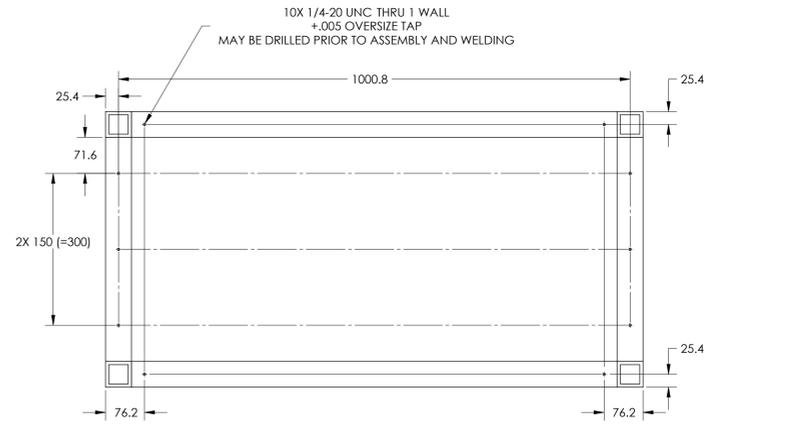
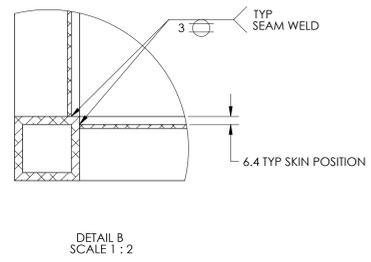
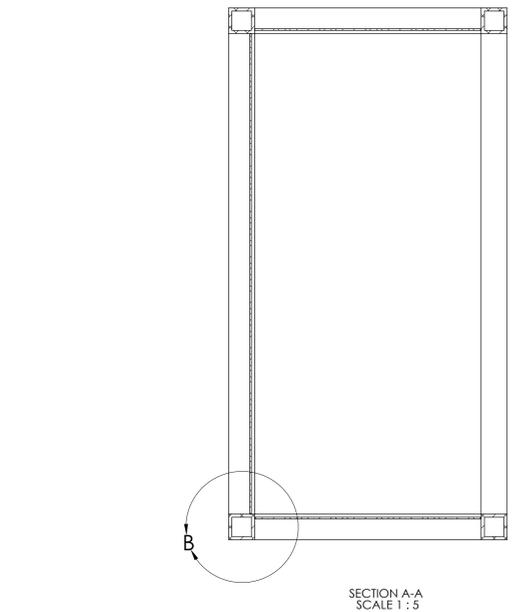
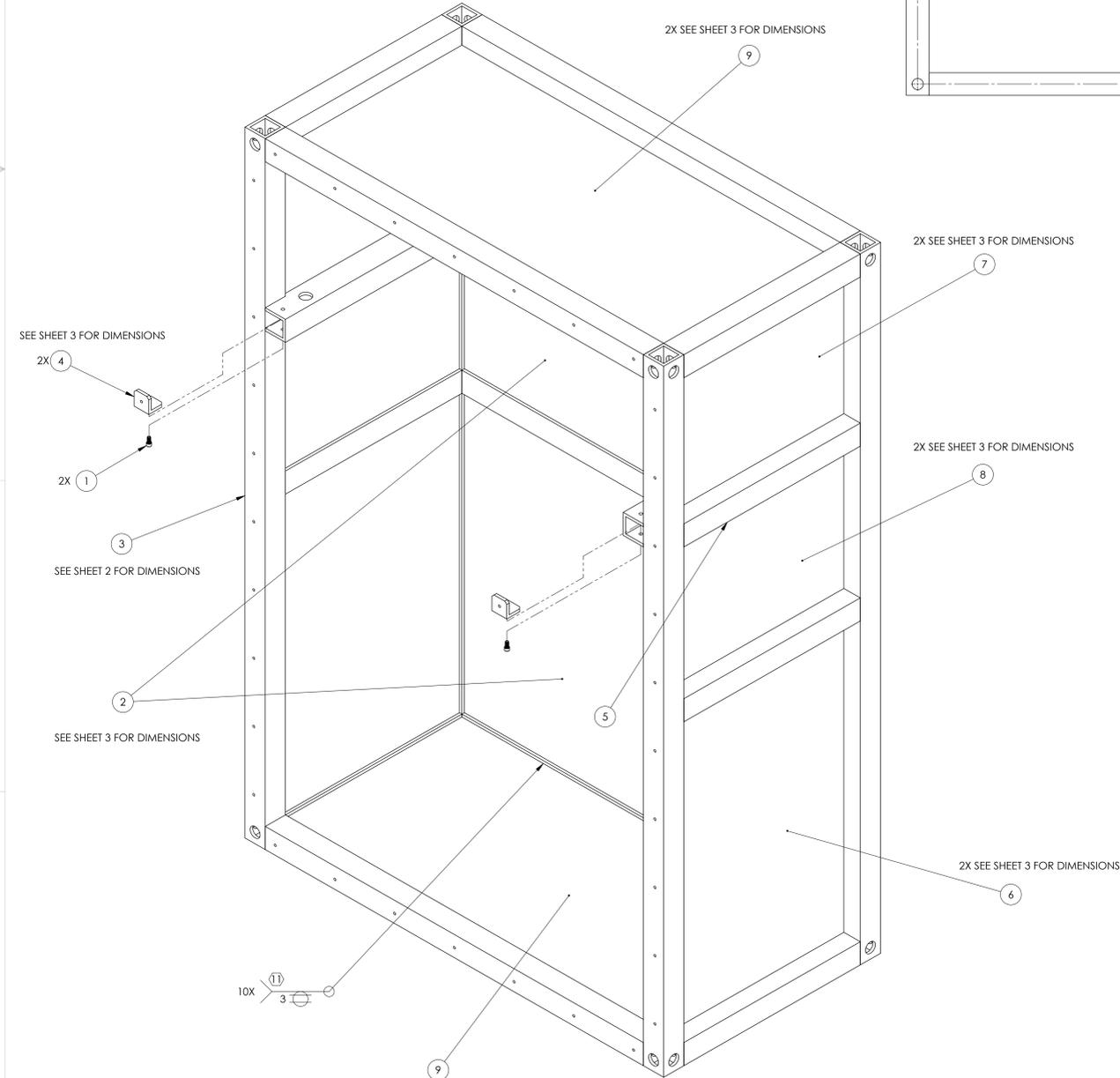
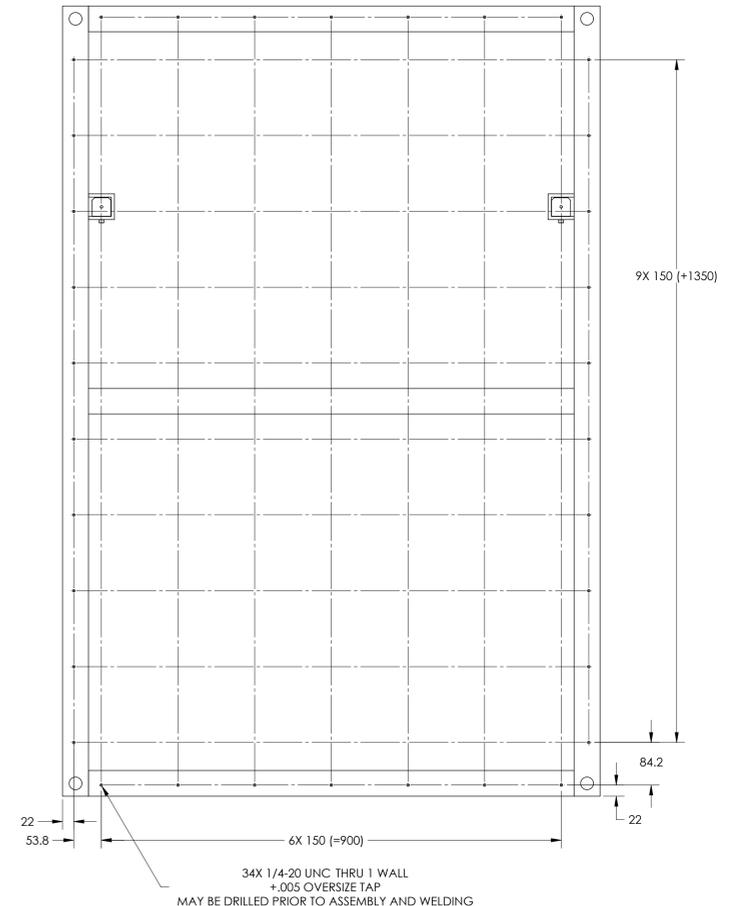
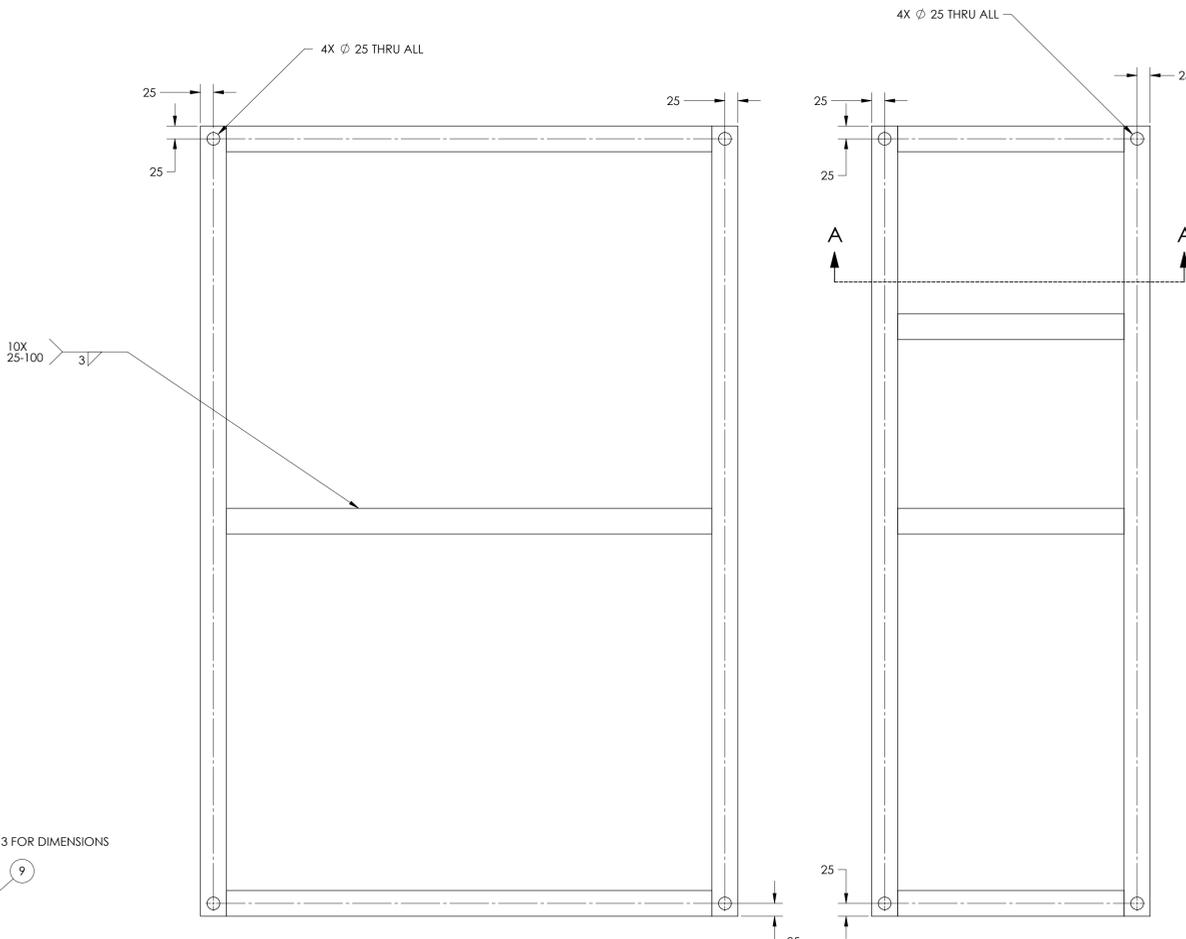


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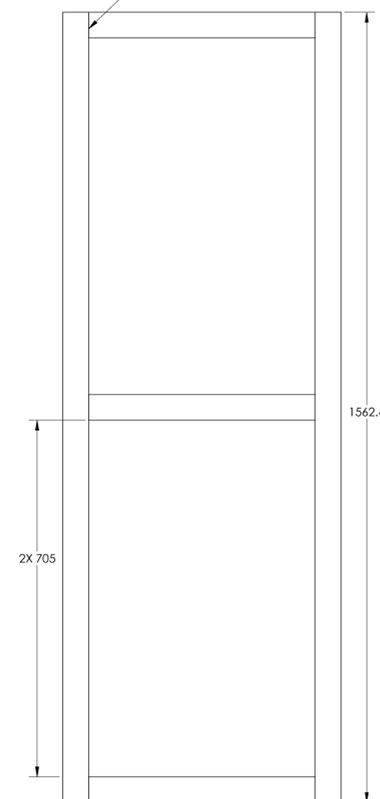
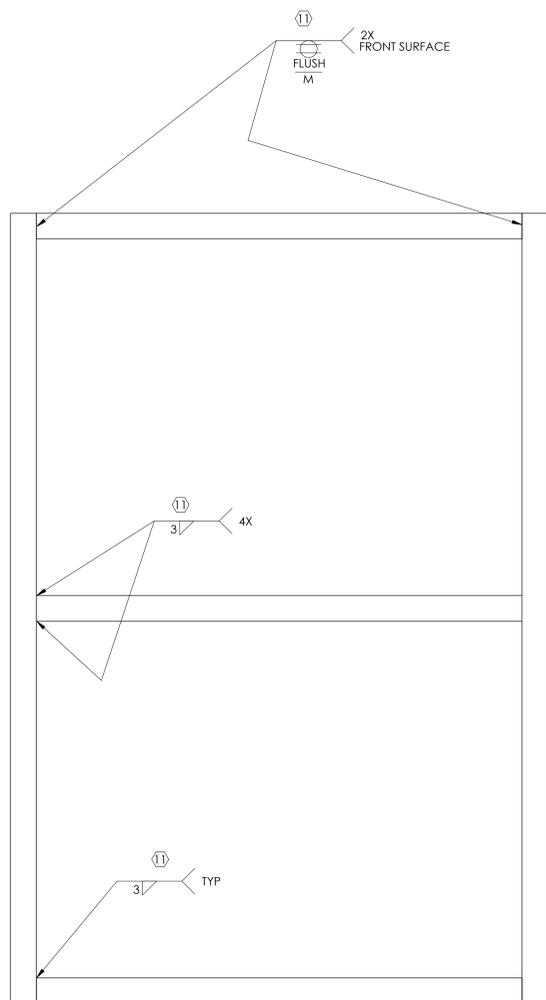
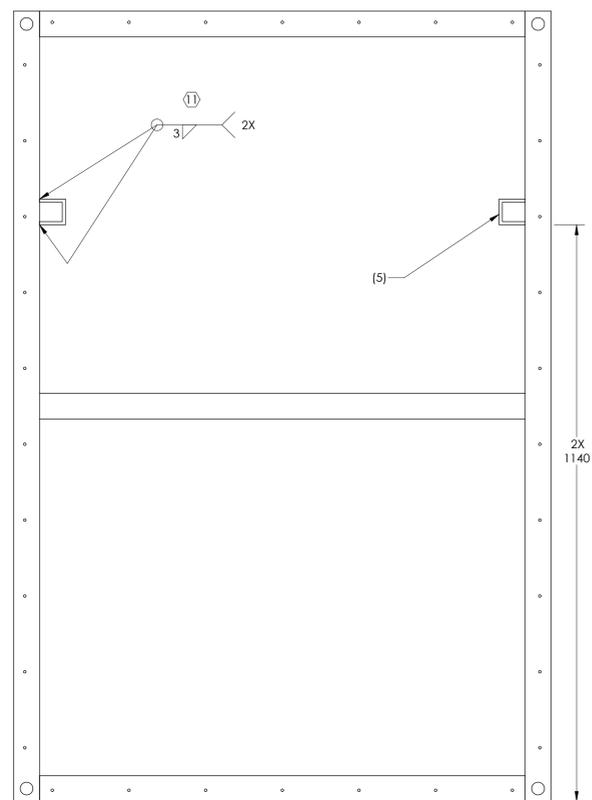
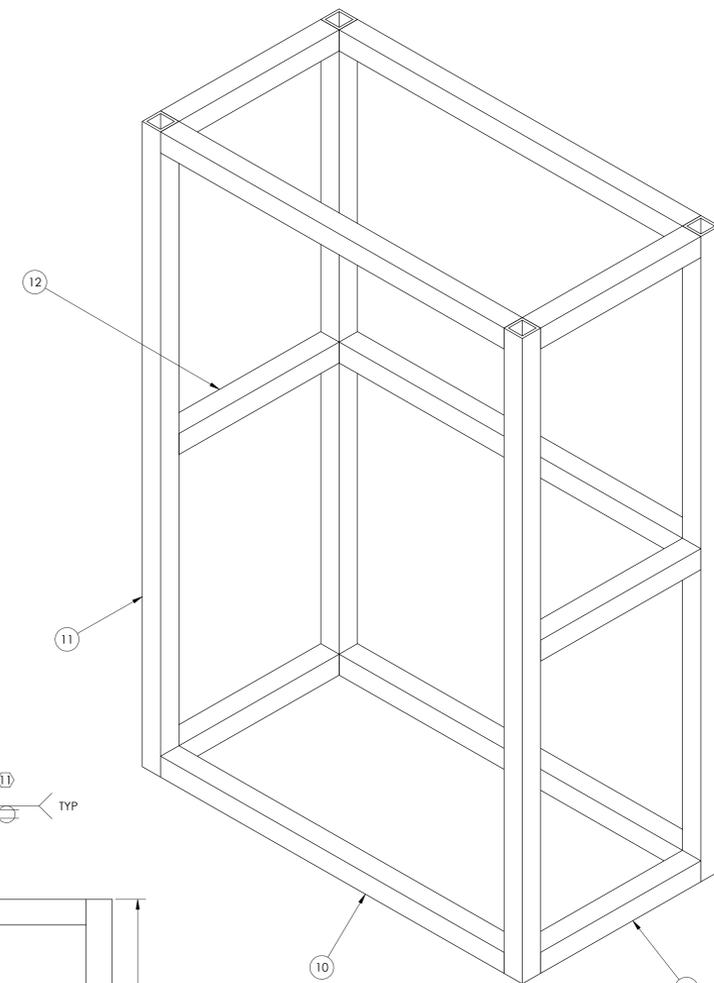
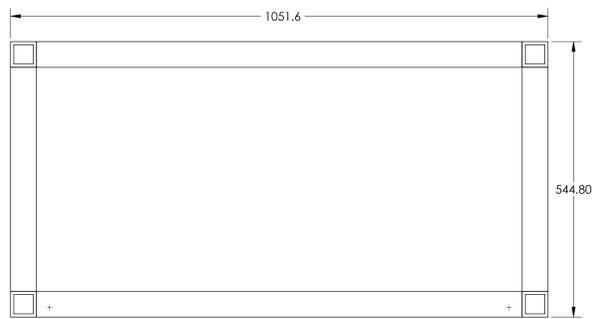
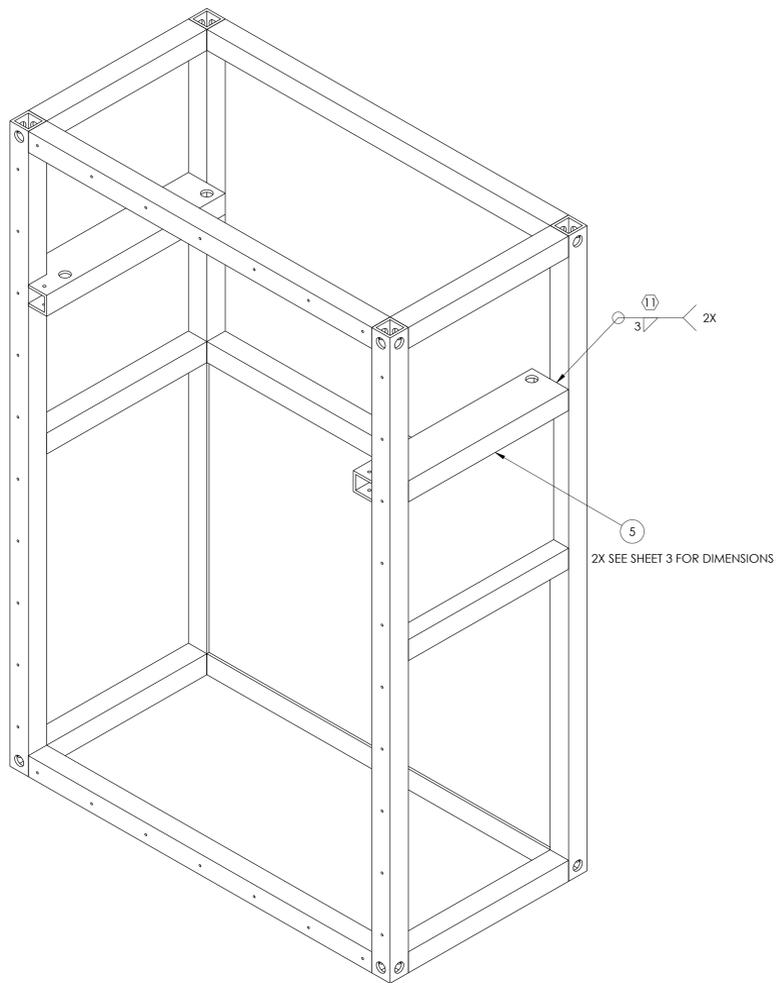
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 155 LB.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. ALL TUBES AND SHEETS TO BE FREE OF DEFECTS, DINGS AND SCRATCHES AND HAVE A WORKMANLIKE FINISH. SURFACE IMPERFECTIONS SUCH AS HANDLING MARK, SHALLOW PITS AND SCRATCHES, ARE ACCEPTABLE PROVIDED THEY ARE WITHIN 10% OF SPECIFIED WALL OR .002" (0.05mm), WHICHEVER IS GREATER.
- 9. EACH TUBE SHOULD BE INDIVIDUALLY WRAPPED AND PROTECTED FROM SCRATCHES, PITTING AND DIGS DURING TRANSPORT AND HANDLING.
- 10. PRIOR TO WELDING, ALL PARTS MUST BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, INK MARKINGS, DIRT AND CHIPS USING SOAP AND WATER OR SOLVENT (ACETONE).
- 11. WELDING: ALL DIMENSIONS APPLY AFTER WELDING. ALL WELDS SHALL BE DONE ON THE INTERIOR OF THE CONTAINER SUCH THAT NO SEAMS ARE EXPOSED ON THE INTERIOR OF THE BOX. ALL WELDS MUST BE CONTINUOUS. SEAMS WILL TRAP CONTAMINATION AND BE HARD TO CLEAN. ALL WELDS MUST BE COMPLETE JOINT PENETRATION WELDS OR PARTIAL PENETRATION WELDS. THE CONTAINER SHOULD FULLY SEAL AT THE WELDS, SUCH THAT THE CONTAINER IS AIR TIGHT. NO TRAPPED VOLUMES ARE PERMITTED. WELDMENTS WITH CREVICES ARE CONSIDERED NON-CLEANABLE SINCE THESE CREVICES ACT AS TRAPS FOR CLEANING SOLUTIONS. ALL WELDERS SHOULD BE CERTIFIED TO AMERICAN WELDING SOCIETY (AWS).

REV.	DATE	DCN #	DRAWING TREE #
V1	17 AUG 2010		
V2	20 AUG 2010		
V3	29 SEPT 2010		
V4	12 OCT 2010	E1000577	



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
9	6061-T6 Al	LOWER QUAD STORAGE CONTAINER TOP AND BOTTOM SKIN	6061-T6 Al	2		2
8	6061-T6 Al	MIDDLE SIDE SKIN	6061-T6 Al	2		2
7	6061-T6 Al	UPPER SIDE SKIN	6061-T6 Al	2		2
6	6061-T6 Al	LOWER SIDE SKIN	6061-T6 Al	2		2
5	6061-T6 Al	LOWER QUAD STORAGE CONTAINER STRUCTURE SHELF	6061-T6 Al	2		2
4	6061-T6 Al	END PLUG	6061-T6 Al	2		2
3	6061-T6 Al	LOWER QUAD STORAGE CONTAINER WELDMENT	6061-T6 Al	1		1
2	6061-T6 Al	LOWER QUAD STORAGE CONTAINER BACK SKIN	6061-T6 Al	2		2
1	92200AS37	SCREW, SHC, 1/4-20 x 1/2, MS16995-48, MC #92200AS37	300 S5TL	2		2

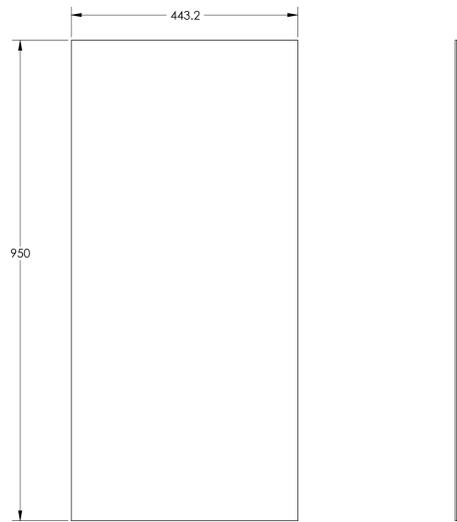
<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>1. INTERPRET DRAWING PER ASME Y14.5-1994.</p> <p>2. REMOVE ALL SHARP EDGES, R.02 MIN.</p> <p>3. DO NOT SCALE FROM DRAWING.</p> <p>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.</p>		<p>CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME LOWER STRUCTURE STORAGE CONTAINER WELDMENT</p>	
<p>DIMENSIONS ARE IN MILLIMETERS</p> <p>TOLERANCES: .XX ± .25 .XXX ± .13 ANGULAR ± .5°</p>		<p>DESIGNER: K. BUCKLAND DRAFTER: K. BUCKLAND CHECKER: APPROVAL:</p>		<p>DATE: 2 AUG 2010 SIZE: E DWG. NO.: D1002119 REV.: v4</p>	
<p>MATERIAL: N/A</p>		<p>FINISH: N/A μinch</p>		<p>SCALE: 1:4 PROJECTION:</p>	



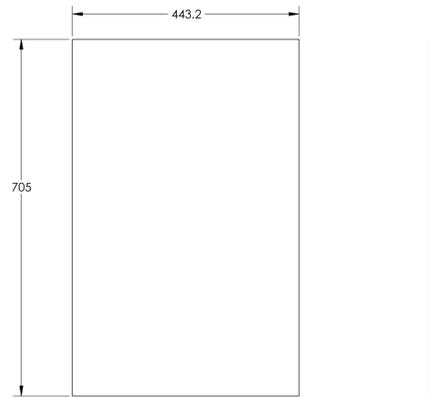
CUT LIST

ITEM NO.	QTY.	DESCRIPTION	LENGTH
10	5	50.8X50.8X6.35 TUBE	950
11	4	50.8X50.8X6.35 TUBE	1562.4
12	6	50.8X50.8X6.35 TUBE	443.2

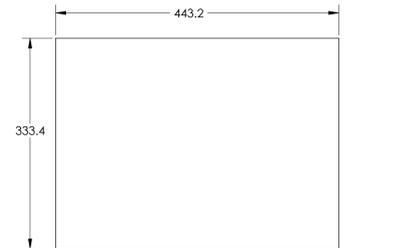
BASIC WELDMENT
 MATERIAL: 2" SQUARE X .25" WALL
 6061 ALUM ALLOY TUBING
 SURFACE FINISH: AS RECEIVED



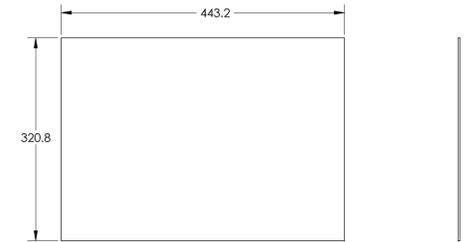
TOP AND BOTTOM SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 SURFACE FINISH: 32 μinch
 2 REQ'D



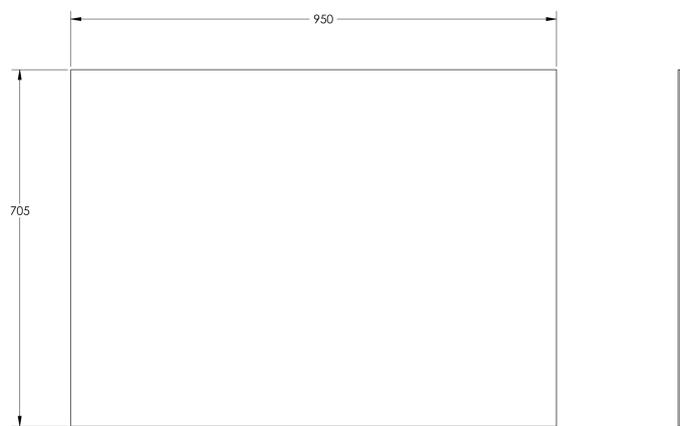
LOWER SIDE SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 SURFACE FINISH: 32 μinch
 2 REQ'D



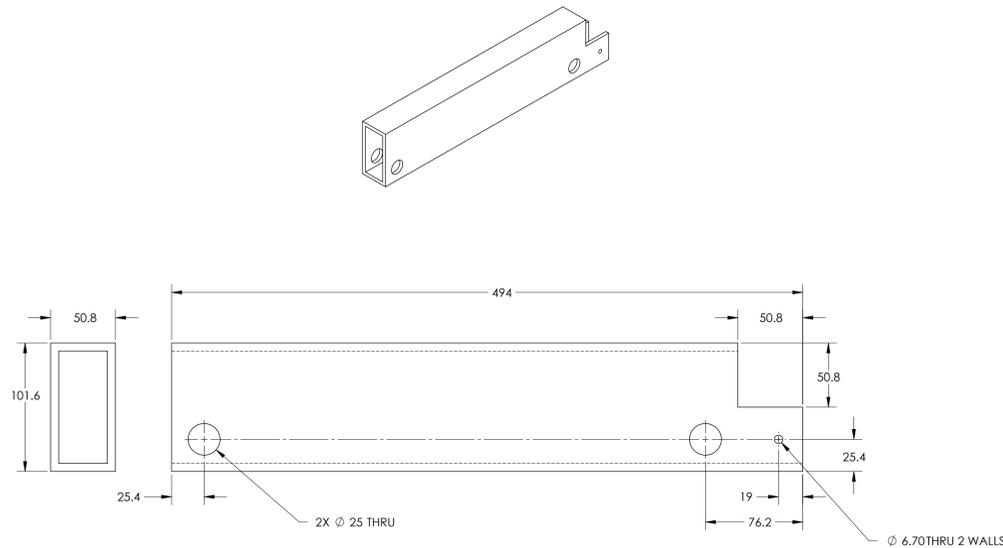
MIDDLE SIDE SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 SURFACE FINISH: 32 μinch
 2 REQ'D



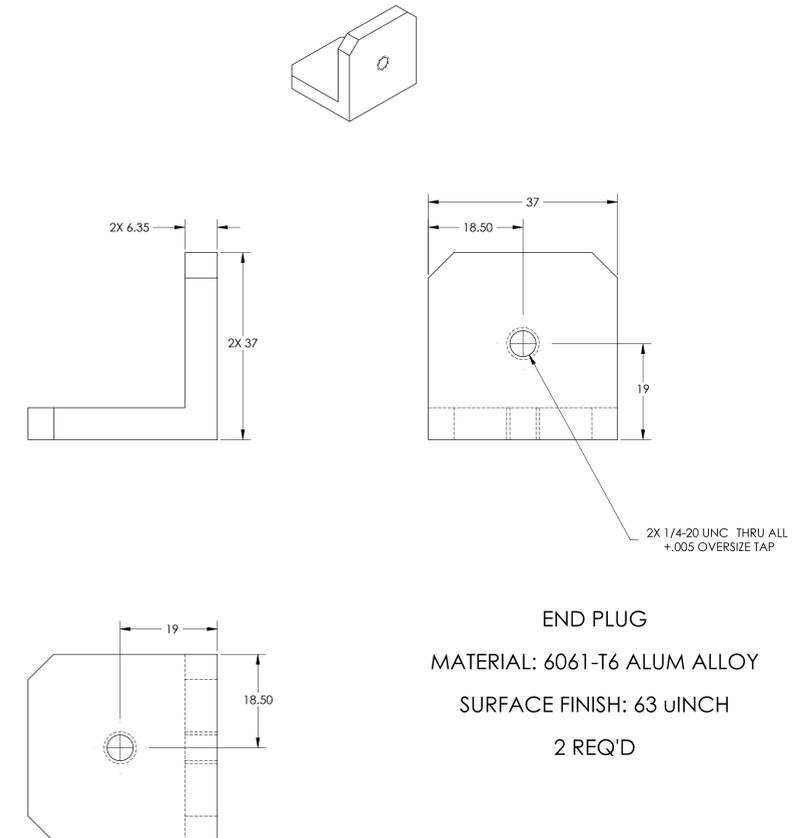
UPPER SIDE SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 SURFACE FINISH: 32 μinch
 2 REQ'D



BACK SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 SURFACE FINISH: 32 μinch
 2 REQ'D



STRUCTURE SHELF
 MATERIAL: 2" X 4" X .25" WALL
 6061 ALUM ALLOY TUBING
 SURFACE FINISH: AS RECEIVED
 TO BE CHEMICALLY CLEANED / ETCHED BY
 ACID AND / OR CAUSTIC PROCESS PRIOR TO WELDING



END PLUG
 MATERIAL: 6061-T6 ALUM ALLOY
 SURFACE FINISH: 63 μINCH
 2 REQ'D