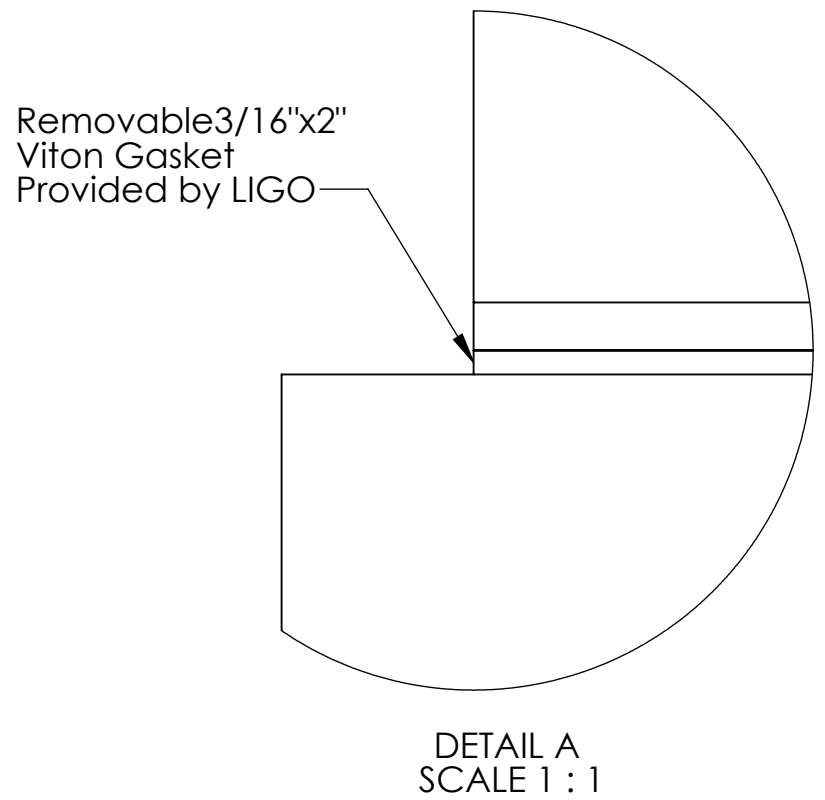
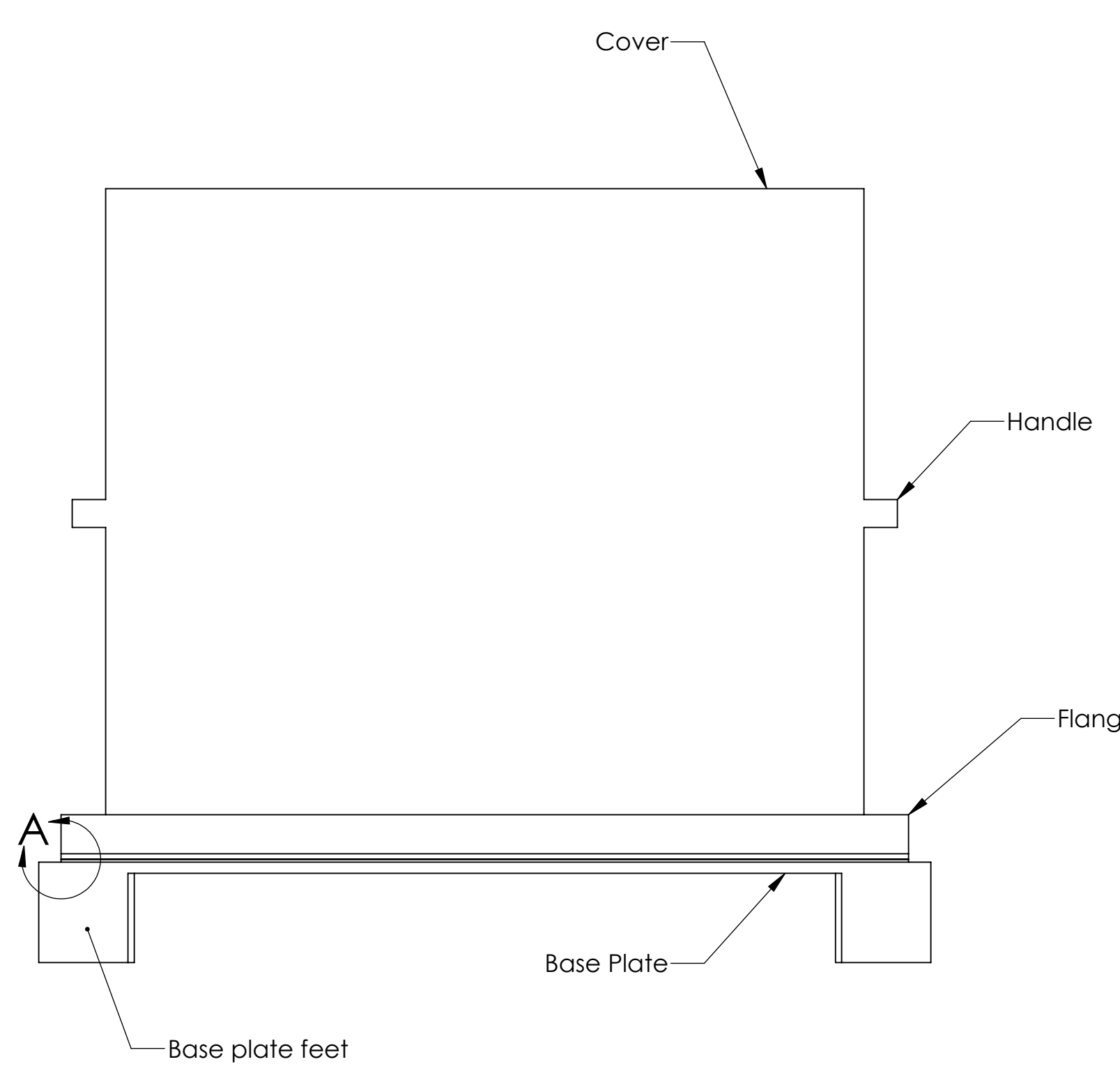
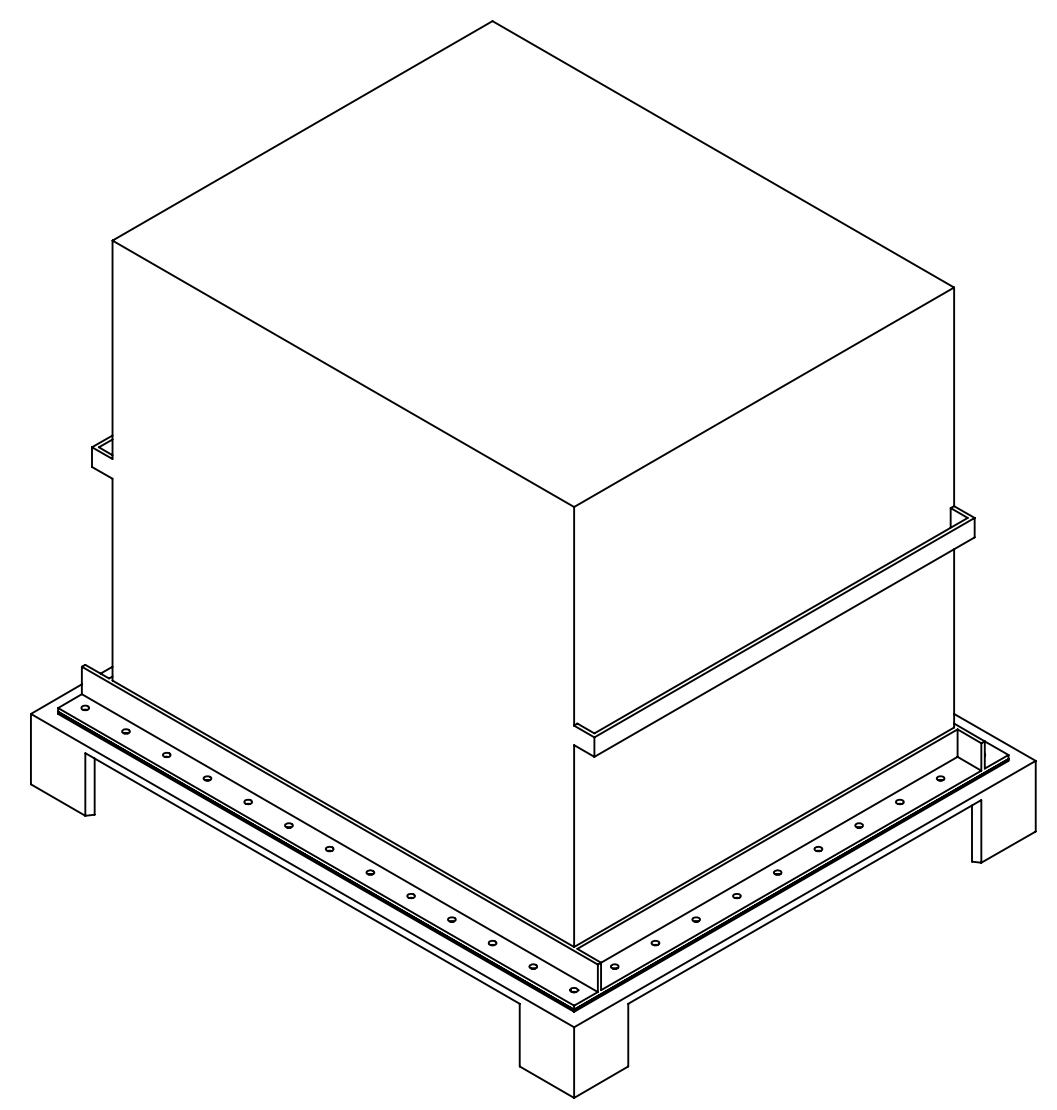


REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-

Storage Container Assembly



ITEM NO.	PART NUMBER	QTY.
1	Upper Structure Cover	1
2	Upper Structure Base Plate	1
3	Flat Viton Gasket	1

DIMENSIONS ARE IN TOLERANCES: .XX ± REFER TO NOTES ON SHEET 2 and 3 .XXX ± ANGULAR ± °		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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <h2 style="margin: 0;">Upper Structure Storage Container</h2>	
		SYSTEM SUS		DESIGNER Jim Warner DRAFTER CHECKER APPROVAL		SIZE c DWG. NO. D1002222 REV. v7	
MATERIAL 6061 or 5052 Aluminum		FINISH refer to notes		NEXT ASSY		SCALE: 1:8 PROJECTION: SHEET 1 OF 3	

44 x \varnothing .41 Thru holes
1" From Edge
3" Spacing

32.00

38.00

34.00

28.00

30.19

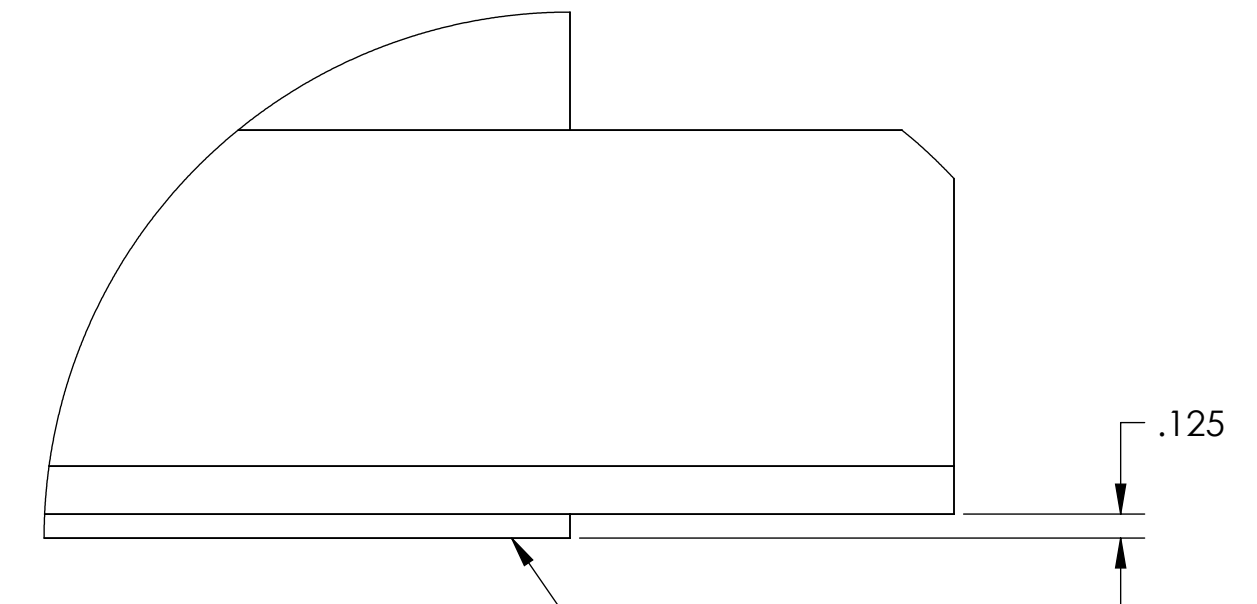
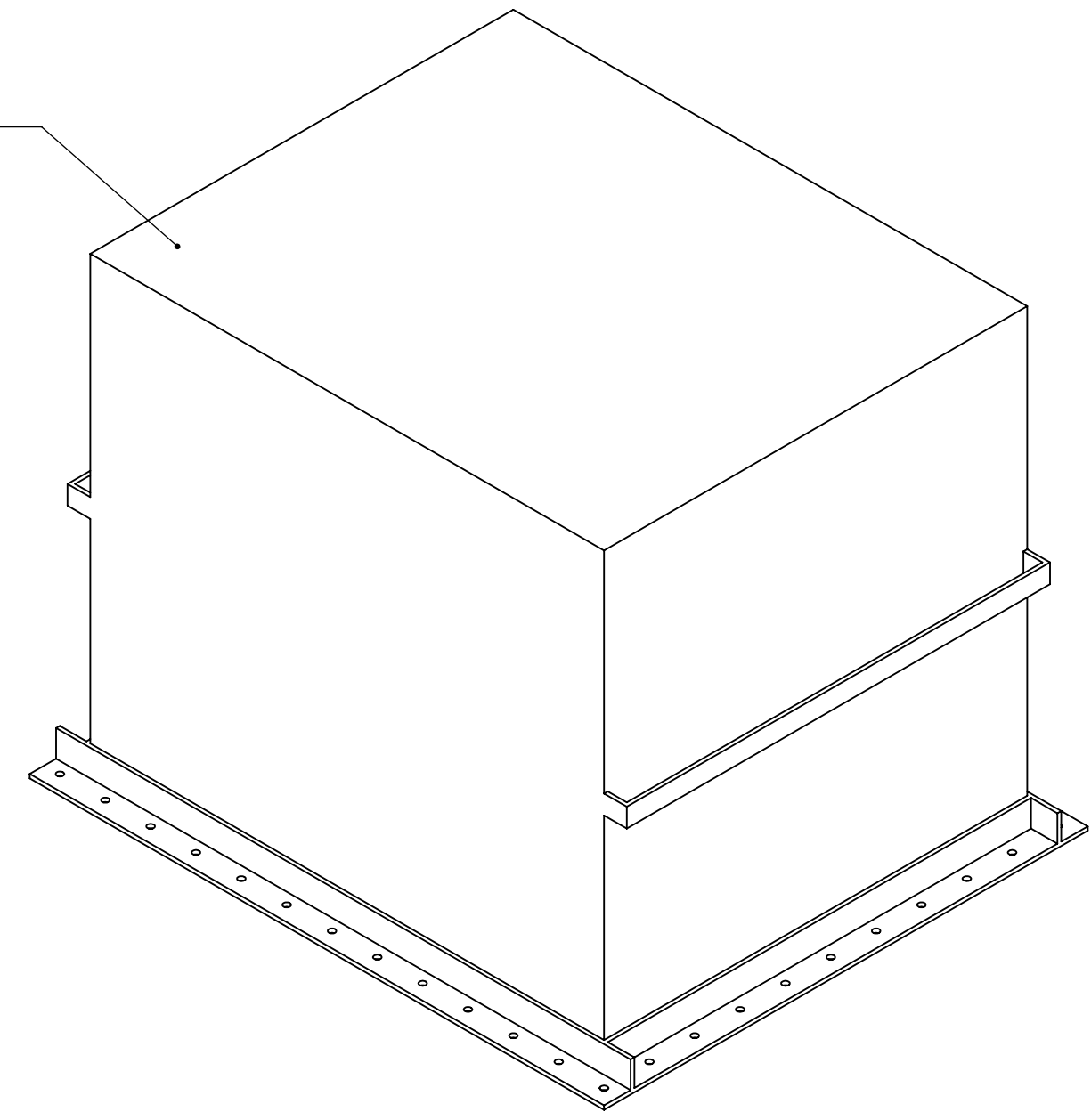
Handle

Handle

4x 2"x2"x1/4"
Aluminum Angle

C

Welded cover



Cover Body To Extend Below
Angle 1/8" For Gasket

DETAIL C
SCALE 1 : 1

I. ALUM WELDED COVER BOX (INCLUDING HANDLES)

5. Use 1/8" 6061 or 5052 Aluminum Sheet for 5-sided cover and handles.
6. 32 micor-inch finish as rec from supplier (for sheet metal, not weld). If surface finish is higher than the standard 32 Ra micro-inch, the surface finish shall be discussed with LIGO officer prior to acceptance.
7. Minimum of 2 handles to be welded at midpoint of the cover such that seal is unaffected, location not critical.
8. 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)

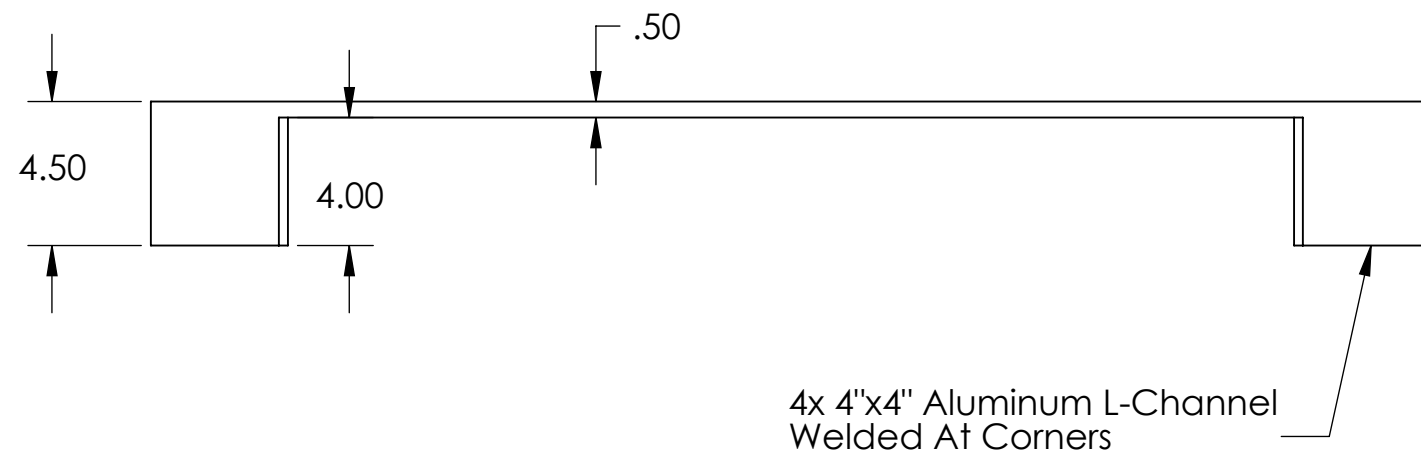
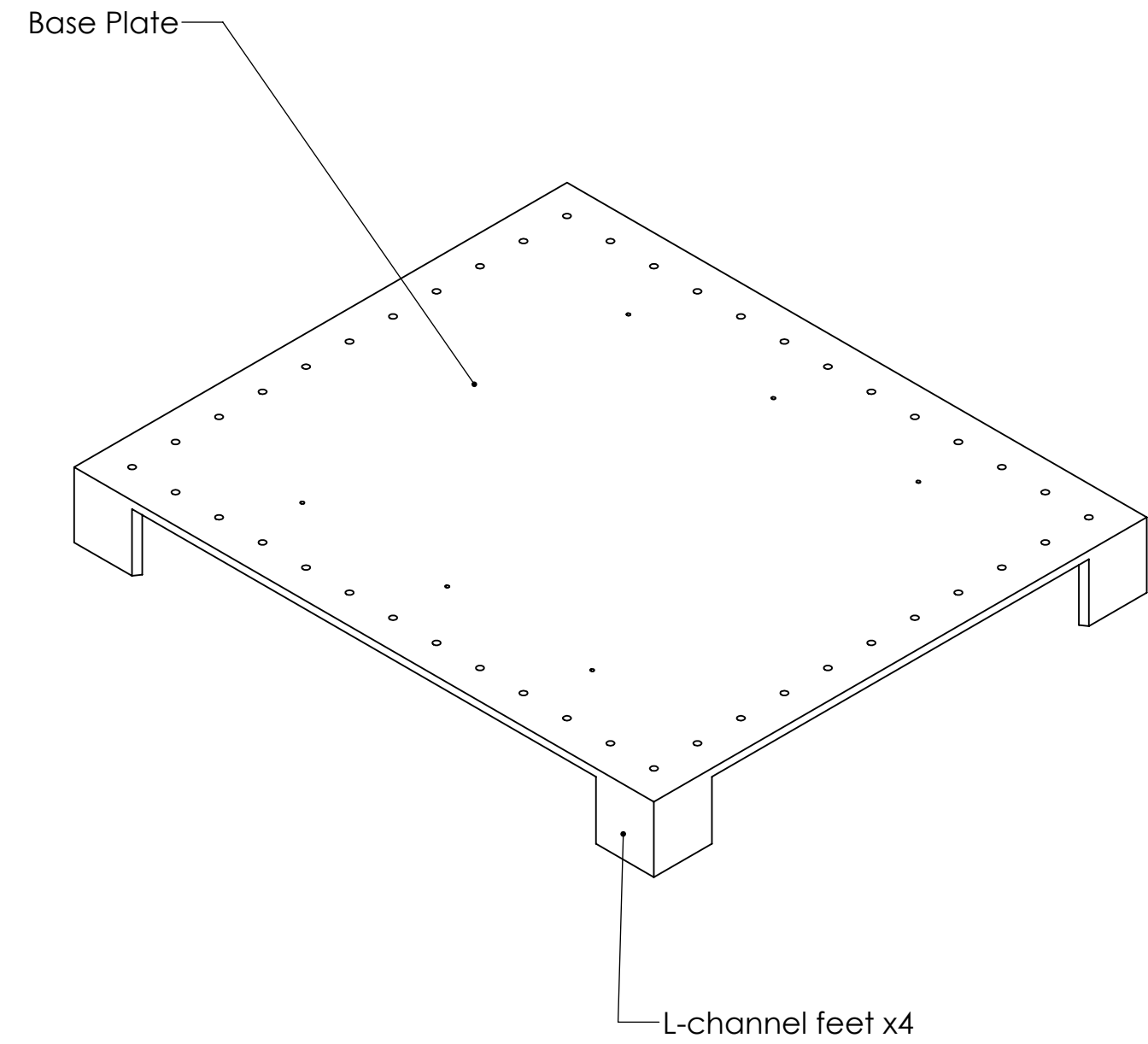
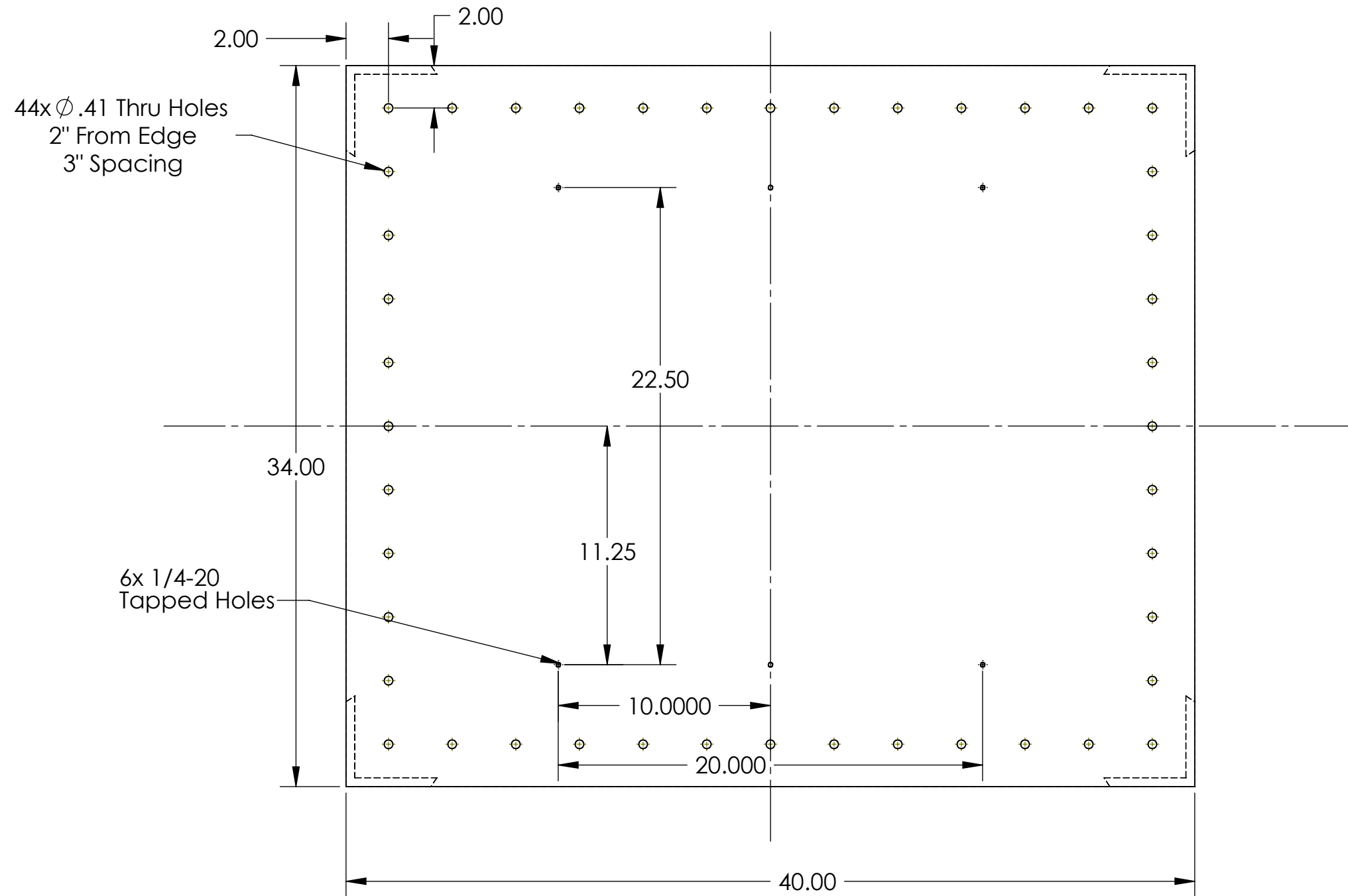
9. ALL DIMENSIONS APPLY AFTER WELDING. ALL WELDS MUST BE FULL PENETRATION AND FULL FUSION WELDS. THE CONTAINER SHOULD FULLY SEAL AT THE WELDS, SUCH THAT THE CONTAINER IS AIR TIGHT. NO TRAPPED VOLUMES ARE PERMITTED. WELDMENTS WITH CREVICES ARE CONSIDERED NON-CLEANABLE SINCE THESE CREVICES ACT AS TRAPS FOR CLEANING SOLUTIONS. ALL WELDS SHALL BE DONE ON THE INTERIOR OF THE CONTAINER SUCH THAT NO SEAMS ARE EXPOSEDON THE INTERIOR OF THE BOX. SEAMS WILL TRAP CONTAMINATION AND BE HARD TO CLEAN.ALL WELDERS SHOULD BE CERTIFIED TO AMERICAN WELDING SOCIETY (AWS).

10. All interior dims +/- 0.010", exterior dims are +/- .125"
11. Regular finish on Alum welding is acceptable. The inside of the box is more important than the outside.
12. If remedial action is required to repair a weld then carbide burrs are allowed.

II. ALUM ANGLE FOR COVER FLANGE

13. Use 4x 2"x2"x1/4" Aluminum angle for cover flange.
14. Material to be chosen such that localized digs, scratches and blemishes is minimized. As received finish is acceptable.
15. All interior dims +/- 0.010", exterior dims are +/- .125"

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE C	DWG. NO. Cover	v7
SCALE: 1:8	PROJECTION: 	SHEET 2 OF 3



III. ALUM BASE PLATE

- 16. Machine all surfaces of 1/2" plate, to achieve 125 micro-inch finish. If can be received with better finish, no machining is required.
- 17. Use 5052 or 6061-T6-Al 1/2" Aluminum Plate
- 18. All interior dims +/- 0.010", exterior dims are +/- .125"

IV. ALUM L-CHANNEL (FEET)

- 19. Use 4x 4"x4"x1/2" Aluminum angle for feet. As received finish is acceptable for feet.
- 20. Material to be chosen such that localized digs, scratches and blemishes is minimized.
- 21. All interior dims +/- 0.010", exterior dims are +/- .125".
- 22. Feet to be welded to base plate at corners.
- 23. Full seal welds on cover to be done from interior of cover.

Option:

Pleased quote as an option the Alkaline Soak Cleaning of all units (D1002118 and D1002222) post fabrication, as per Section 5.1 of E0900364.

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	v7
C	Base Plate	
SCALE: 1:8	PROJECTION:	
		SHEET 3 OF 3