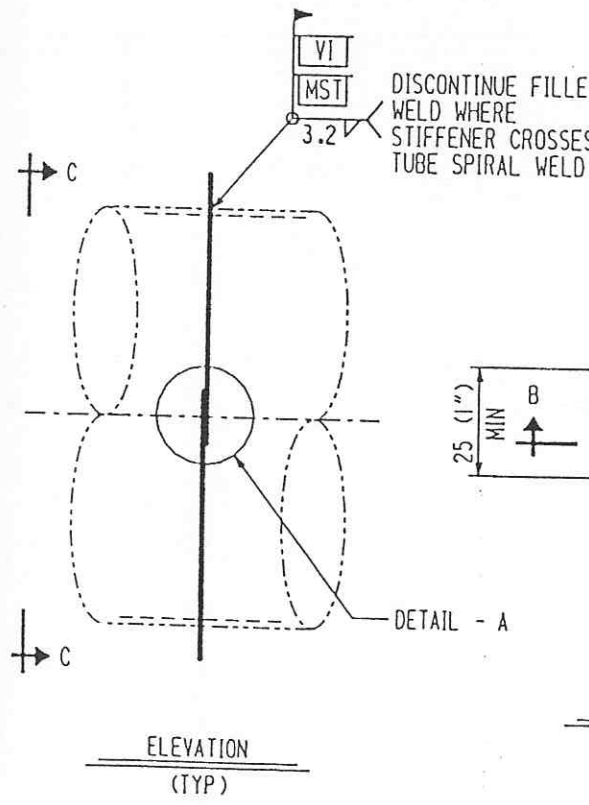
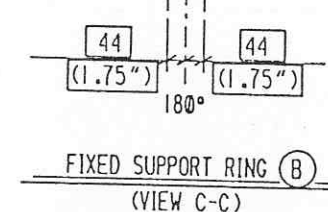
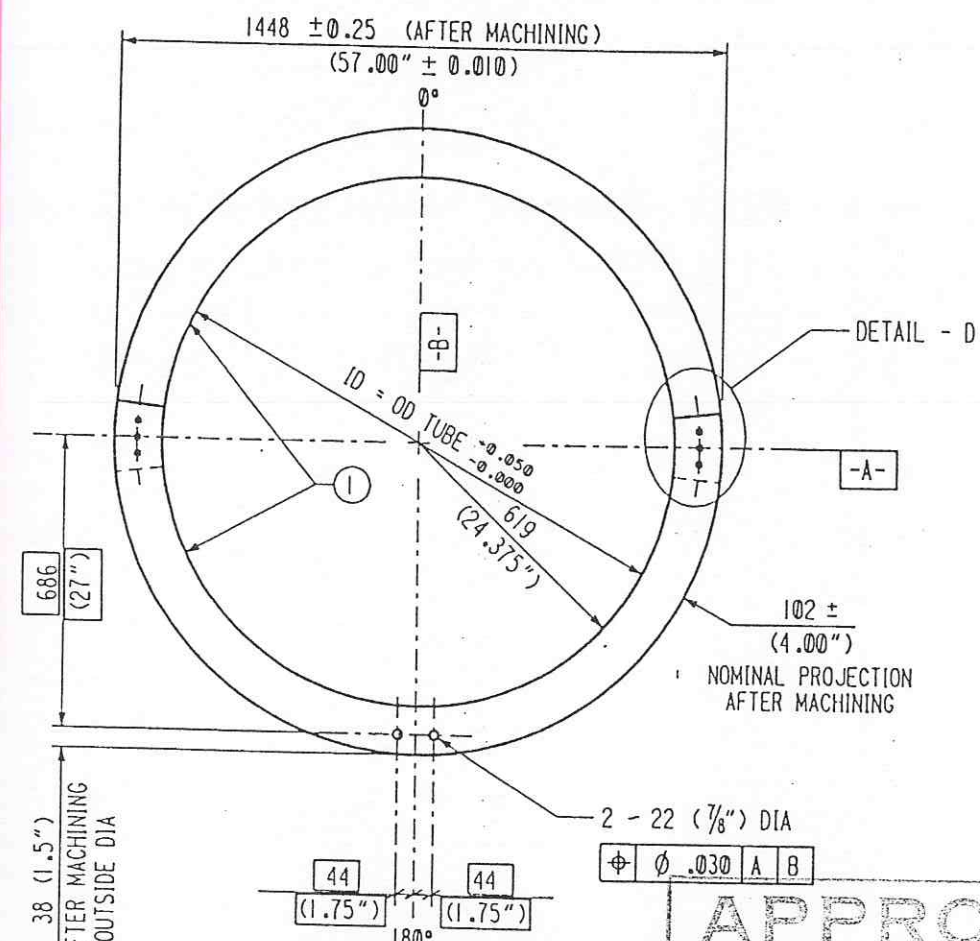
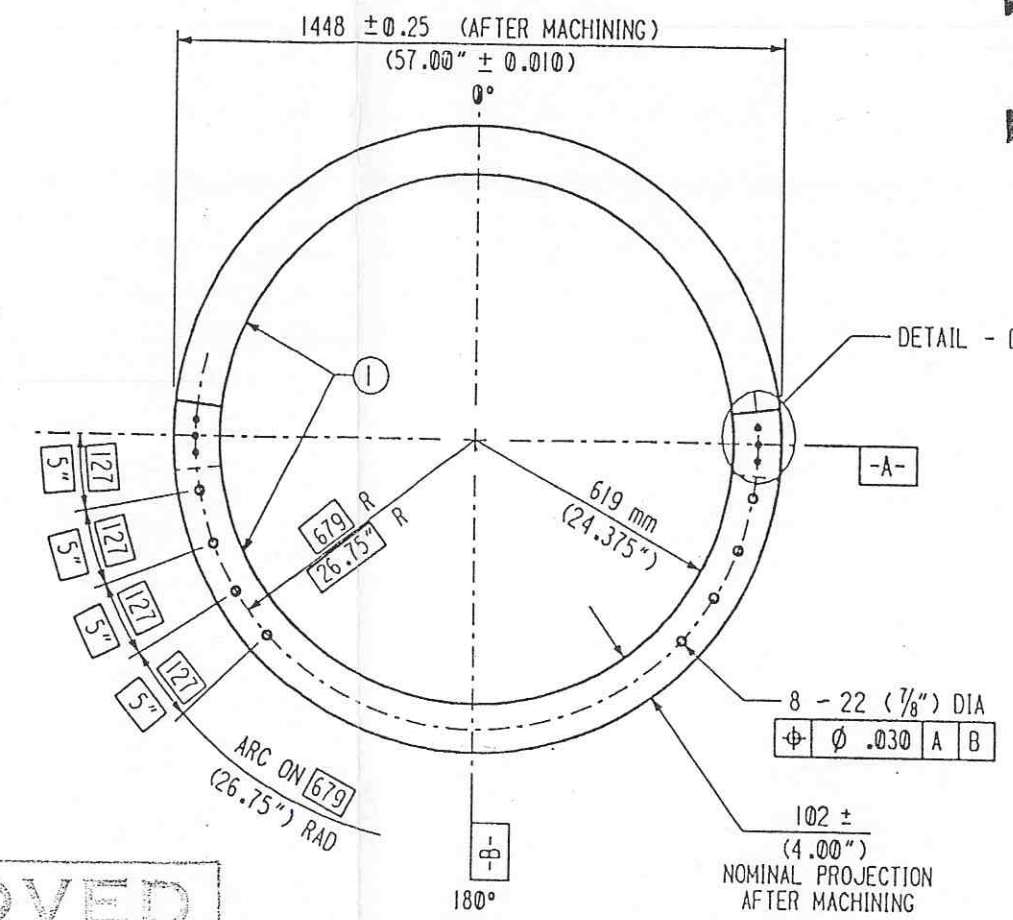
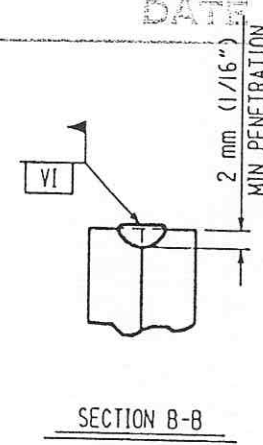


Date Rec'd: LIGO: D950041-03-B  
 11/10/95 Contractor # 00116 Rev. 3  
 TIM#: 25 Date: 3/12/96 Approved: JH  
 LIGO: C969675-00-V Approved: JH  
 TDM: Date: / / Approved: / /  
 LIGO: Date: / / Approved: / /  
 Gen'l Transmittal LIGO- Approved: / /  
 Date: / /

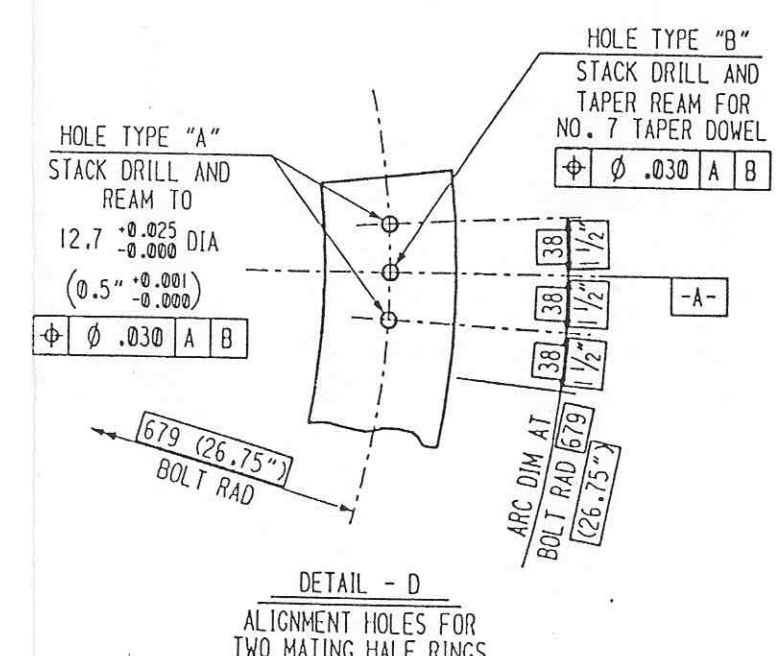


APPROVED

*M. Jellalian* 11/10/95 DATE  
 CBI  
*J. Jones* 11/10/95 DATE  
 CALTECH



GUIDED SUPPORT RING (C)  
(VIEW C-C)



SHIP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC
392	16-B-XX		- 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-XX		- 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		A307
			5/8" SHOULDER LENGTH		
			3/8" - 16 UNC-3A THD		
			M4 = MAT'L SPEC C-SUPSTF-1 (SA240 TP 304L)		

\* XX = ID SIZE DESIGNATION (SEE NOTE 2 BELOW)

- NOTES**
- REFER TO VENDOR SPECIFICATION C-SUPSTF-1 FOR ADDITIONAL MATERIAL AND FABRICATION INFORMATION.
  - MEASURE THE OUTSIDE CIRCUMFERENCE OF THE BEAM TUBE AT THE SUPPORT RING LOCATIONS AND CALCULATE THE AVERAGE OD. SELECT THE ID SIZE OF THE SUPPORT RING THAT WILL FIT THE BEAM TUBE. THE ID SIZE MUST BE EQUAL TO OR LARGER THAN THE TUBE OD. THE FOLLOWING ARE THE DESIGNATED ID SIZES:

DESIGNATION	TUBE OD (INCHES)	RING ID (INCHES)
4	49.000 TO 49.040	49.040 TO 49.050
8	49.040 TO 49.080	49.080 TO 49.090
12	49.080 TO 49.120	49.120 TO 49.130
16	49.120 TO 49.160	49.160 TO 49.170
20	49.160 TO 49.200	49.200 TO 49.210
24	49.200 TO 49.240	49.240 TO 49.250
28	49.240 TO 49.280	49.280 TO 49.290

- MACHINE THE SUPPORT RINGS TO THE SIZE DESIGNATION AND IMMEDIATELY AFTER MACHINING STAMP THE SIZE DESIGNATION ONTO THE SUPPORT RING.
- REMOVE THE BOLTS ONLY TO INSTALL THE SUPPORT RING AROUND THE BEAM TUBE. FIT THE SUPPORT RING AROUND THE BEAM TUBE USING A NO. 7 DOWEL PIN TO LOCATE THE CENTER HOLE.
  - WELD THE SUPPORT TO THE TUBE. REMOVE ALL THE FASTENERS AFTER WELDING

<b>CBI</b>		SUPPORT RING	
LIGO BEAM TUBE HANFORD, WA & LIVINGSTON, LA			
CUSTOMER'S NO		CONTRACT NO	
BY KJR CHKD VJC DATE 4-4-94		930212	
D.F. THORN		DWG 16	
ENGINEERING ASSIGNED		SHT 3	
LIGO-D950041-03-B			

INDICATES CHANGE FROM PREVIOUS ISSUE