



SHIP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC
392	16-B		- FIXED SUPPORT RING ASS'Y -		
	16-1	784	BAR 114 x 9.5 ROLL FIN (4 1/2 x 3/8 x 7'-5 5/8)	2277	M4
800	16-C		- GUIDED SUPPORT RING ASS'Y -		
	16-1	1600	BAR 114 x 9.5 ROLL FIN (4 1/2 x 3/8 x 7'-5 5/8)	2277	M4
2384	16-4		BOLT 3/8" - 16 UNC-2A W/NUT	38 (1 1/2")	A307
2384	16-5		NO. 7 TAPER DOWEL PIN	152	A307
4768	16-6		SHOULDER BOLT 1/2" DIA SOCKET HD WITH NUT 5/8" SHOULDER LENGTH 3/8" - 16 UNC-3A THD		A307
			M4 = MAT'L SPEC C-SUPSTF-1 (SA240 TP 304L)		

SHOP:  
REFER TO FABRICATION SPECIFICATION C-SUPSTF-1 FOR INSTRUCTIONS.

- FIELD
1. MEASURE THE CIRCUMFERENCE OF THE TUBE WHERE THE STIFFENER SUPPORT WILL BE PLACED. CALCULATE THE OD OF THE TUBE.
  2. MACHINE THE SUPPORT RING ID TO MATCH THE OD OF THE TUBE WHERE IT WILL BE ATTACHED WITH A TOLERANCE ON THE RING ID OF +0.050/-0.000
  3. REMOVE BOLTS ONLY TO INSTALL. FIT SUPPORT AROUND BEAM TUBE, USING A NO. 7 DOWEL PIN TO LOCATE THE HOLE CENTERS
  4. USE CARE TO MAKE SURE EACH SUPPORT IS FITTED TO THE PLACE IT WAS MACHINED FOR.
  5. WELD THE SUPPORT TO THE TUBE. REMOVE ALL FASTENERS AFTER WELDING.

K.R. ADDED FEATURE CONTROL DIM 2-15-94 K.R. REV BILLING K.R. REV'D MAT'L SPEC. K.R. DETAIL - A, AND NOTE 3. 7-8-94 ADDED ASSEMBLIES. SIONS	<b>CBI</b>		SUPPLIER'S / PURCHASER'S NO
	SUPPORT RING		
LIGO BEAM TUBE HANFORD, WA & LIVINGSTON, LA			
CUSTOMER'S NO		CONTRACT NO	
BY K.R. CHKD WJC DATE 4-4-94		930212	
D.E. Thorn ENGINEERING ASSIGNED		DWG 16	REV 2

LIGO-D950041-02-B