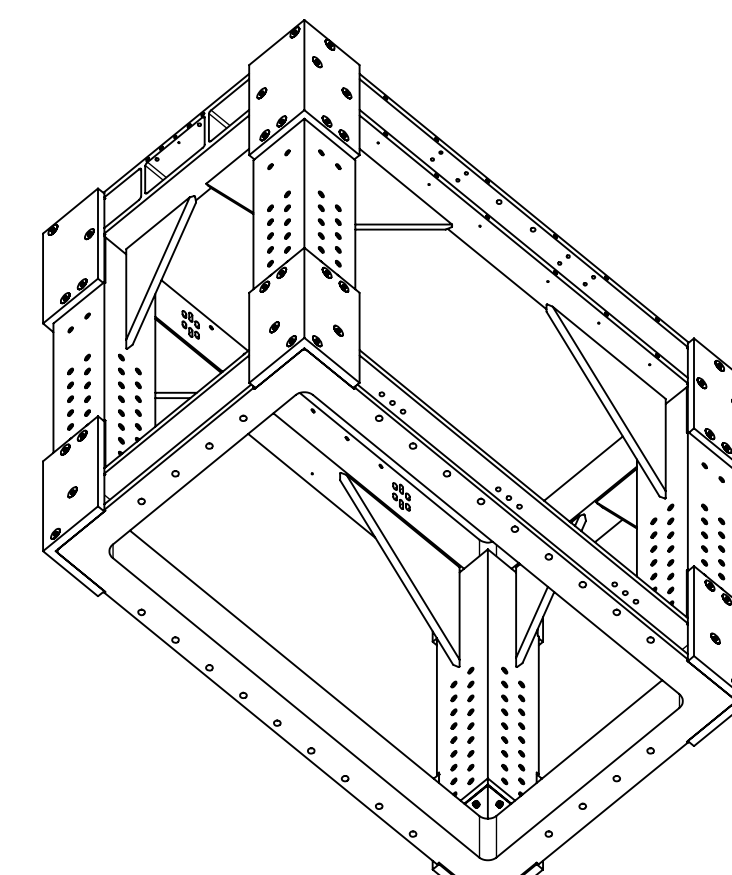
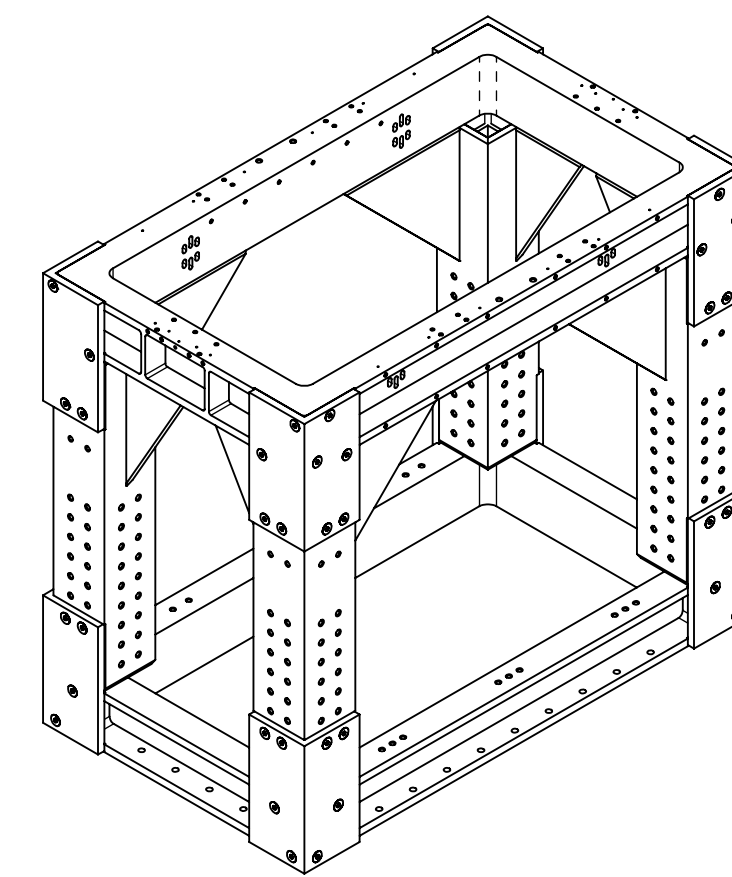
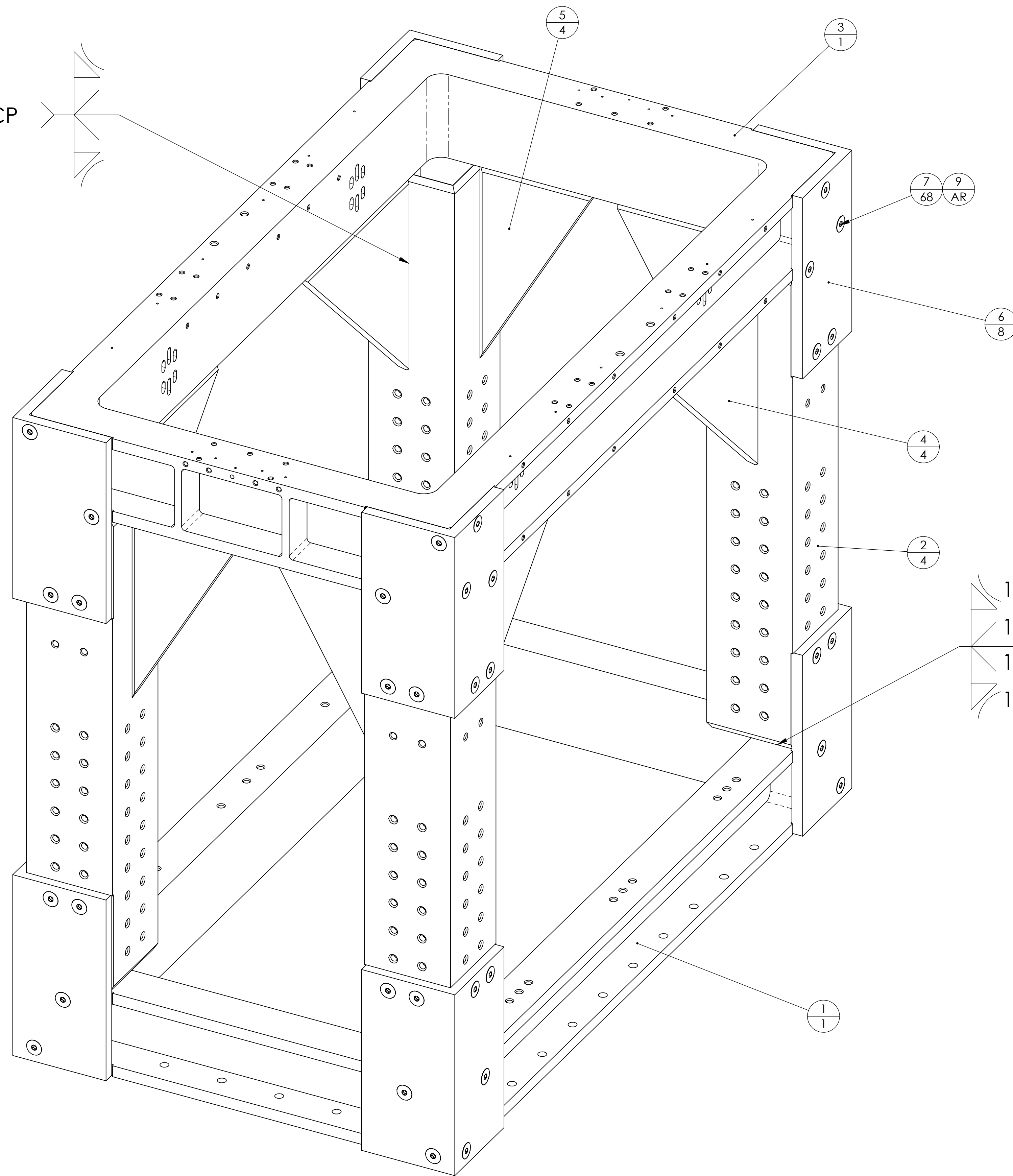


16 PLACES CP

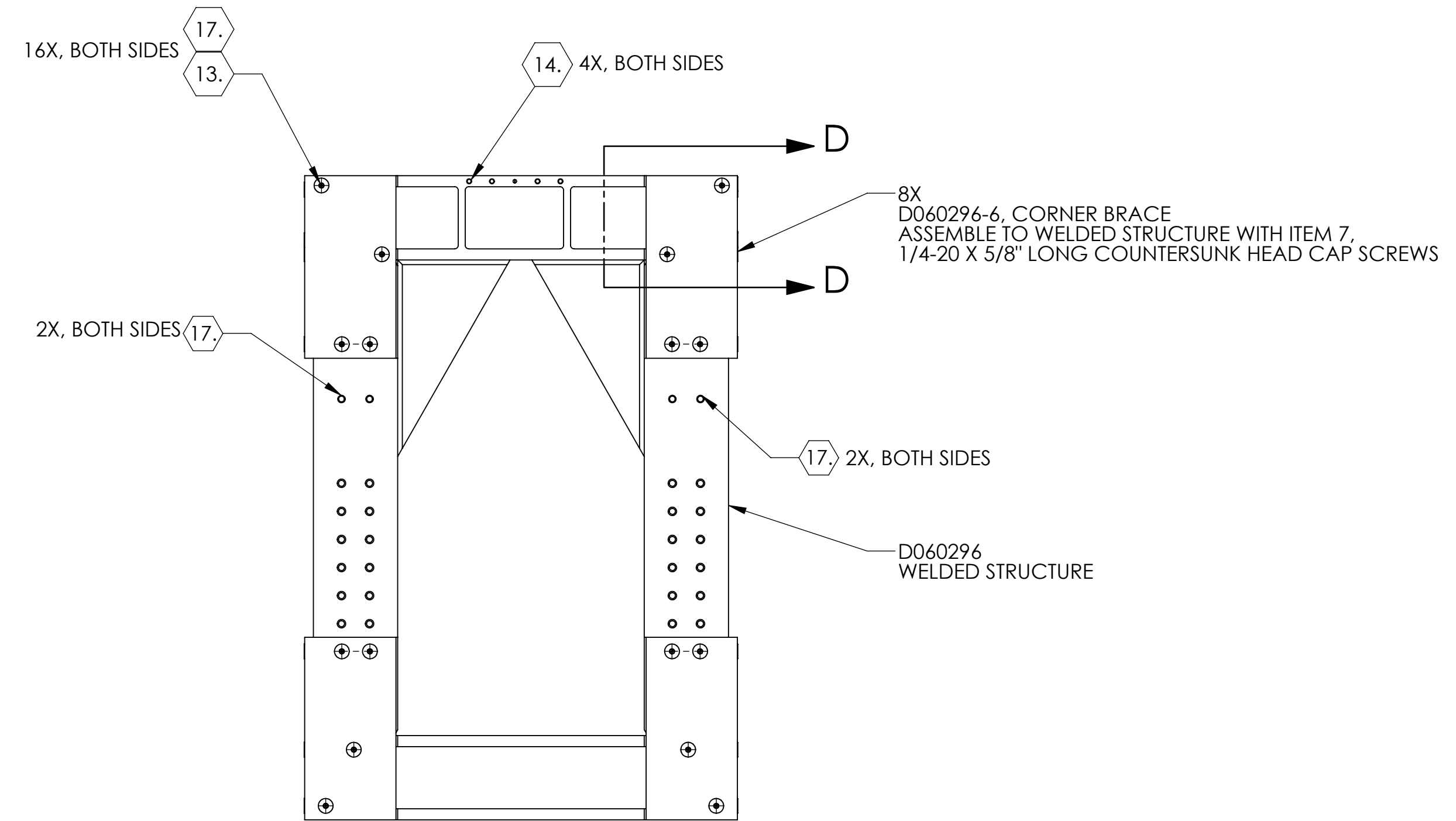
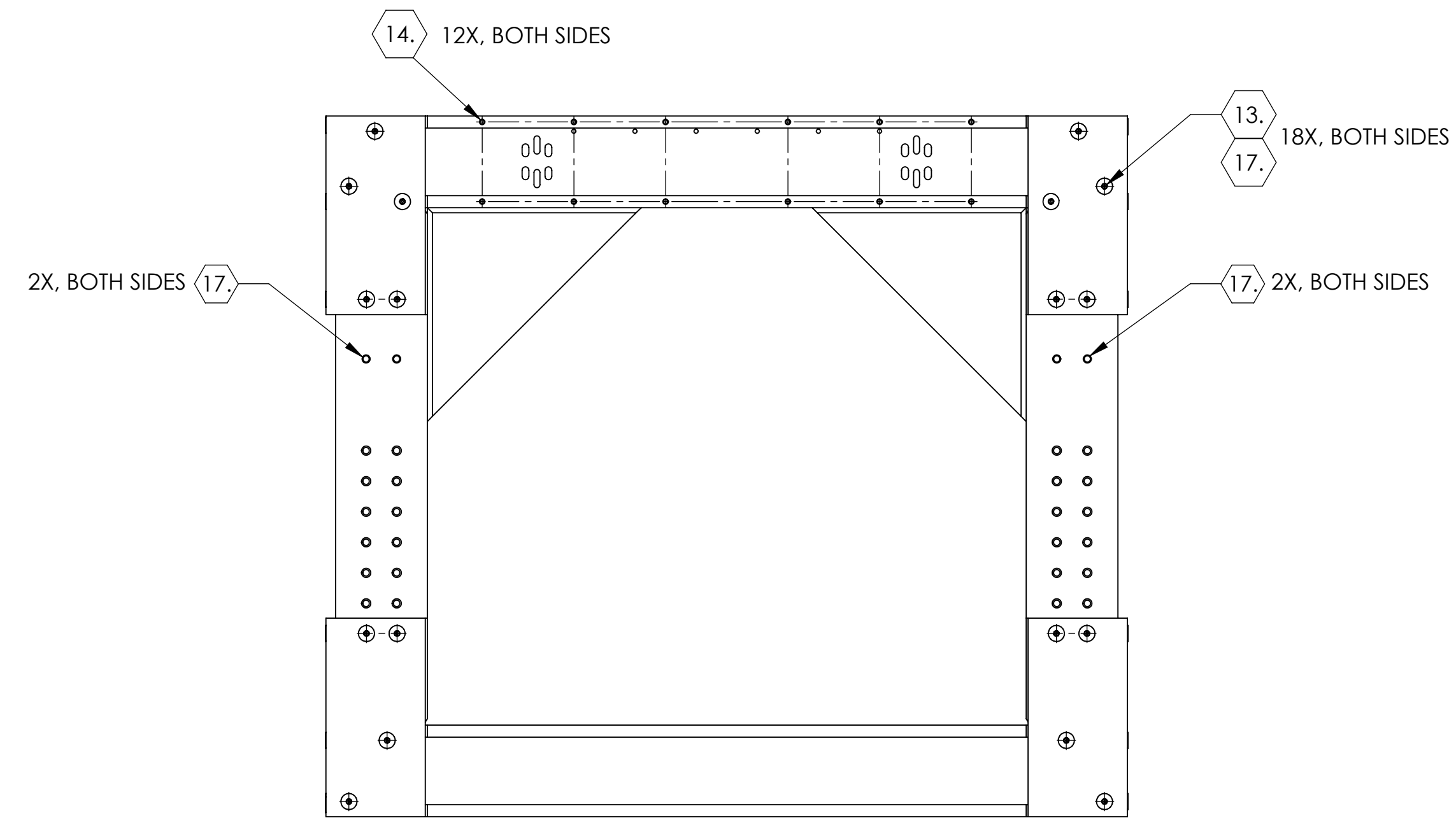
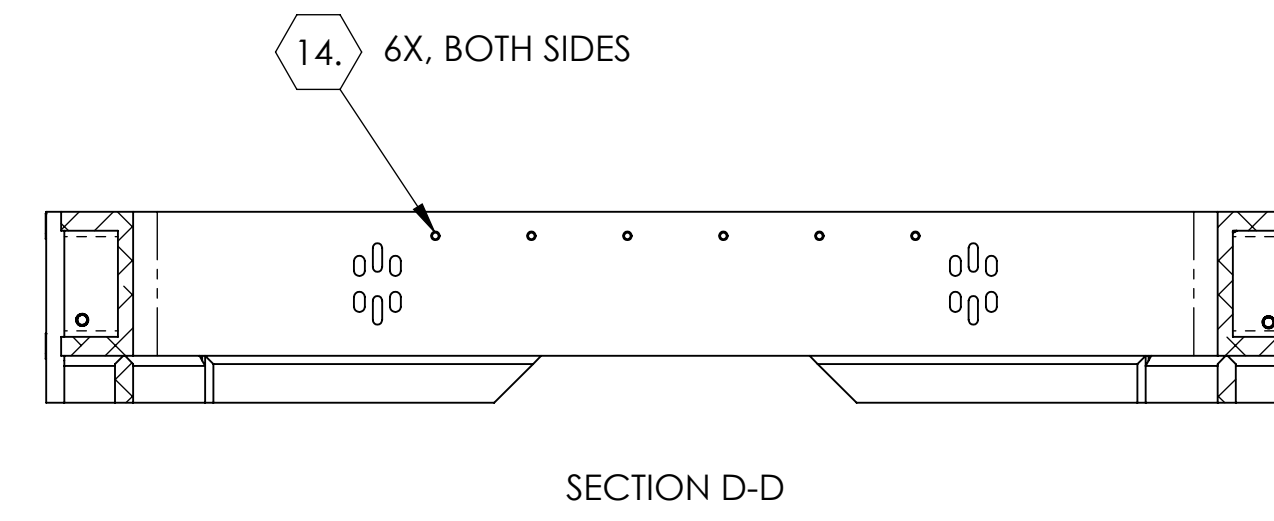
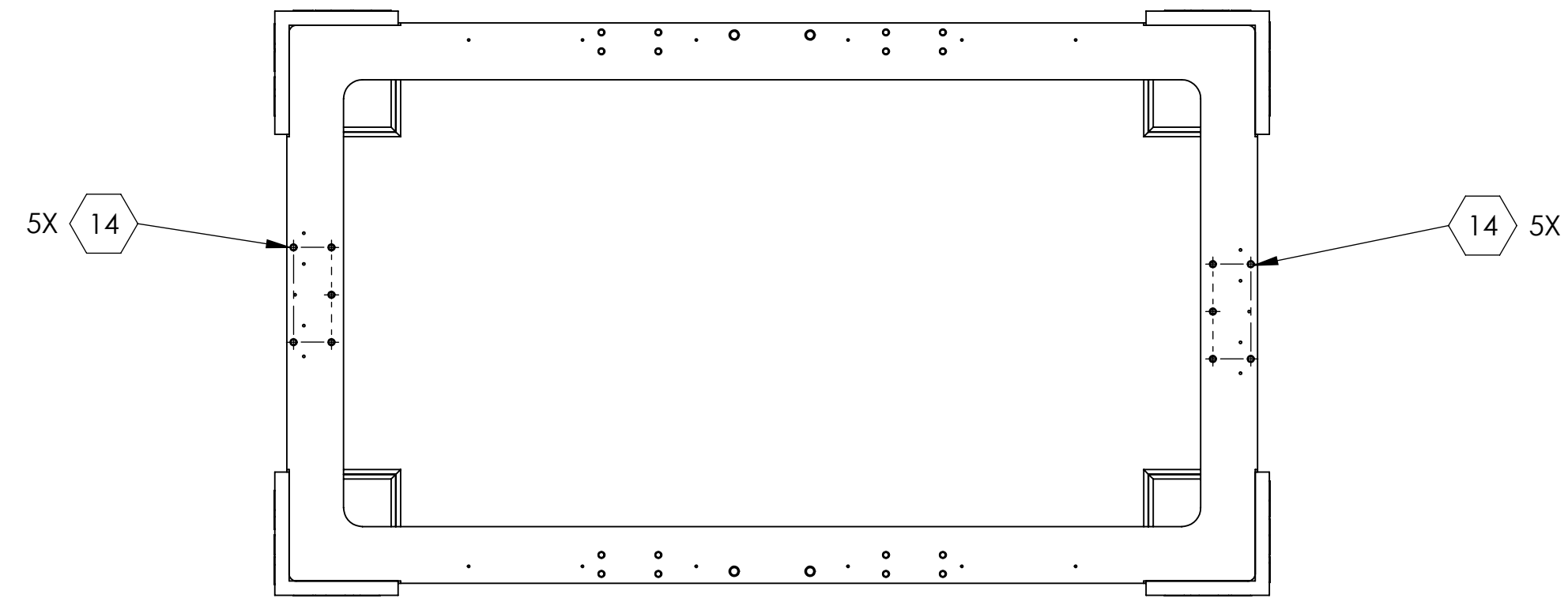


ADDITIONAL NOTES:

5. MATERIAL FOR BASE AND TOP, D060296-1 AND -3, SHALL BE AL ALY 6061-T6 PLATE. OUTSIDE PROFILE AND LARGE INTERIOR CUTS SHALL BE PERFORMED USING WATERJET MACHINING TECHNOLOGY.
6. MATERIAL FOR LEGS, D060296-2, SHALL BE AL ALY 6061-T6 3 IN X 3 IN EXTRUSION, .25 IN WALL THICKNESS.
7. MATERIAL FOR GUSSETS, D060296-4 AND -5, SHALL BE AL ALY 6061-T6 PLATE, .375 IN THICK.
8. SUGGESTED SOURCE OF SUPPLY FOR ITEM 7: McMASTER-CARR, (562) 463-4277, www.mcmaster.com.
9. SUGGESTED SOURCE OF SUPPLY FOR ITEM 8: AIR HARDWARE, 12675 ENCINTAS AVE, SYLMAR CA 91342, (877) 247-4393, www.airhardware.com.
10. INTERPRET DRAWING PER ANSI Y14.5 1994.
11. PRIOR TO WELDING, ALL PARTS SHALL BE CLEANED, VACUUM BAKED AND SEALED IN BAGS FOR DELIVERY TO THE WELDER.
12. WELDING PROCEDURES AND TECHNIQUES SHALL BE CHOSEN SO THAT FULL PENETRATION WELDS ARE ACHIEVED IN ALL LOCATIONS, WITH NO INCLUSIONS OR SIGNIFICANT GAS POCKETS. A REASONABLE ATTEMPT TO ACHIEVE CLASS A WELDS PER MIL-STD-2219 SHALL BE MADE. NO DYE PENETRANTS MAY BE USED DURING ANY STAGE OF THIS PROCESS.
13. MATCH DRILL CORNER BRACE (D060296-6) AND WELDED STRUCTURE APPROXIMATELY WHERE SHOWN, ENSURING MINIMUM THREAD DEPTH SPECIFIED BELOW. DRILL AND TAP WELDED STRUCTURE FOR ITEM 9, 1/4-20 HELICOIL. .43 MIN FULL THD DEPTH.  $\checkmark$   $\phi$ .265 X 82°. DRILL  $\phi$ .06 VENT HOLE THRU STRUCTURE IN LINE WITH TAPPED HOLE. DRILL AND COUNTERSINK CORNER BRACE  $\phi$ .257 THRU.  $\checkmark$   $\phi$ .507 X 82°.
14. INSTALL ITEM 8, #8-32 HELICOILS, IN INDICATED LOCATIONS AFTER CLEANING AND BAKING.
15. AFTER WELDING, MACHINE INDICATED SURFACES TO ACHIEVE NOTED DIMENSIONS.
16. ESTIMATED WEIGHT FROM CAD MODEL: 59.8 lbs. [27.1 kg]
17. INSTALL ITEM 9, 1/4-20 HELICOILS, IN INDICATED LOCATIONS AFTER CLEANING AND BAKING.

ITEM NO.	PART NUMBER	DESCRIPTION	MATL	QTY
9	1185-4EN375	1/4-20 X .375" LONG HELICOIL	NITRONIC 60	AR
8	1185-2EN328	#8-32 X .328" LONG HELICOIL	NITRONIC 60	AR
7	90585A540	SCREW, COUNTERSUNK HEAD CAP SCREW, 1/4-20 X 5/8" LG	316 SS TL	68
6	D060296-6	CORNER BRACE, OMC STRUCTURE WELDMENT	AL ALY 6061-T6	8
5	D060296-5	GUSSET, 7" X 4", OMC STRUCTURE WELDMENT	(7)	4
4	D060296-4	GUSSET, 7" X 7", OMC STRUCTURE WELDMENT	(7)	4
3	D060296-3	TOP, OMC STRUCTURE WELDMENT	(5)	1
2	D060296-2	LEG, OMC STRUCTURE WELDMENT	(6)	4
1	D060296-1	BASE, OMC STRUCTURE WELDMENT	(5)	1

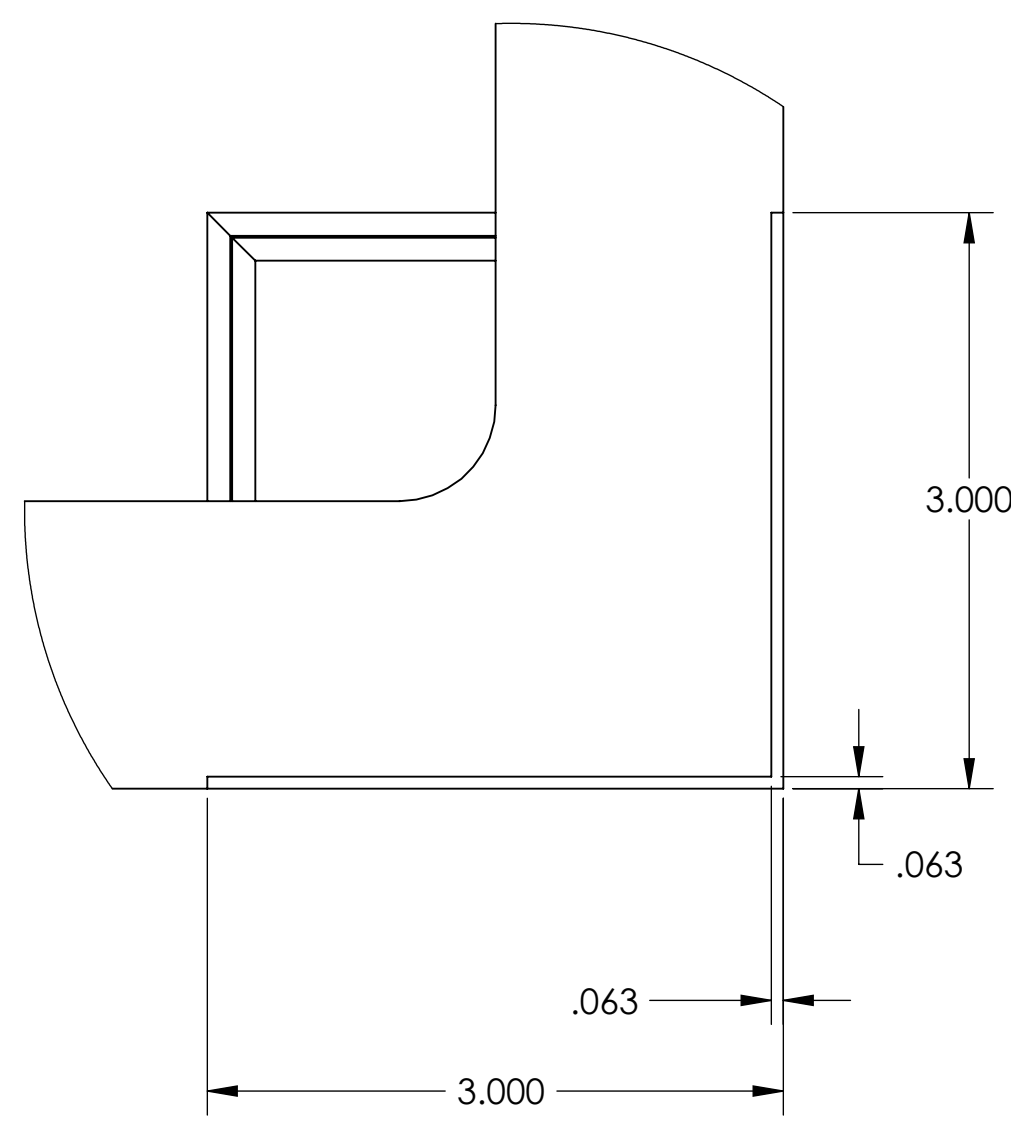
NOTES (UNLESS OTHERWISE SPECIFIED)		PARTS LIST	
1. DO NOT SCALE FROM DRAWING.	DIMENSIONS ARE IN INCHES	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MICHIGAN STATE UNIVERSITY IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
2. REMOVE ALL SHARP EDGES, R.02 MAX.	TOLERANCES: X ± 0.1 XX ± 0.01 XXX ± 0.005 ANGULAR ± 0.5°	SYSTEM ADVANCED LIGO	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.	MATERIAL ALL ALY 6061-T6	SUB-SYSTEM SUS	
4. SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING DIMENSIONS OR PART NUMBERS, REV. AND DASH NO. ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER, SERIAL NUMBERS SHALL AS 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE 17" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLES:	FINISH N/A	NEXT ASSY D060306	
D060296-2-A 3/29/007	DRAWN C. RICHARDS CHECKED J. BROWN STRESS C. TORRE ENGR C. TORRE	NAME DATE C. RICHARDS 17 DEC 2008	PART NAME STRUCTURE WELDMENT, OUTPUT MODE CLEANER
	SCALE: 1:2	PROJECTION:	SHEET 1 OF 7



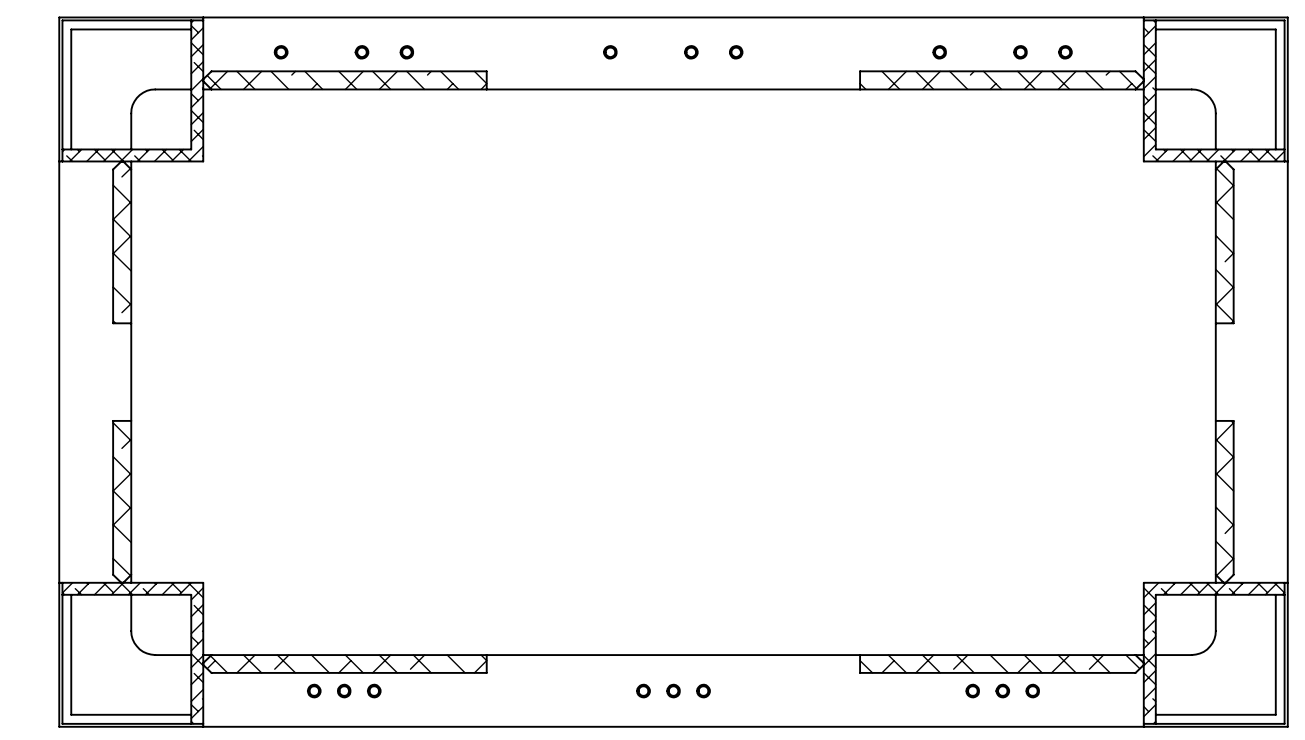
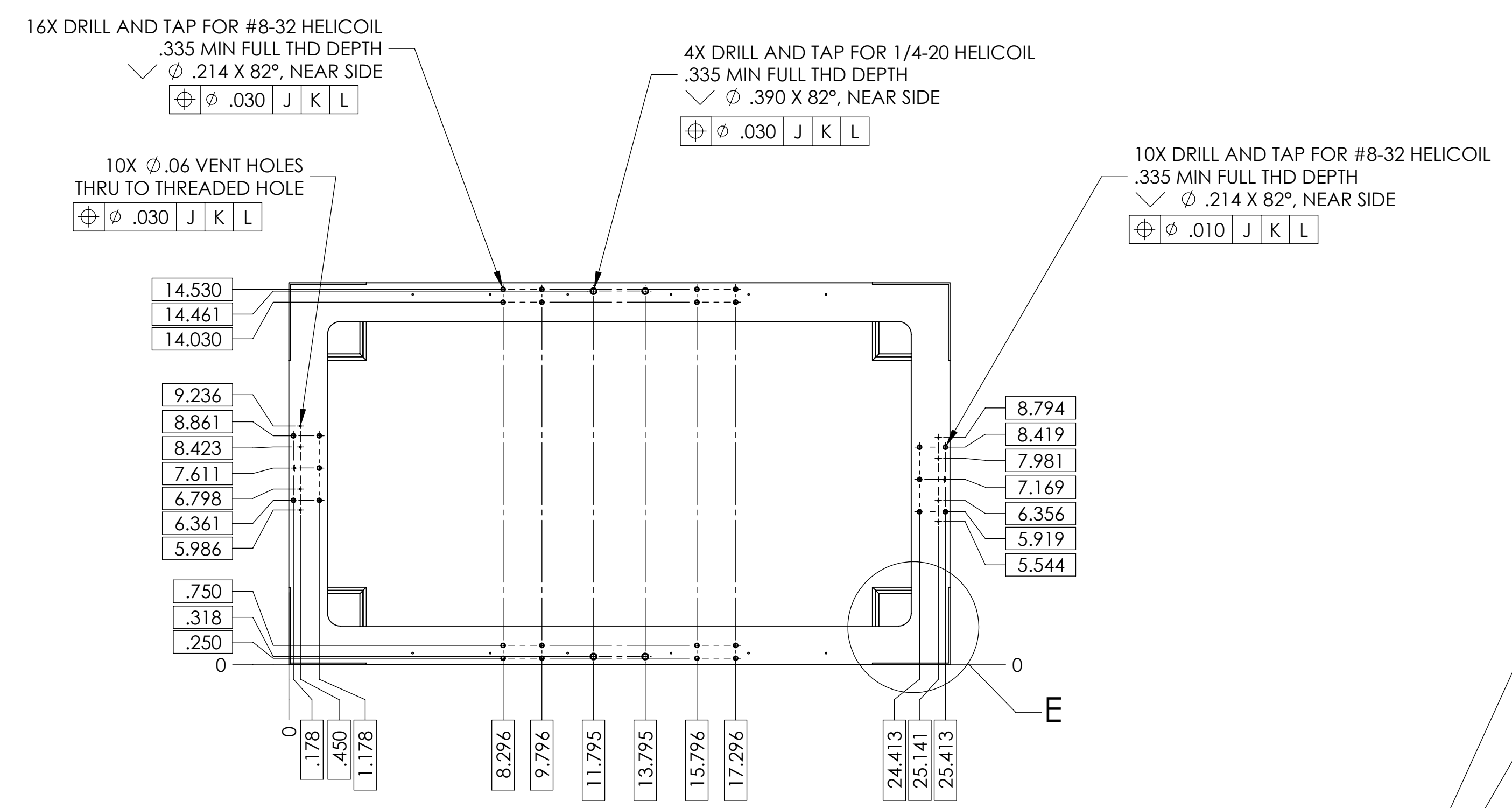
FINAL MACHINING AND ASSEMBLY

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 400 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D060306
PART NAME STRUCTURE WELDMENT, OUTPUT MODE CLEANER	
SIZE	D
DWG. NO.	D060296
SCALE	1:4
PROJECTION	
REV.	A
SHEET 2 OF 7	

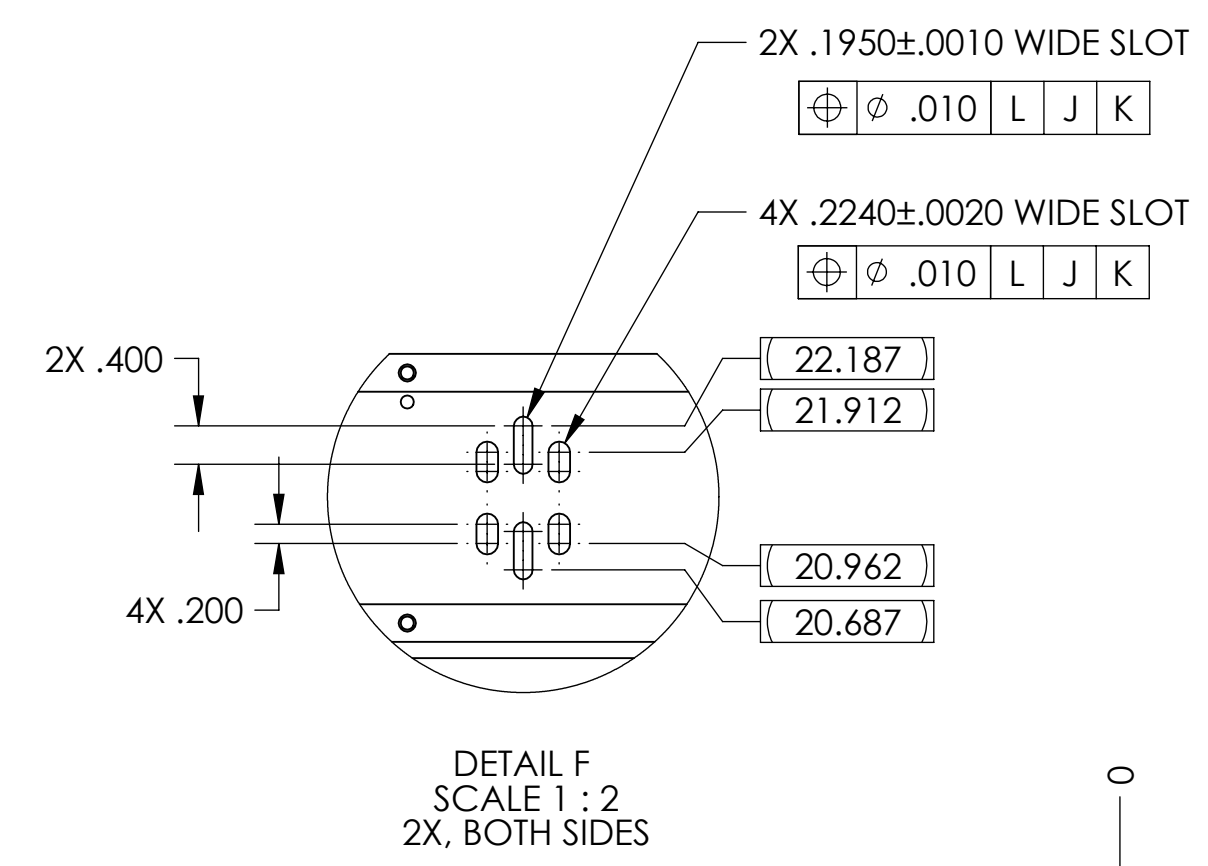
DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± 0.01  
 .XXX ± 0.005  
 ANGULAR ± 0.5°



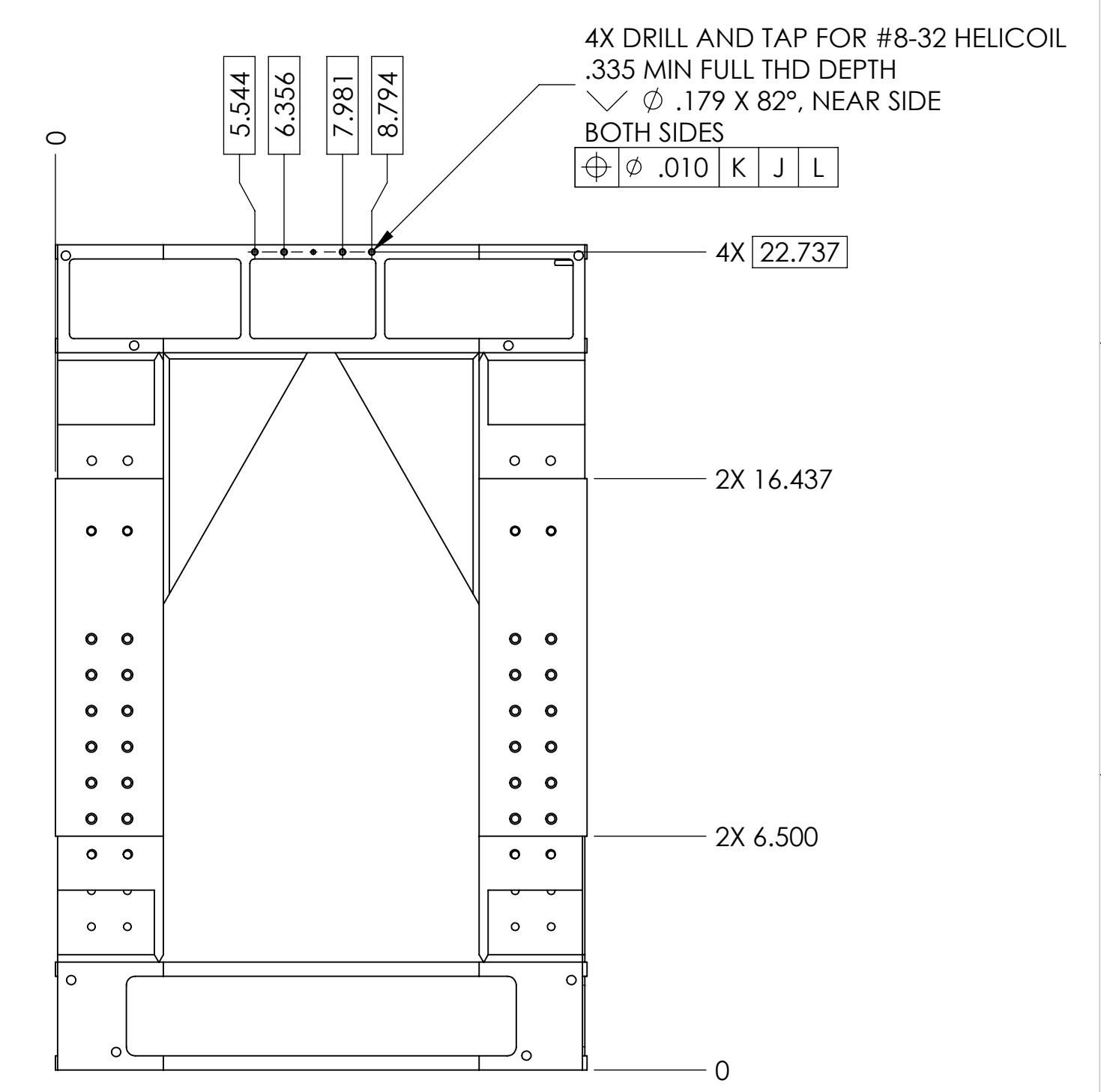
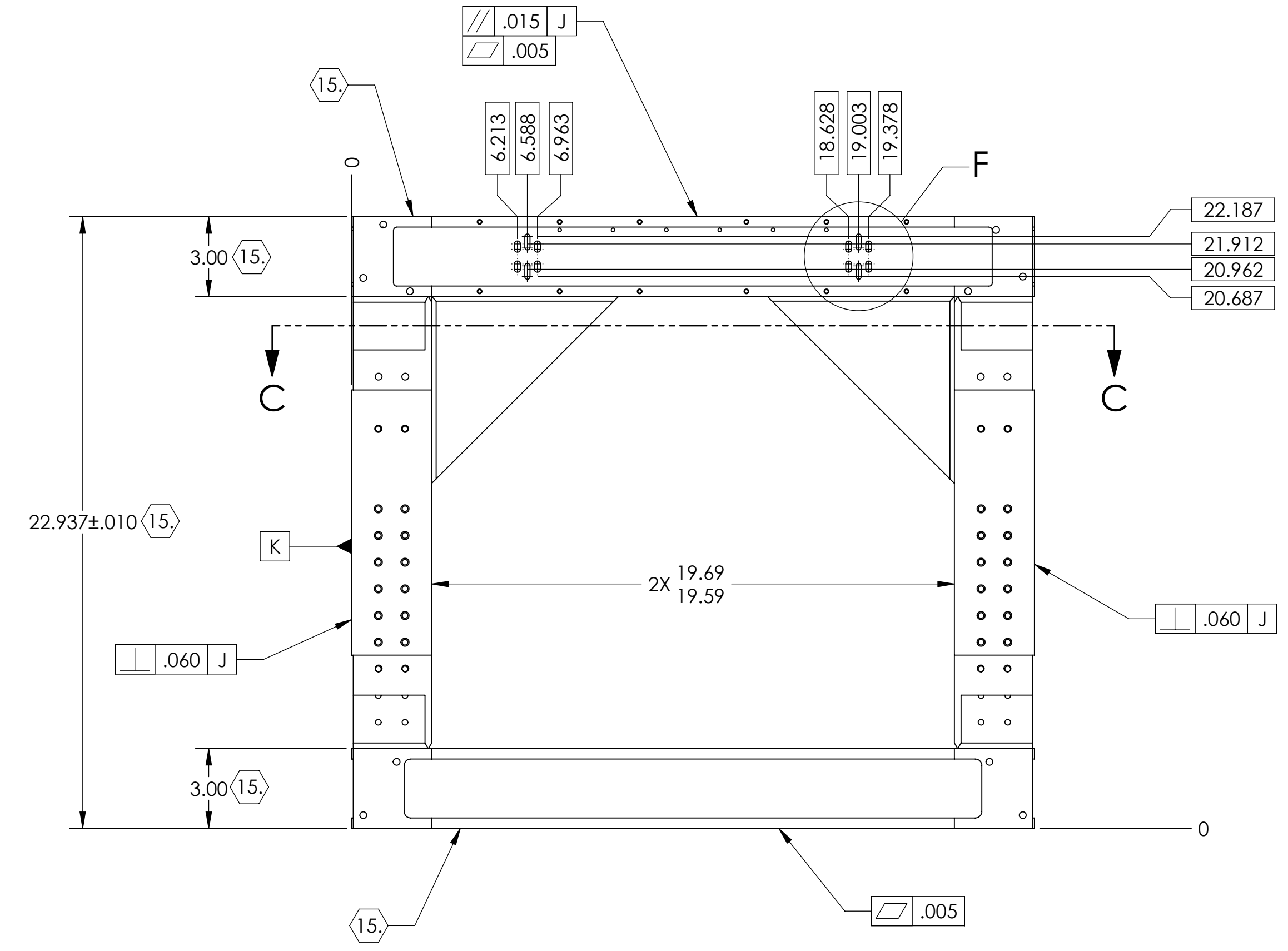
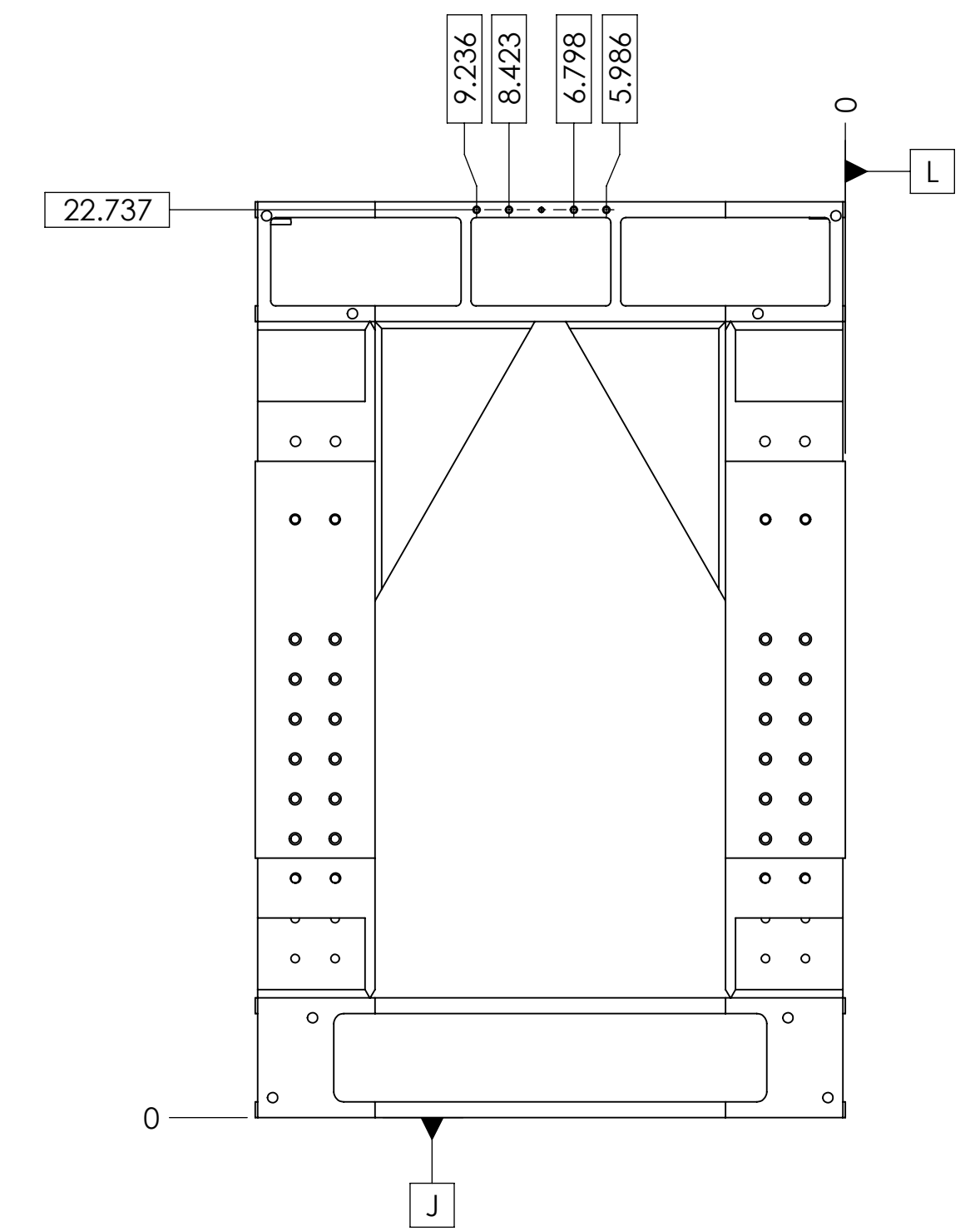
DETAIL E  
SCALE 1 : 1



SECTION C-C

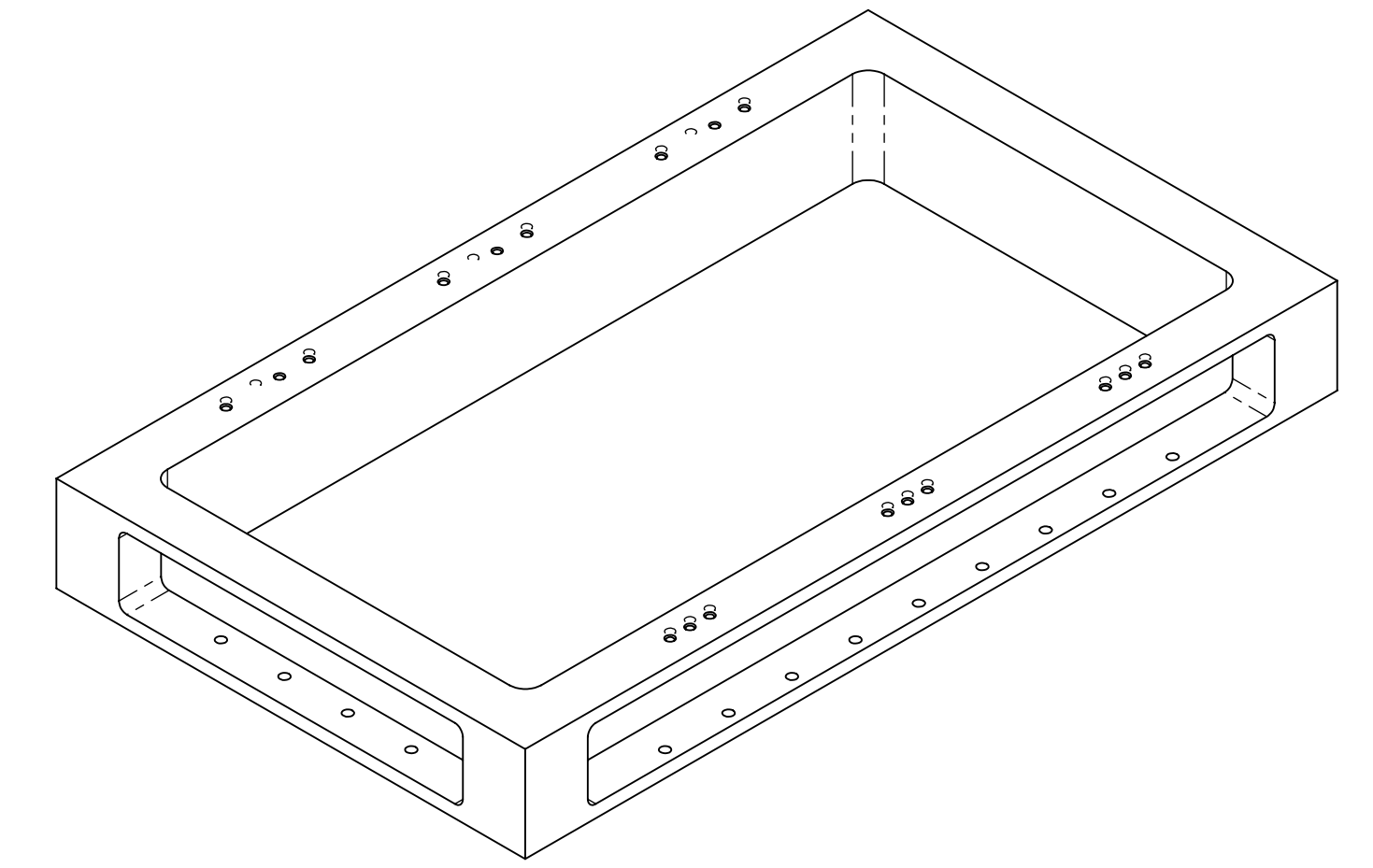
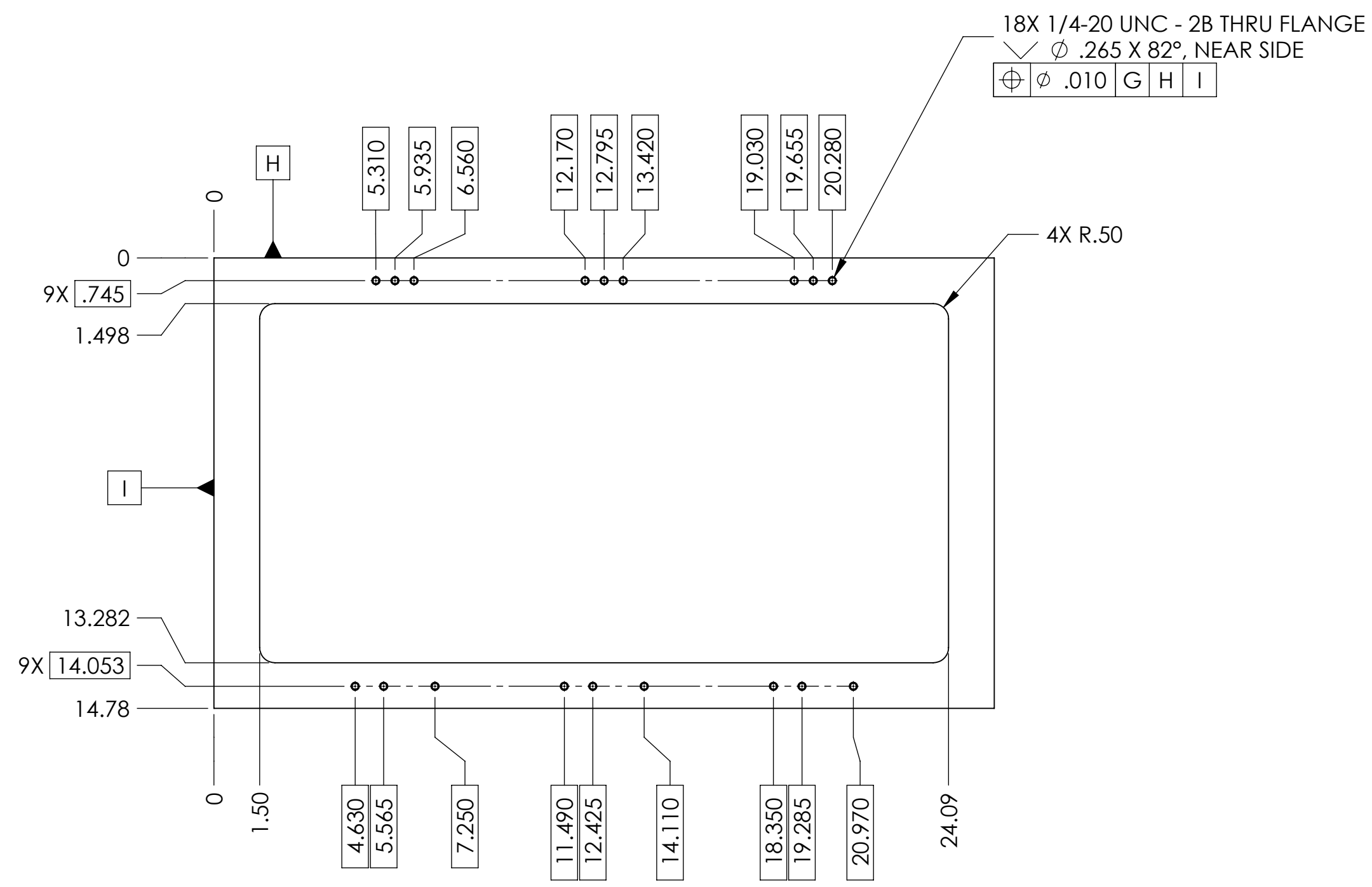


DETAIL F  
SCALE 1 : 2  
2X, BOTH SIDES

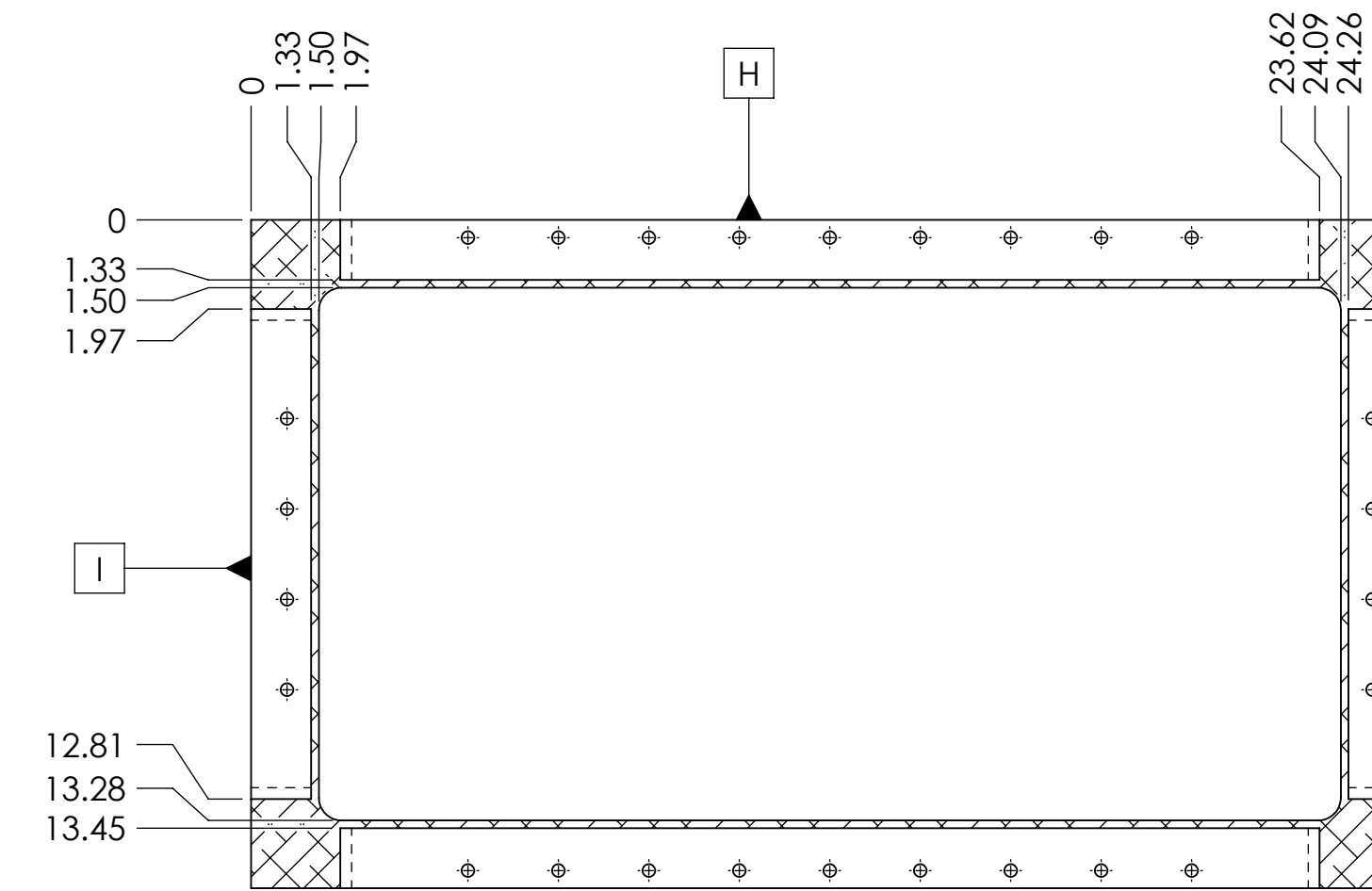
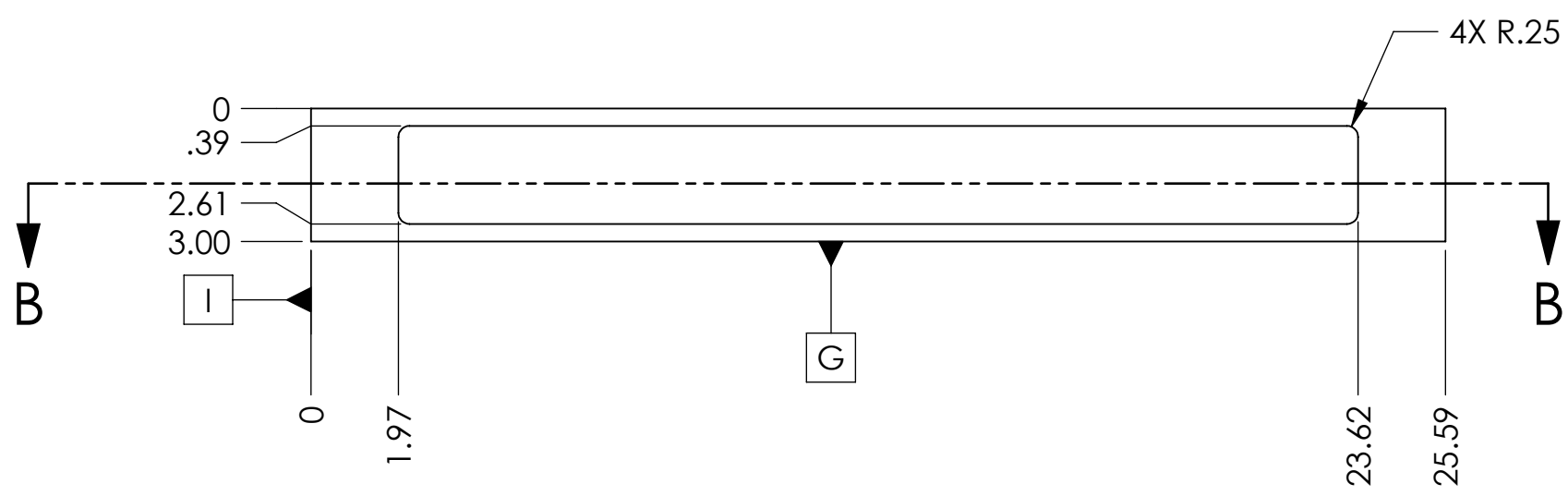


POST-WELD MACHINING

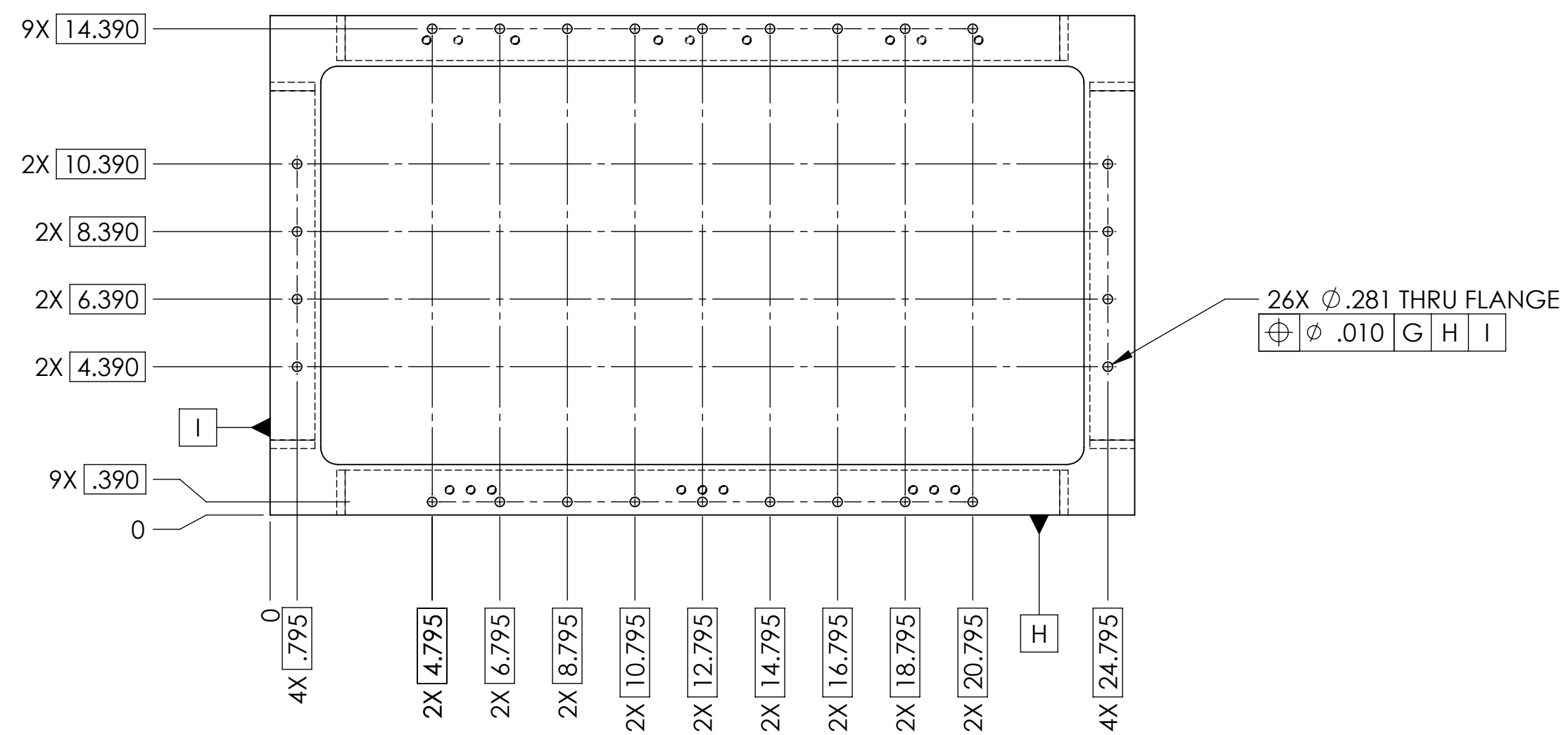
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 400 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D060306
PART NAME	STRUCTURE WELDMENT, OUTPUT MODE CLEANER
SIZE	DWG. NO. <b>D060296</b>
SCALE	1:4
PROJECTION	
REV.	A
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .001 .XXX ± 0.005 ANGULAR ± 0.5°	
SHEET 3 OF 7	



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



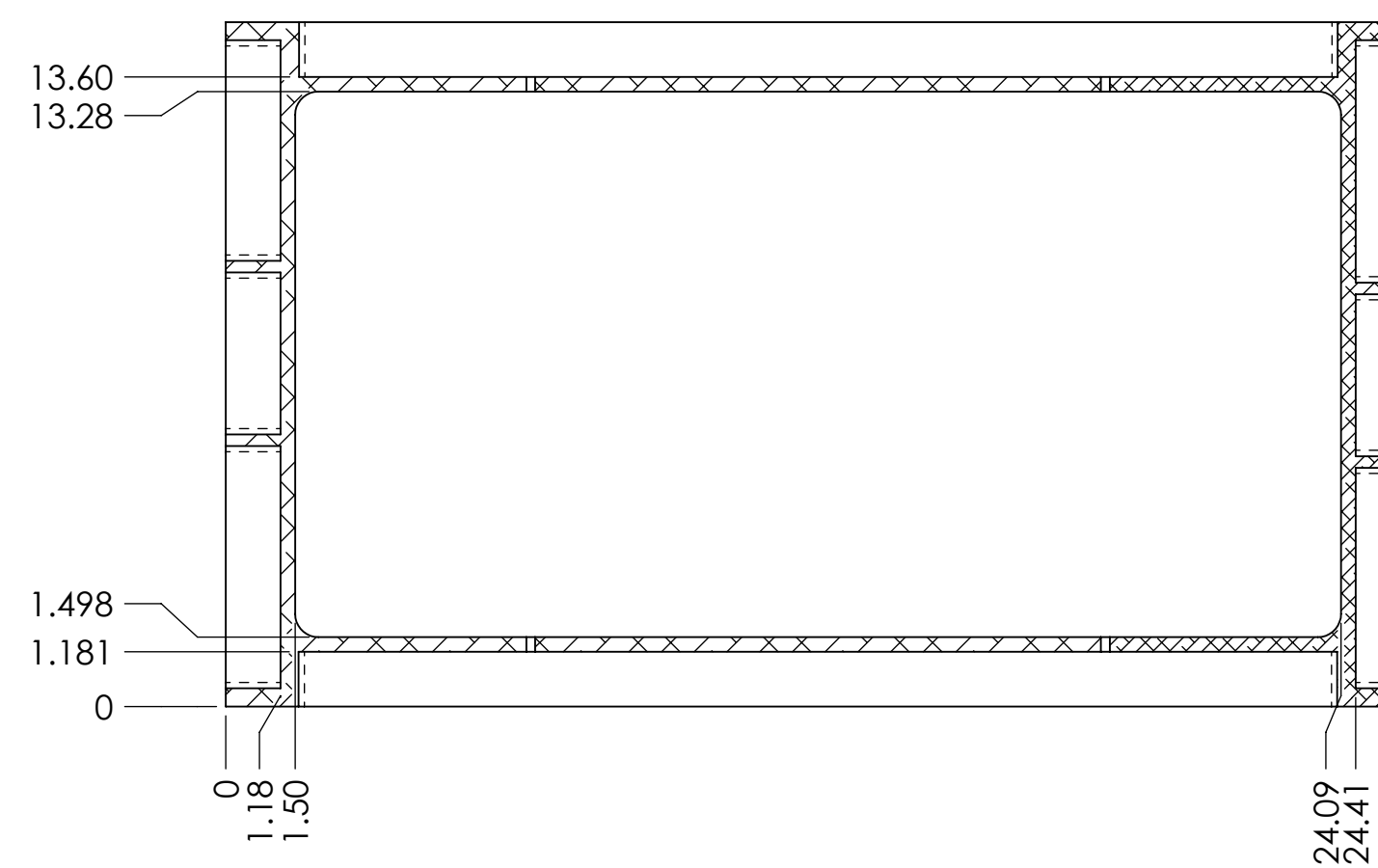
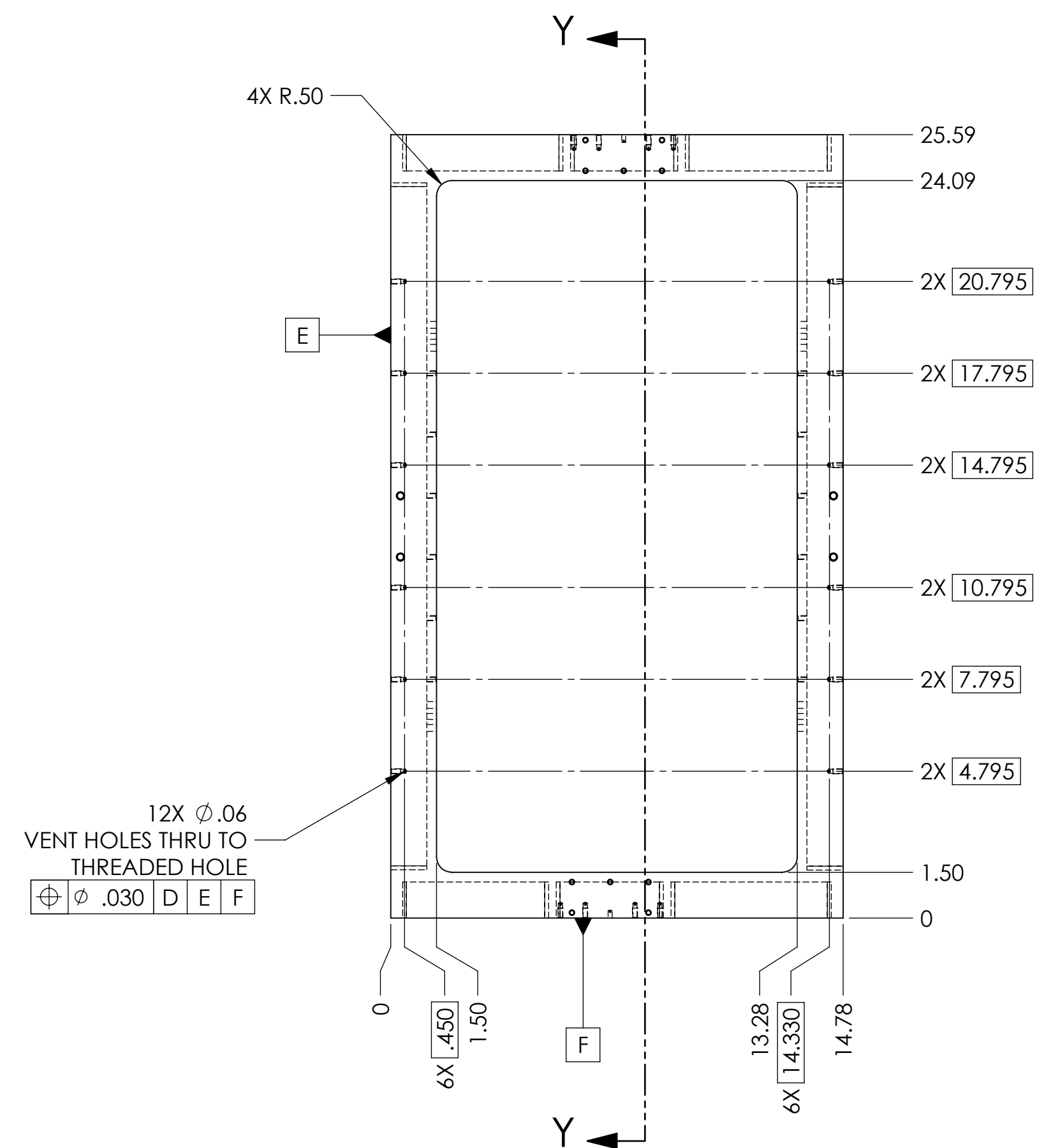
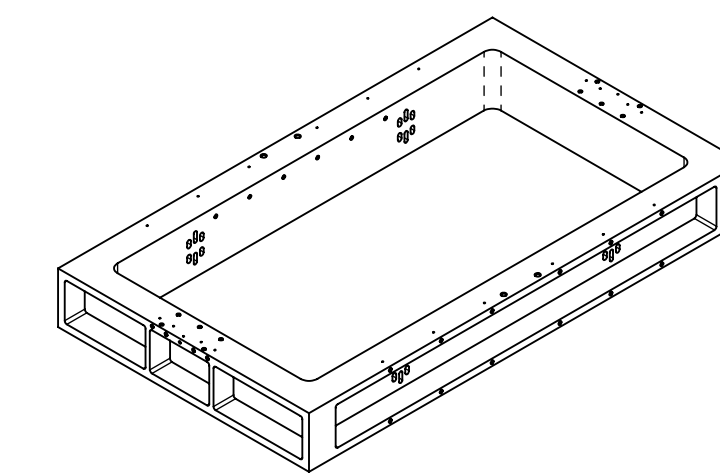
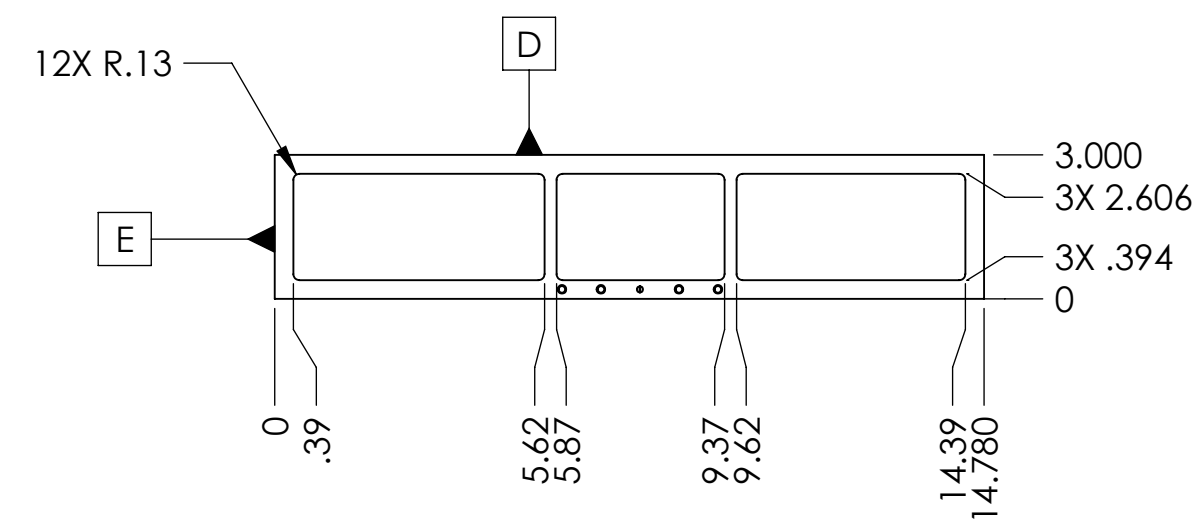
SECTION B-B



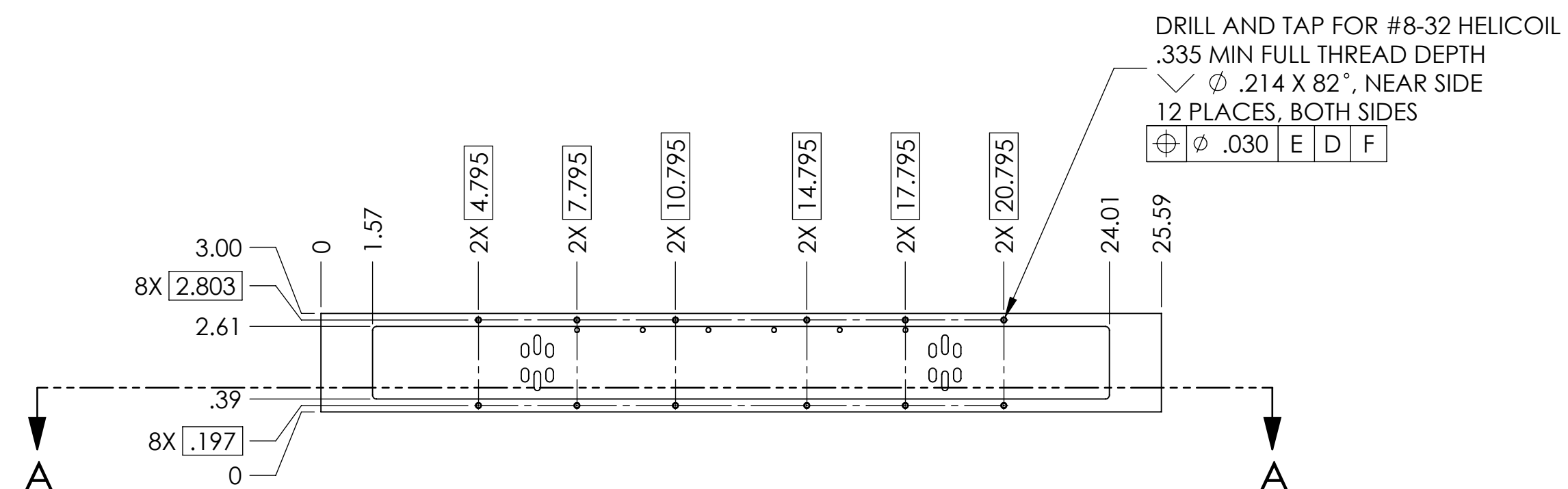
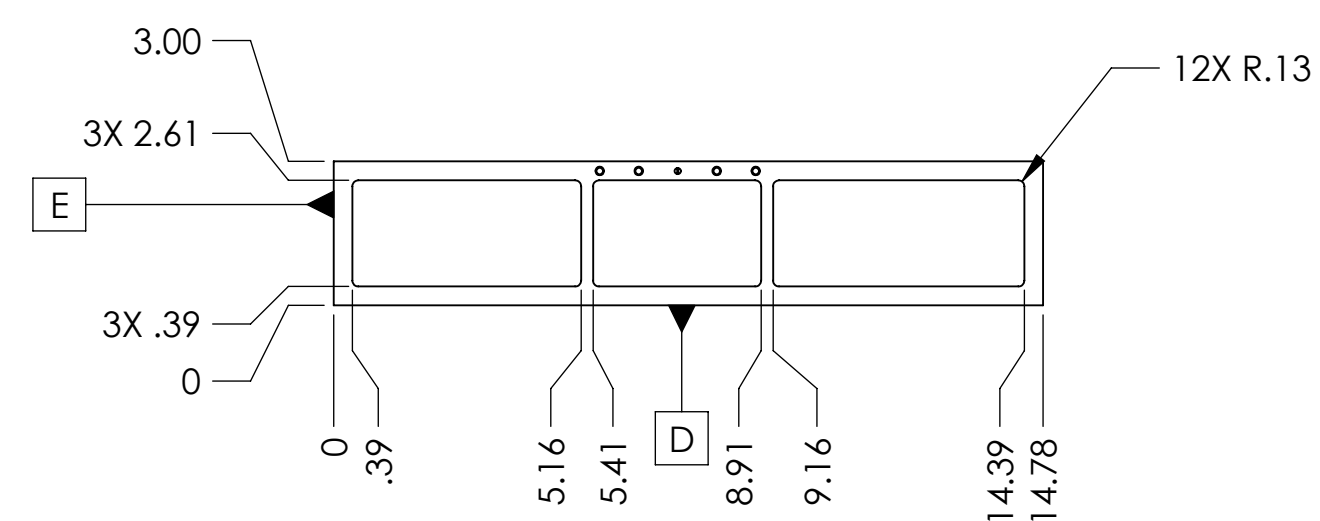
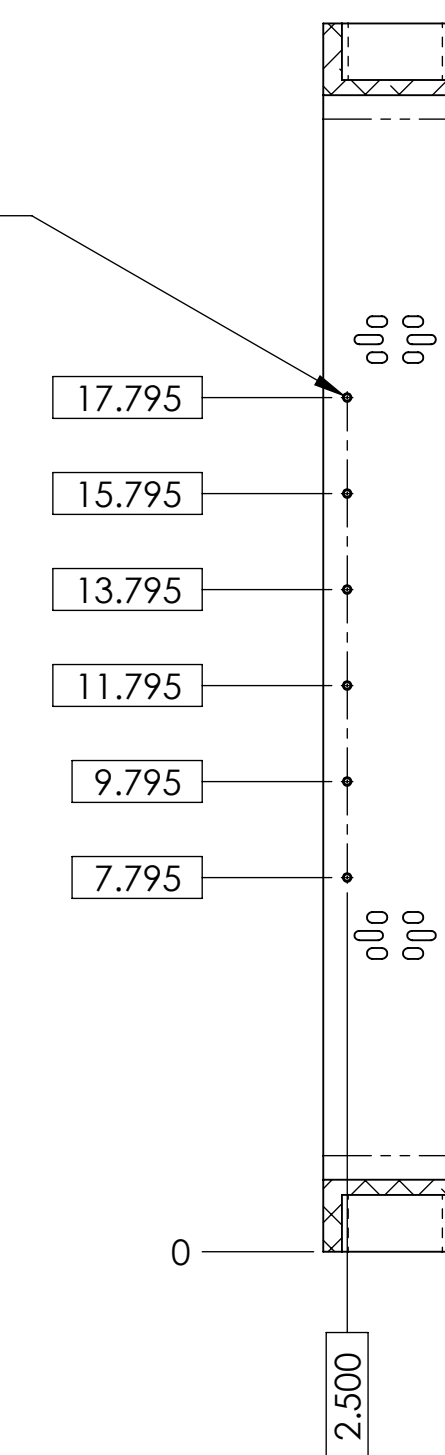
D060296-1  
BOTTOM

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± 0.01  
 .XXX ± 0.005  
 ANGULAR ± 0.5°

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 400 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D060306
PART NAME	STRUCTURE WELDMENT, OUTPUT MODE CLEANER
SIZE	DWG. NO. <b>D060296</b>
SCALE	1:4
PROJECTION	
REV.	A
SHEET 4 OF 7	

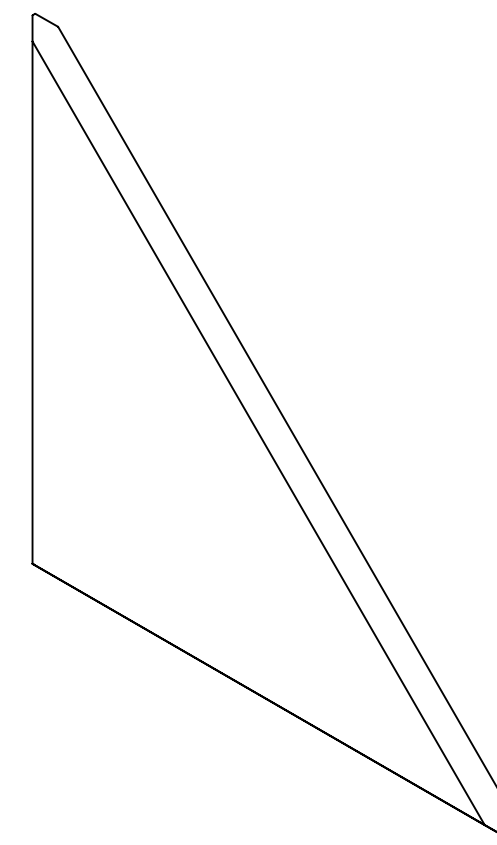
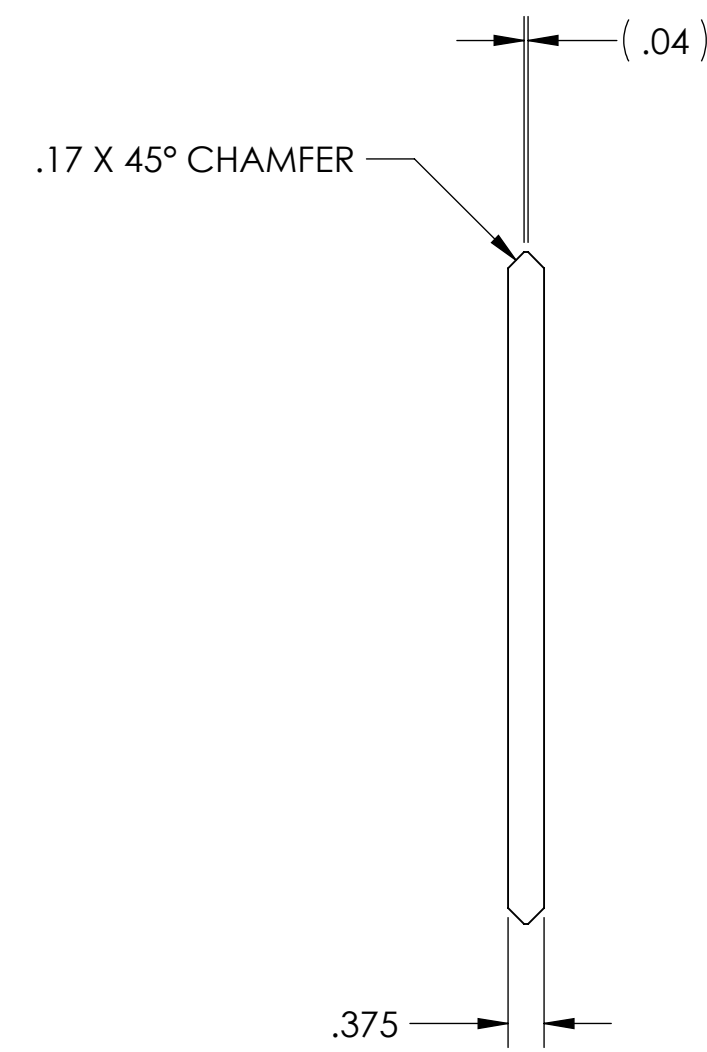
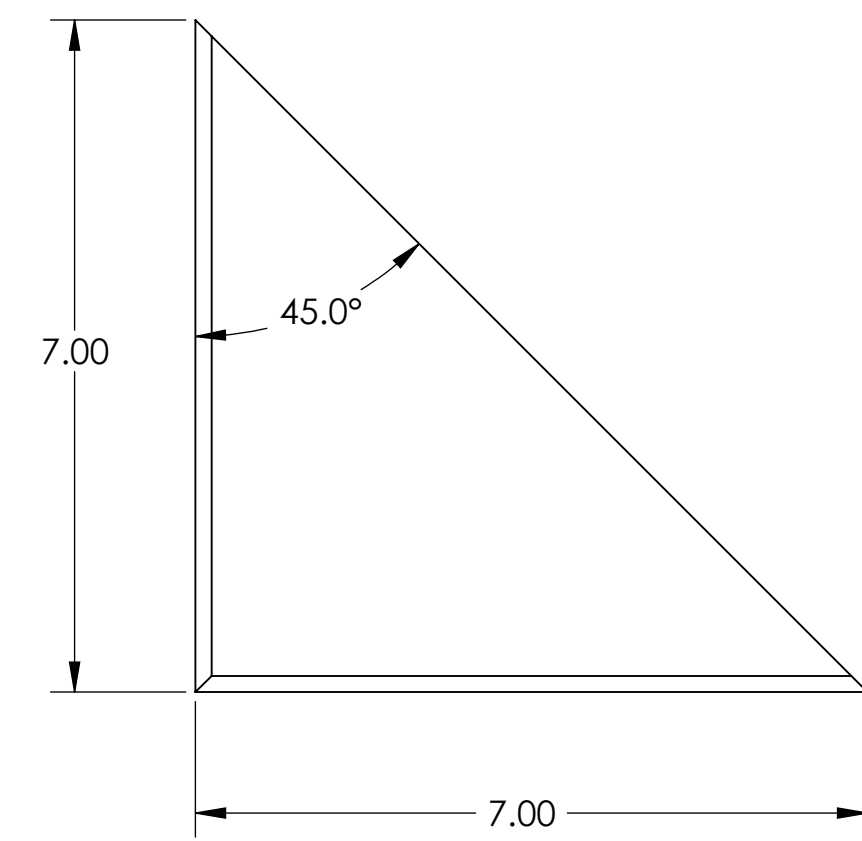


DRILL AND TAP FOR #8-32 HELICOIL, THRU WALL  
 $\phi$ .214 X 82°, NEAR SIDE  
 6 PLACES, BOTH SIDES  
 $\phi$ .030 D E F



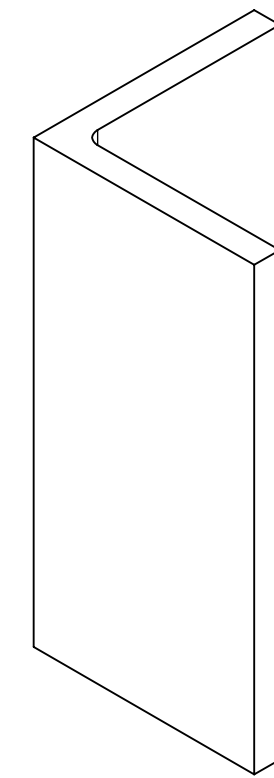
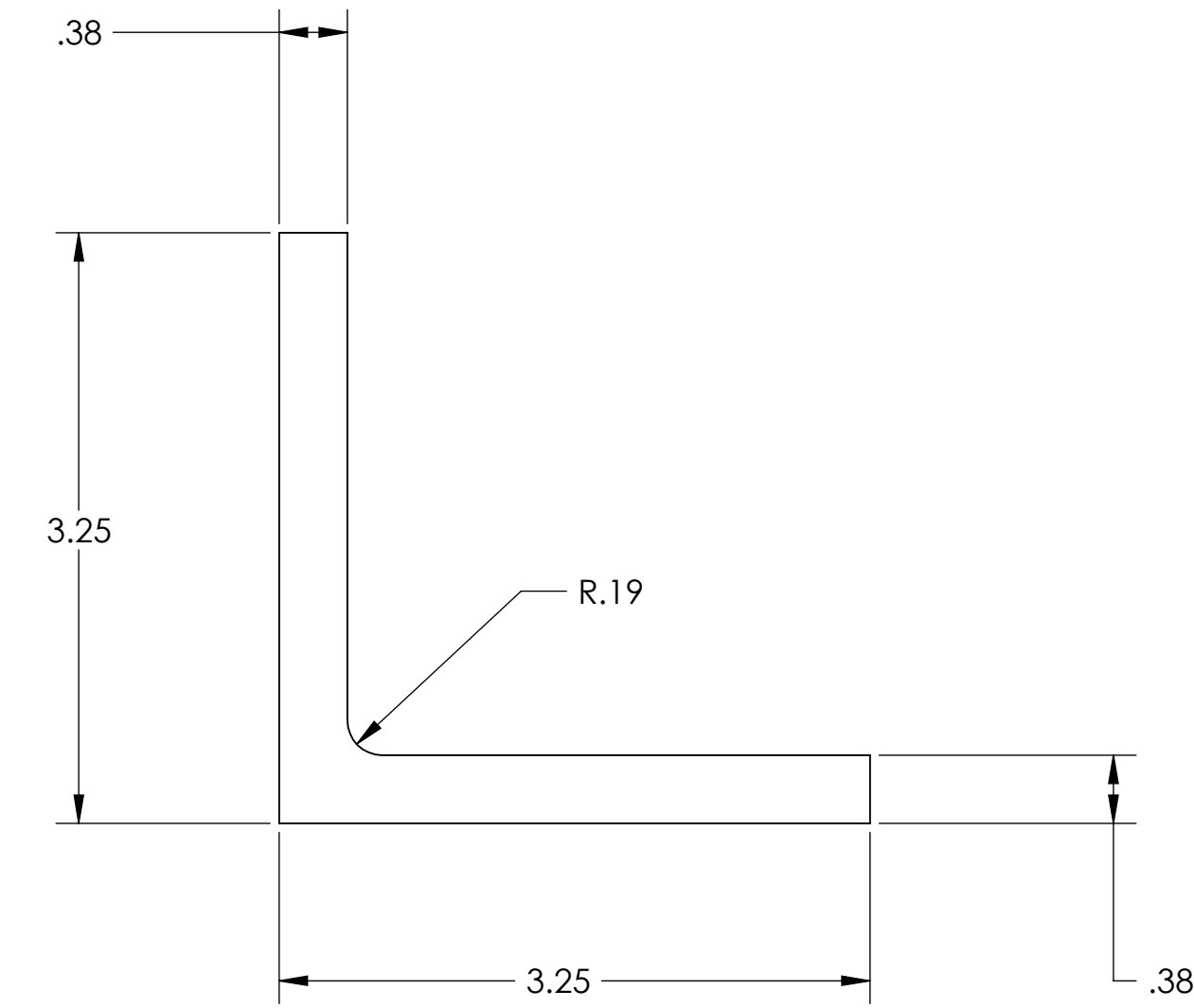
D060296-3  
 TOP

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 400 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D060306
PART NAME STRUCTURE WELDMENT, OUTPUT MODE CLEANER	
SIZE	D
DWG. NO.	D060296
SCALE	1:4
PROJECTION	1st Angle
REV.	A
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .001 .XXX ± 0.005 ANGULAR ± 0.5°	
SHEET 5 OF 7	

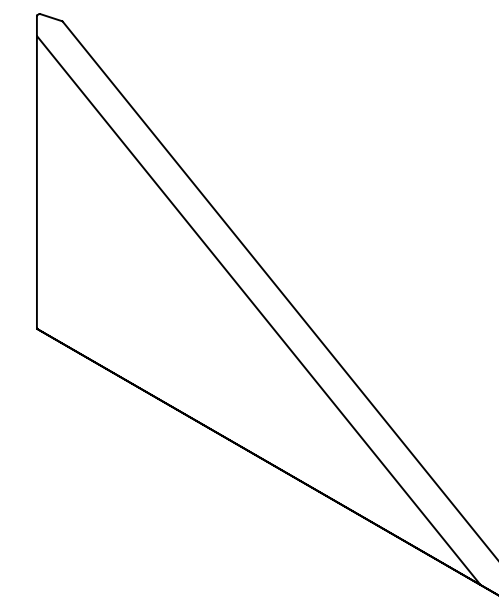
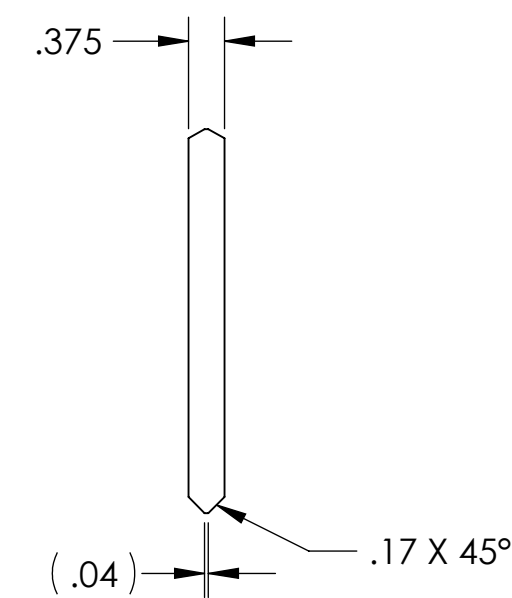
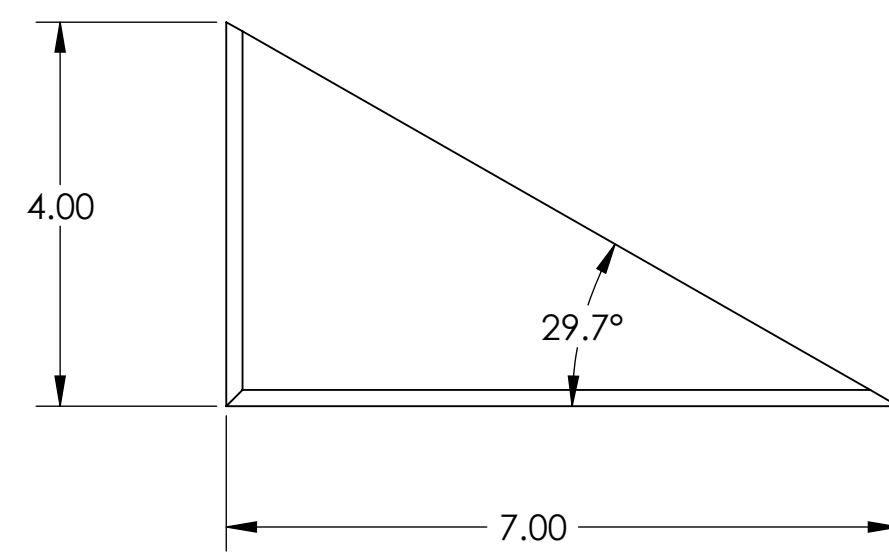


GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE

D060296-4  
7 IN X 7 IN GUSSET

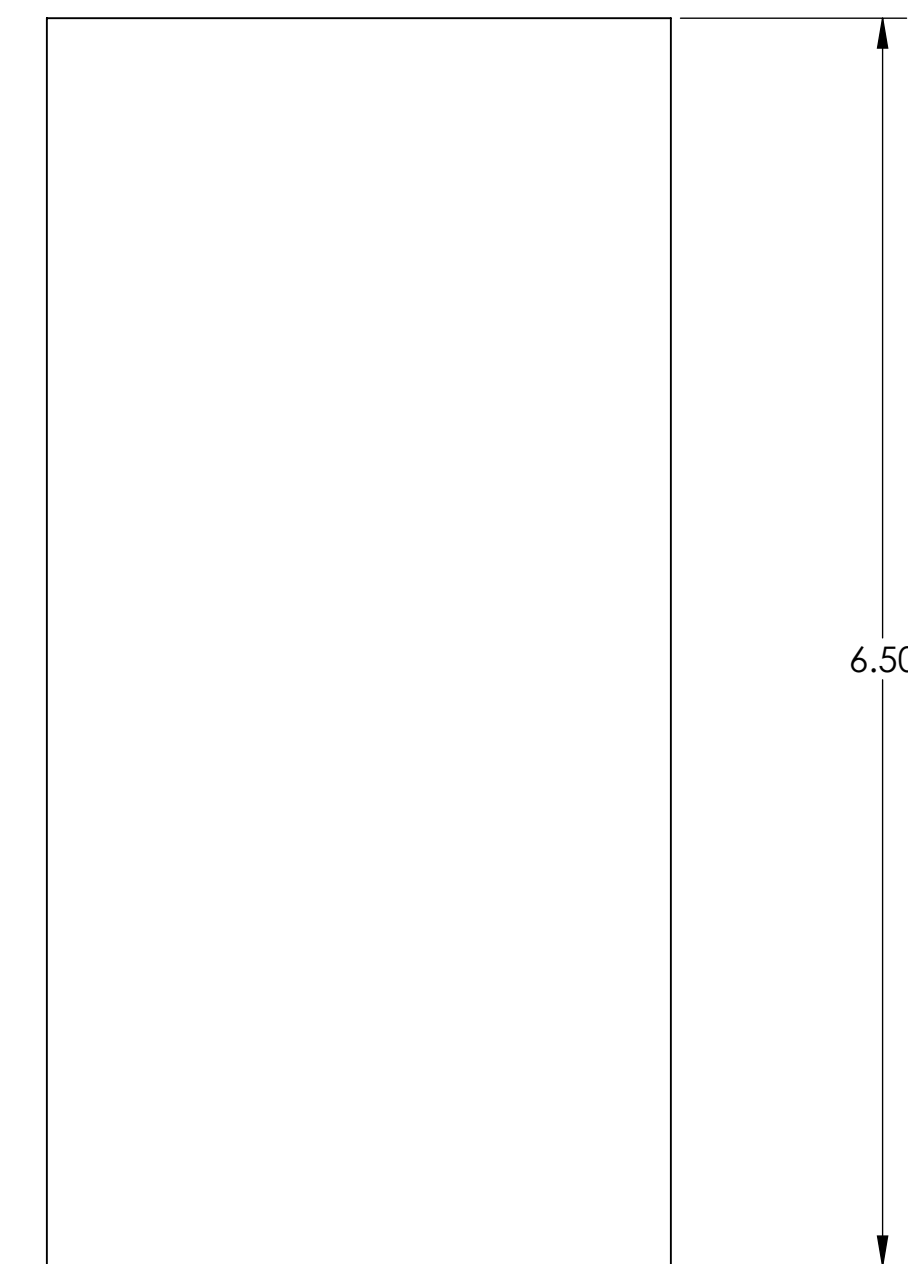


D060296-6  
CORNER BRACE



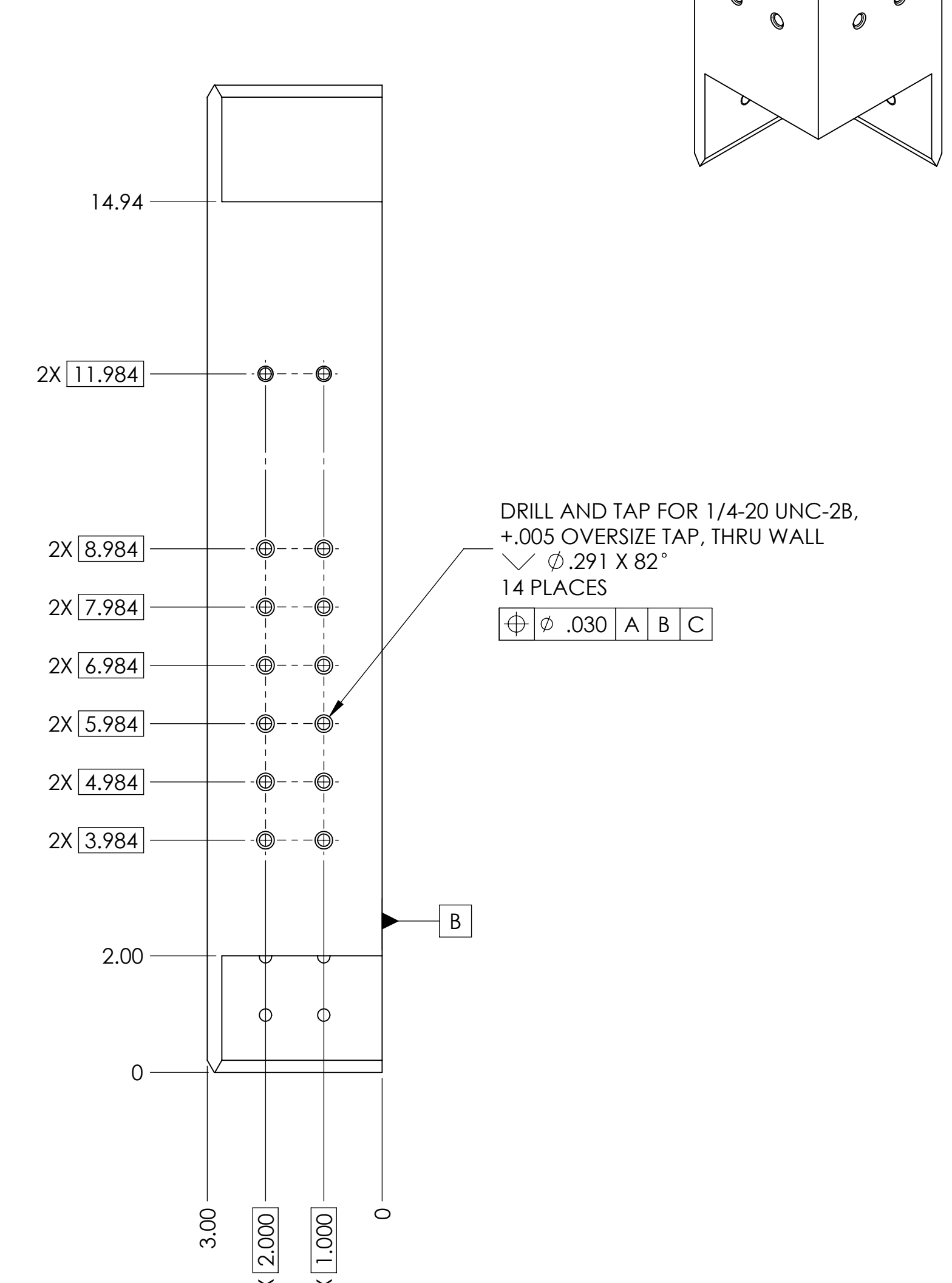
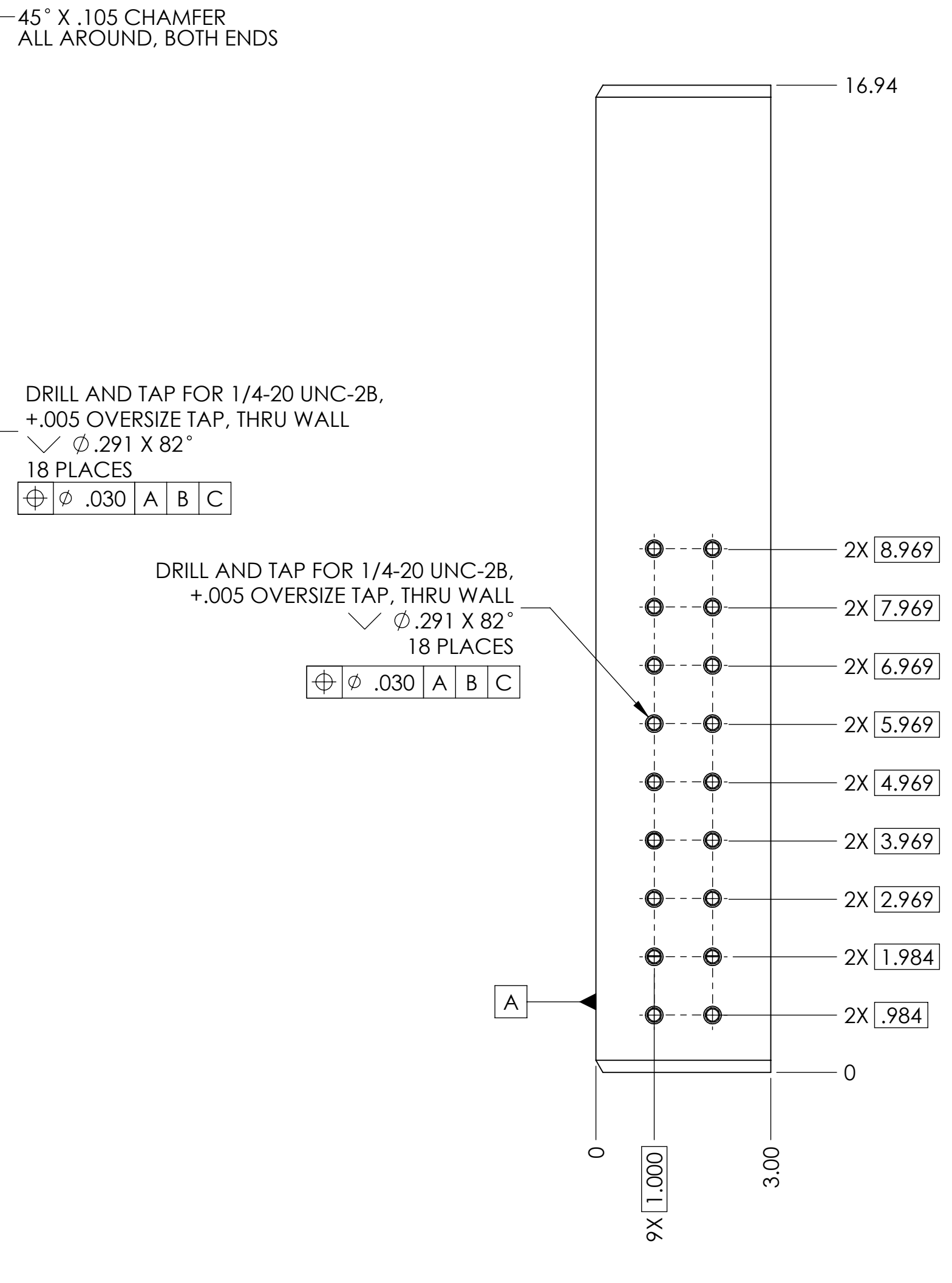
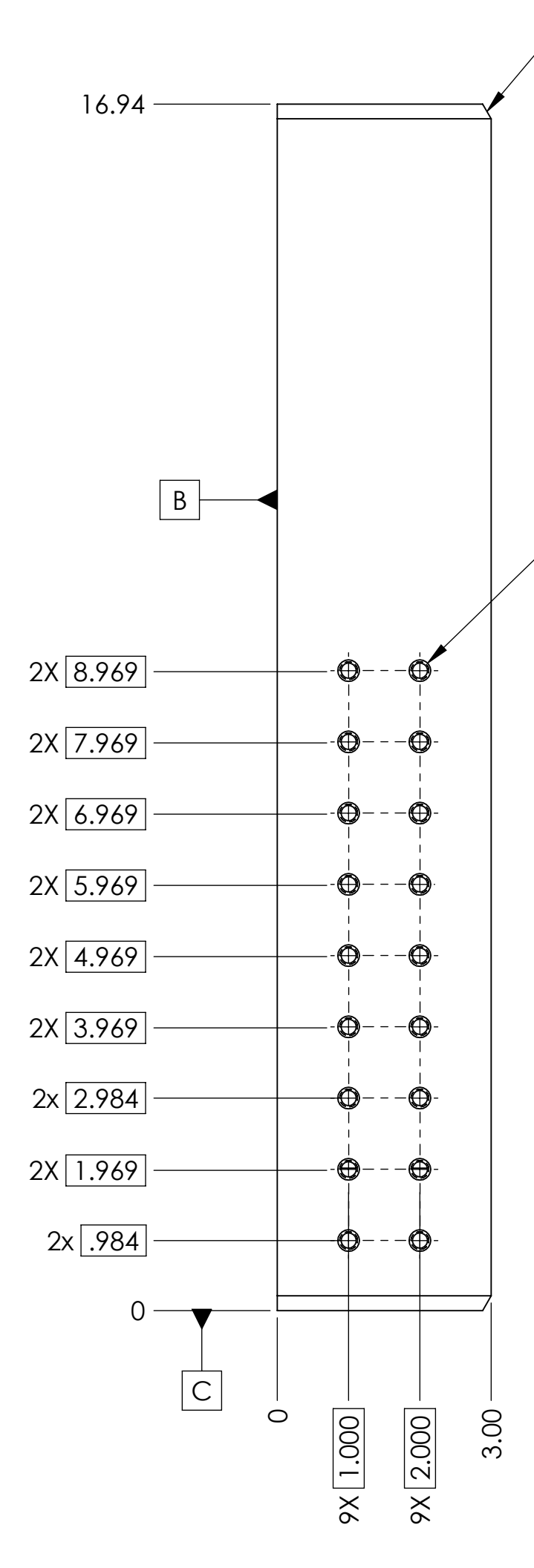
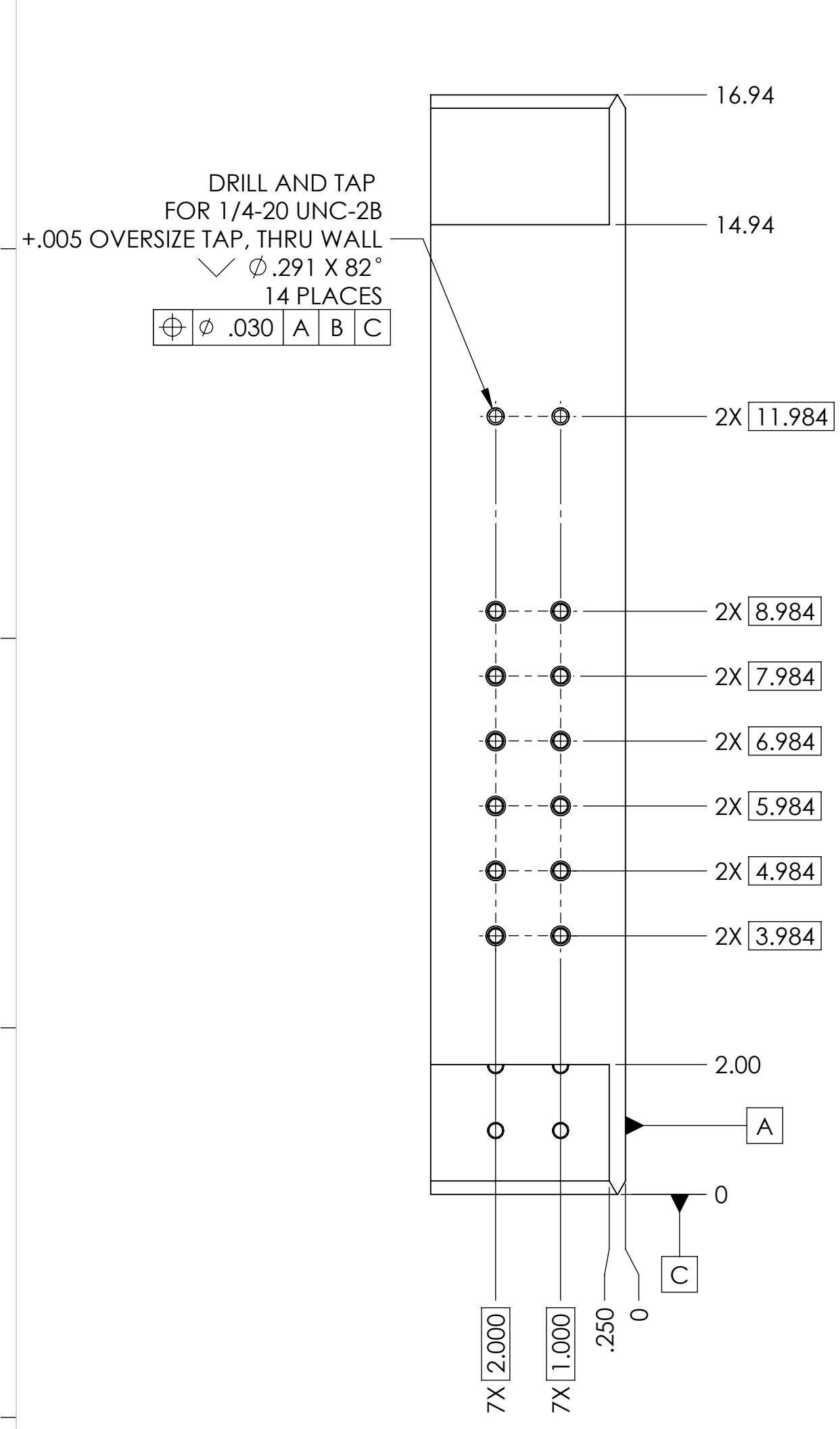
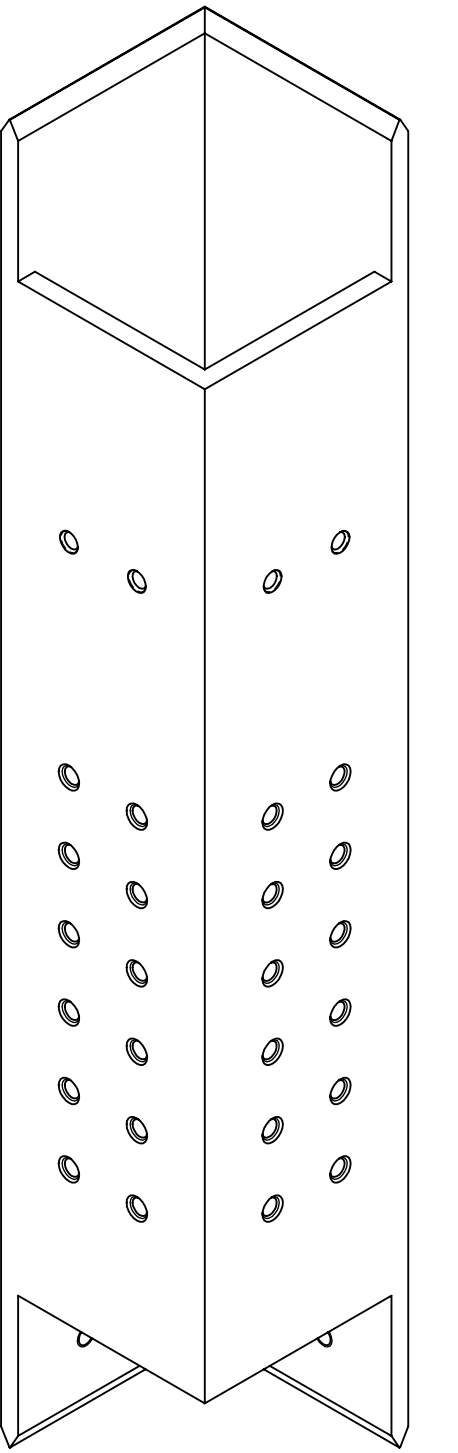
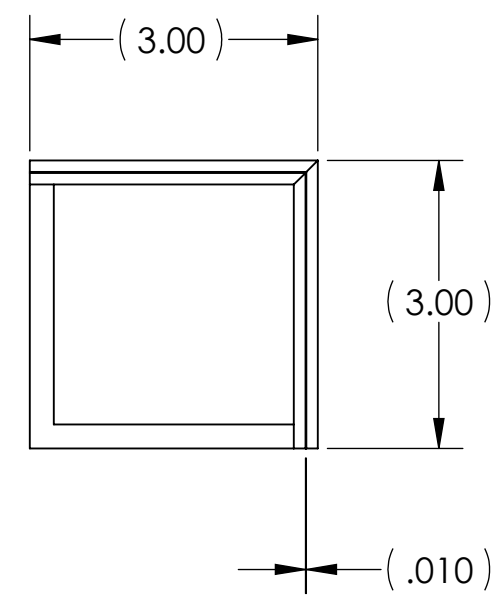
GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE

D060296-5  
4 IN X 7 IN GUSSET



DIMENSIONS ARE IN INCHES  
TOLERANCES:  
XXX ± 0.031  
XXXX ± 0.005  
ANGULAR ± 0.5 °

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 400 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D060306
PART NAME	STRUCTURE WELDMENT, OUTPUT MODE CLEANER
SIZE	D
DWG. NO.	D060296
SCALE	1:2
PROJECTION	
REV.	A
SHEET 6 OF 7	



D060296-2  
LEG