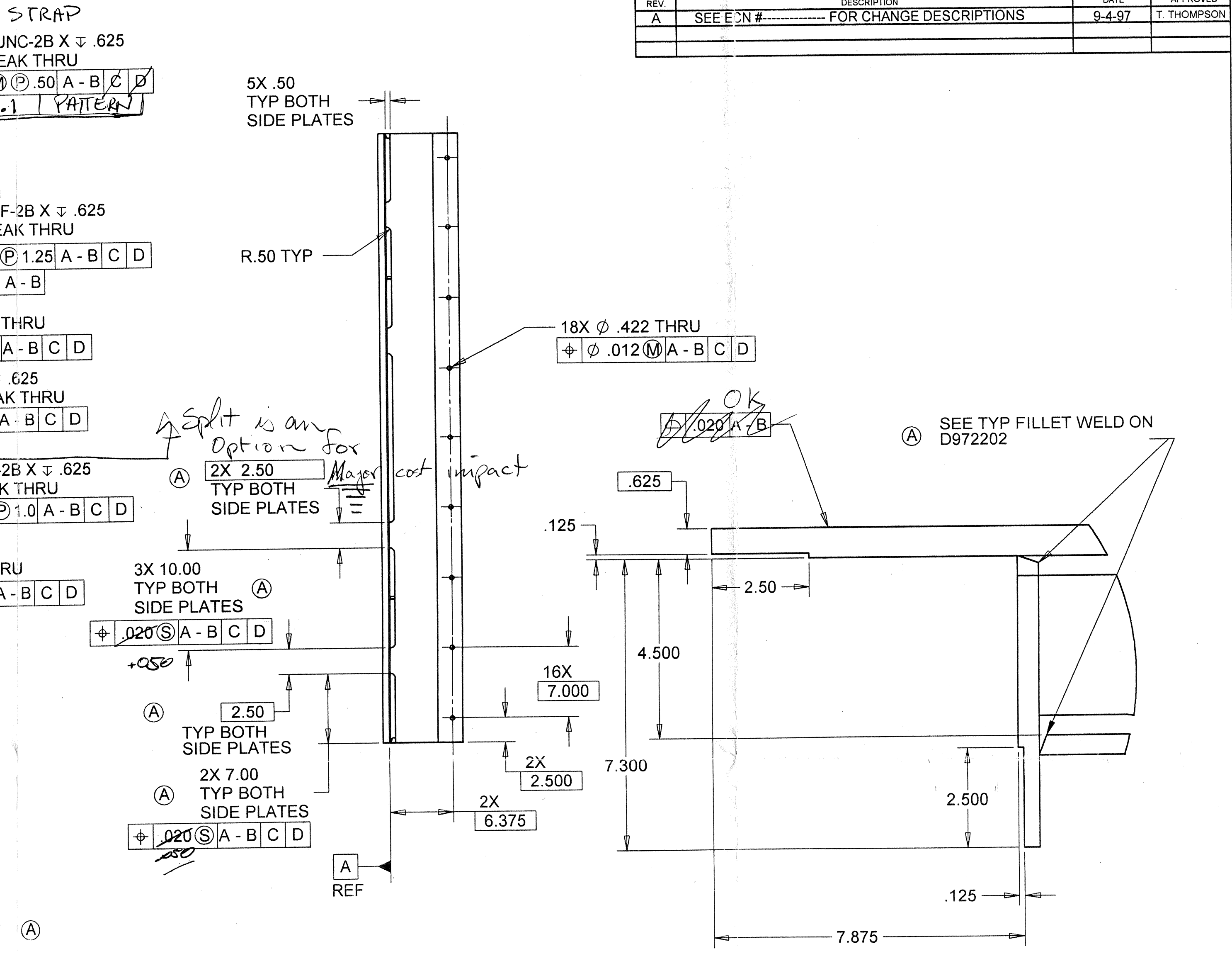
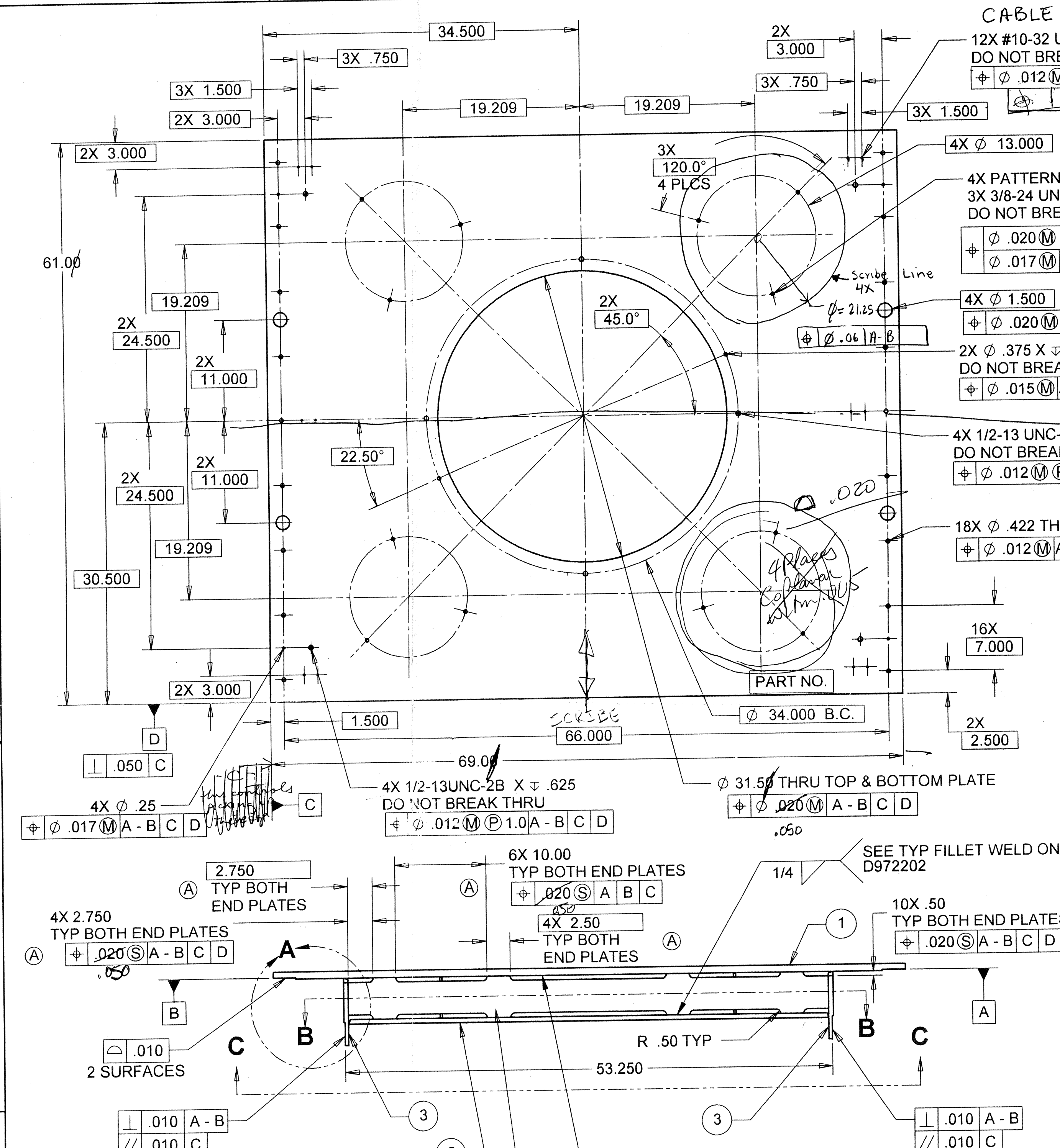


REV	DESCRIPTION	DATE	APPROVED
A	SEE ESN #----- FOR CHANGE DESCRIPTIONS	9-4-97	T. THOMPSON



- NOTES: UNLESS OTHERWISE SPECIFIED
- ALL DIMENSIONS IN INCHES
 - DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
 - SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
 - REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
 - ALL INSIDE CORNERS TO BE .015 RADIUS MAX
 - COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
 - COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
 - PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
 - ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION LIGO-TS-03 CATEGORY 1.
 - ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN WELDING ELECTRODES AND ER4043 WELDING ROD (SPEC. PER AWS A5.10-80).
 - NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: ALUMICUT, MISTIC METAL MOVER, PRINCETON, IL.

SEE SHEET D2 FOR SECTIONS B & C

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	TOP PLATE	ALUM. 6061-T651
2	2	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651
3	2	SIDE PLATE, .50 THK	ALUM. 6061-T651
4	2	END PLATE, .50 THK	ALUM. 6061-T651
5	1	BOTTOM PLATE, .50 THK	ALUM. 6061-T651
6	2	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651
7	4	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651

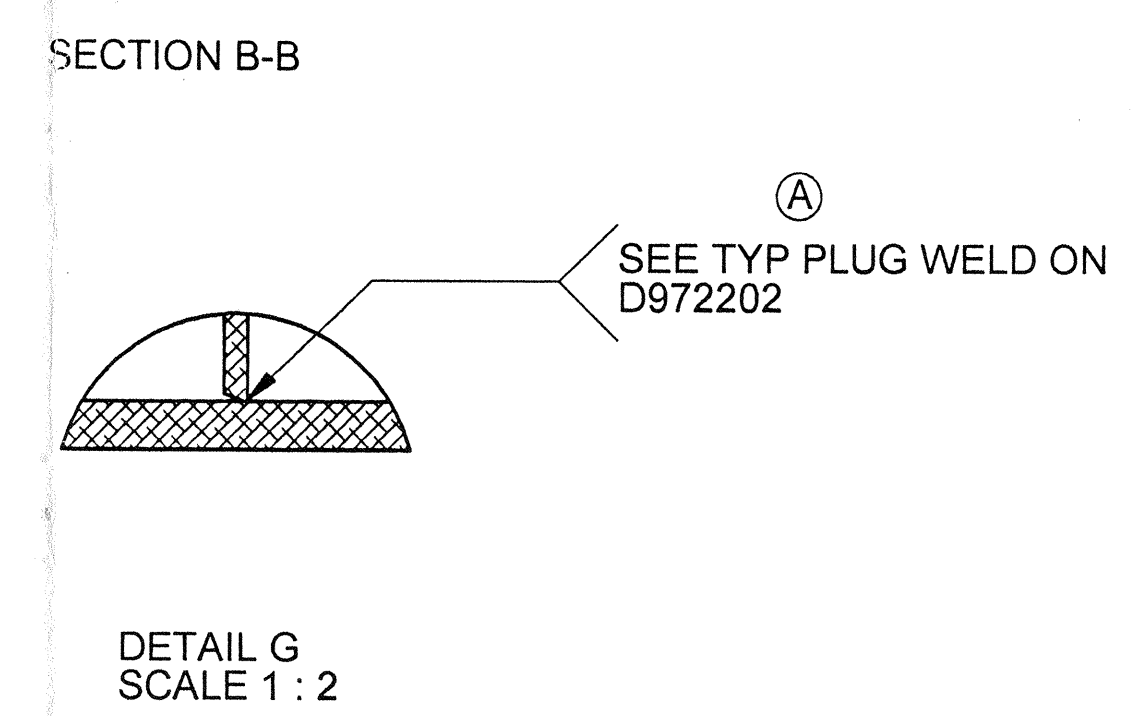
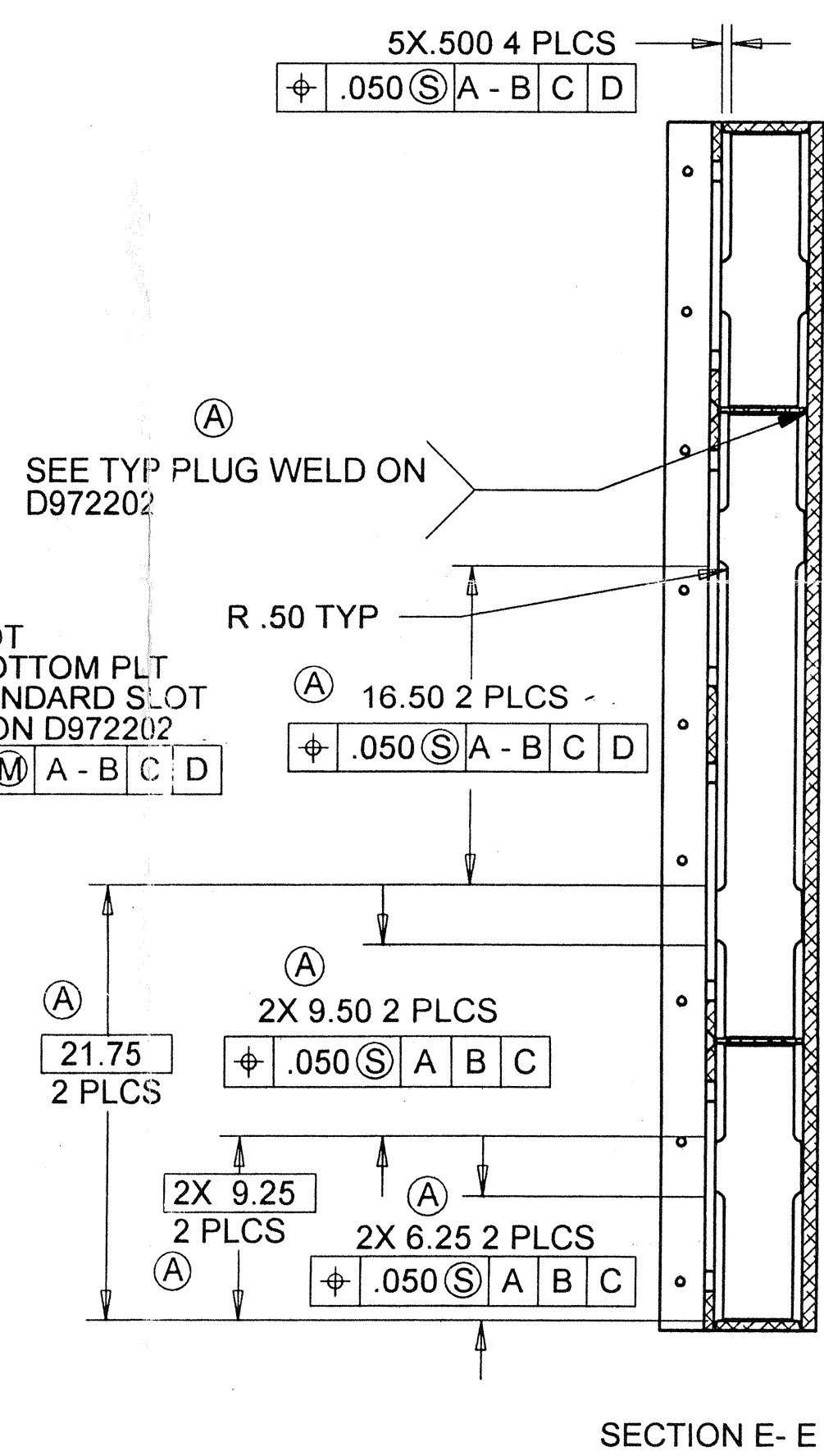
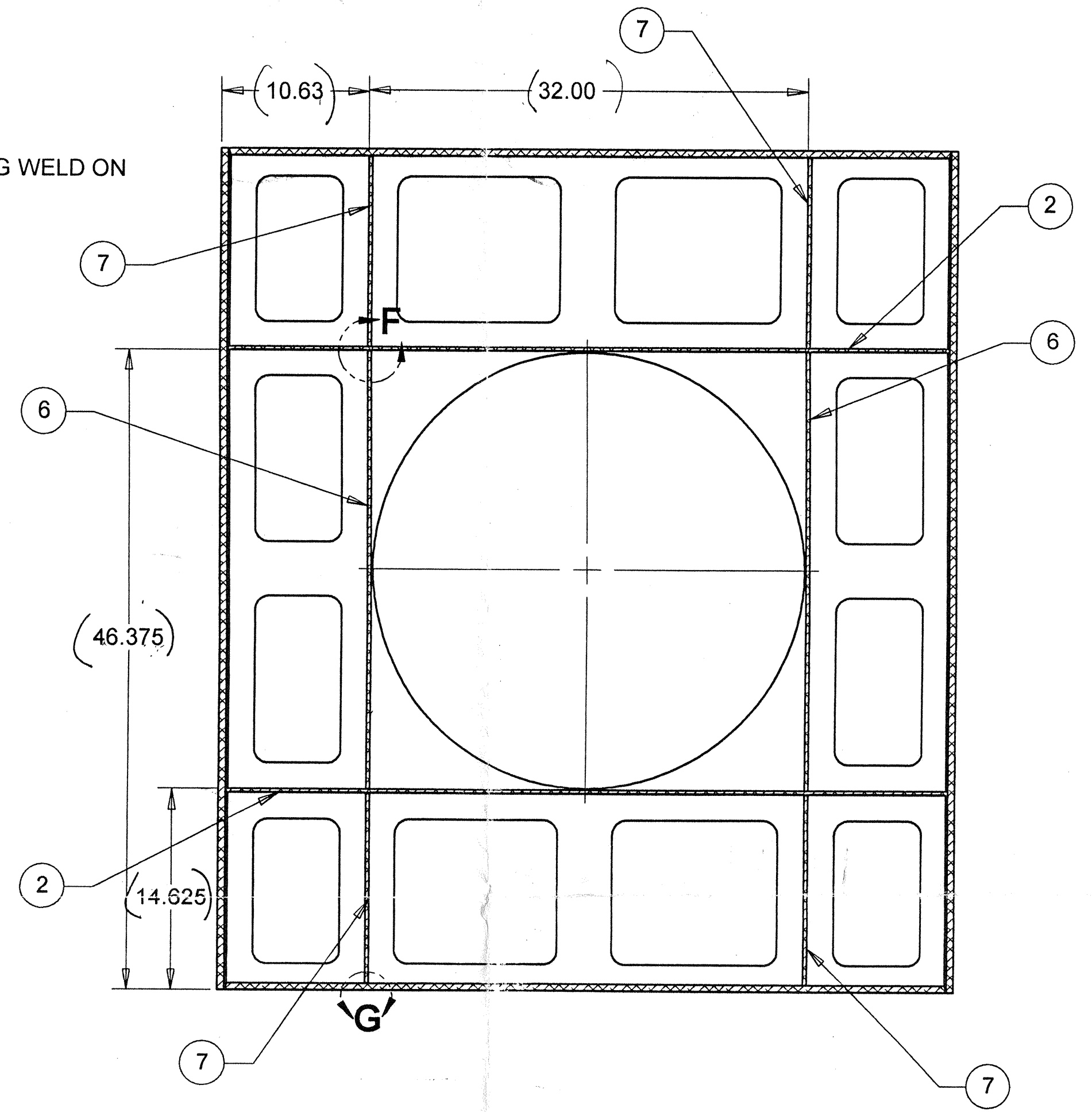
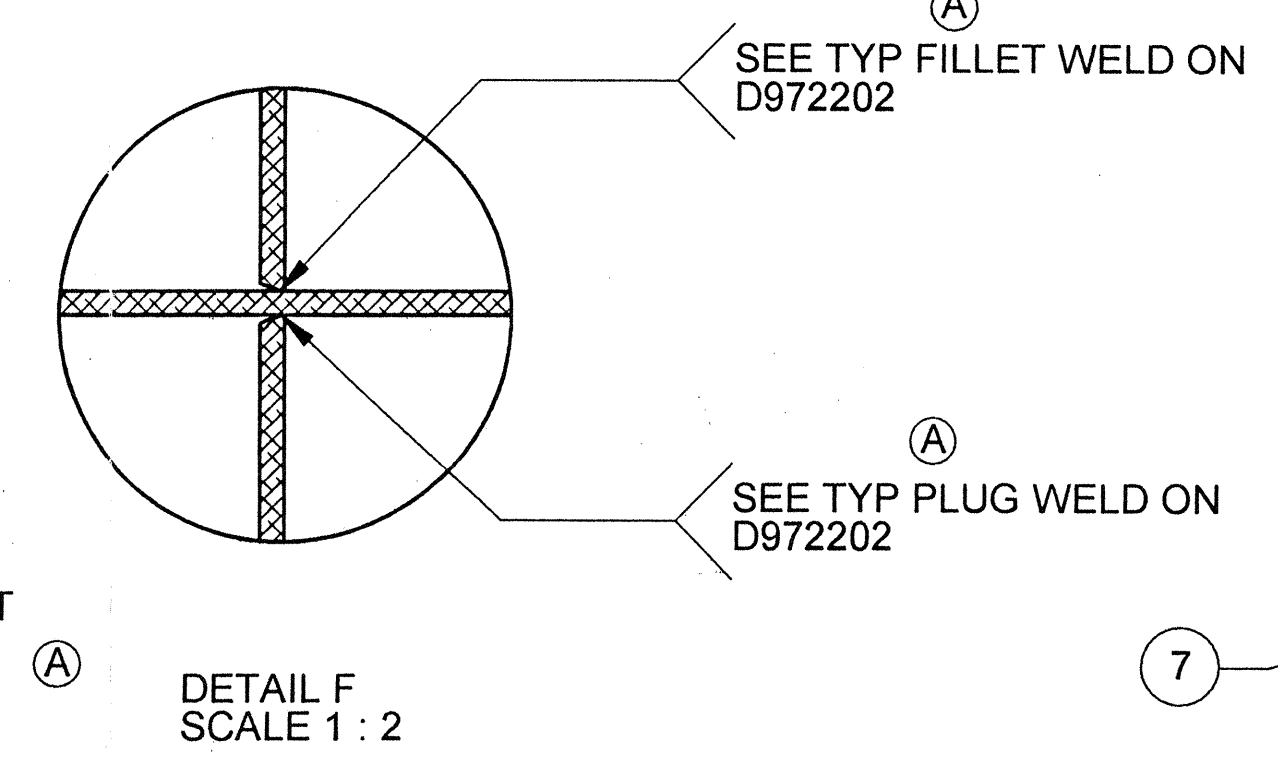
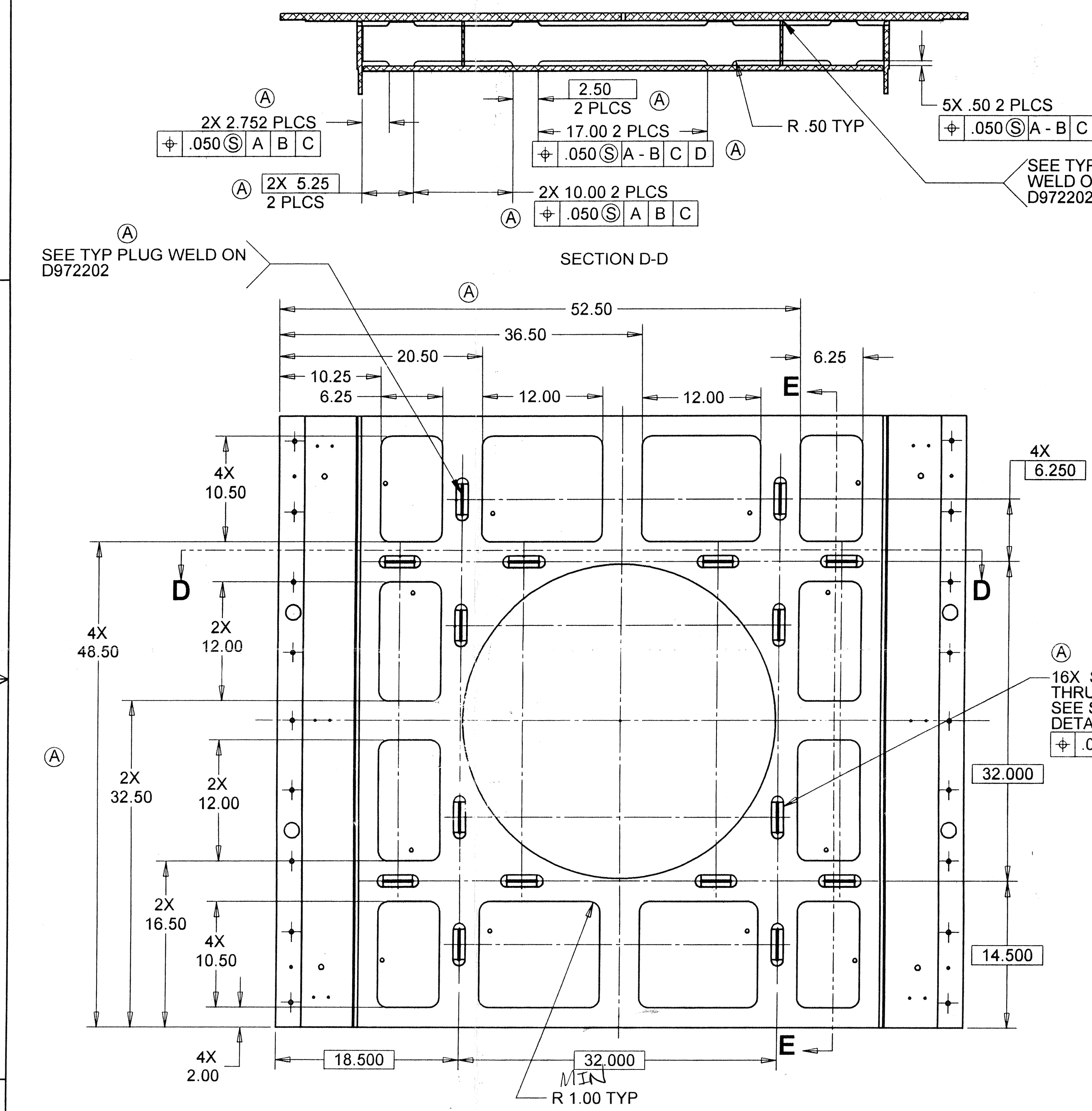
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	<p align="center">HYTEC, INC</p> <p align="center">LIGO BSC SUPPORT TABLE WELDMENT</p>	
FINISH ALL MACHINED SURFACES b4 -32-RMS			
PART NO. D972212-1			

PARTS LIST			
DESIGNED	ROGER L. SMITH	DATE	5-28-97
DRAWN	ROGER L. SMITH	DATE	5-28-97
CHECKED	HARRY SALAZAR	DATE	6-6-97
ENGR.	T. THOMPSON	DATE	7-10-97
APPROVED	T. THOMPSON	DATE	7-10-97

DWG. NO.	D972212	SIZE	D	SHEET NO.	1 of 2
SCALE	1/8	REVISION	A		

8 7 6 5 4 3 2 1

REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN # FOR CHANGE DESCRIPTIONS	9-4-97	T. THOMPSON



VIEW C - C

λ=1.1

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30' SURFACE FINISH = 250	TITLE HYTEC, INC LIGO BSC SUPPORT TABLE WELDMENT	
FINISH ALL MACHINED SURFACES 32 RMS	DESIGNED ROGER L. SMITH	SIGNATURE ROGER L. SMITH	DATE 5-28-97
PART NO. D972212-1	DRAWN HARRY SALAZAR	SIGNATURE HARRY SALAZAR	DATE 6-6-97
	ENGR. T. THOMPSON	SIGNATURE T. THOMPSON	DATE 7-10-97
	APPROVED T. THOMPSON	SIGNATURE T. THOMPSON	DATE 7-10-97
DWG. NO. D972212		SCALE 1/8	SIZE SHEET NO. D 2 of 2
REVISION A			

8 7 6 5 4 3 2 1