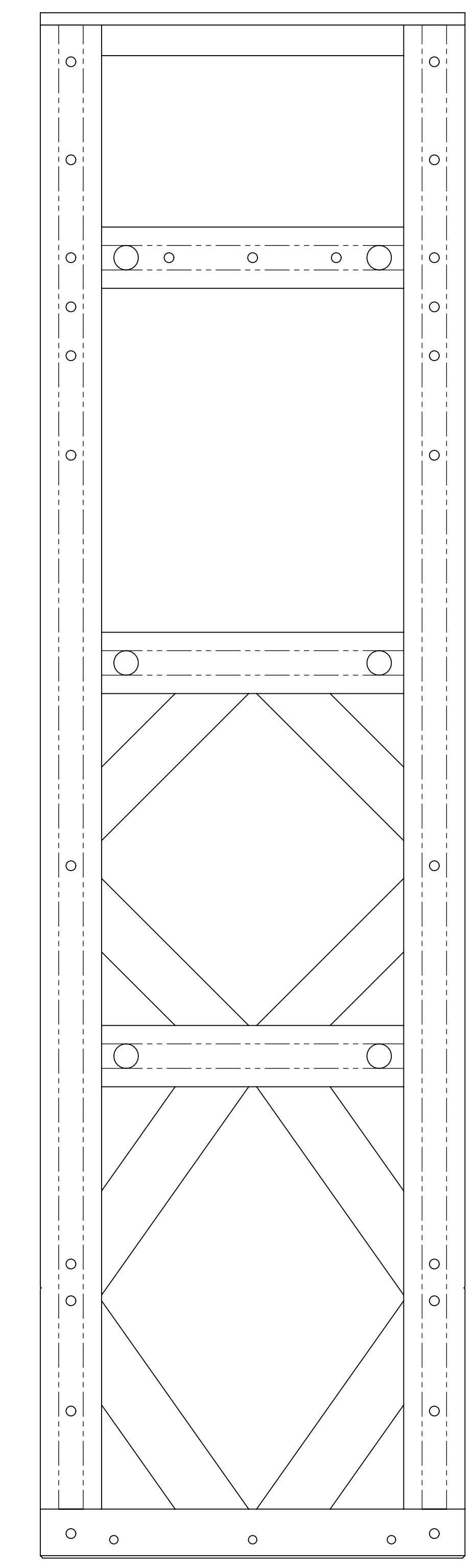
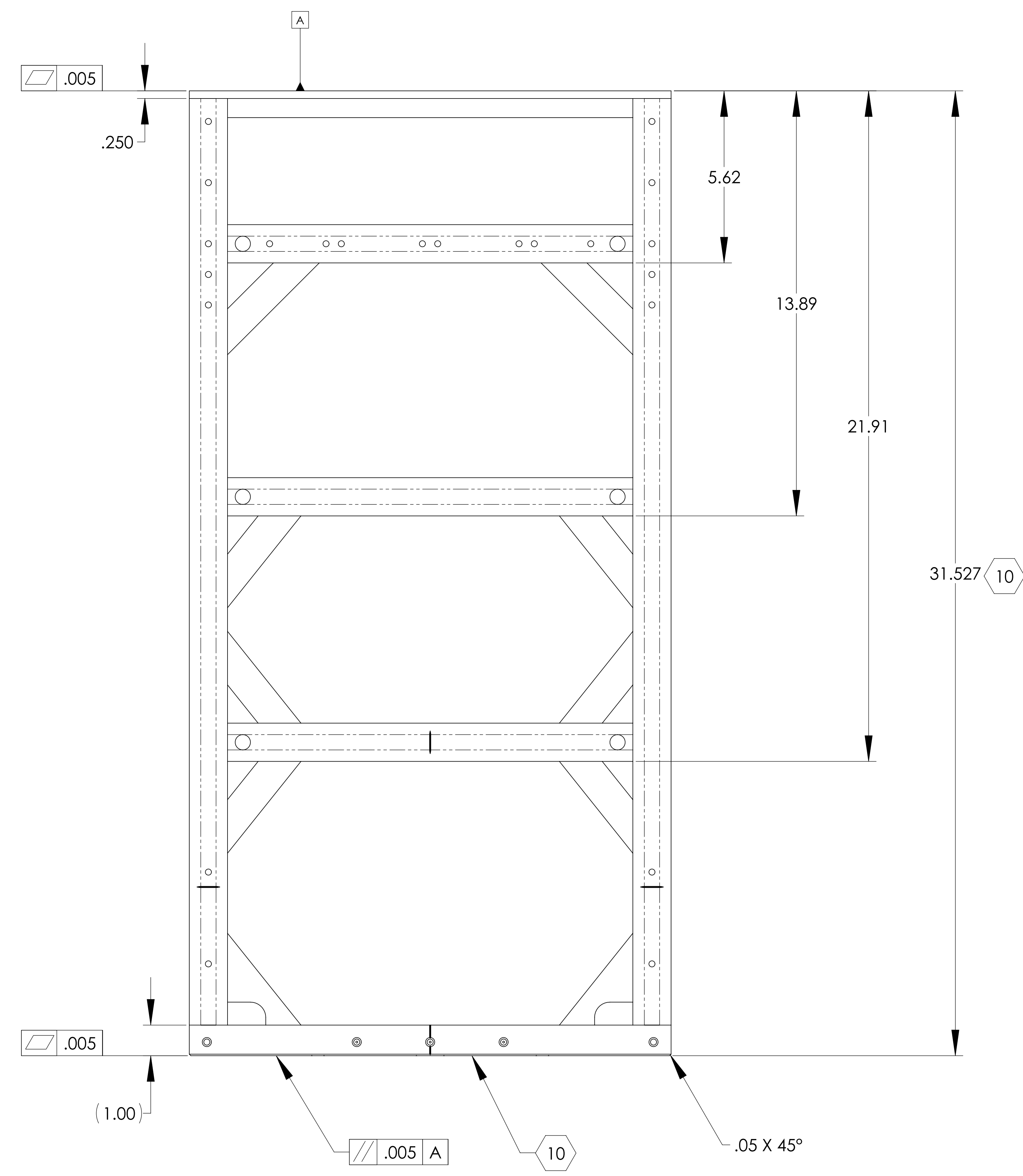
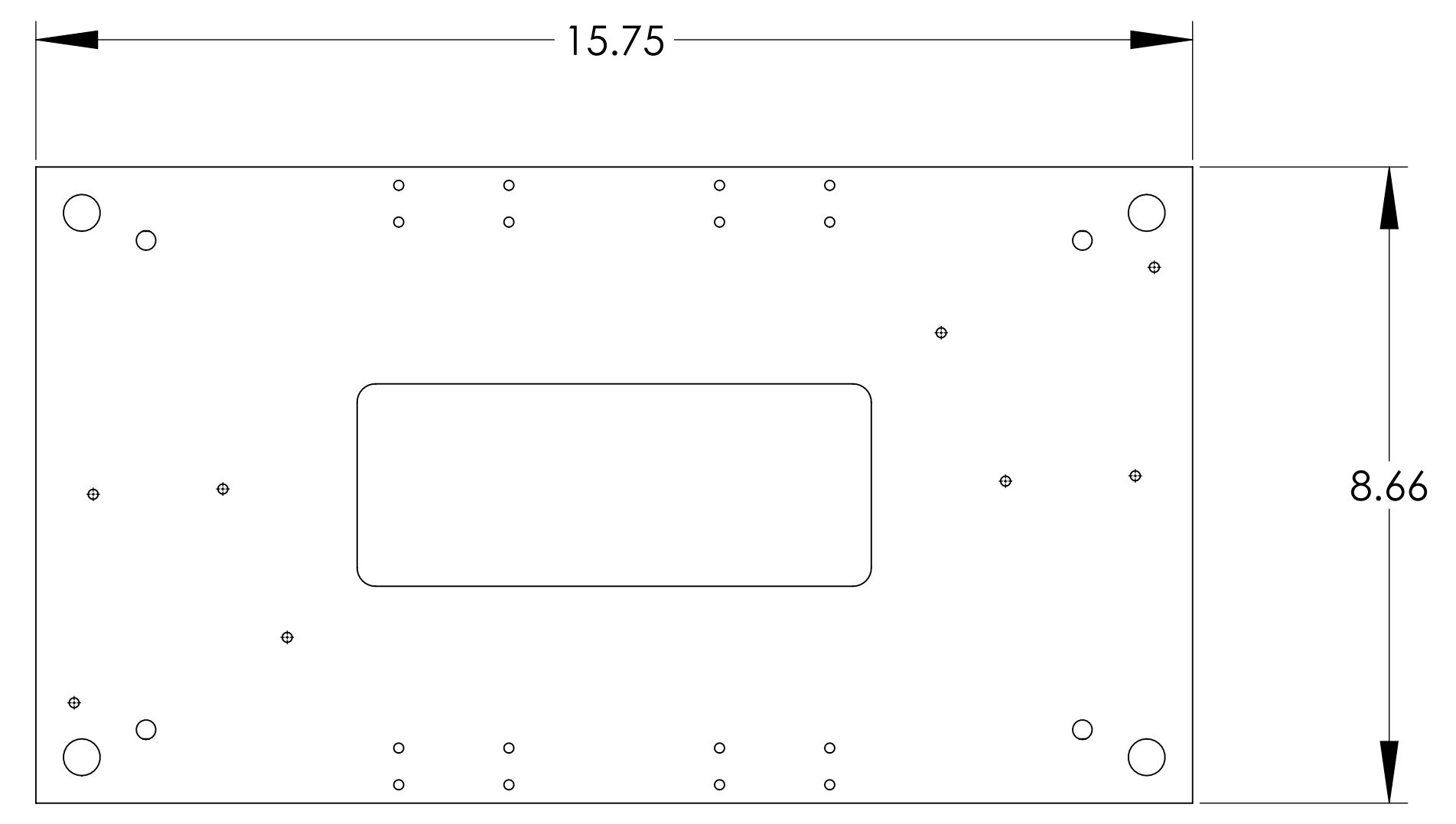
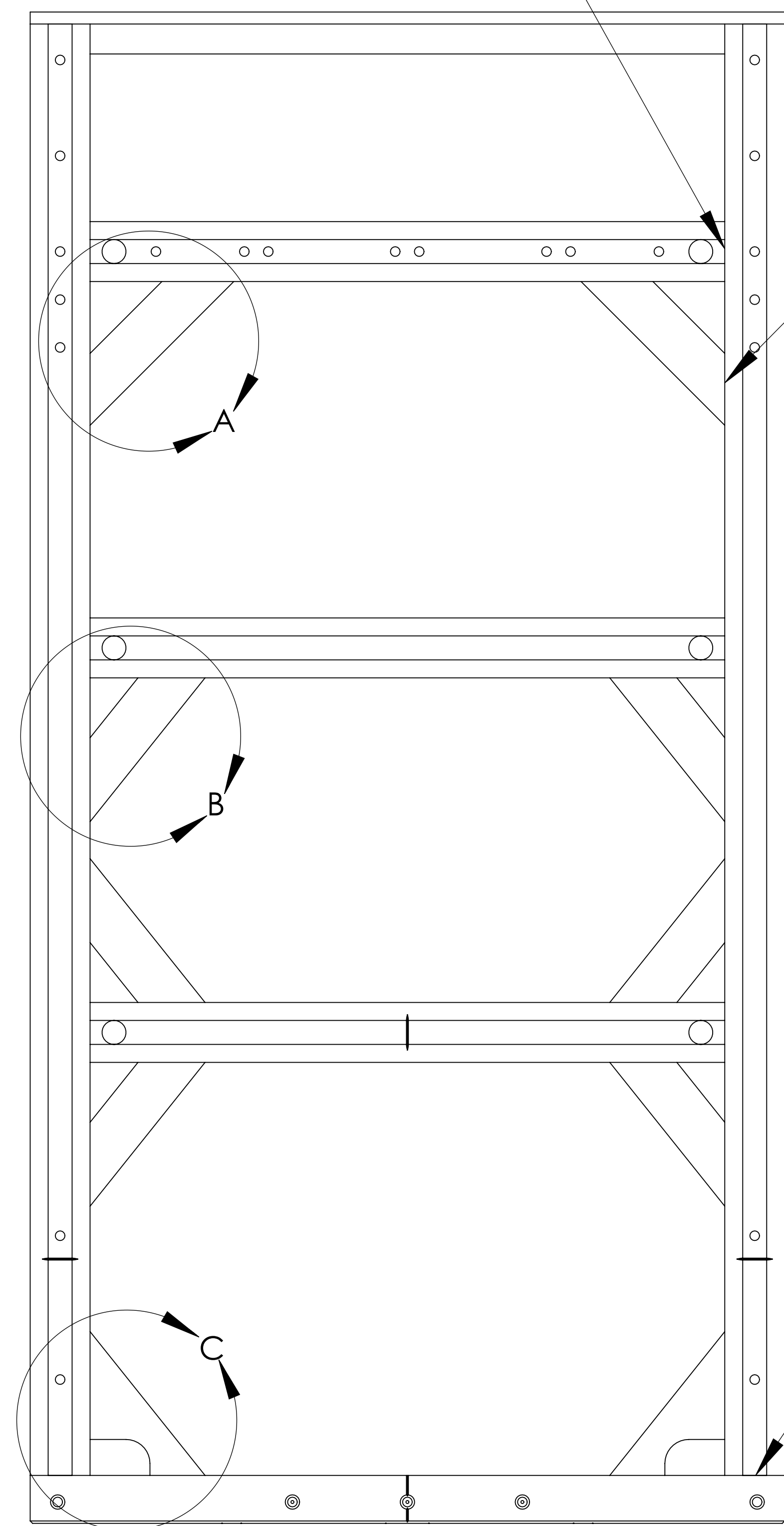


- NOTES CONTINUED:
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-V1, TYPE-XX, S/N XXX
  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, INCLUDING FLY-CUTTING, 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.

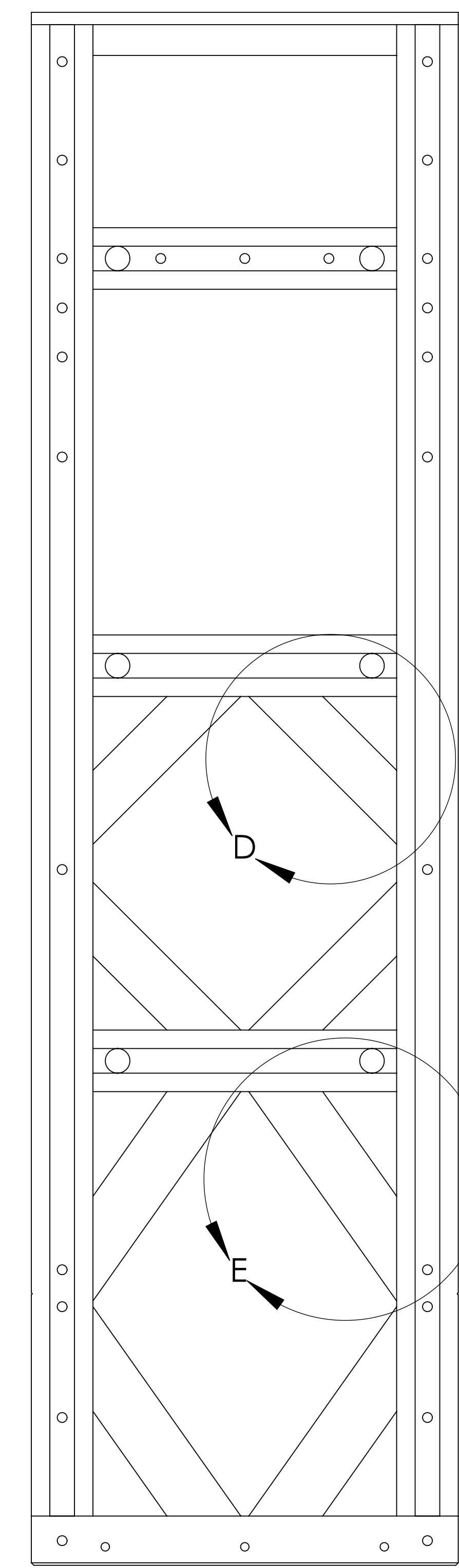
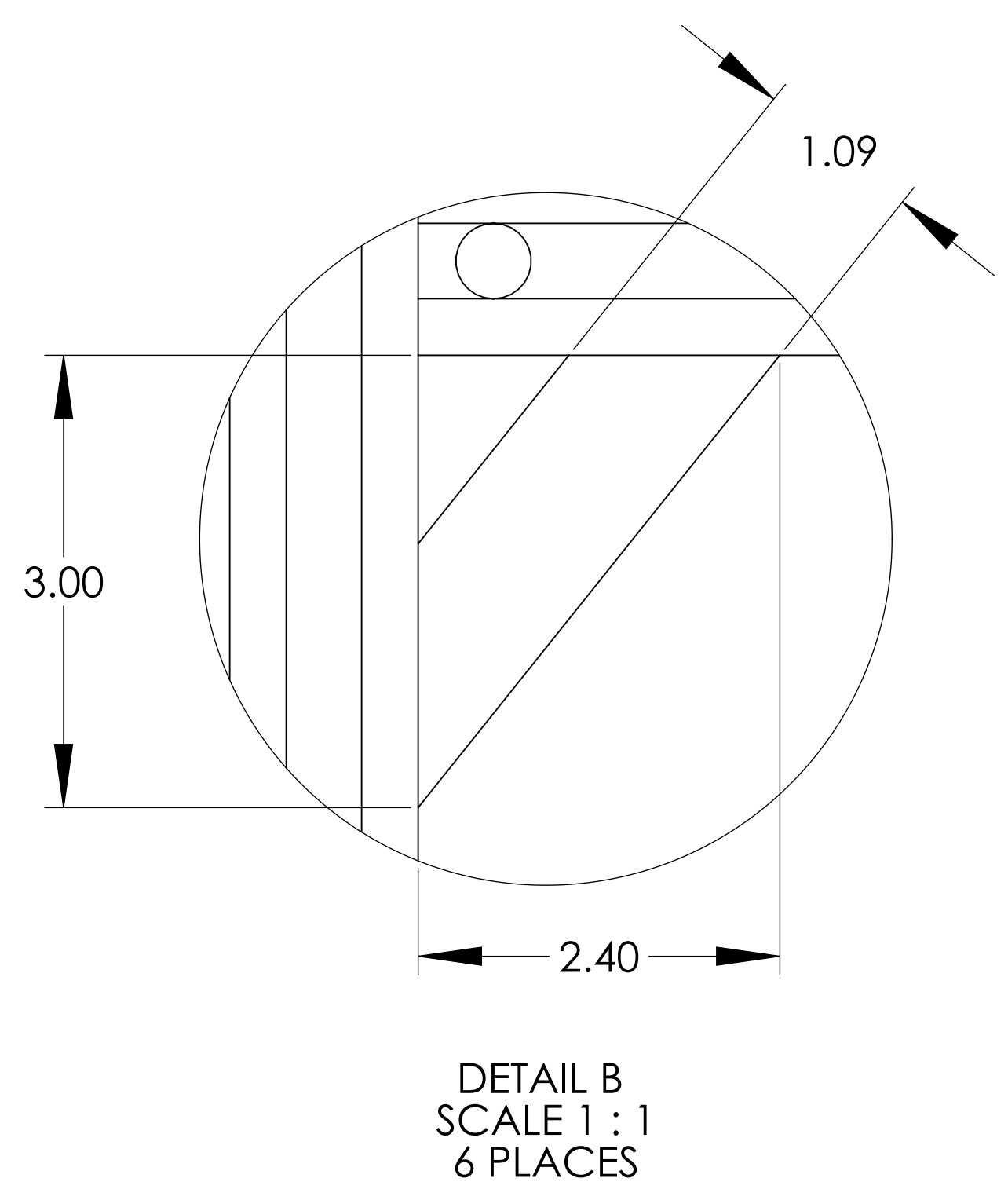
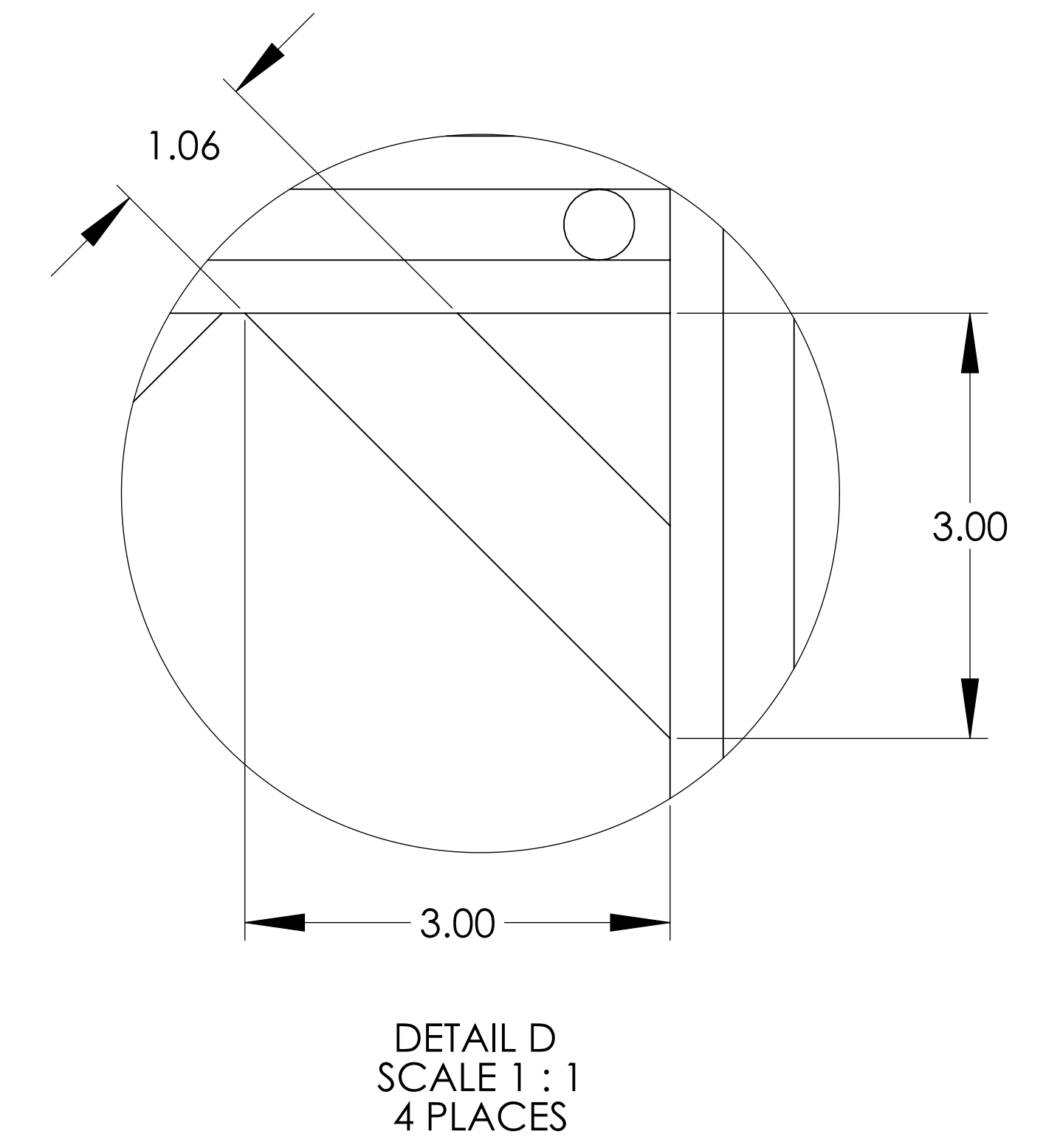
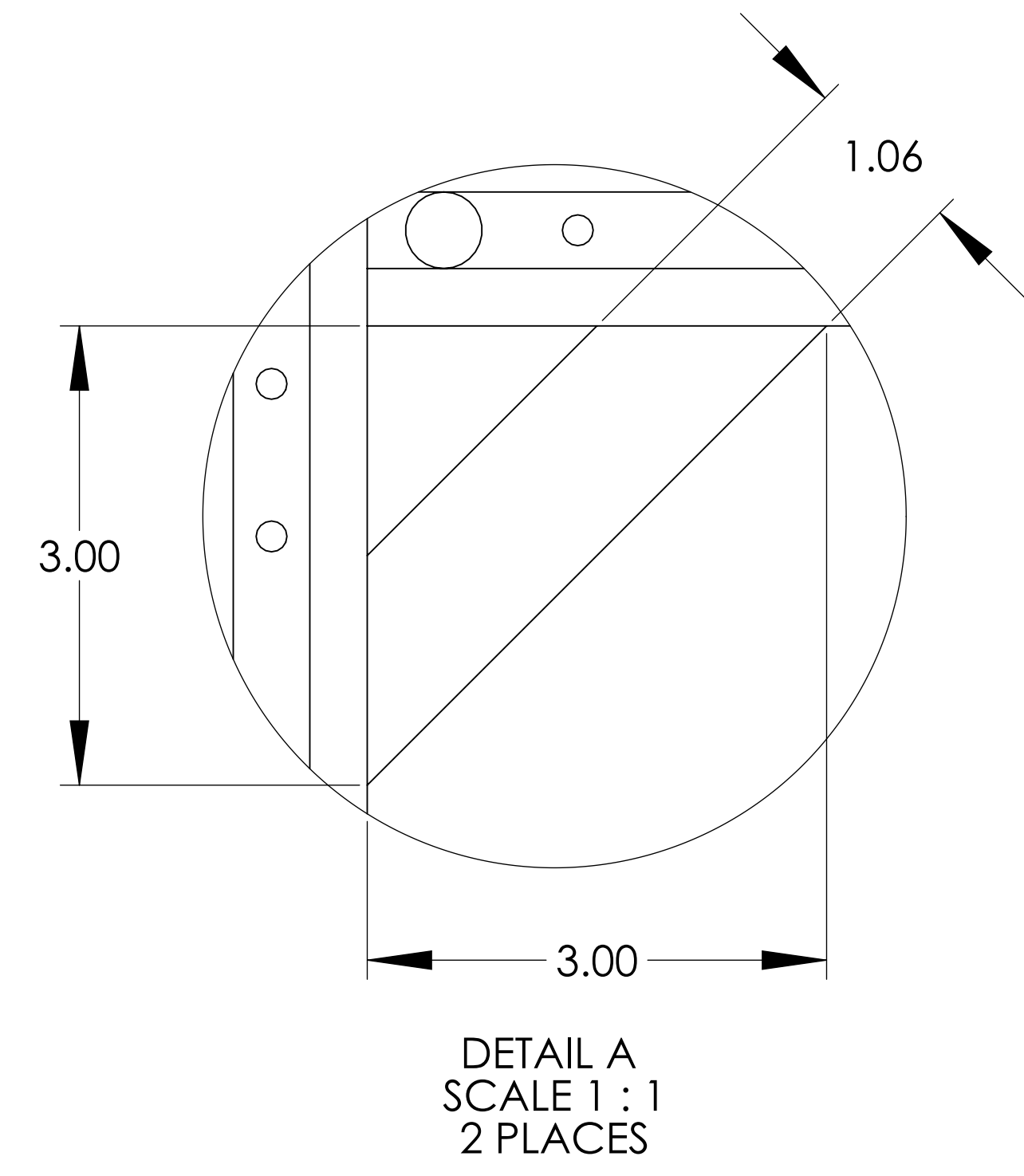
REV.	DATE	DCN #	DRAWING TREE #
A	24 JUN 2004	E040303-00	-
v1	-	INTERNAL REVISION	-
v2	30 APR 2010	E0900352	E0900353
v3	30 JUN 2010	E1000242	E0900353
v4	13 JUL 2010	E1000253	E0900353



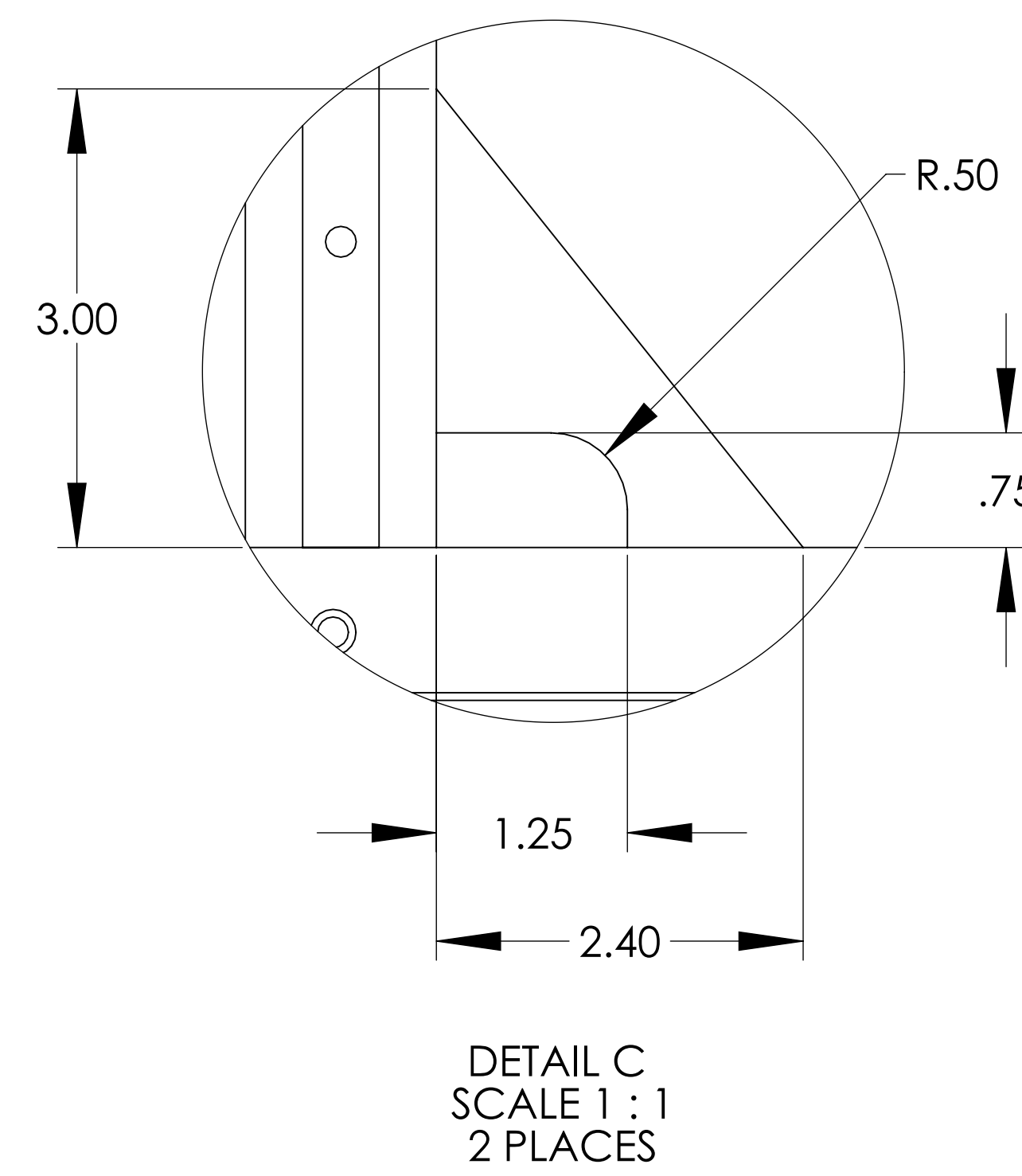
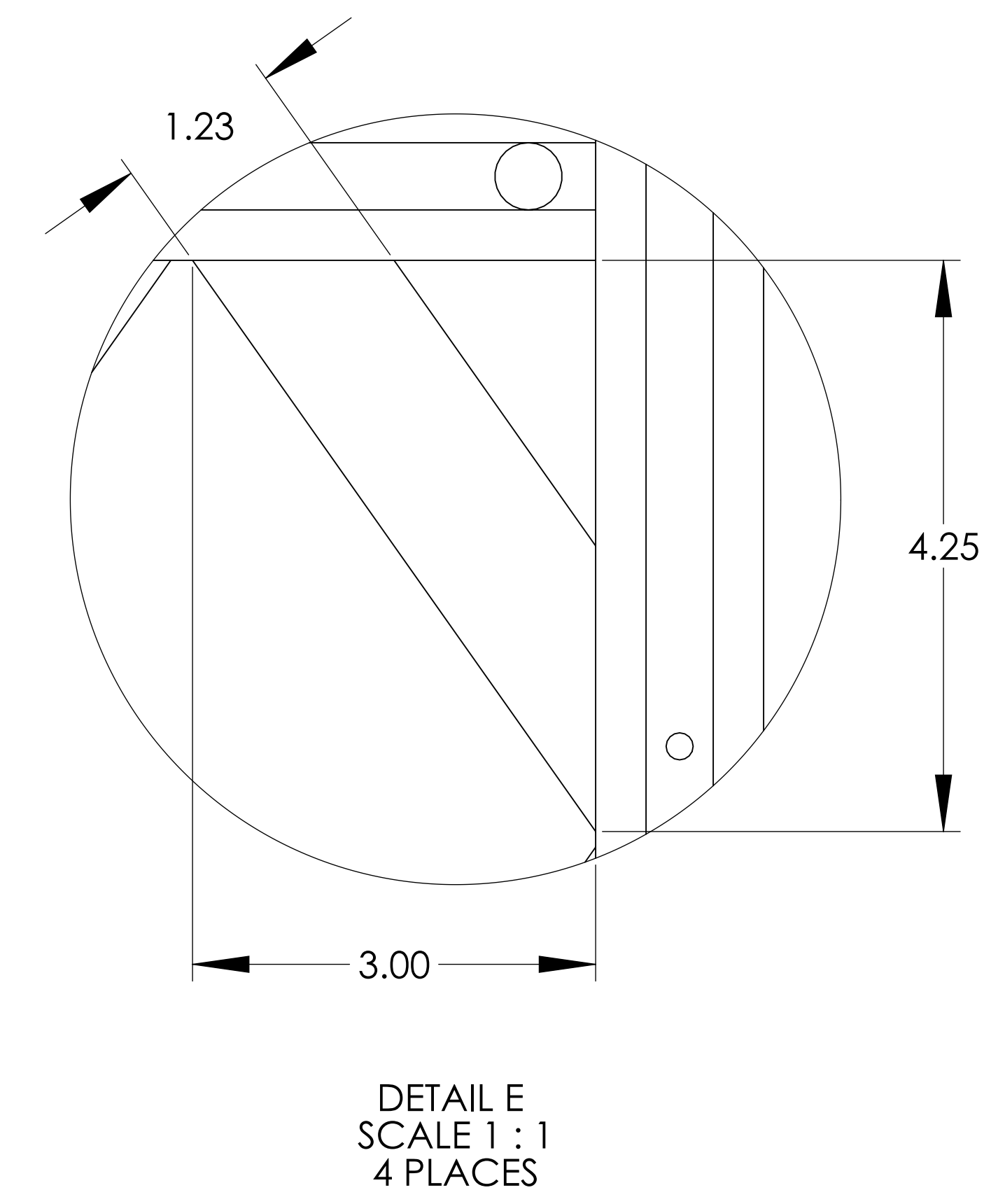
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .005 ANGULAR ± 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <b>STRUCTURAL WELDMENT ASSEMBLY, HSTS</b>	
MATERIAL 304 OR 304L SSSL 8 9		FINISH 32 μinch		NEXT ASSY D020700		SYSTEM ADVANCED LIGO	
SUB-SYSTEM SUS		DESIGNER M. MEYER		DATE 10 JUN 2009		SIZE DWG. NO. E D020023	
CHECKER M. MEYER		DATE 01 APR 2010		APPROVAL		SCALE: 1:2 PROJECTION:	
						SHEET 1 OF 9	



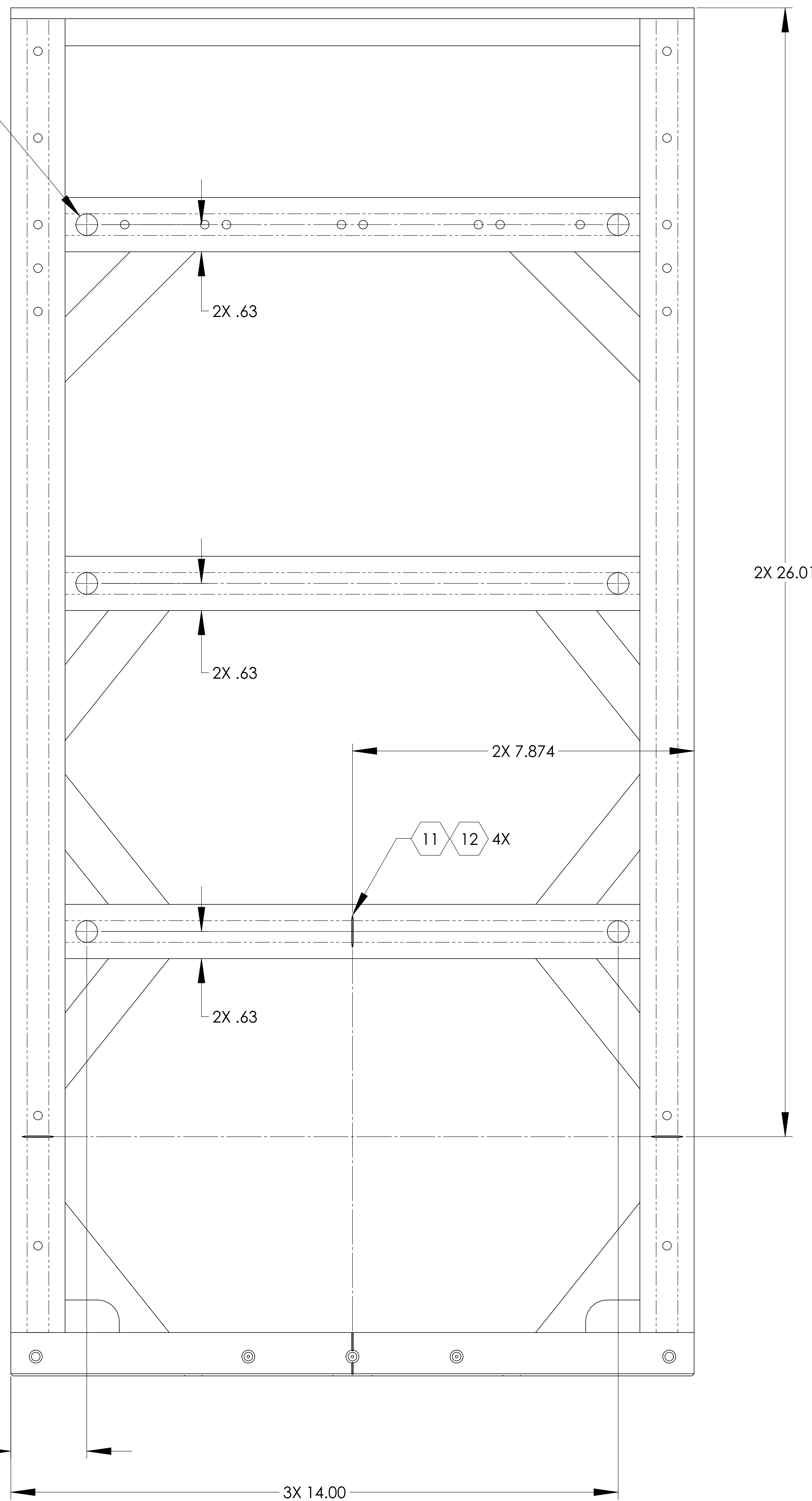
9 FRONT AND BACK SIDES



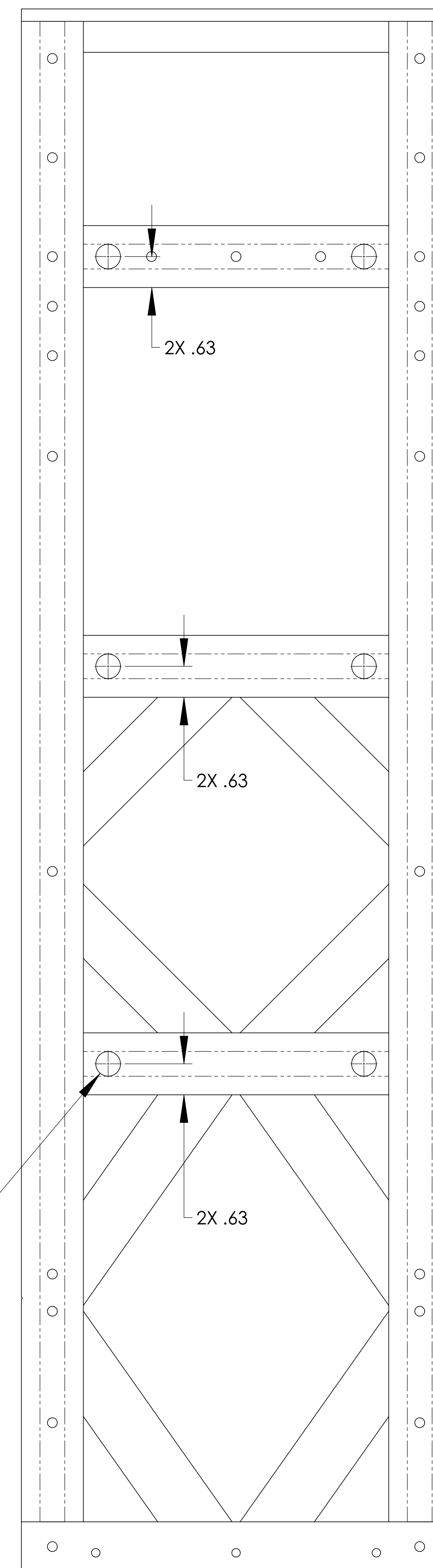
9 LEFT AND RIGHT SIDES



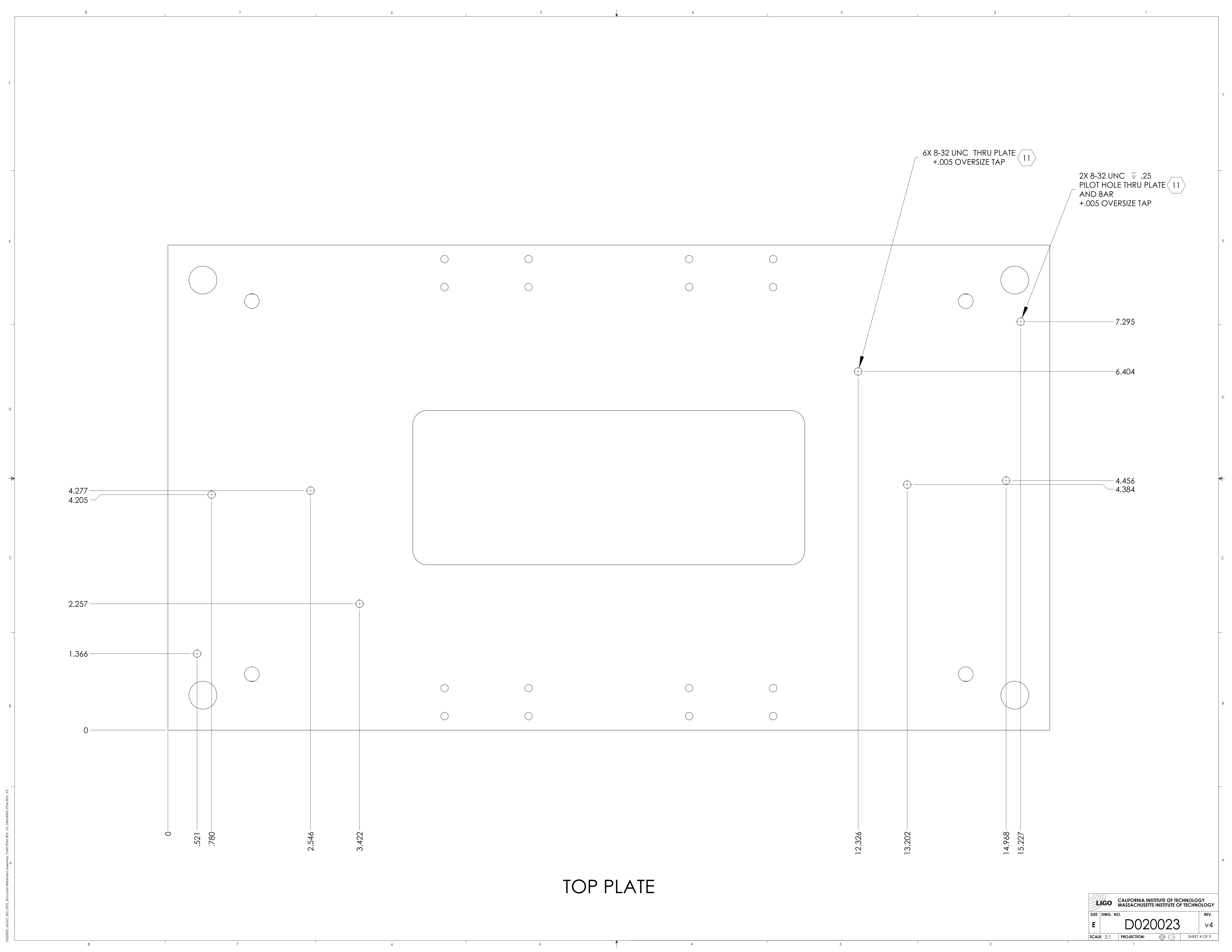
6X  $\varnothing$ .50 THRU TUBE



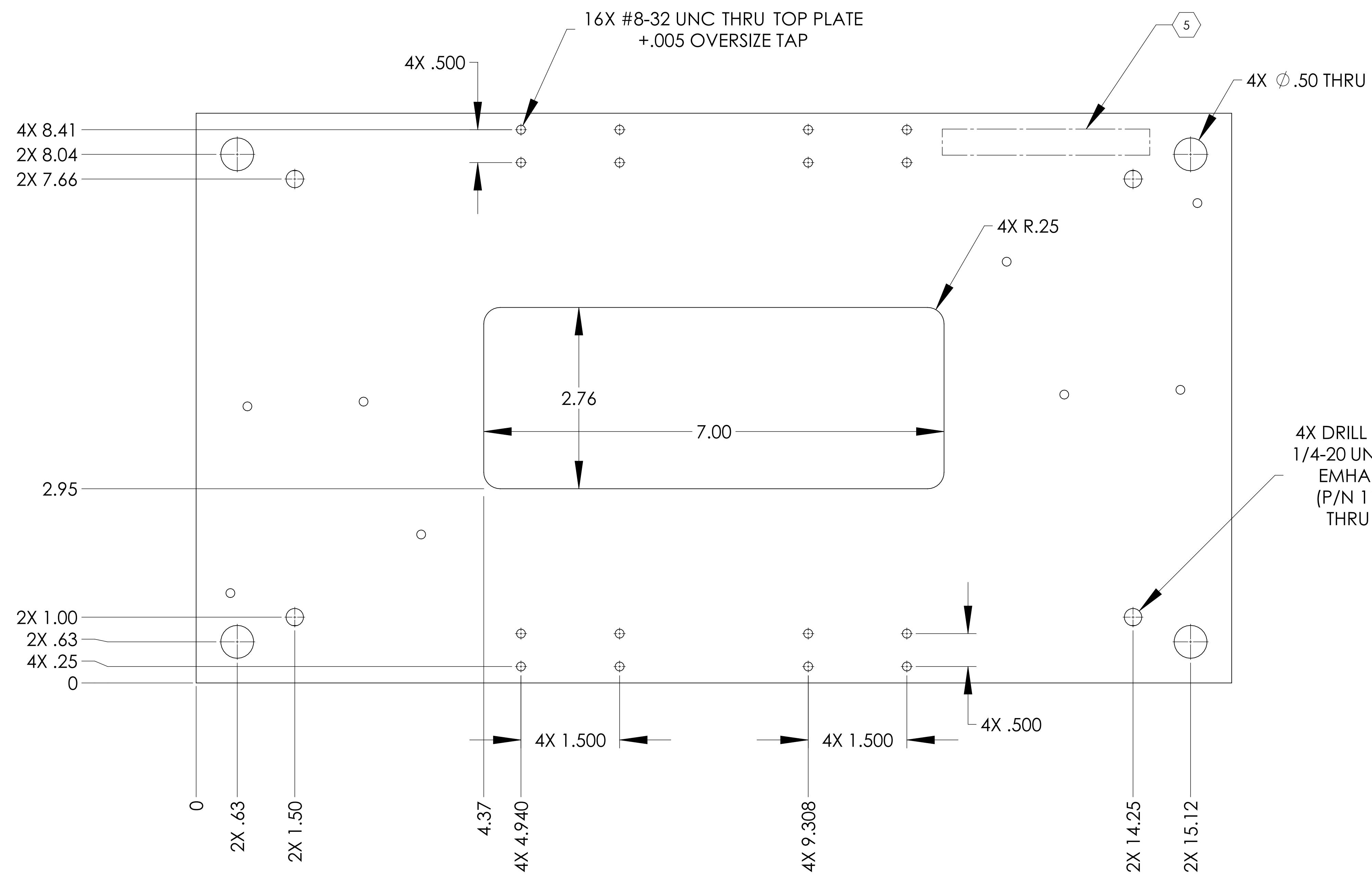
FRONT AND BACK SIDES



LEFT AND RIGHT SIDES



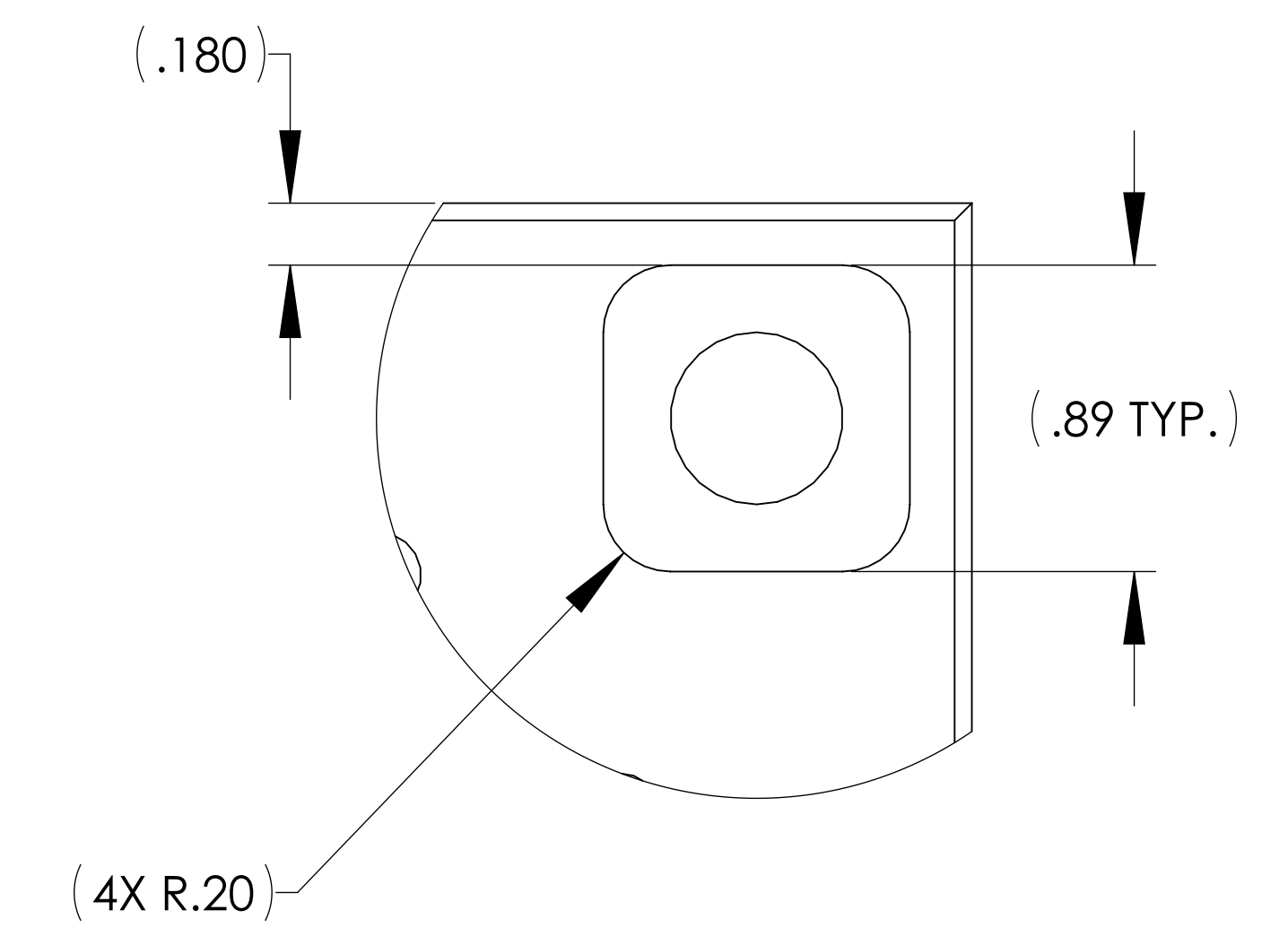
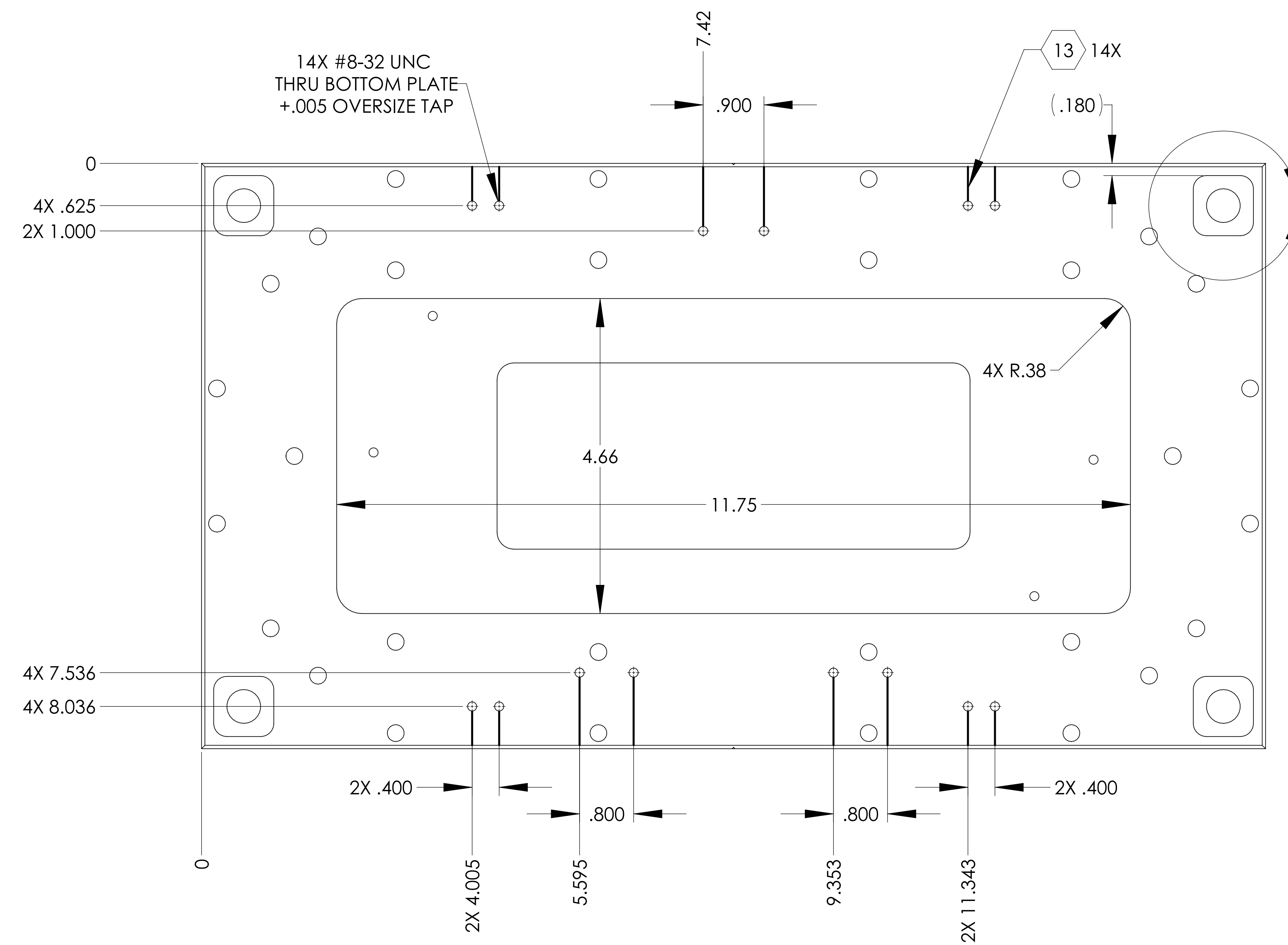
TOP PLATE



4X DRILL AND TAP FOR  
1/4-20 UNC-2B X 1.0 DIA  
EMHART HELICOIL  
(P/N 1185-4EN250)  
THRU TOP PLATE

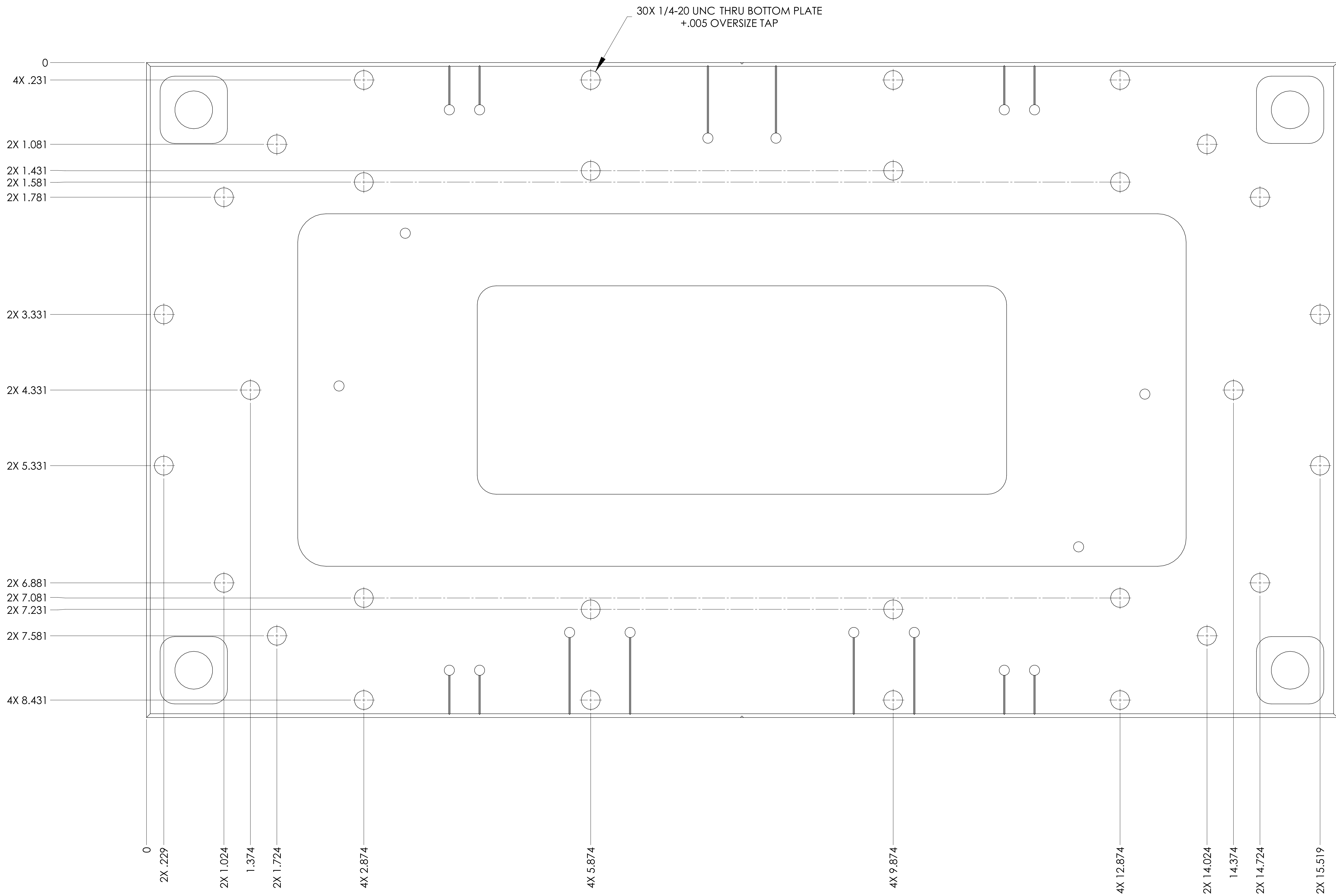
14 15

TOP PLATE

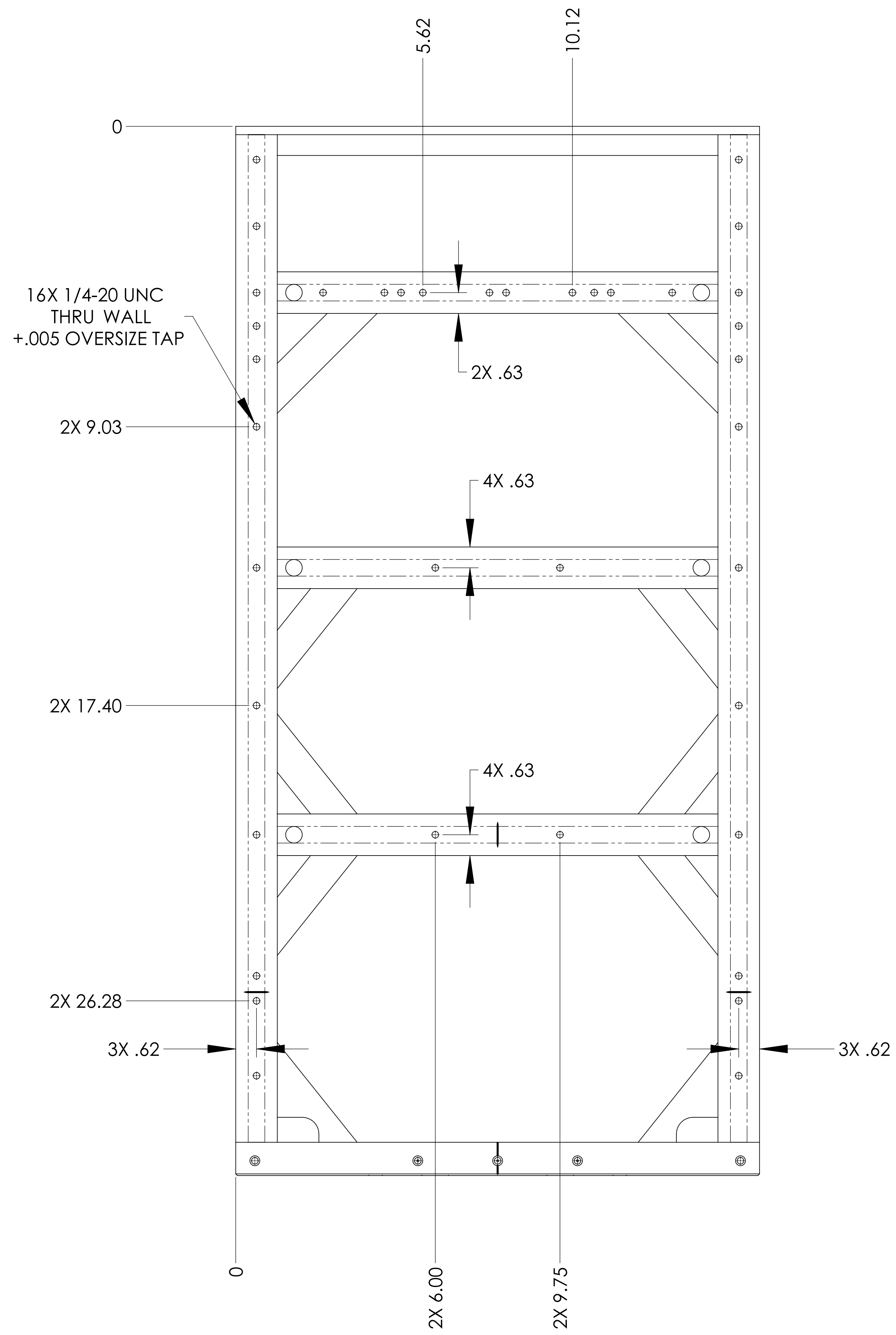


DETAIL F  
THRU BOTTOM PLATE  
SCALE 2:1  
4 PLACES  
MACHINE CUT-OUT TO MATCH  
INNER PROFILE OF LEG TUBING

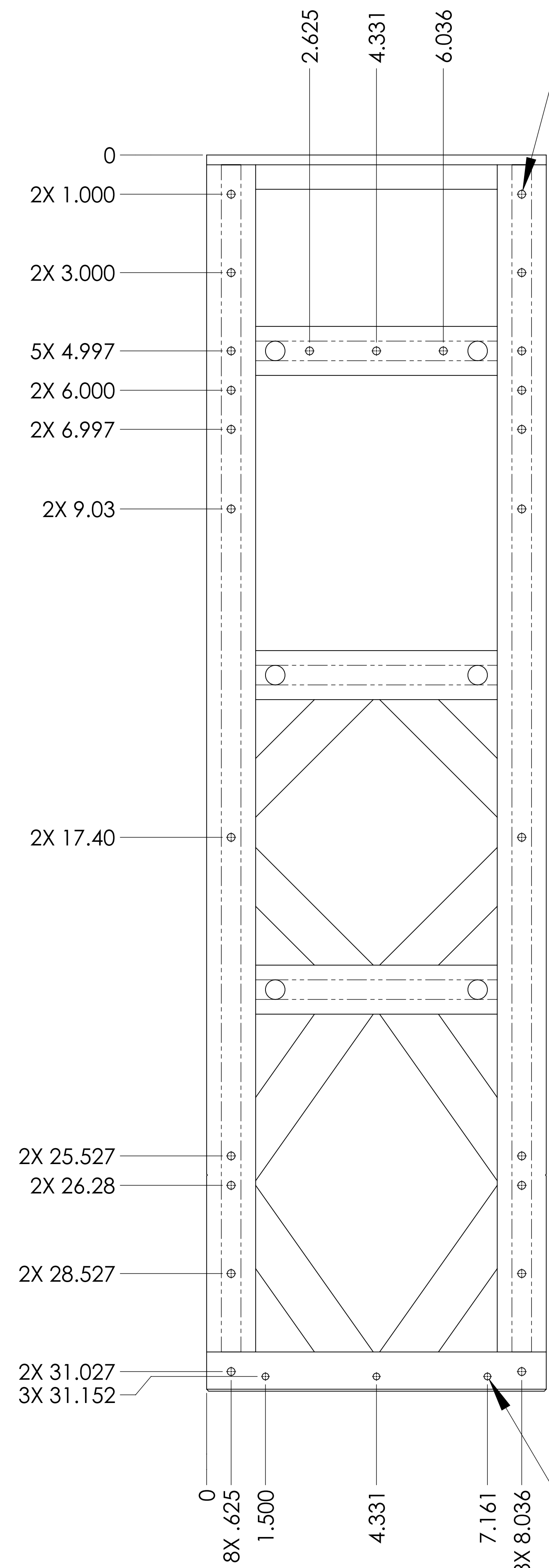
BOTTOM PLATE



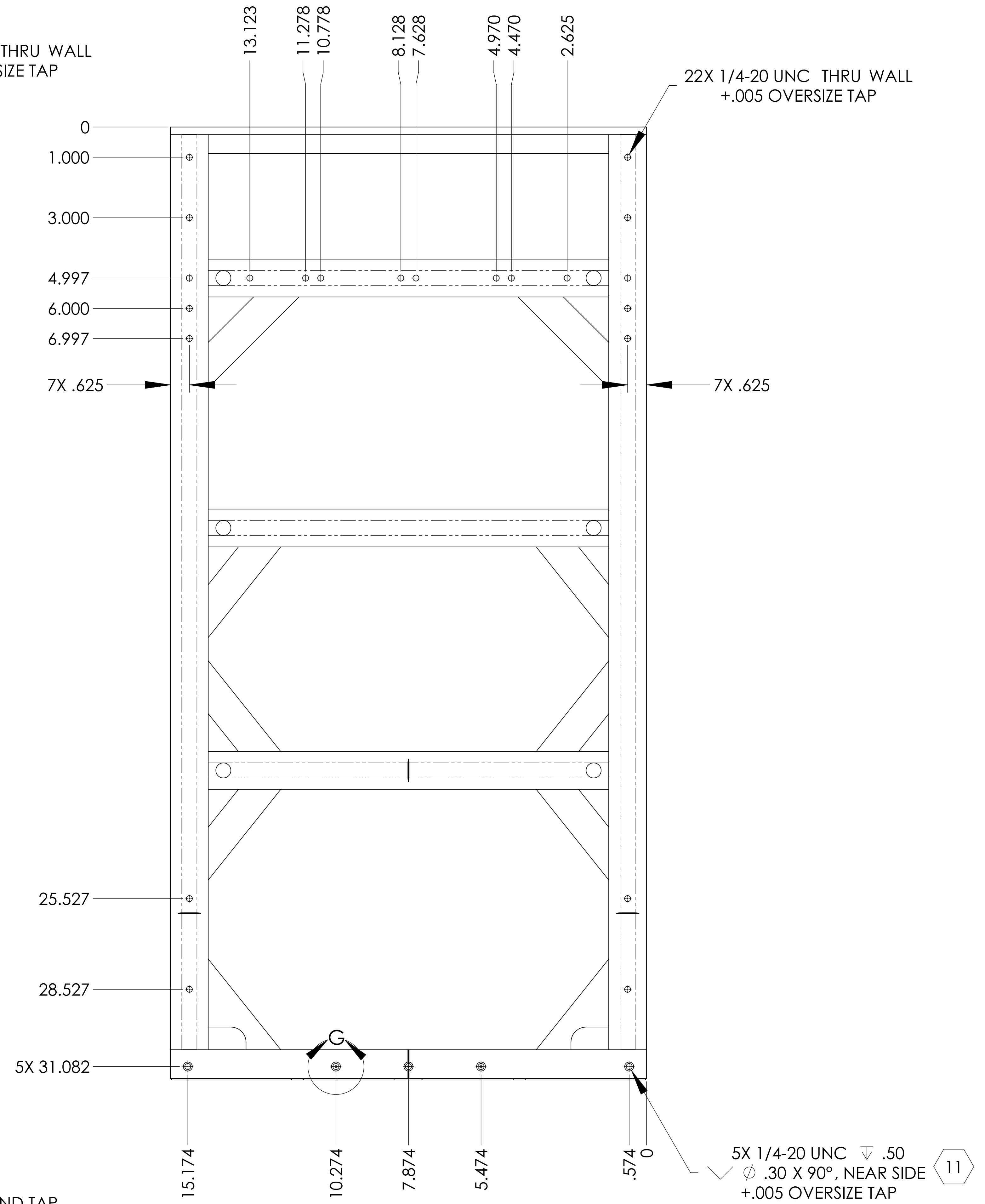
BOTTOM PLATE



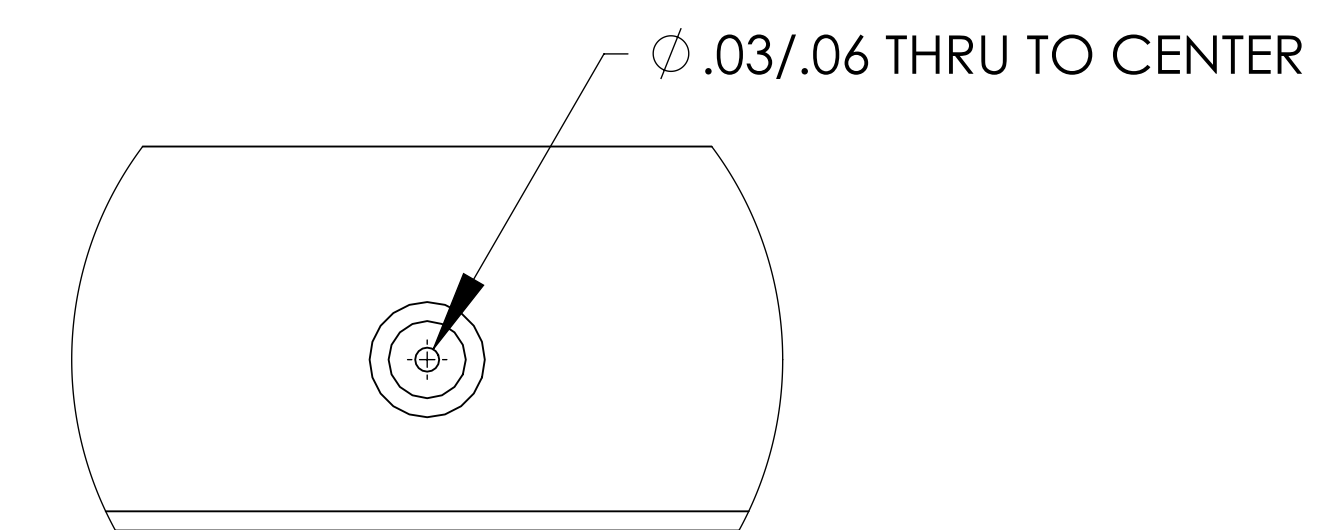
BACK SIDE



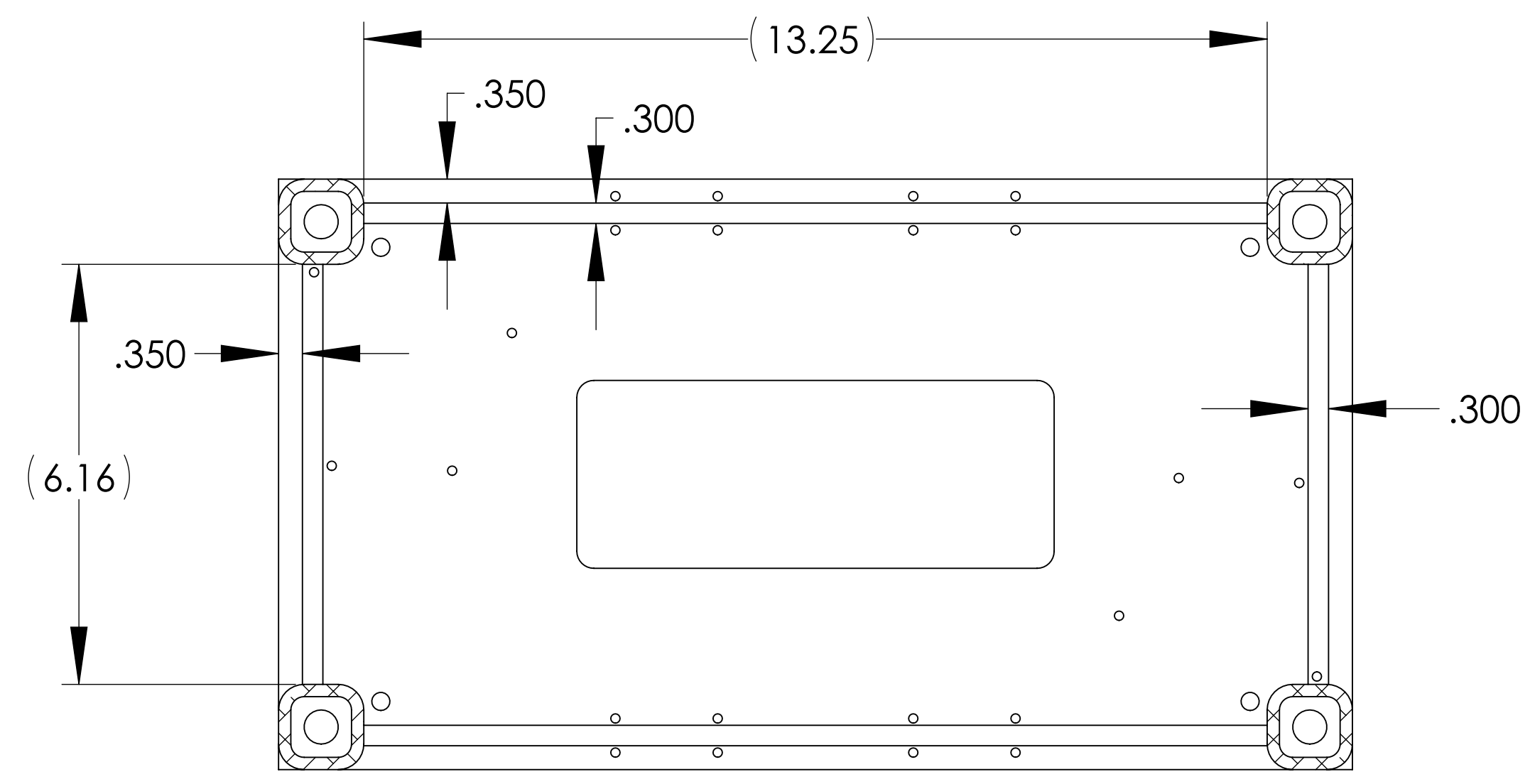
LEFT AND RIGHT SIDES



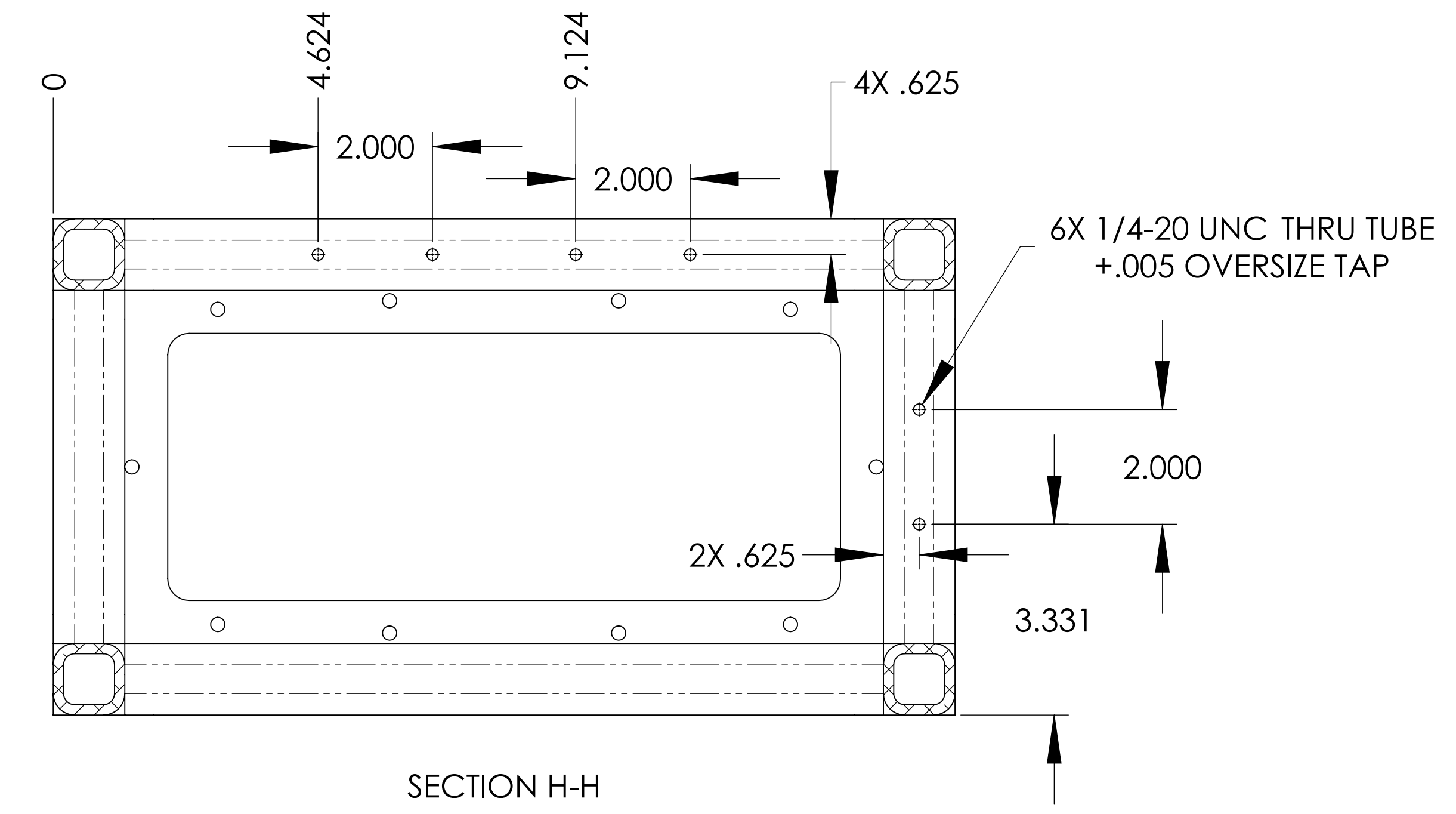
FRONT AND BACK SIDES



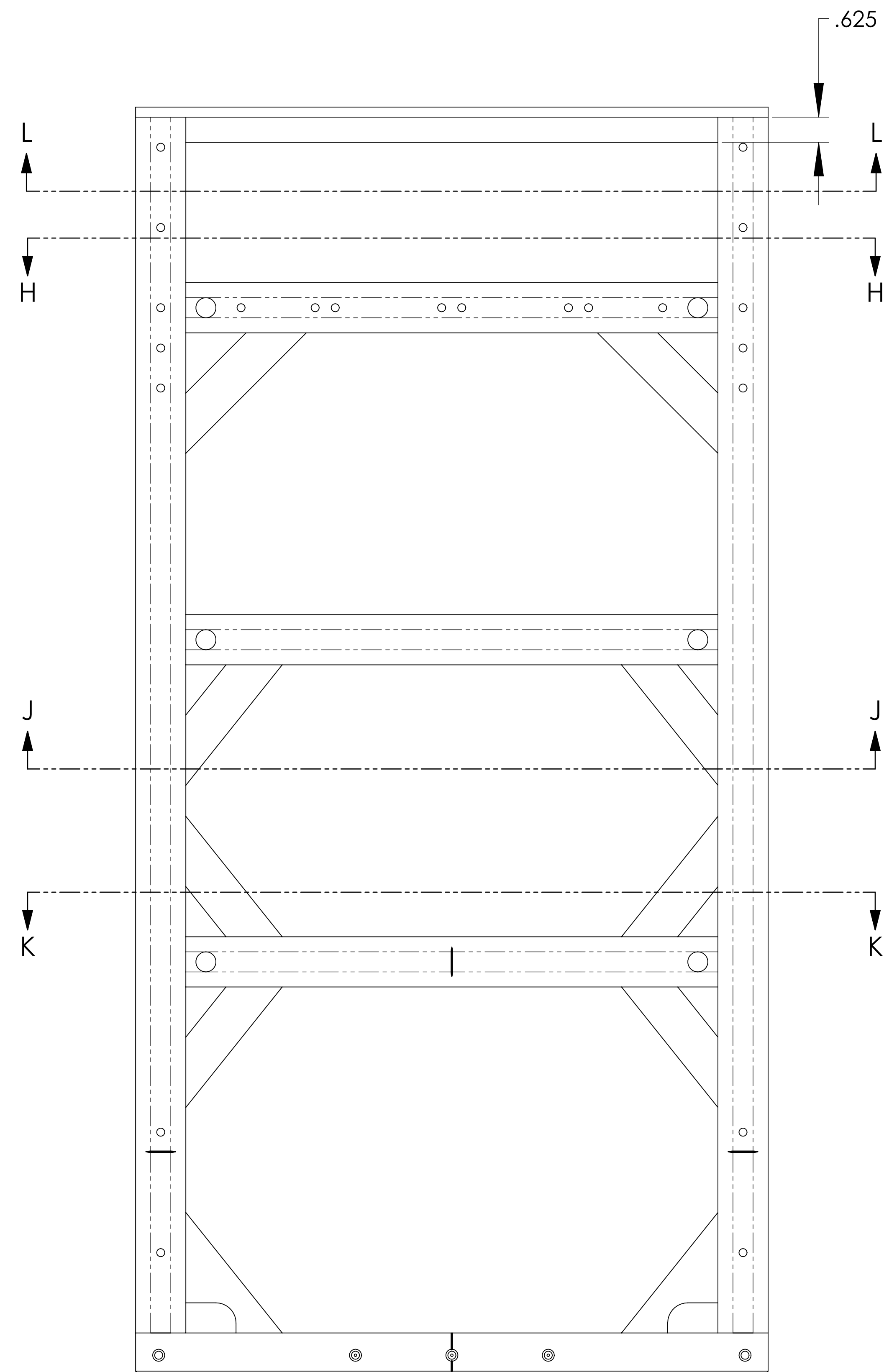
DETAIL G  
SCALE 2:1  
5 PLACES



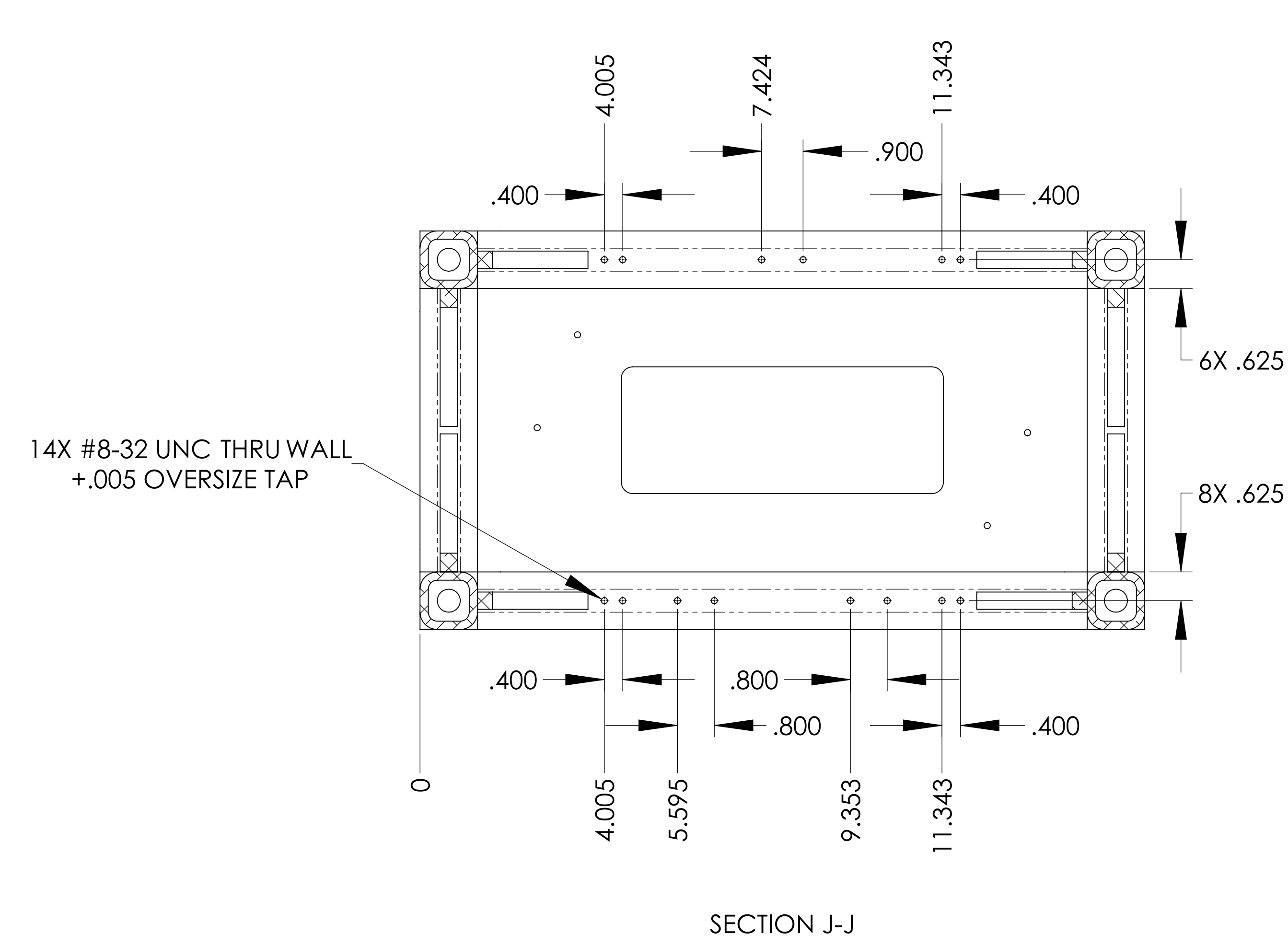
SECTION L-L



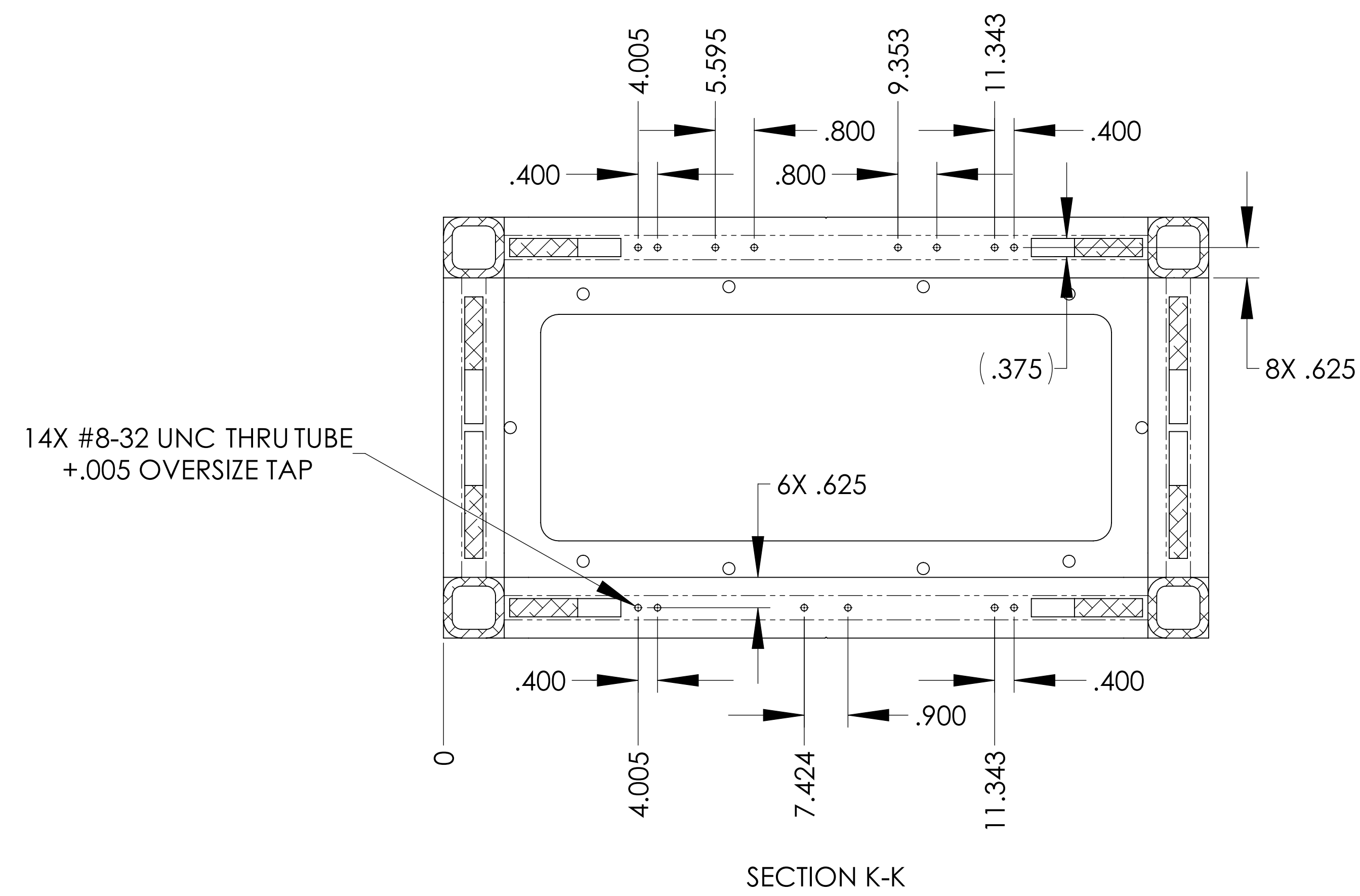
SECTION H-H



FRONT VIEW

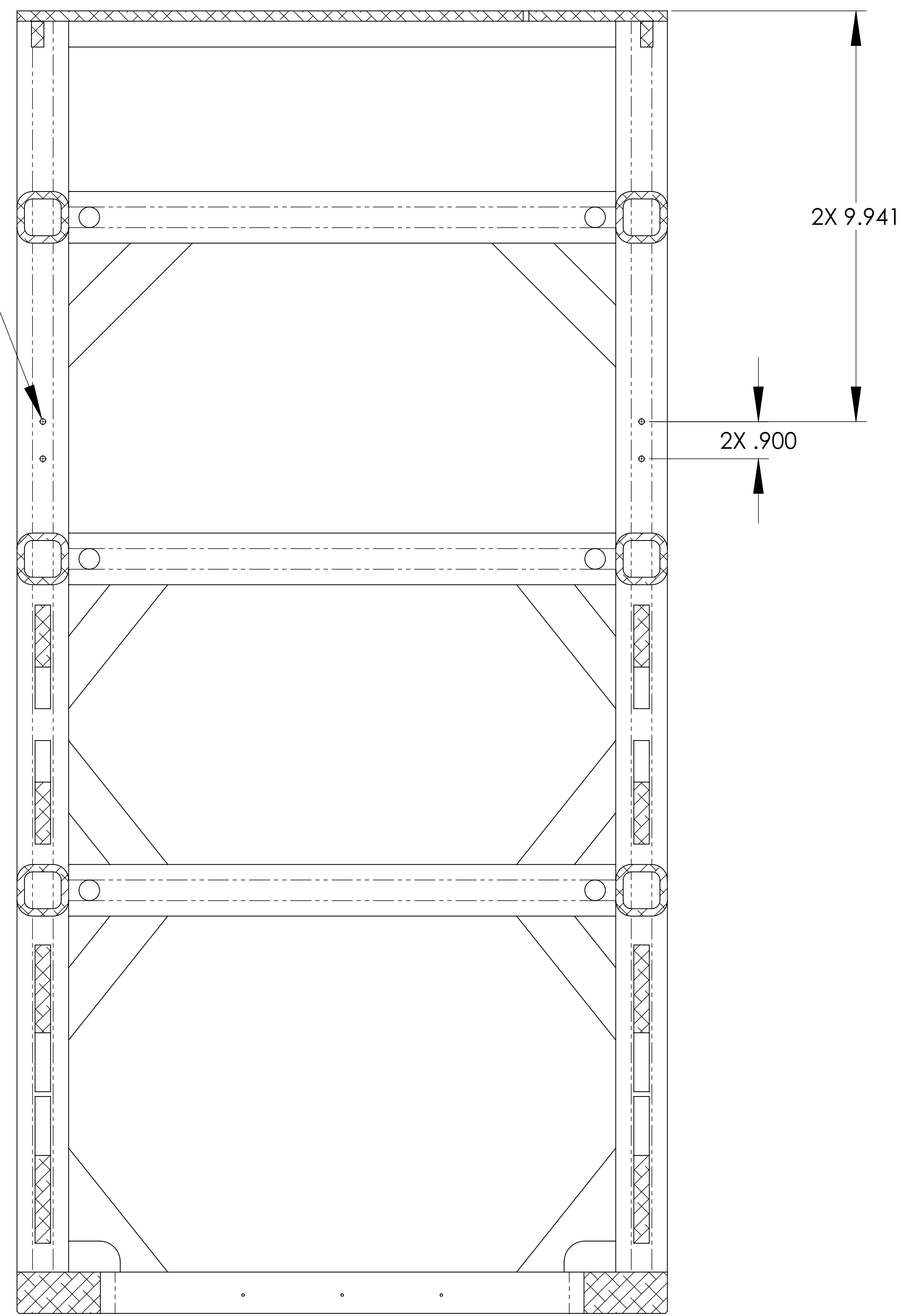


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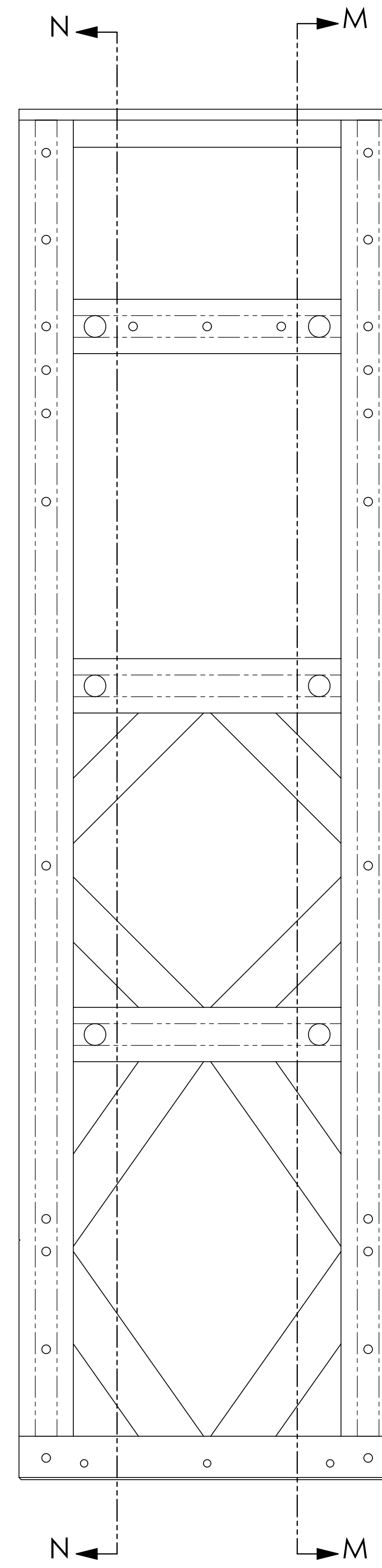


SECTION K-K

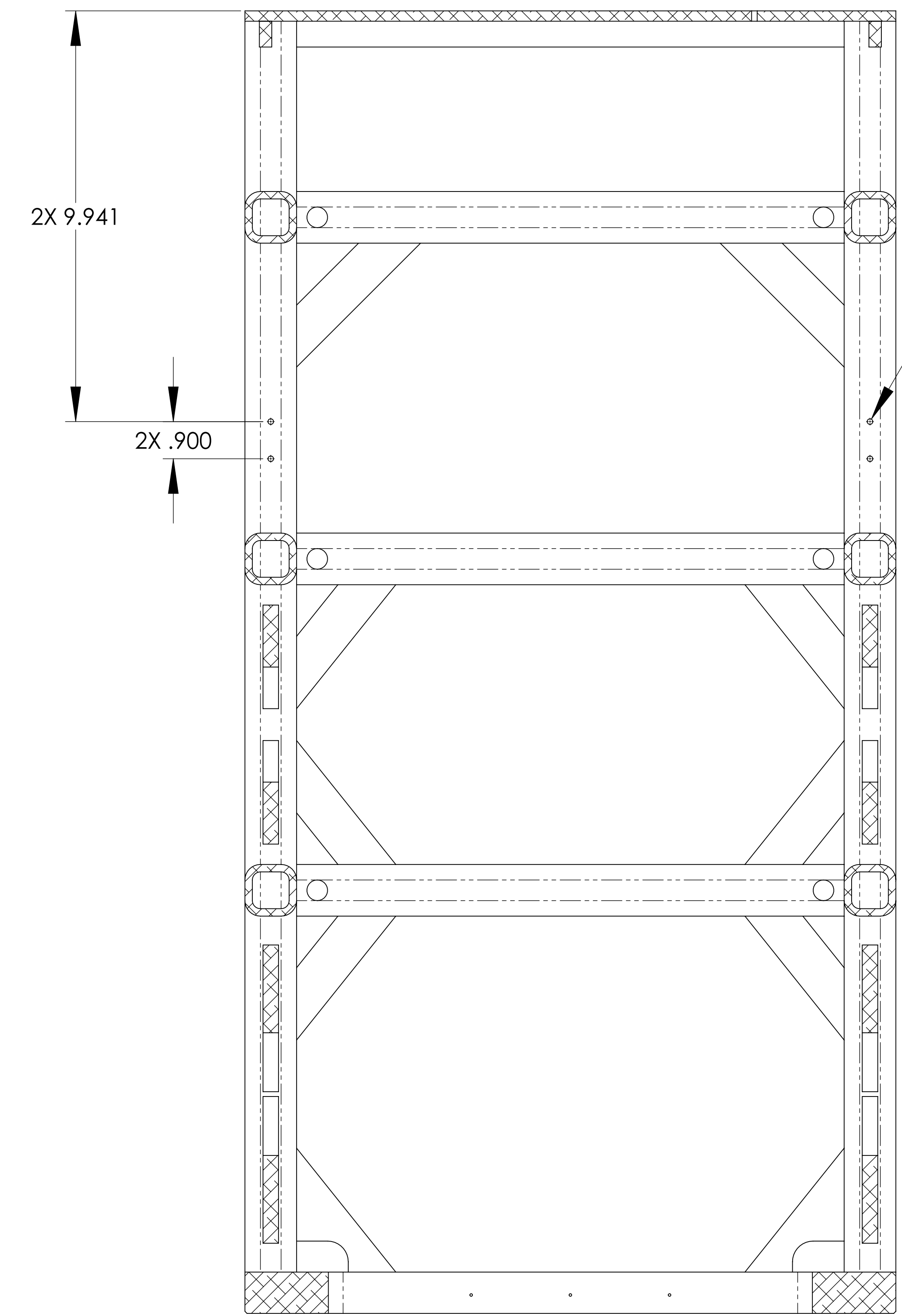




SECTION N-N



INTERIOR HOLES FRONT AND BACK



SECTION M-M