

SHIP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
1208	16-A-XX		- SUPPORT RING ASS'Y -			
	16-1	2416	BAR SK X 9.5 (3/8)		M4	Ac
2416	16-4		BOLT 11 (7/16) DIA - 14 UNC-2A	38	A307	D
			W/ NUT AND 2 WASHERS	(1 1/2)		
36	16-5		ALIGNMENT PIN (SEE SKETCH)		**	D
			M4 = SEE SPEC C-SUPSTF-1 (SA240 TP 304L)			
			** = HARDENED & GROUND			

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

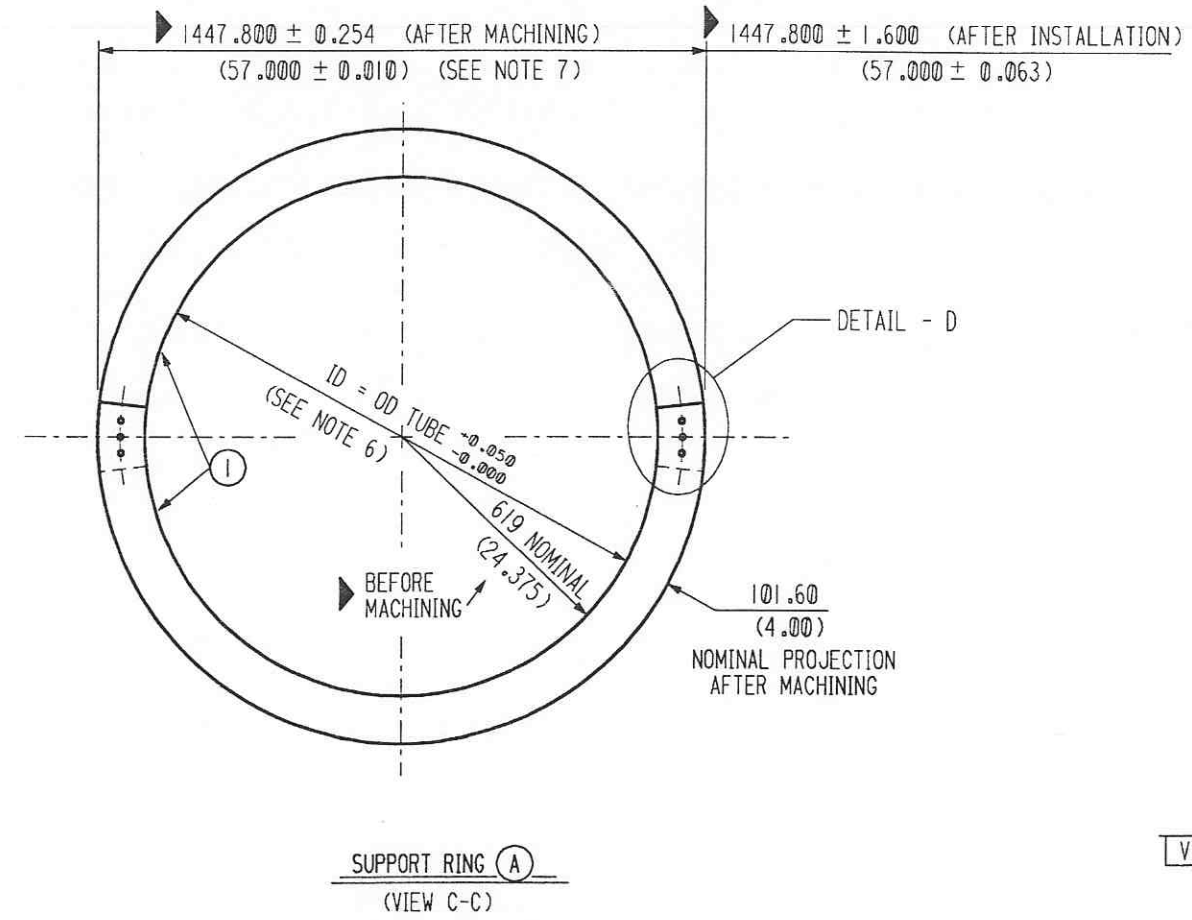
NOTES:

- 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:

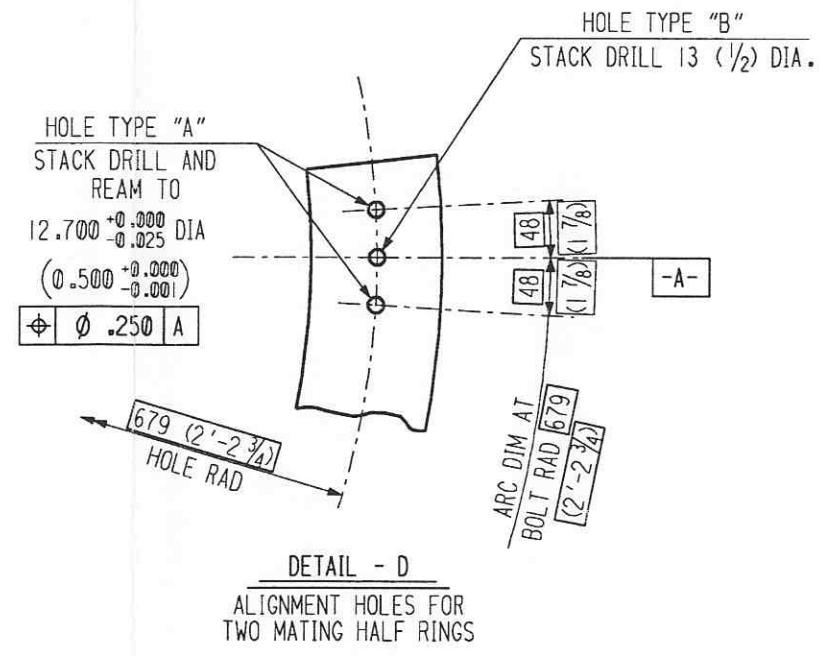
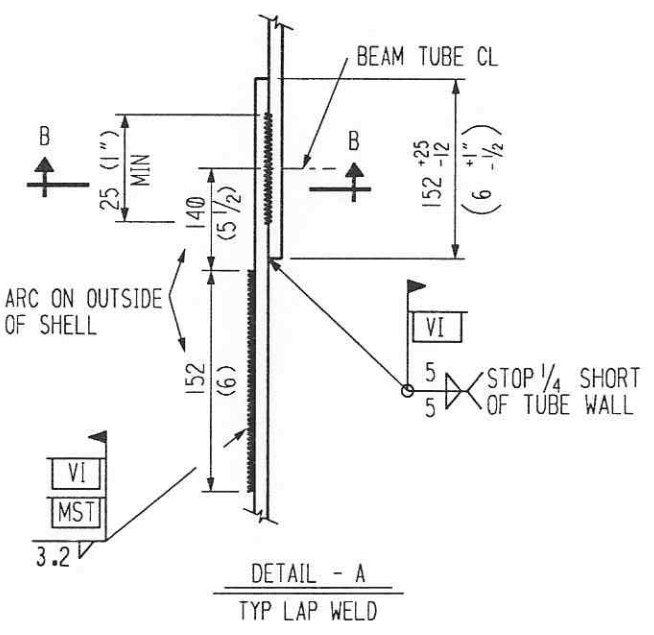
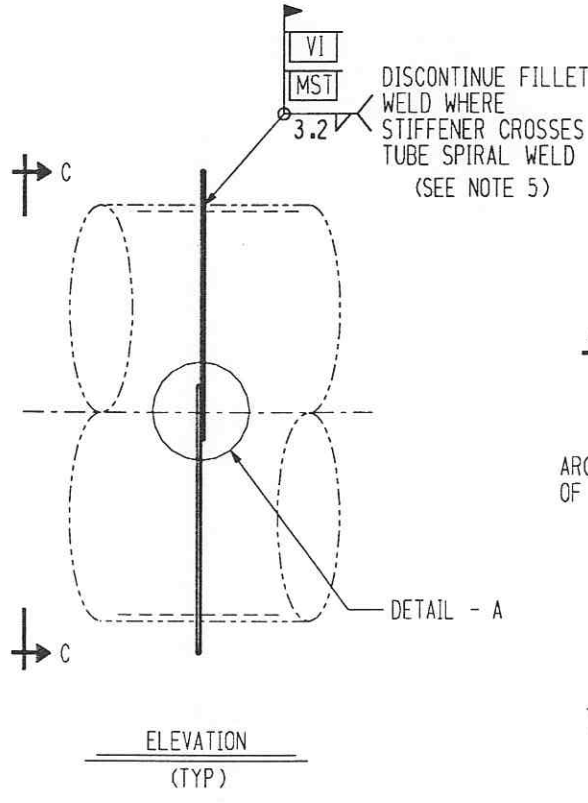
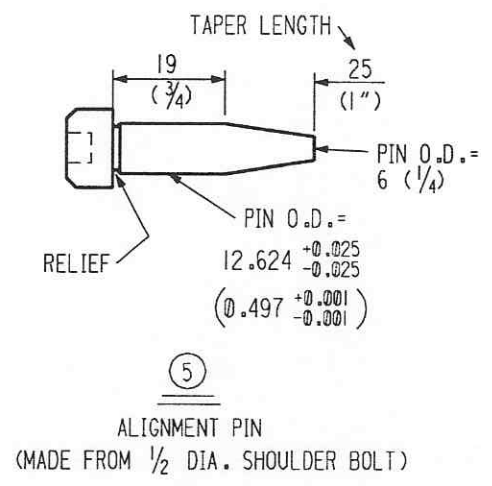
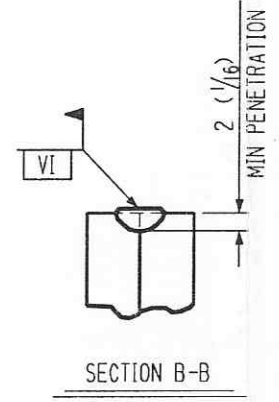
SIZE DESIGNATION	TUBE OD (INCHES)	RING ID (INCHES)
4	49.000 TO 49.040	49.040 TO 49.050
8	49.040 TO 49.080	49.080 TO 49.090
12	49.080 TO 49.120	49.120 TO 49.130
16	49.120 TO 49.160	49.160 TO 49.170
20	49.160 TO 49.200	49.200 TO 49.210
24	49.200 TO 49.240	49.240 TO 49.250
28	49.240 TO 49.280	49.280 TO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

MACHINE THE SUPPORT RINGS TO THE SIZE DESIGNATION AND IMMEDIATELY AFTER MACHINING, STAMP THE SIZE DESIGNATION ONTO THE SUPPORT RING.

- REMOVE THE 7/16 DIA. BOLTS FROM TYPE B HOLES TO INSTALL THE SUPPORT RING AROUND THE BEAM TUBE. POSITION AND FIT THE SUPPORT RING AROUND THE BEAM TUBE AND INSTALL THE 7/16 DIA. BOLTS INTO THE TYPE B HOLES. BEFORE TACKING RING TO THE BEAM TUBE, INSTALL THE ALIGNMENT PINS INTO THE TYPE A HOLES.
- AFTER THE SUPPORT RING IS WELDED TO THE BEAM TUBE, REMOVE THE ALIGNMENT PINS AND THE 7/16 DIA. BOLTS.
- ALL WELDING TO TUBE WALL TO BE DONE USING FILLER METAL CLEANED PER SPEC. WMS-ER308L.
- AFTER FINAL MACHINING, ID OF SUPPORT RING (A) IS TO BE CONCENTRIC WITH THE OD WITHIN +/- 0.254 (0.010).
- AFTER MACHINING, OD OF SUPPORT RING (A) IS TO BE ROUND WITHIN 0.254 (0.010).



APPROVED
M. Tellalian 9-13-96
 CBI DATE
J. Jones 9/23/96
 CALTECH DATE



INDICATES CHANGE FROM PREVIOUS ISSUE

REVISIONS		REMARKS	
BY	CHKD	DATE	REVISIONS
BY	CHKD	DATE	REVISIONS
BY	CHKD	DATE	REVISIONS
BY	CHKD	DATE	REVISIONS
BY	CHKD	DATE	REVISIONS
BY	CHKD	DATE	REVISIONS

CBI		SUPPLIER'S / PURCHASER'S NO	
LIGO BEAM TUBE HANFORD, WA & LIVINGSTON, LA			
SUPPORT RINGS FIXED, GUIDED AND TERMINATION SUPPORTS			
CUSTOMER'S NO		CONTRACT NO	
BY KJR CHKD WJC DATE 4-4-94		953571	
M.J. TELLALIAN ENGINEERING ASSIGNED		DWG 16	REV 6
SHT			
Ligo-D950041-06-B			

55710016.DGN