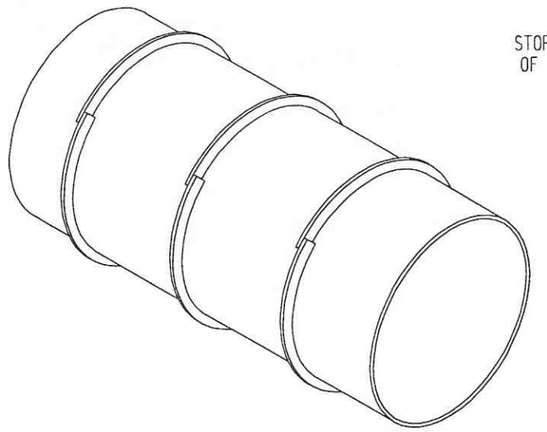
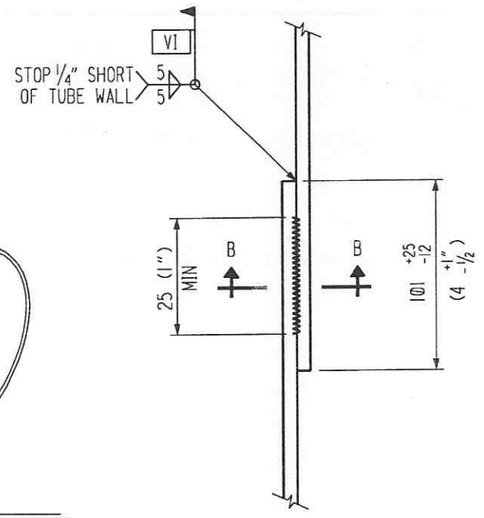
SHIP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
9950	15-1		BAR SK X 5 (3/16)		M3	Ac
9874	15-1		BAR SK X 5 (3/16)		M3	Ac
			M3 = SEE SPEC C-VAC-1			
			(SA240-TP304L)			



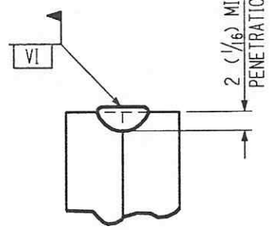
TYP STIFFENER LAYOUT

SEE SUB-ASSEMBLY DRAWING #4 FOR EXACT SPACING

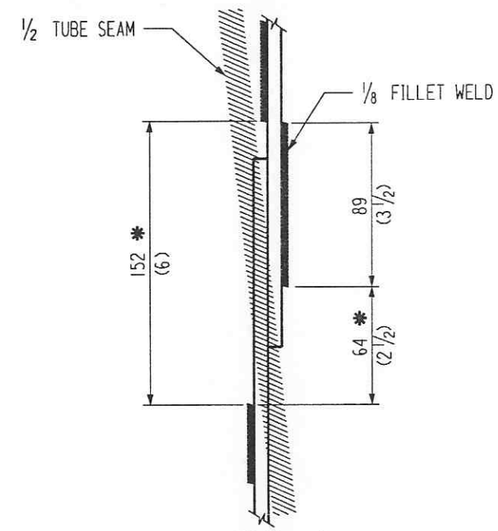


DETAIL - A

TYP LAP WELD

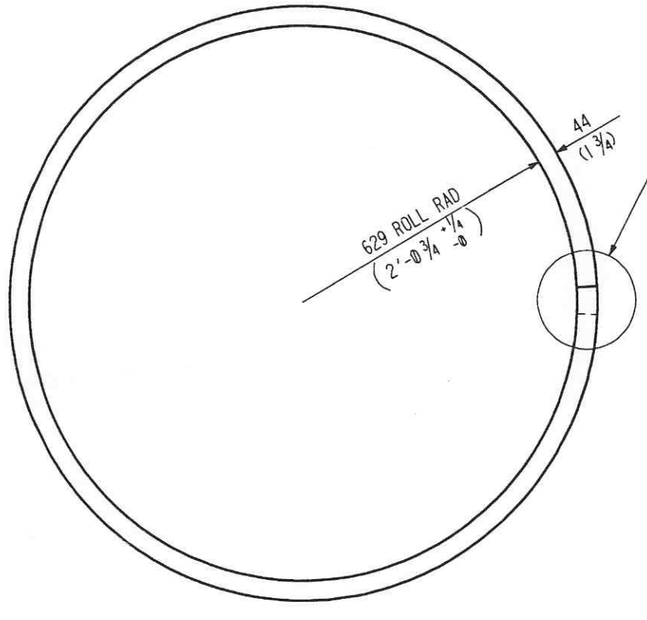


SECTION B-B

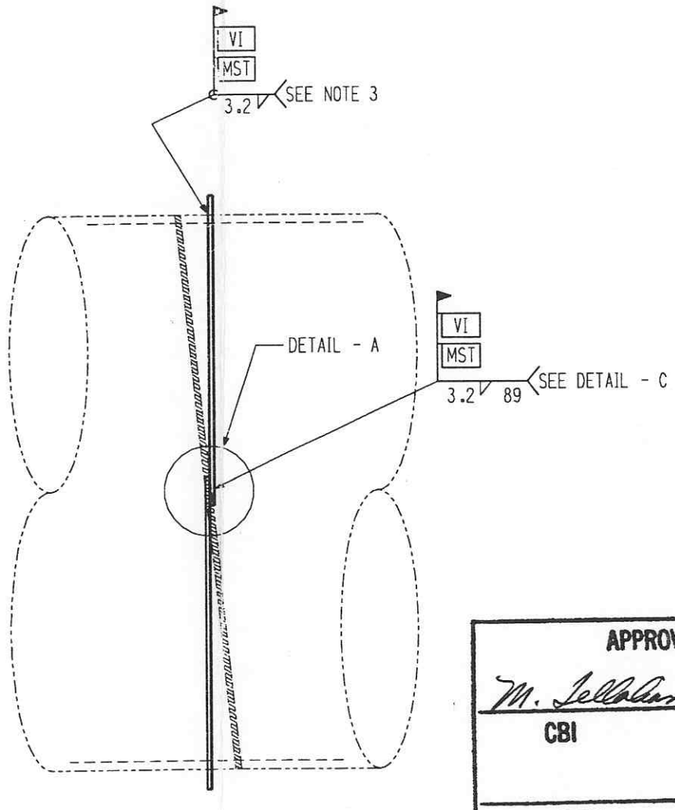


DETAIL - C

FILLET WELD GAP



VACUUM STIFFENER (1)



NOTES:

1. STIFFENERS TO BE A SINGLE CONTINUOUS PIECE FORMED BY ROLLING 3/16 X 1 3/4 FLATS; ONLY THE ENDS OF THE STIFFENER TO BE CUT EDGES.
2. STIFFENERS ARE TO BE INSTALLED BY EXPANDING OVER THE TUBE AND RELEASING INTO PLACE WITH A TIGHT FIT AROUND THE TUBE.
3. DISCONTINUE FILLET WELD WHERE STIFFENER CROSSES TUBE SPIRAL WELD. SEE DETAIL - C.
4. ALLOW EXTRA LENGTH FOR FORMING SO THAT THE ENDS OF THE STIFFENERS ARE ROLLED TO 622 (2'-0 1/2 +1/4 -0) RADIUS. STIFFENERS NOT FORMED AT ENDS MAY BE REJECTED.
5. WORK THIS DRAWING WITH DRAWING #4.

▶ * UNWELDED AREA MAY BE DECREASED BY LOCATING SPLICE CAREFULLY WITH LAP ON RIGHT SIDE.

APPROVED

M. Tellalian 6-28-96

CBI DATE

CALTECH DATE

▶ INDICATES CHANGE FROM PREVIOUS ISSUE

REVISIONS	REMARKS
BY DTR CHKD CST DATE 4-11-96	REV. QUANTITY AND CONTRACT #
BY KJR CHKD DET DATE 5-15-95	ADDED NOTE 4 REV LENGTH OF PC (1)
BY DTR CHKD MLT DATE 6-28-96	REV. NOTE. REMOVED OWNERSHIP NOTE.

CBI

SUPPLIER'S / PURCHASER'S NO

LIGO BEAM TUBE

HANFORD, WA & LIVINGSTON, LA

VACUUM STIFFENER DETAILS

CUSTOMER'S NO

BY KJR CHKD DET DATE 3-14-94

M.L. TELLALIAN

ENGINEERING ASSIGNED

CONTRACT NO 953571

DWG 15 REV 4D

SHT

LIGO-D950040-04-B

55710015.DGN