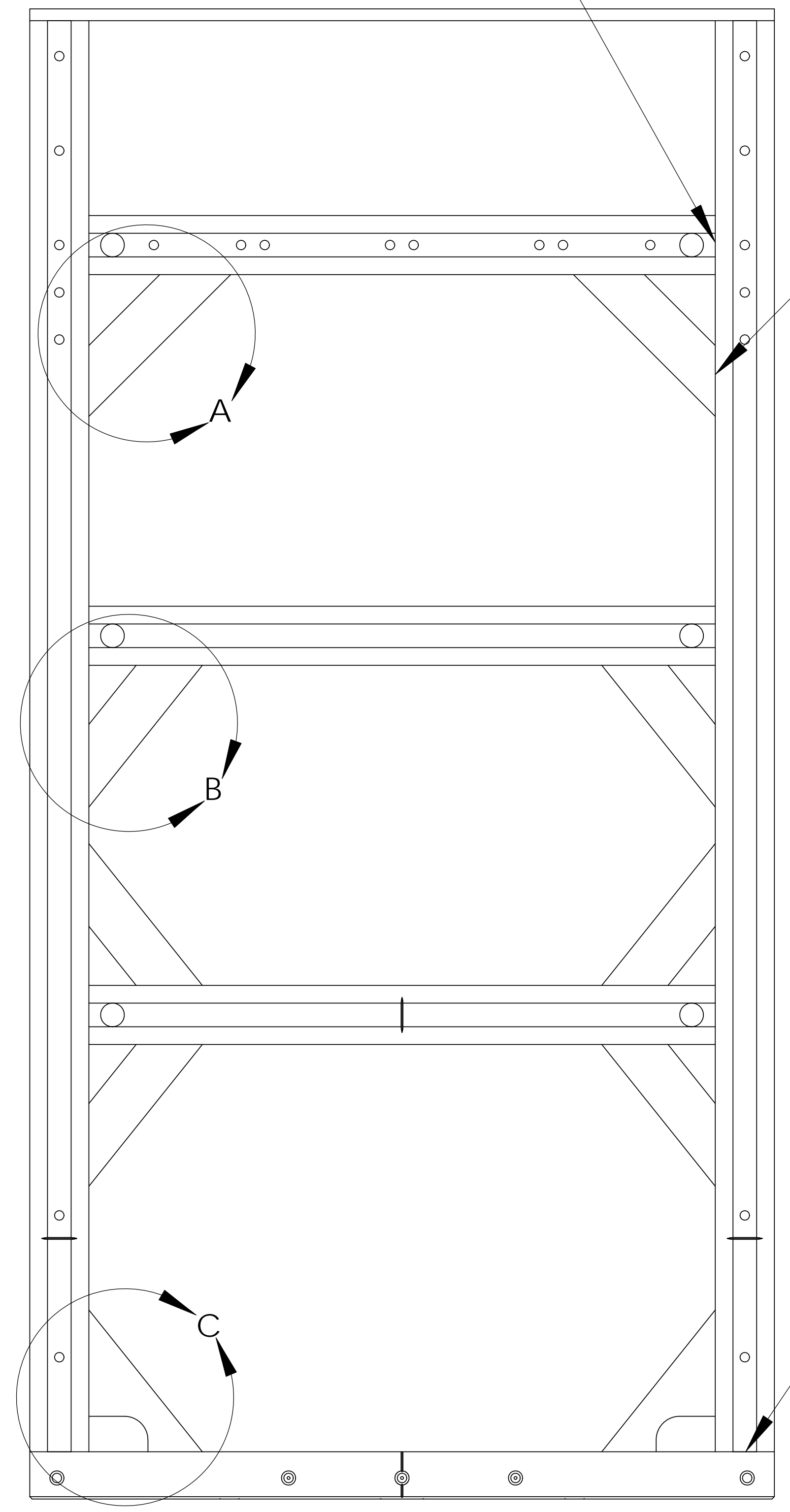


- NOTES CONTINUED:
- 5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 100 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
  - 6) ALL SURFACES OF ALL PARTS ARE TO BE MACHINED (NO AS RECEIVED, AS ROLLED, AS MILLED SURFACES WILL BE ACCEPTED), EXCEPT INNER SURFACES AND OUTER RADIUS OF TUBING. NO GRINDING OR LAPPING WITH ABRASIVE WHEELS, CLOTH, OR STONES IS PERMITTED. NO PARTS SHALL BE CAST OR MOLDED (NO TOOLING PLATE IS PERMITTED). BLANCHARD GRINDING IS ACCEPTABLE IF ALL GROUND SURFACES ARE MACHINED AFTERWARDS.
  - 7) ALL WELDING SHALL BE PERFORMED IN ACCORDANCE WITH LIGO E0900048.
  - 8) ALL TUBING IS 1.25" SQUARE WITH A WALL THICKNESS OF .180" ± .010".
  - 9) ALL GUSSETS ARE .375" THICK.
  - 10) AFTER WELDING, STRESS RELIEF, AND HEAT TREATMENT, FLY-CUT INDICATED SURFACE TO MEET REQUIRED DIMENSION.
  - 11) INDICATED FEATURES ARE TO BE ADDED AFTER ALL WELDING, HEAT TREATMENT, AND OTHER MACHINING OPERATIONS ARE COMPLETED.
  - 12) SCRIBE LINE WHERE INDICATED. LINE SHOULD BE .04" WIDE X .02" DEEP AND RUN THE LENGTH OF THE FACE AS SHOWN.
  - 13) SCRIBE VENT LINE TO INTERSECT INTENDED HOLE. SCRIBE MARK SHOULD BE .02" X .04".
  - 14) MACHINE ALL HELICOIL HOLES ACCORDING TO EMIHART HELICOIL SYSTEMS CATALOG HC2000, REV. 4, PAGE 17.
  - 15) ALL HELICOILS TO BE INSERTED BY LIGO PERSONNEL FOLLOWING CLEANING AND BAKING.

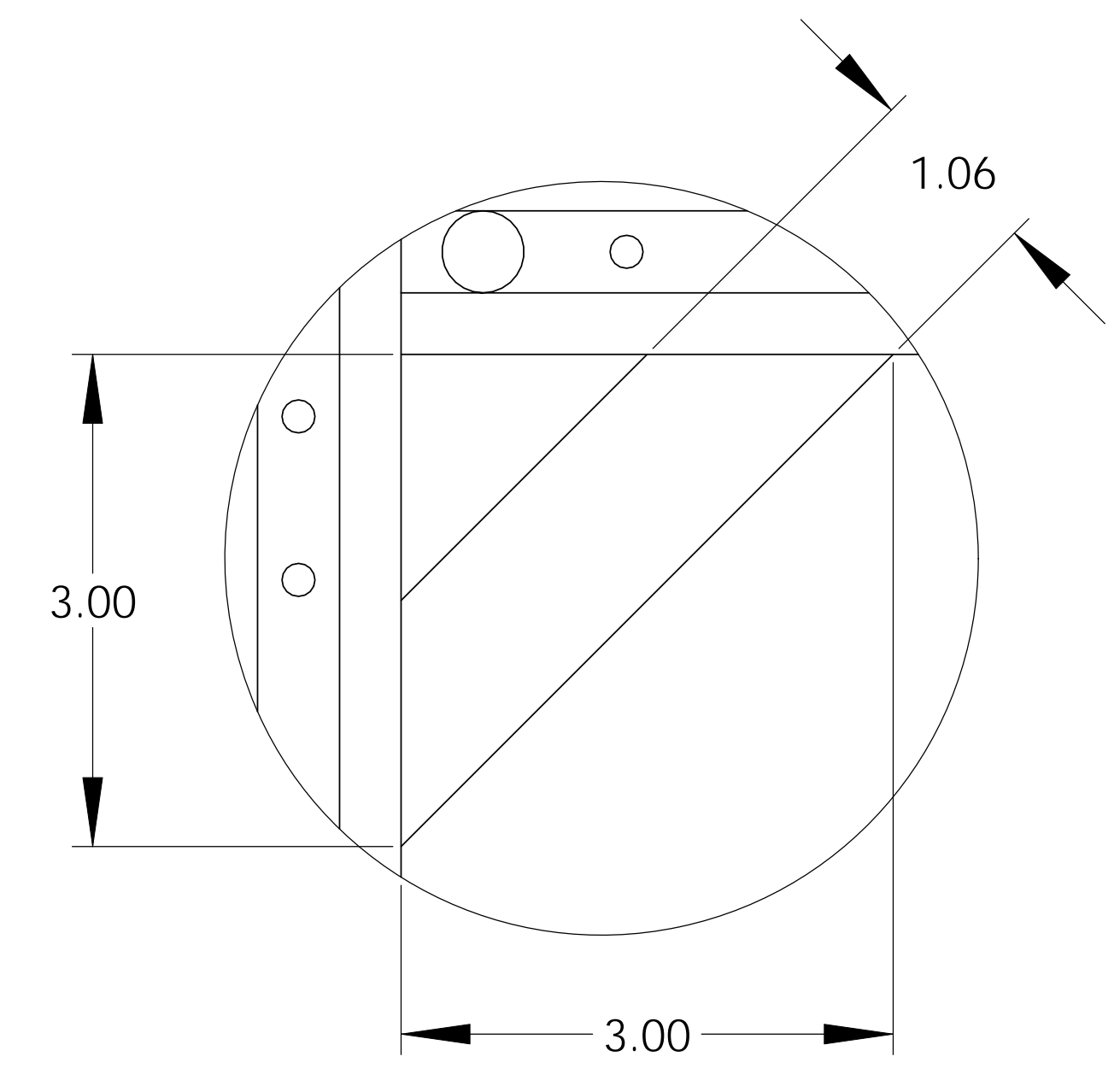
REV.	DATE	DCN #	DRAWING TREE #
A	24 JUN 2004	E040303-00	-
v1	-	INTERNAL REVISION	-
v2	30 APR 2010	E0900352	E0900353



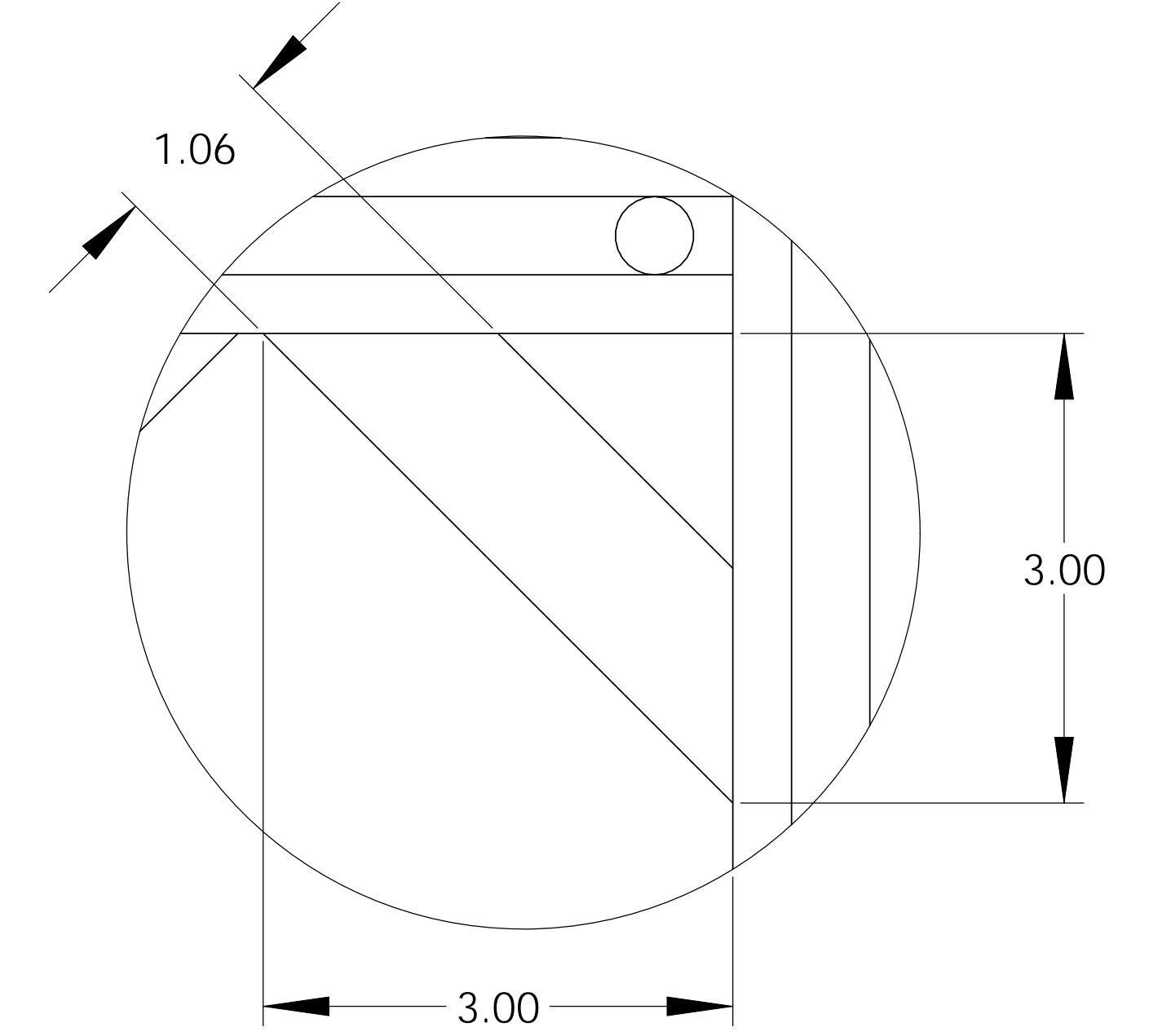
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: XX ± .03 XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		STRUCTURAL WELDMENT ASSEMBLY, HSTS	
ANGULAR ± 0.5°		MATERIAL 304 OR 304L SSSL		SYSTEM ADVANCED LIGO		DESIGNER M. MEYER	
		FINISH 32 μinch		SUB-SYSTEM SUS		DRAFTER B. MOORE	
		NEXT ASSY D020700				CHECKER M. MEYER	
						APPROVAL	
						SCALE: 1:2	
						PROJECTION:	
						SHEET 1 OF 9	



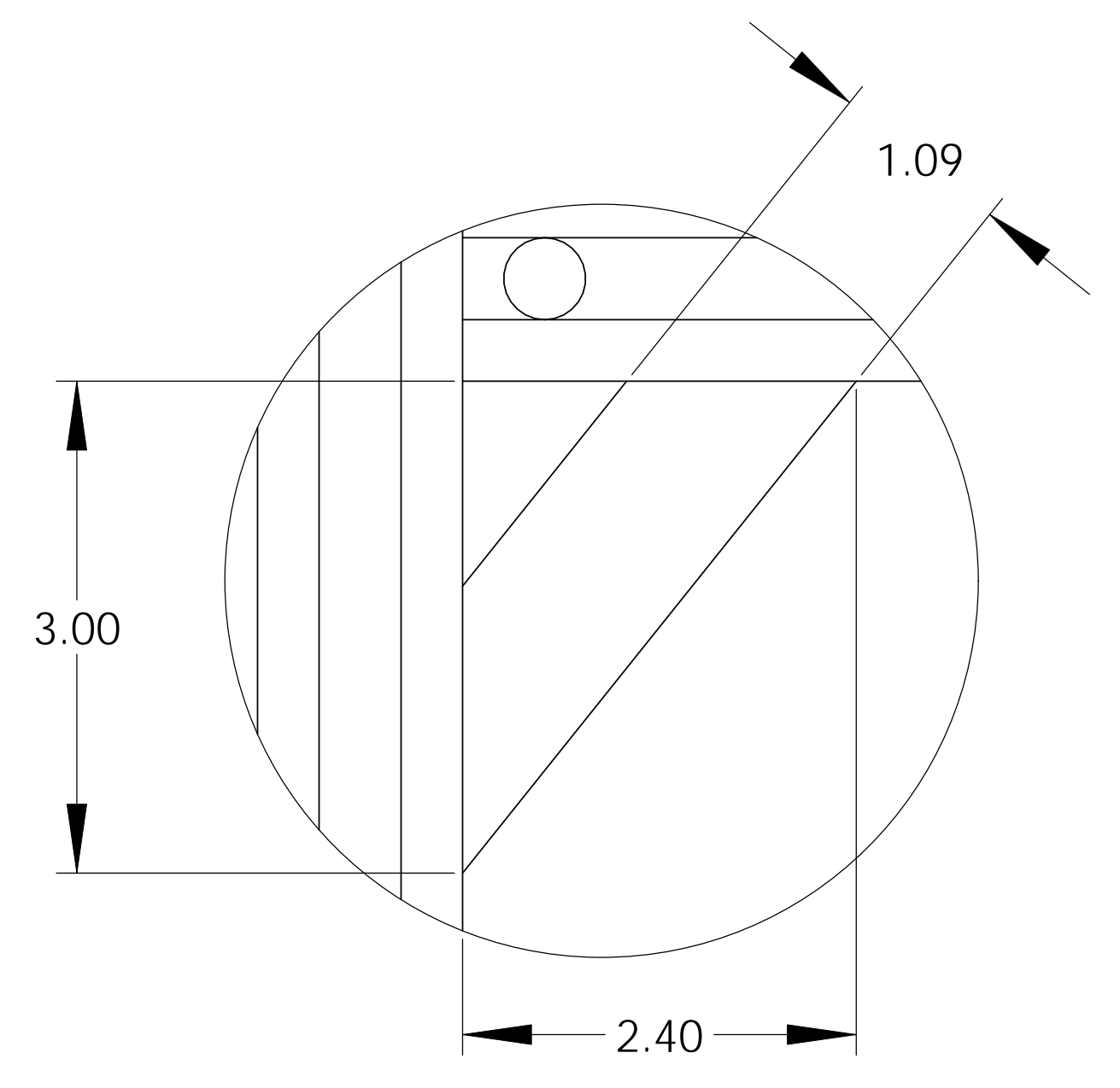
9 FRONT AND BACK SIDES



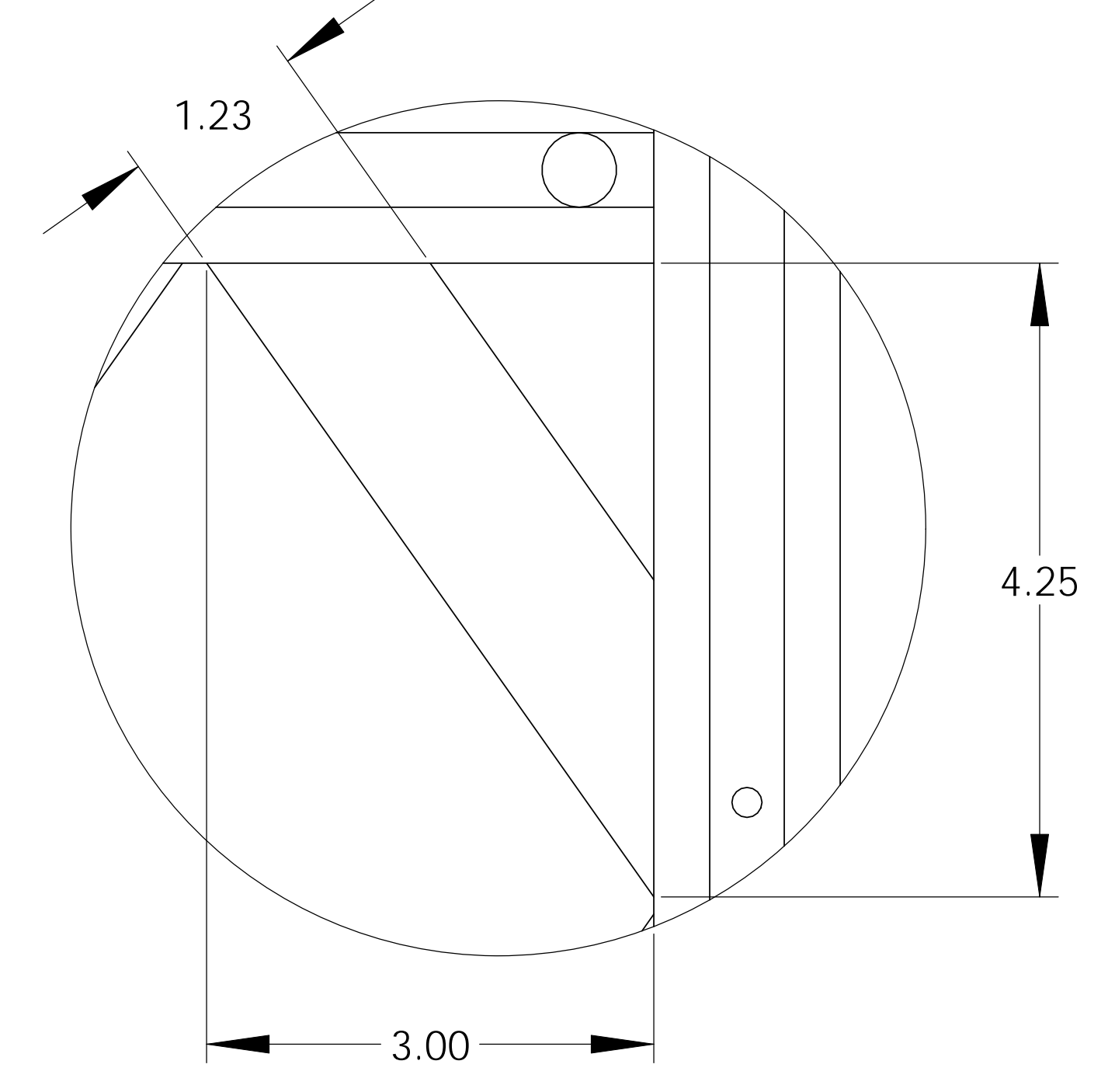
DETAIL A  
SCALE 1 : 1  
2 PLACES



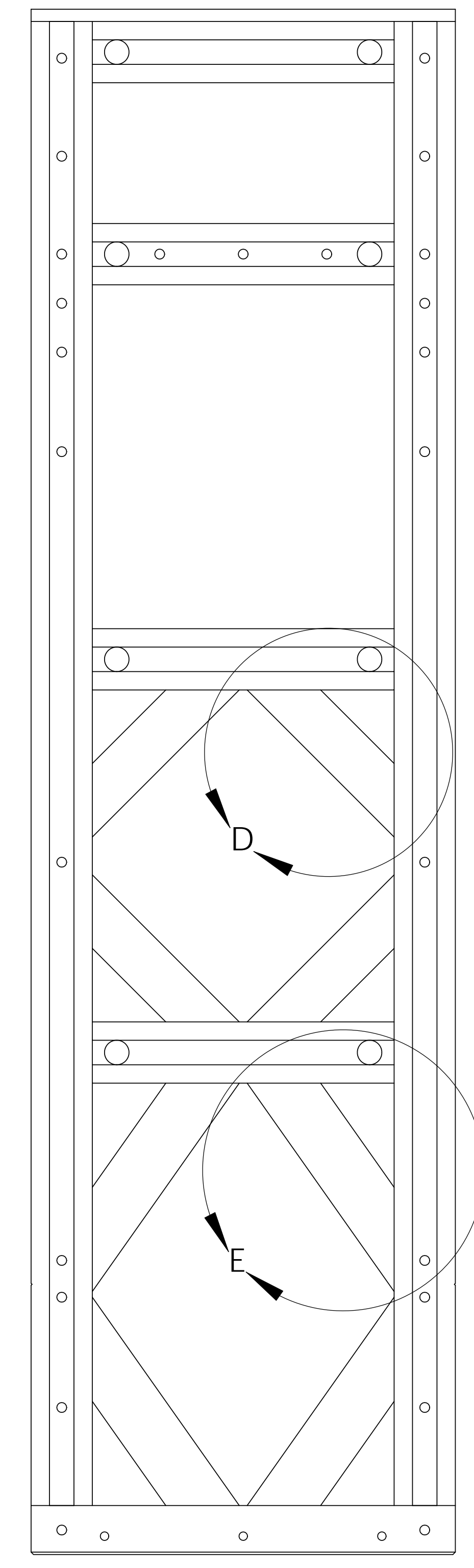
DETAIL D  
SCALE 1 : 1  
4 PLACES



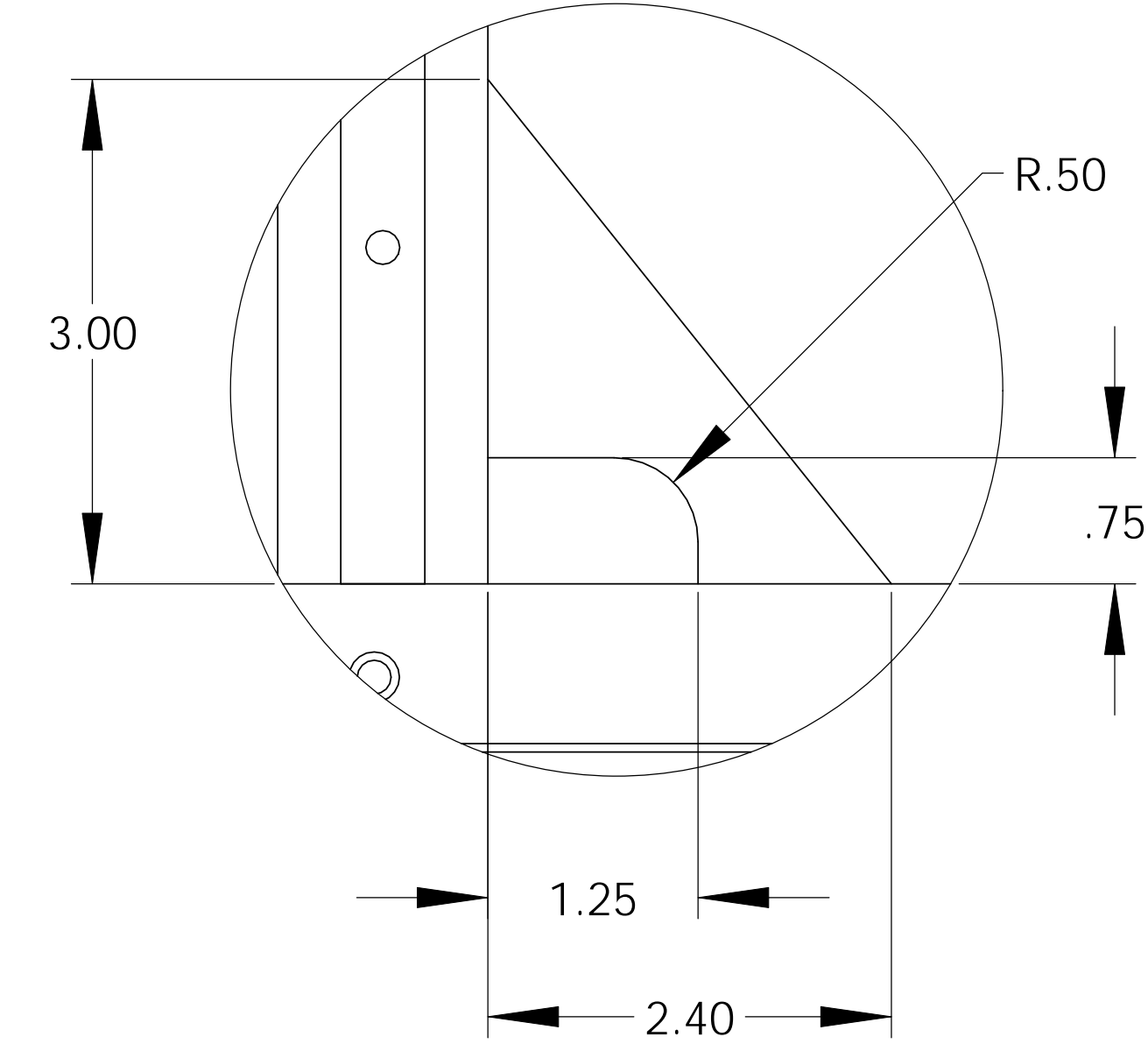
DETAIL B  
SCALE 1 : 1  
6 PLACES



DETAIL E  
SCALE 1 : 1  
4 PLACES

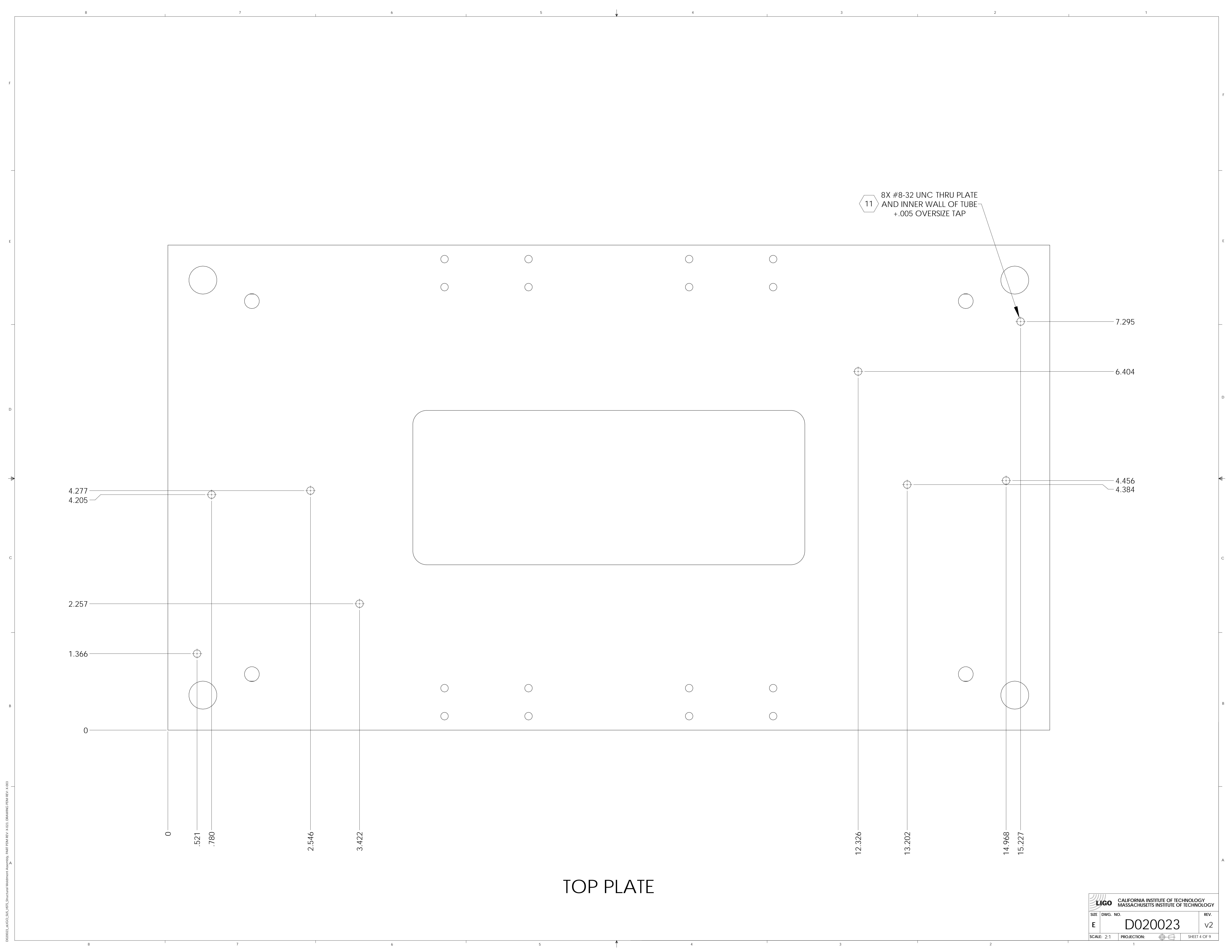


9 LEFT AND RIGHT SIDES



DETAIL C  
SCALE 1 : 1  
2 PLACES

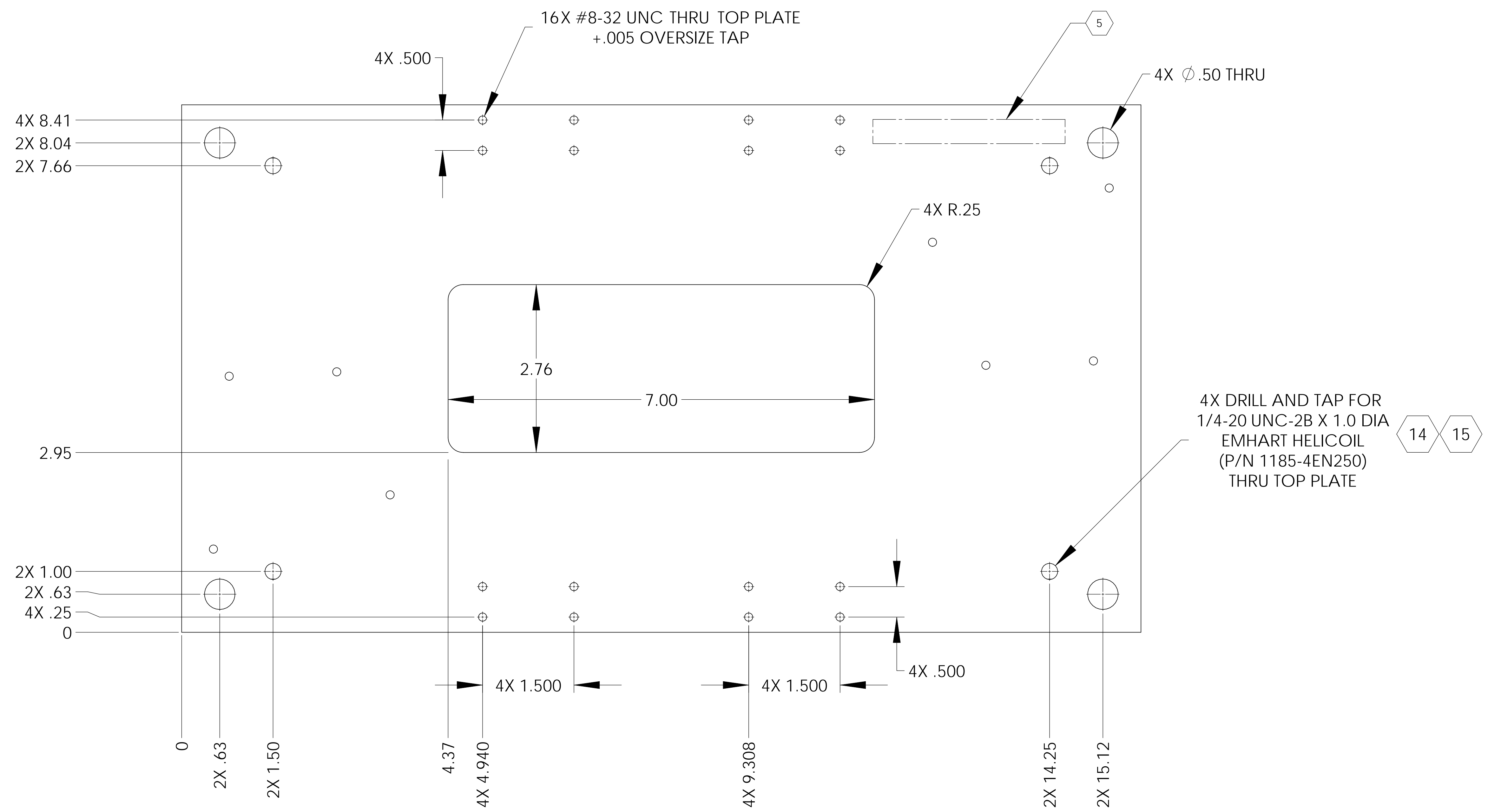




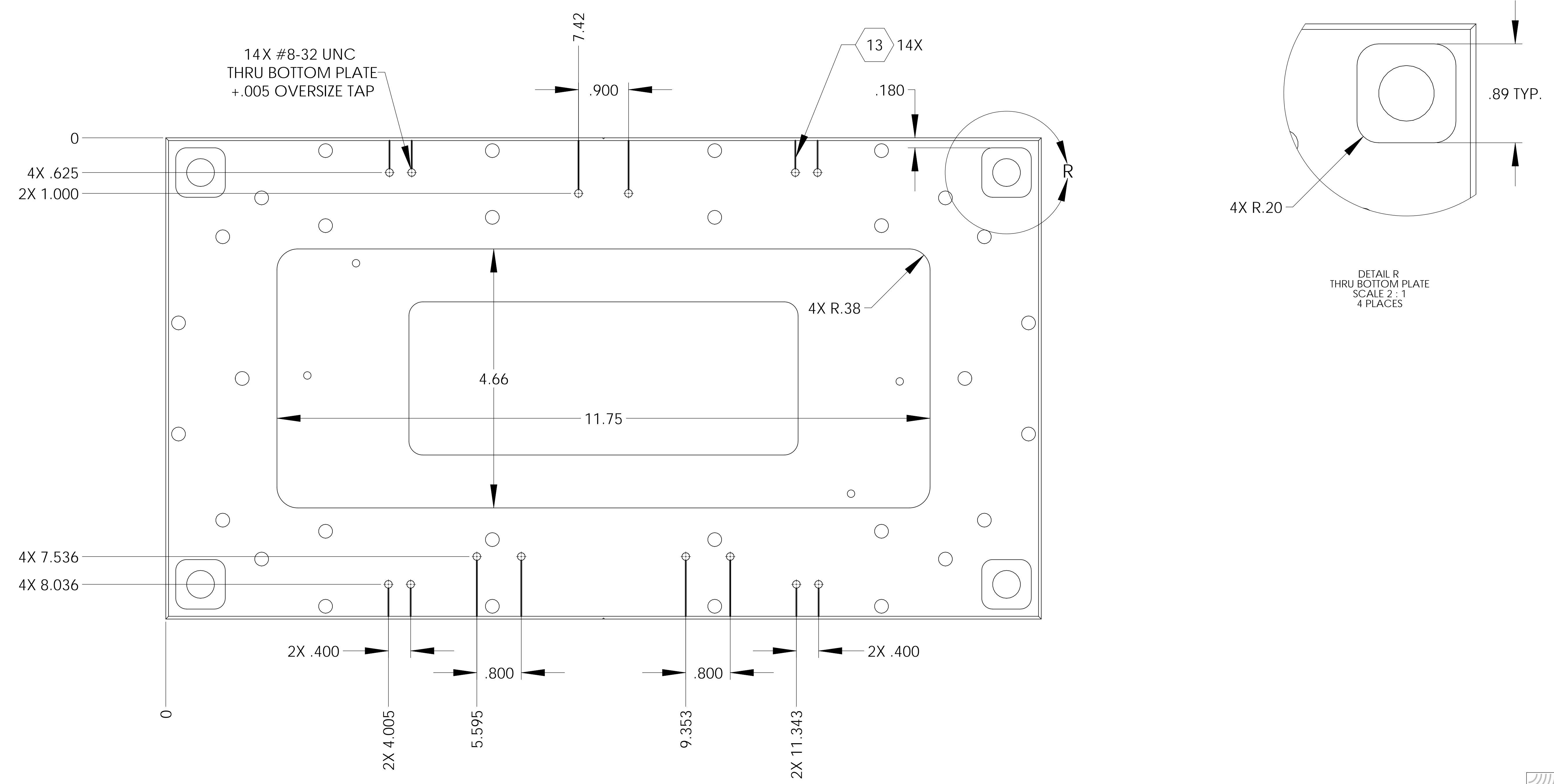
11

8X #8-32 UNC THRU PLATE  
AND INNER WALL OF TUBE  
+.005 OVERSIZE TAP

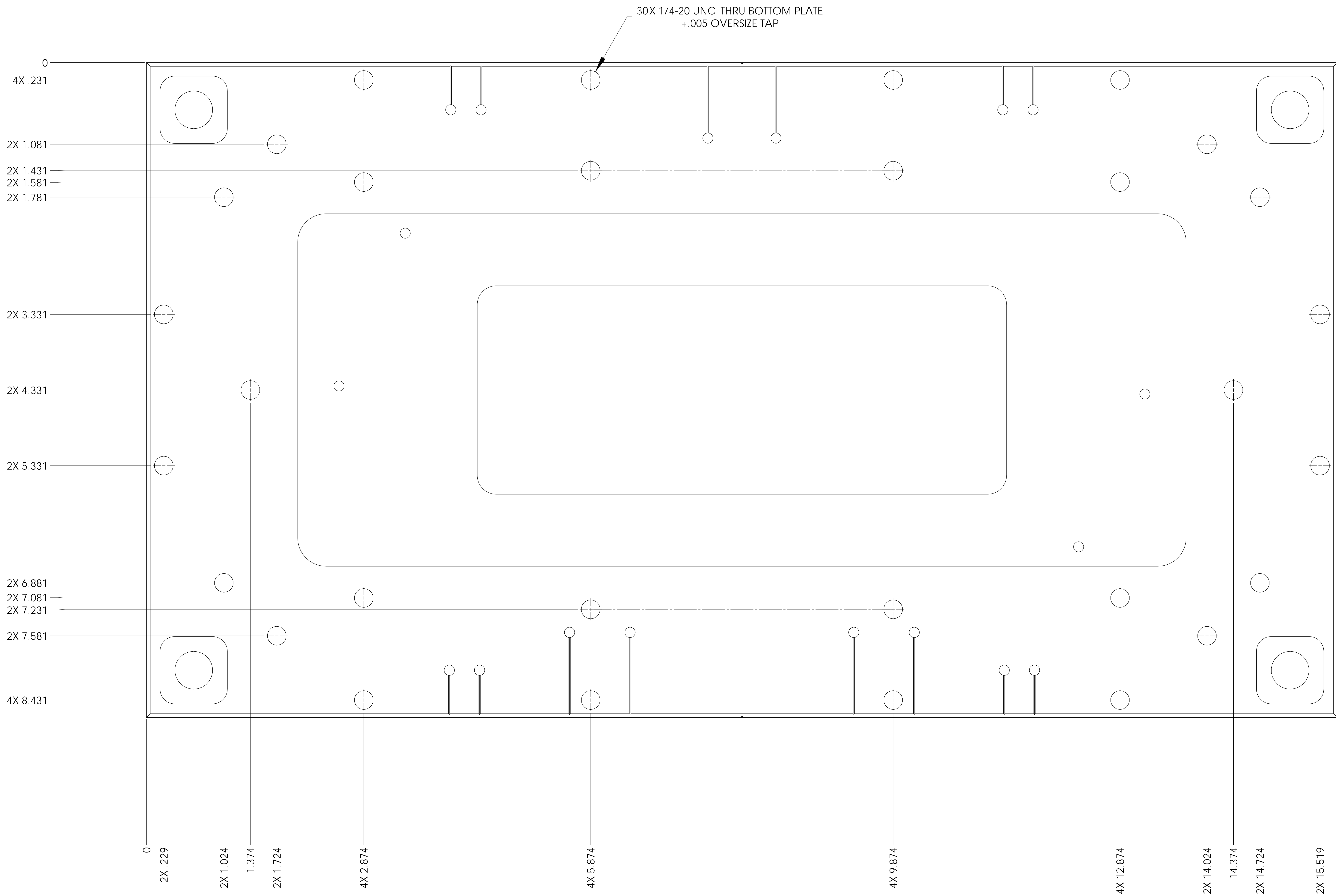
TOP PLATE



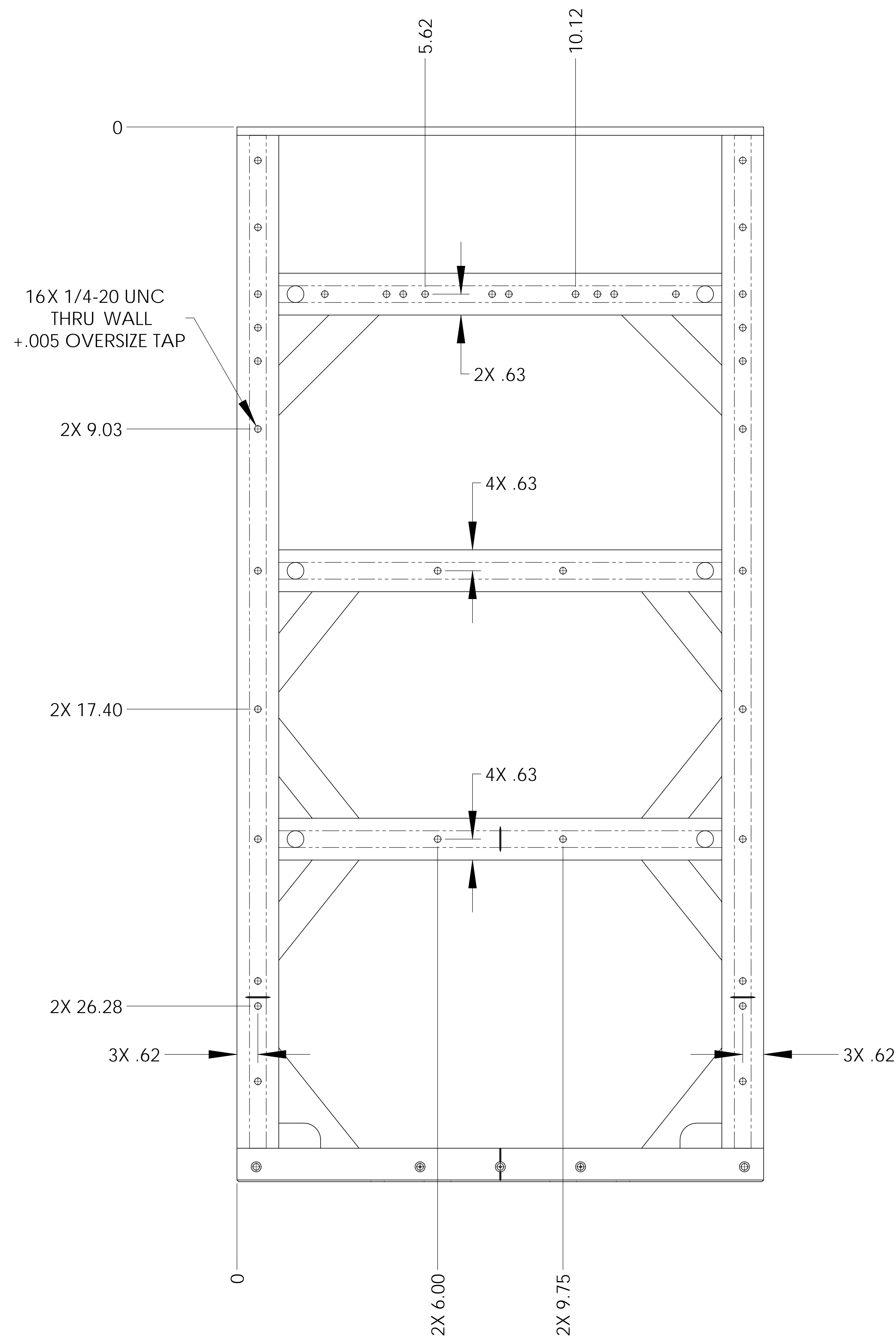
TOP PLATE



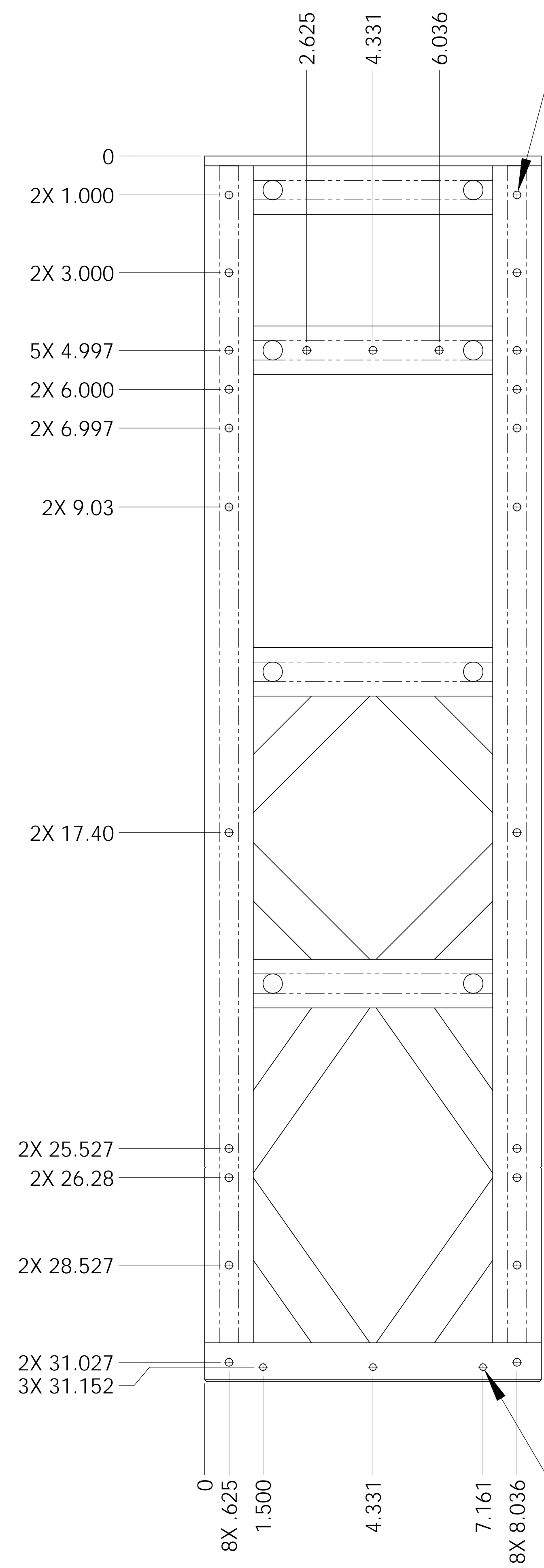
BOTTOM PLATE



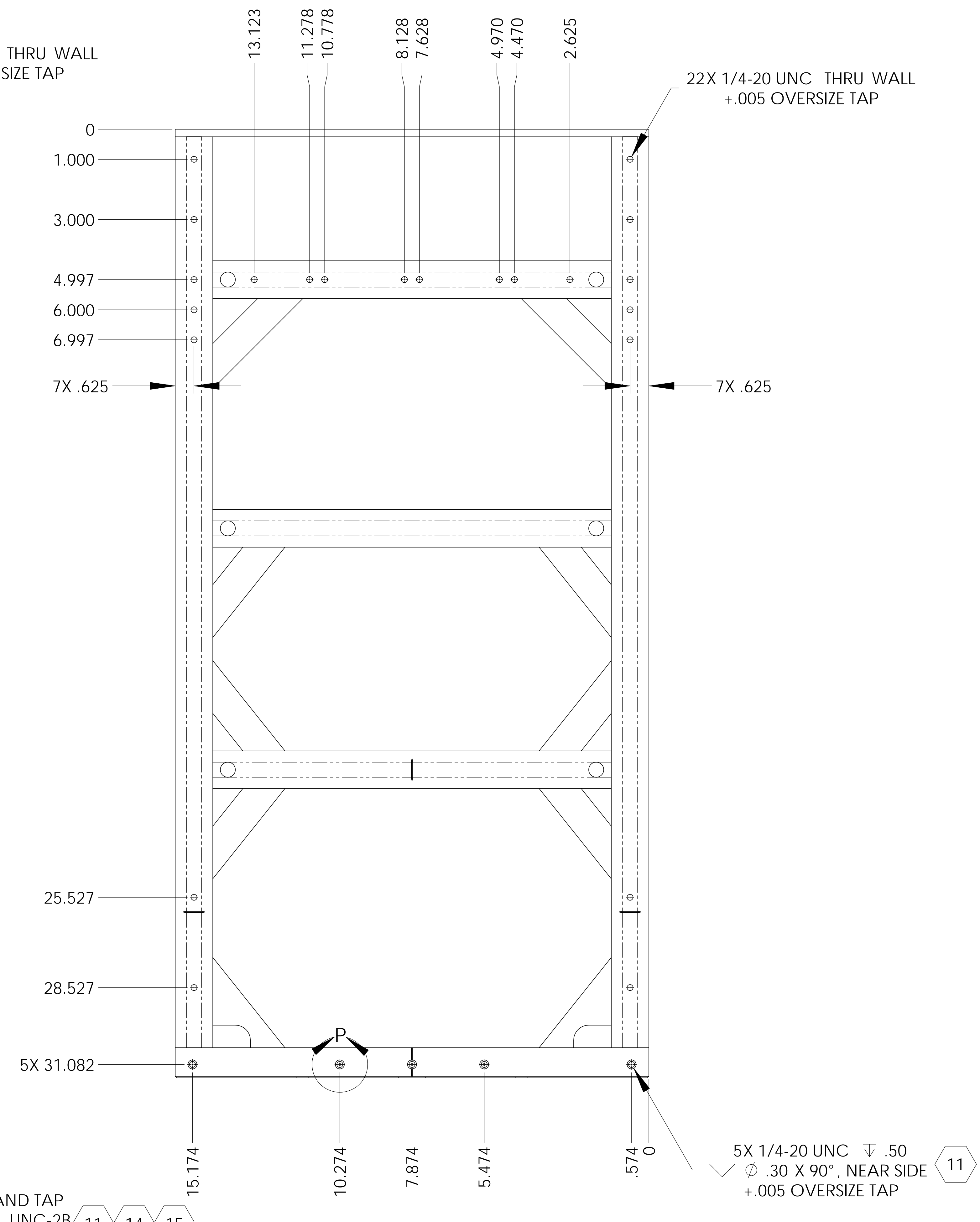
BOTTOM PLATE



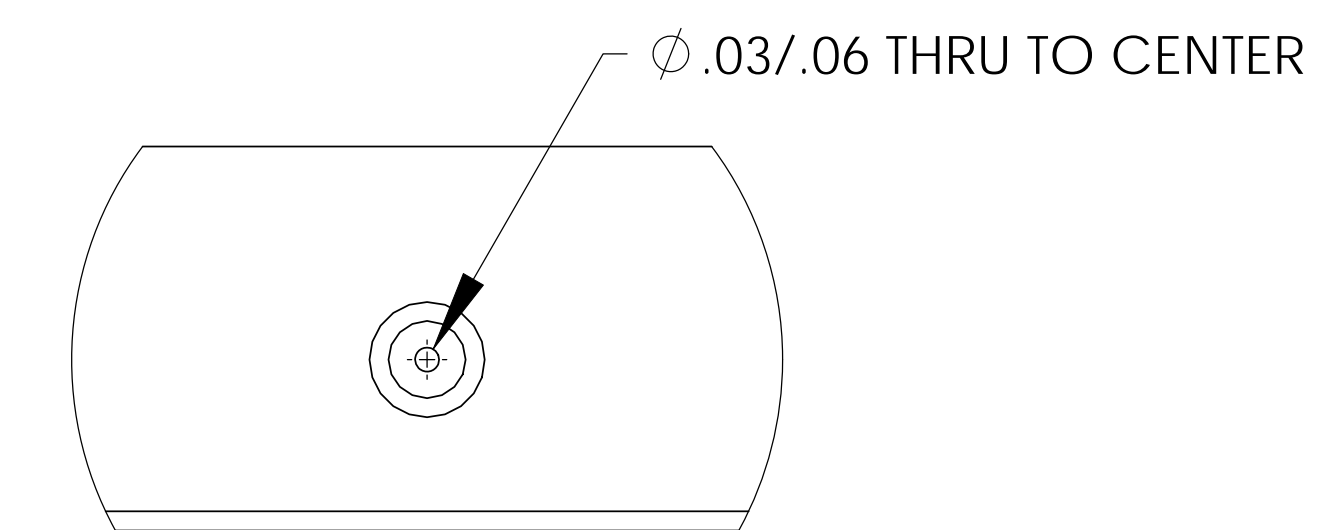
BACK SIDE



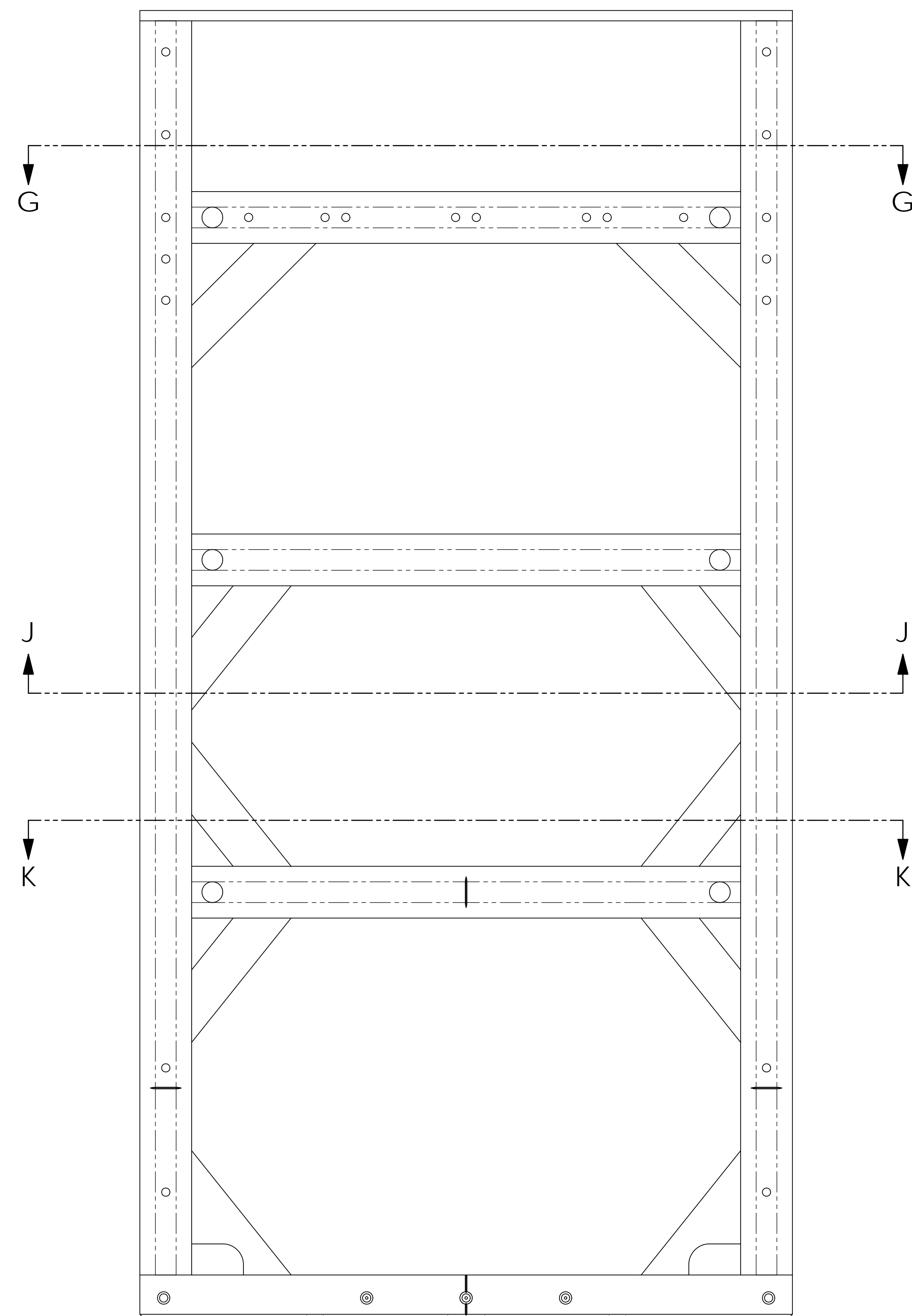
LEFT AND RIGHT SIDES



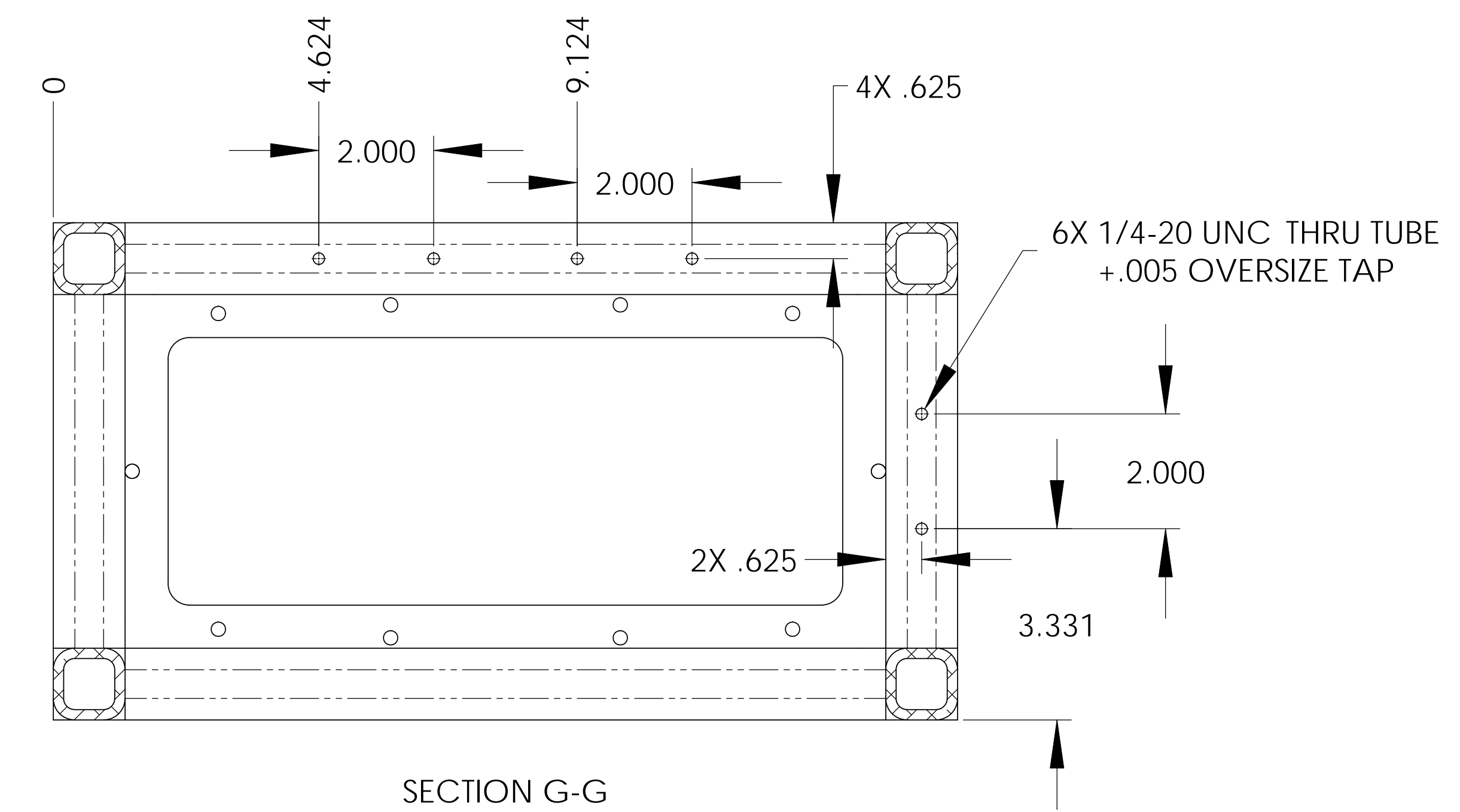
FRONT AND BACK SIDES



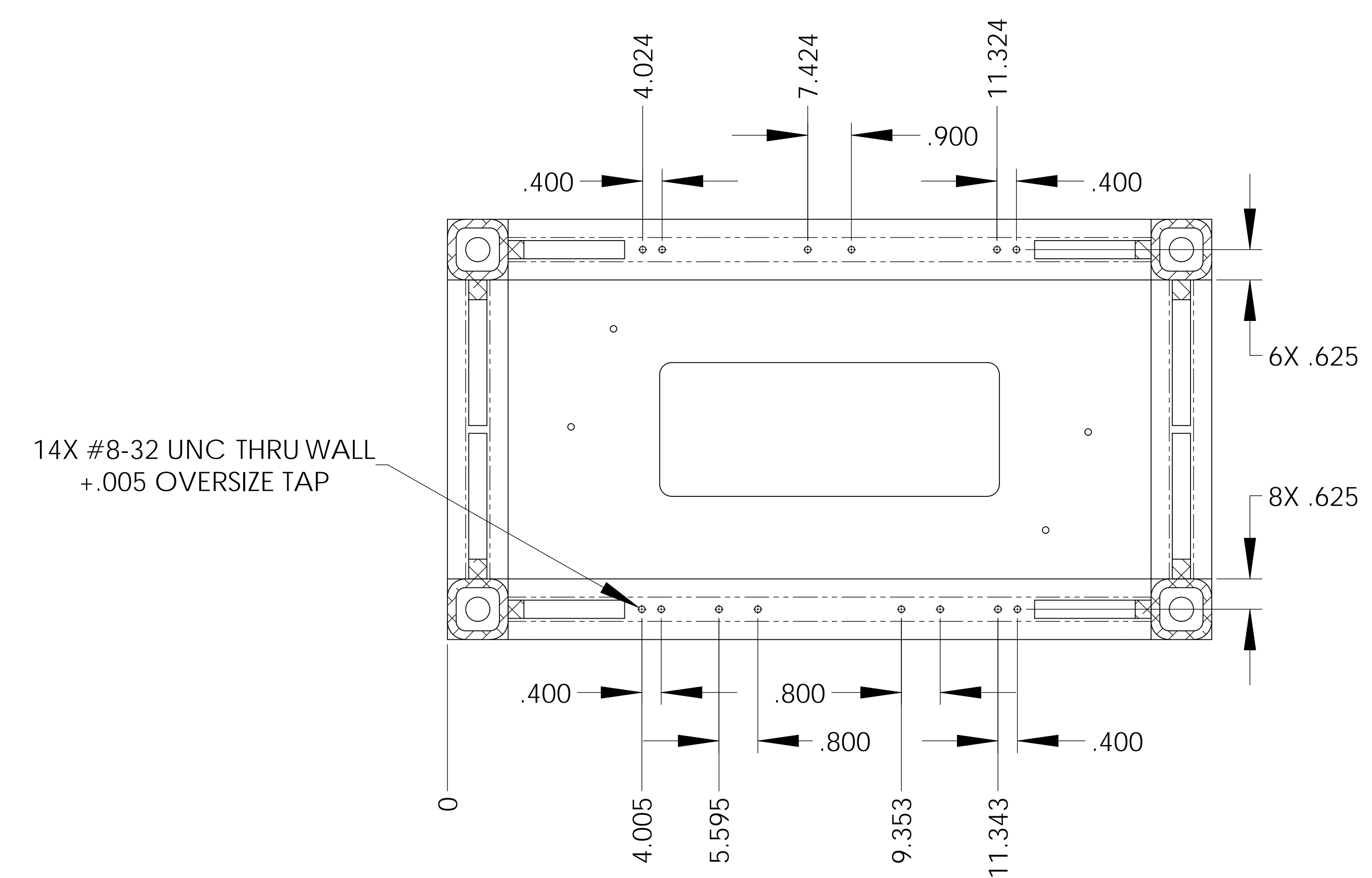
DETAIL P  
SCALE 2:1  
5 PLACES



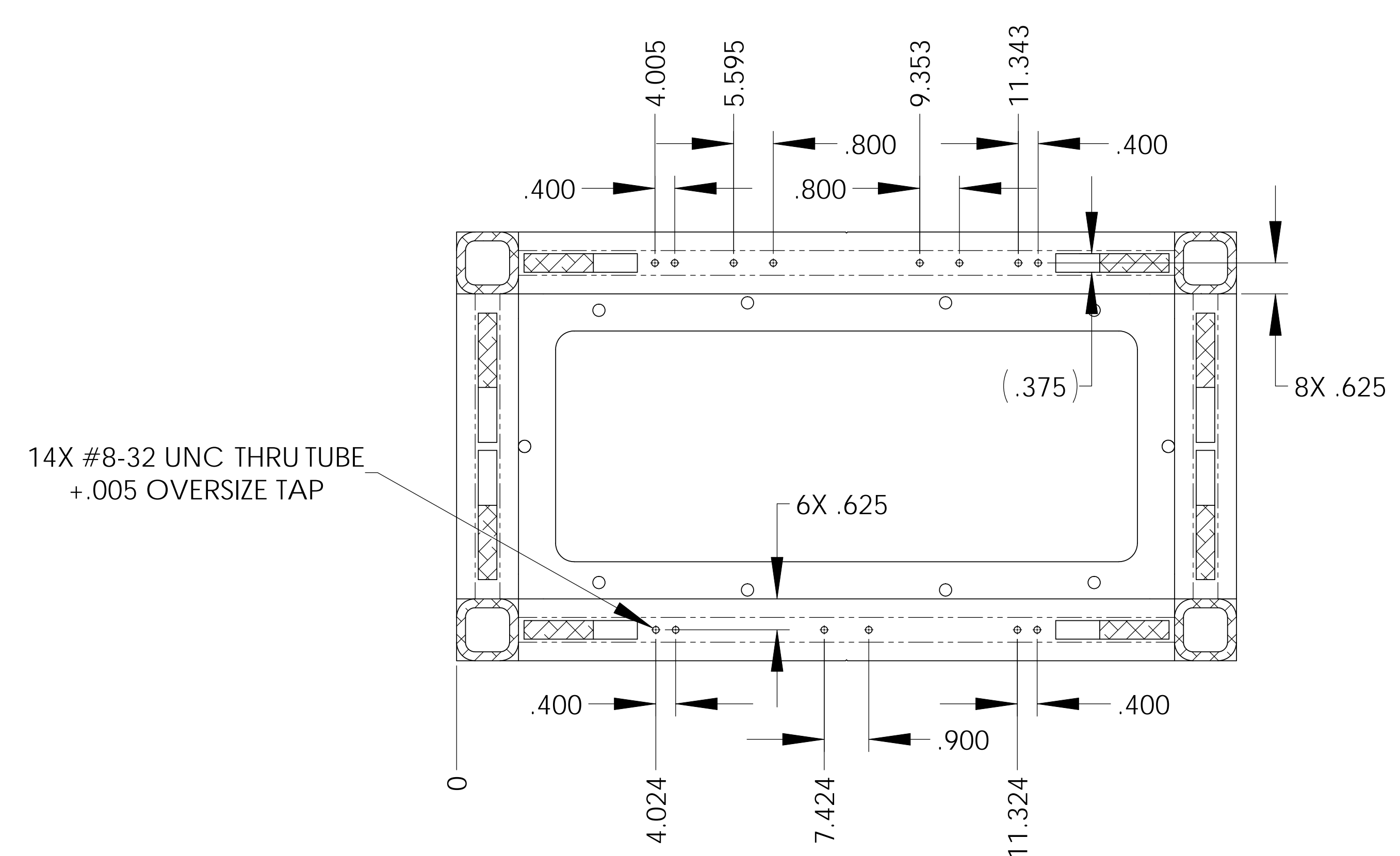
FRONT VIEW



SECTION G-G

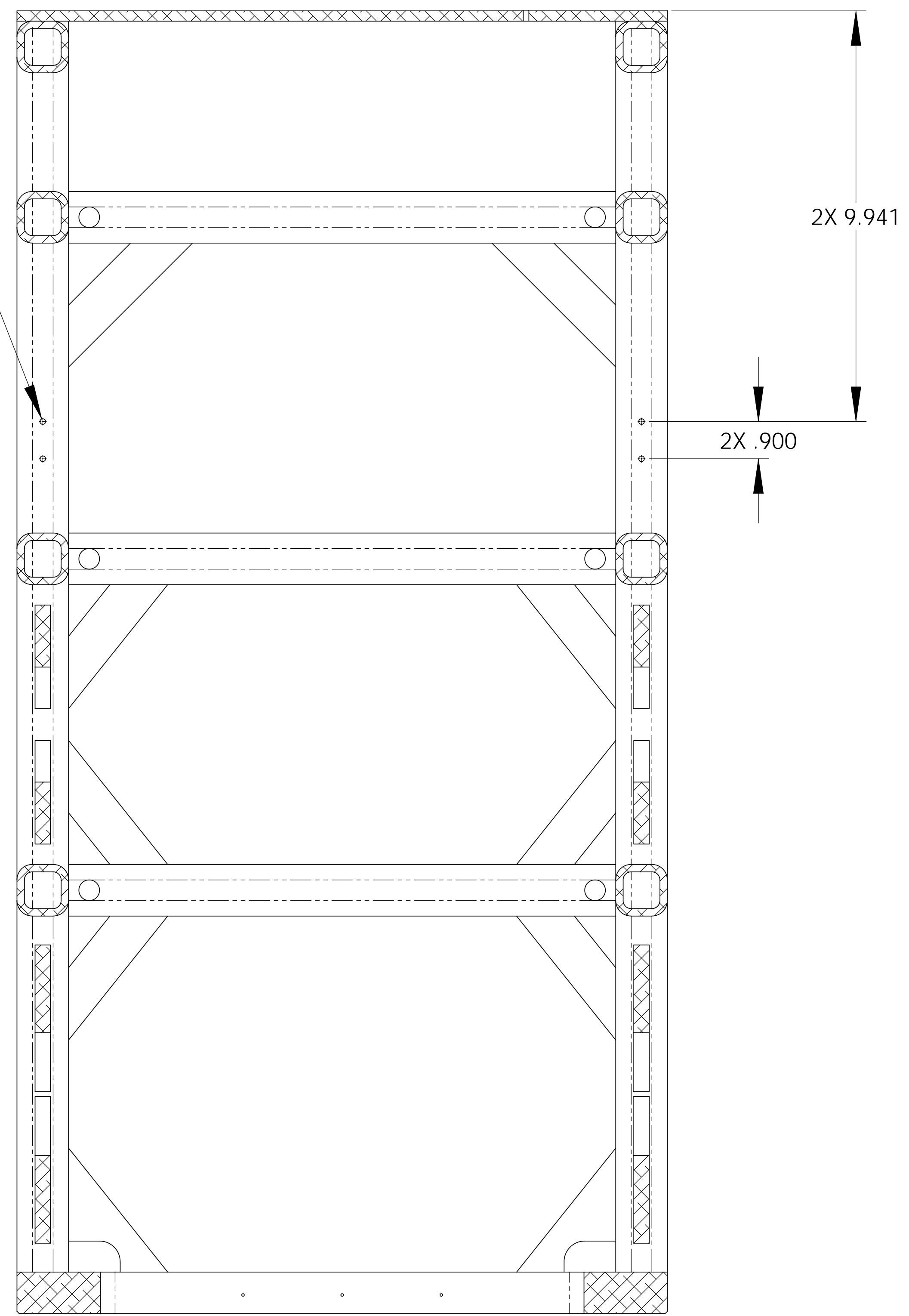


SECTION J-J

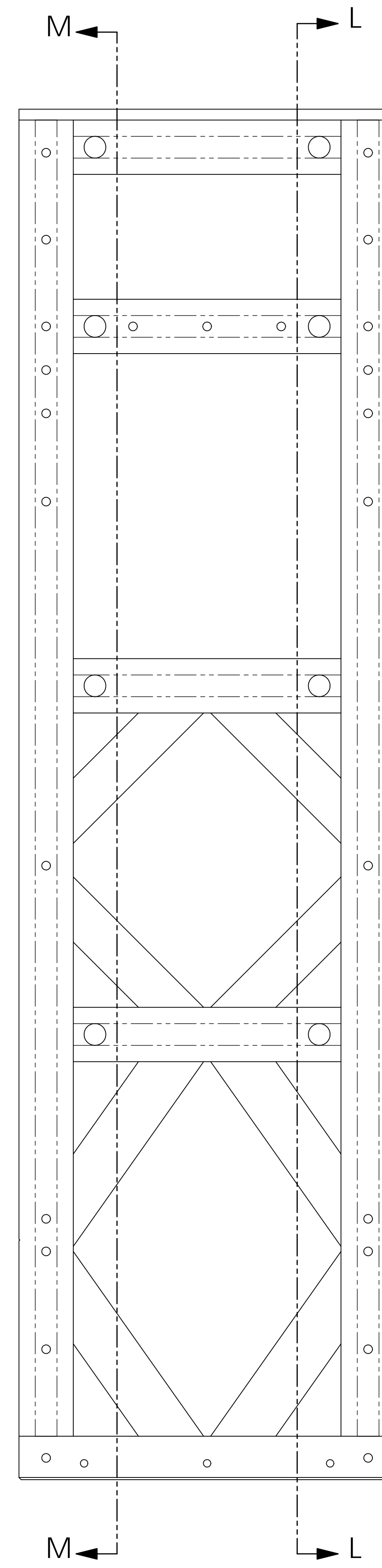


SECTION K-K

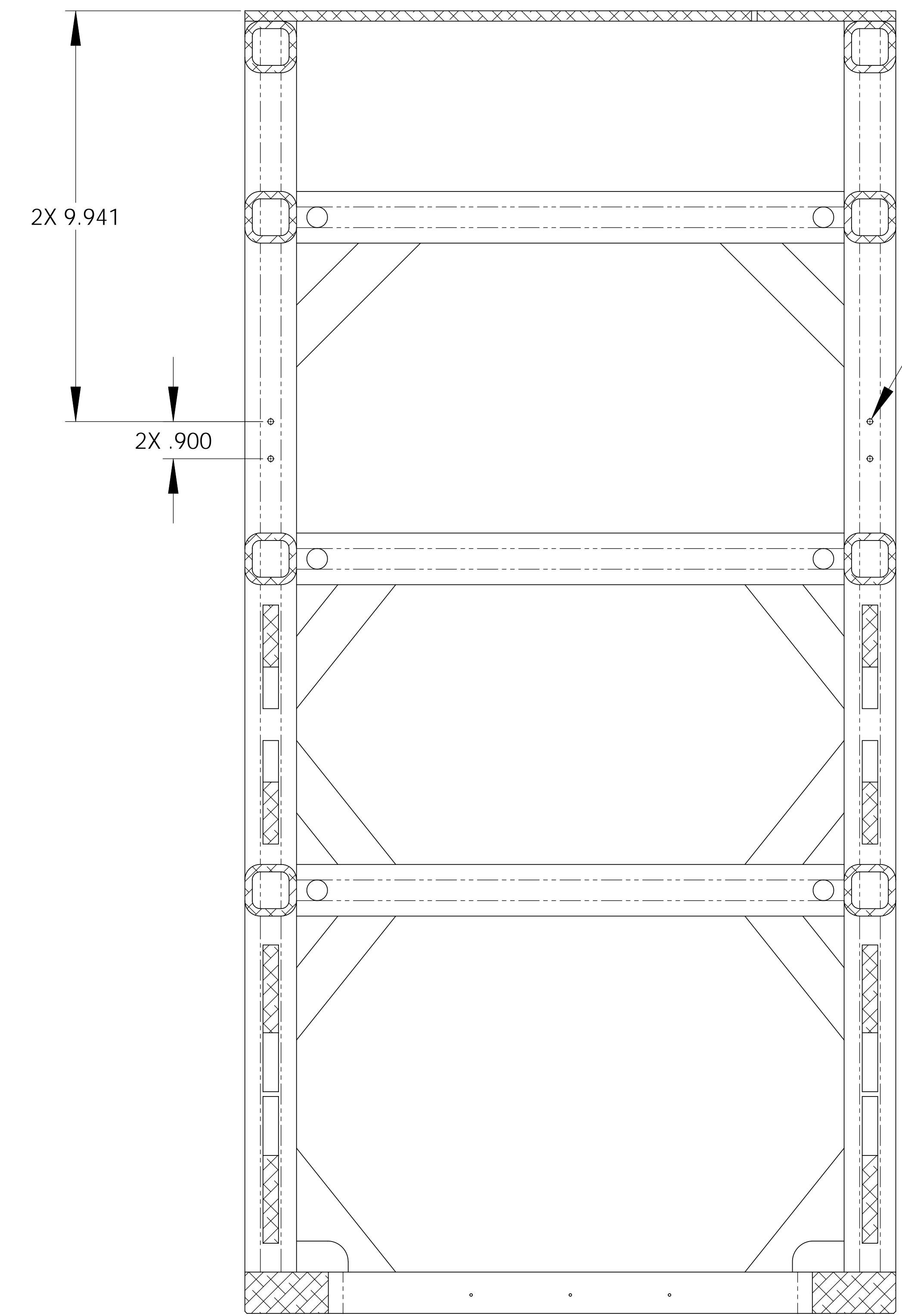




SECTION M-M



INTERIOR HOLES FRONT AND BACK



SECTION L-L