



**ELECTRONIC COPY**

- NOTES**
- STEEL CONSTRUCTION SHALL CONFORM TO THE AISC SPECIFICATION FOR THE DESIGN, FABRICATION, AND ERECTION OF STRUCTURAL STEEL.
  - WELDING OF STEEL SHALL BE IN ACCORDANCE WITH AWS D11.
  - FABRICATOR SHALL SAND BLAST ALL EXPOSED SURFACES IN ACCORDANCE WITH SSPC-SP-6.
  - STEEL SHALL BE PAINTED WITH WHITE EPOXY POLYMER. ALL SURFACES SHALL BE CLEAN AND FREE OF RUST. SEE SCALE. CLEAN AND PRIME IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS.
  - ALUMINUM CONSTRUCTION SHALL CONFORM TO THE ALUMINUM ASSOCIATION SPECIFICATIONS FOR ALUMINUM STRUCTURES.

LIGO-D970435-02-V

| ITEM | PART NUMBER | QTY | U/M | DESCRIPTION   |
|------|-------------|-----|-----|---|
| 10   |             | 15  | FT  | FLAT BAR, STEEL, A36<br>1/2" THK X 4" W             |
| 9    |             | 8   | EA  | 3/8"-16 X 4 1/2" LG HEX HEAD BOLT, SS               |
| 8    |             | 8   | EA  | 3/8" FLAT WASHER, SS                                |
| 7    |             | 8   | EA  | 3/8"-16 HEX NUT, SS                                 |
| 6    |             | 25  | SF  | PLATE, ALUMINUM, 6061-T6<br>1/2" THK X 6 1/8" W     |
| 5    |             | 37  | FT  | TUBE, ALUMINUM, 6061-T6<br>3" X 3" X 3/16" WT       |
| 4    |             | 34  | FT  | TUBE STEEL, A500 GR B<br>2" X 2" X 3/16" WT         |
| 3    |             | 435 | FT  | TUBE STEEL, A500 GR B<br>4" X 2" X 3/16" WT         |
| 2    |             | 555 | FT  | TUBE STEEL, A500 GR B<br>6" X 3" X 3/16" WT         |
| 1    |             | 26  | FT  | TUBE STEEL, A500 GR B<br>3 1/2" X 3 1/2" X 3/16" WT |

APPROX. WT. = 1700 LB

**PROPRIETARY AND CONFIDENTIAL**

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| DWG NO     | DESCRIPTION         | DWG NO | DESCRIPTION |
|------------|---------------------|--------|-------------|
| V049-4-136 | CLEAN ROOM ASSY HAM |        |             |

| REV | DESCRIPTION                   | CHKD | DRWN | DATE     | DESIGN |
|-----|-------------------------------|------|------|----------|--------|
| 2   | REISSUED FOR FAB AS NOTED     |      |      | 08/19/97 | 0540   |
| 1   | REISSUED FOR PSI FAB AS NOTED | PEF  | RDC  | REC      | JR     |
| 0   | ISSUED FOR FAB                | PEF  | DHW  | RW       | BAR    |

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES  
FUNCTIONAL: ± 0.01  
ANGULAR: MACH 40°-90° BEND ± 0.2°  
TWO PLACE DECIMAL ± 0.05  
THREE PLACE DECIMAL ± 0.005  
FINISHED SURFACE RING BREAK CORNERS 30°  
REMOVE ALL BURRS

DO NOT SCALE THIS DRAWING

USED ON: \_\_\_\_\_

NEXT ASSY: \_\_\_\_\_

ISSUE DESCRIPTION: \_\_\_\_\_

**PROCESS SYSTEMS INTERNATIONAL, INC.**  
20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA

**CLEAN ROOM STRUCTURE WELDMENT HORIZONTAL ACCESS MODULE**

**LIGO VACUUM EQUIPMENT**

DWG NO: V0494137  
REV: D  
DATE: 04/22/97  
SHEET: 2 OF 2

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