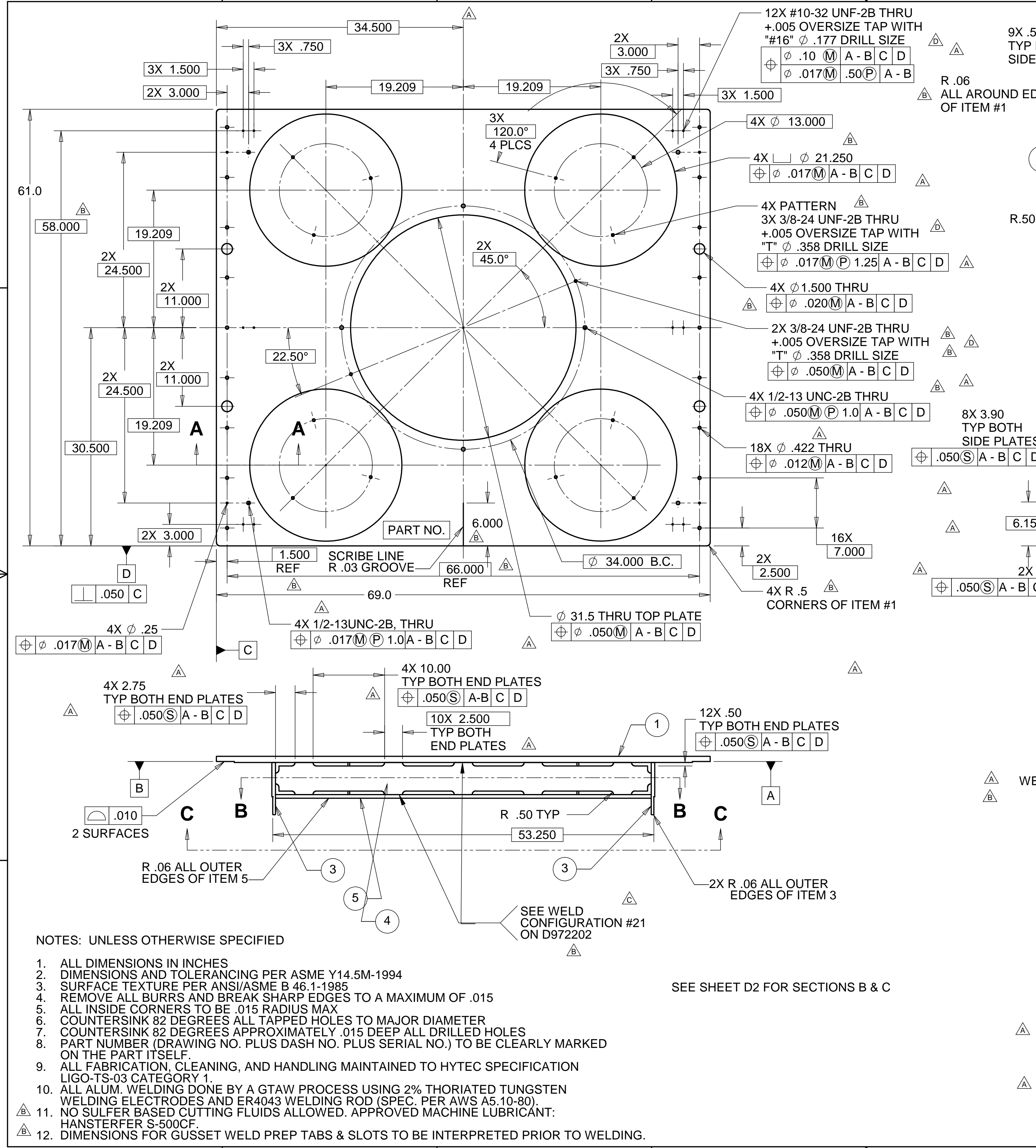


REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972212-A FOR CHANGE LIST	11/03/97	T. THOMPSON
B	SEE ECN# D972212-B FOR CHANGE LIST	03/11/98	T. THOMPSON
C	SEE ECN# D972212-C FOR CHANGE LIST	03/24/98	T. THOMPSON
D	SEE ECN# D972212-D FOR CHANGE LIST	04/23/99	T. THOMPSON



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

- 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: HANSTERFER S-500CF.
 - DIMENSIONS FOR GUSSET WELD PREP TABS & SLOTS TO BE INTERPRETED PRIOR TO WELDING.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
-TOLERANCES-

DECIMALS ANGULAR = +/- .30°
X = +/- .1
XX = +/- .03
XXX = +/- .010 SURFACE FINISH = 250

CAD GENERATED DRAWING.
DO NOT MANUALLY UPDATE
DO NOT SCALE DRAWING

HYTEC, INC

TITLE: LIGO BSC SUPPORT TABLE WELDMENT

DWG. NO. D972212 SIZE D SHEET NO. 1 of 3

SCALE 1/8 REVISION D

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

PART NO. D972212-1

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972212-A FOR CHANGE LIST	11/03/97	T. THOMPSON
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C	SEE ECN# D972212-C FOR CHANGE LIST	03/24/98	T. THOMPSON
D	SEE ECN# D972212-D FOR CHANGE LIST	04/23/99	T. THOMPSON

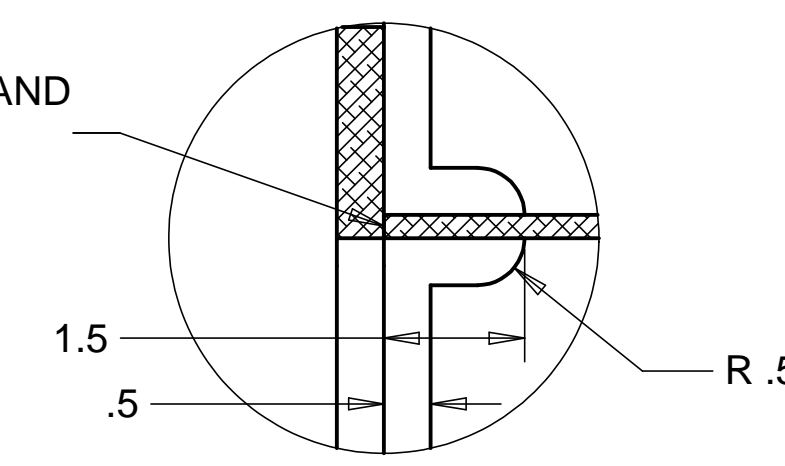
D

D

SEE WELD CONFIGURATION #14 ON D972202

2X 1.50 2 PLCS
ITEMS 2 & 4
⊕ .050(S) A - B | C | D

ALL GUSSETS TO BE FLUSH WITH INTERIOR SURFACES OF LOWER AND UPPER PLATES



DETAIL H
SCALE 1 : 2
VIEW TYP ALL RELIEFS

2X 2.750 2 PLCS
(ITEMS 2 & 4)
⊕ .050(S) A - B | C

5X 2.500
2 PLCS

2X 10.00 2 PLCS
(ITEMS 2 & 4)
⊕ .050(S) A - B | C

SECTION D-D

6X .50 2 PLCS
ITEMS 2 & 4
⊕ .050(S) A - B | C | D

SEE WELD CONFIGURATION #14 ON D972202

2X R .06 BOTH EDGES OF BOTH ITEMS #3

8X .06 MAX CHAMFER BOTH SIDES ALL AROUND

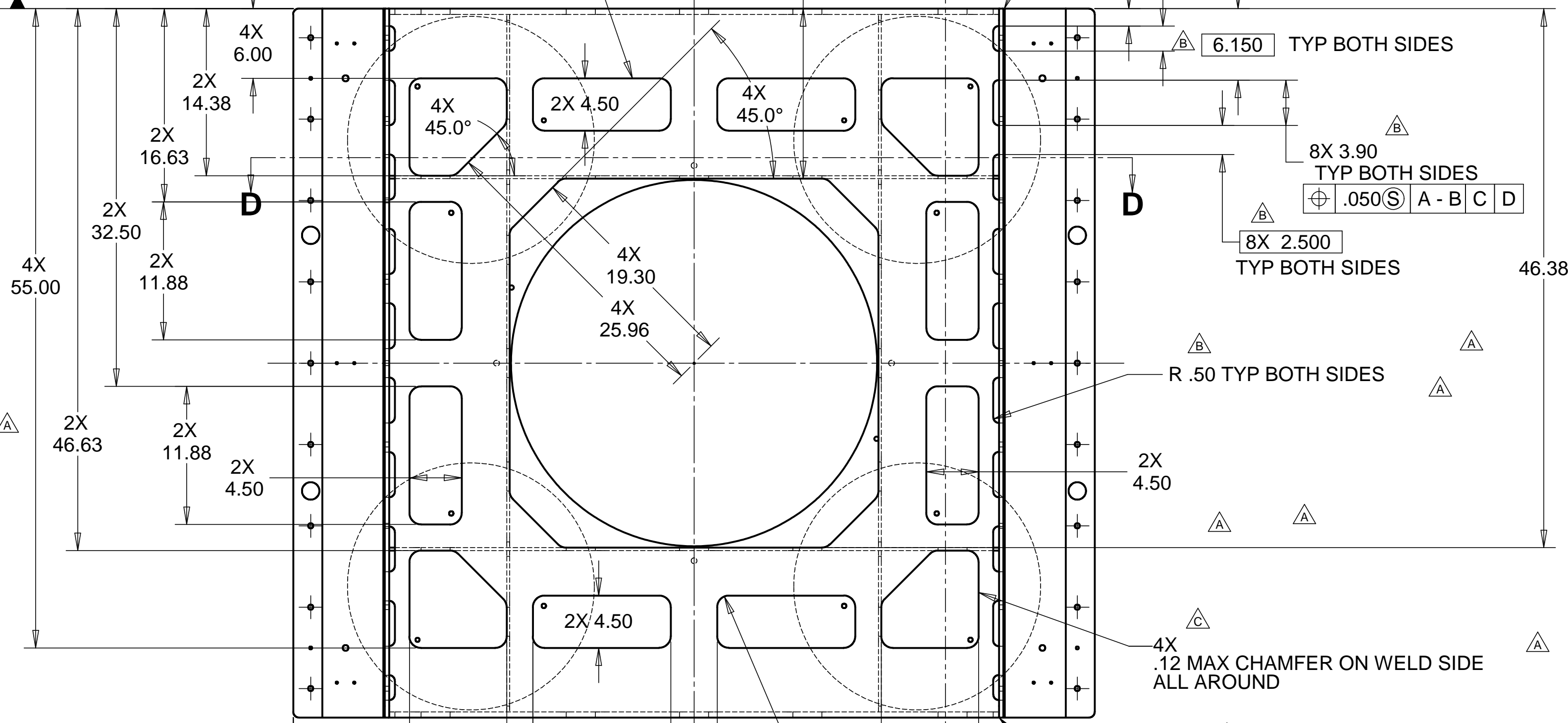
4X R .06

1.500 TYP BOTH SIDES

2X 2.15 TYP BOTH SIDES
⊕ .050(S) A - B | C | D

C

C



VIEW C - C
FROM SHEET D1

B

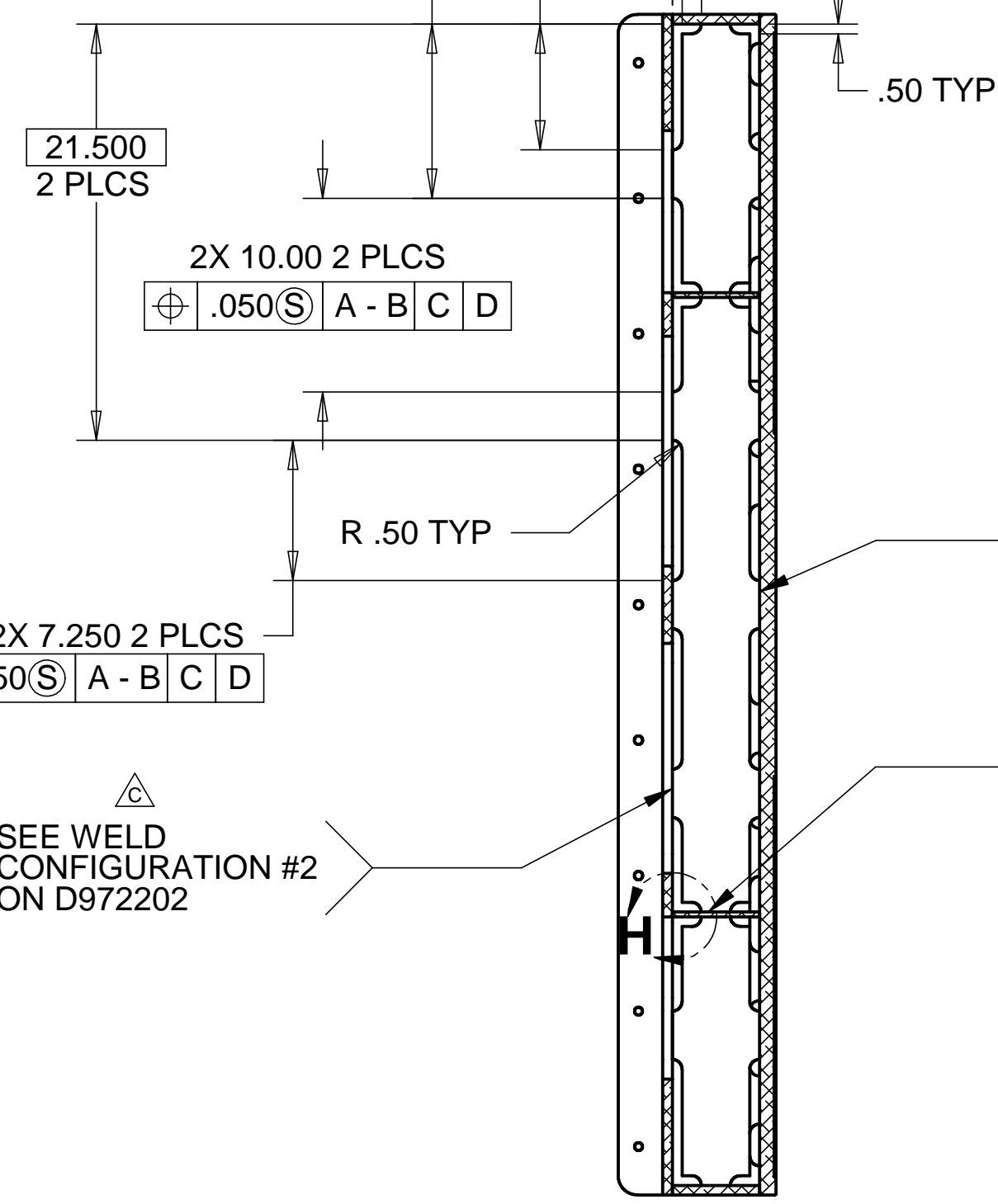
B

2X 6.50 2 PLCS
⊕ .050(S) A - B | C | D

2X 9.000
2 PLCS

8X .50 4 PLCS
⊕ .050(S) A - B | C | D

6X 1.50 4 PLCS
⊕ .050(S) A - B | C | D



SECTION E - E

SEE WELD CONFIGURATION #2 ON D972202

SEE WELD CONFIGURATION #2 ON D972202

2X 7.250 2 PLCS
⊕ .050(S) A - B | C | D

SEE WELD CONFIGURATION #2 ON D972202

SEE WELD CONFIGURATION #14 ON D972202

A

A

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010		ANGULAR = +/- .30° SURFACE FINISH = 250	
FINISH ALL MACHINED SURFACES 64 RMS	SIGNATURE ROGER L. SMITH	DATE 5-28-97	TITLE HYTEC, INC LIGO BSC SUPPORT TABLE WELDMENT
PART NO. D972212-1	DRAWN ROGER L. SMITH	5-28-97	
	CHECKED HARRY SALAZAR	6-6-97	
	ENGR. T. THOMPSON	7-10-97	
	APPROVED T. THOMPSON	7-10-97	DWG. NO. D972212
			SIZE D
			SHEET NO. 2 of 3
			REVISION D

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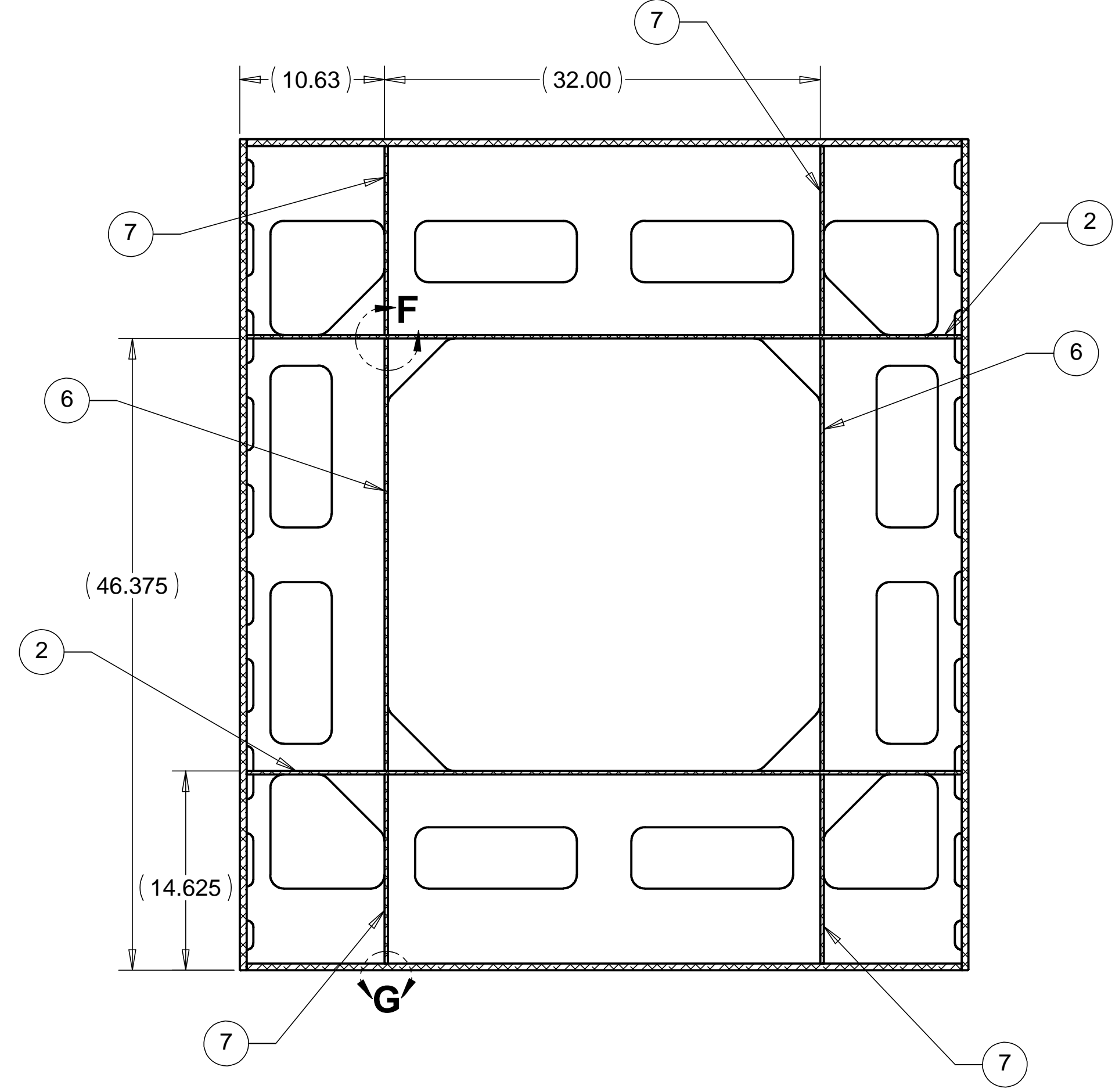
2

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972212-A FOR CHANGE LIST	11/03/97	T. THOMPSON
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C	SEE ECN# D972212-C FOR CHANGE LIST	03/24/98	T. THOMPSON
D	SEE ECN# D972212-D FOR CHANGE LIST	04/23/99	T. THOMPSON

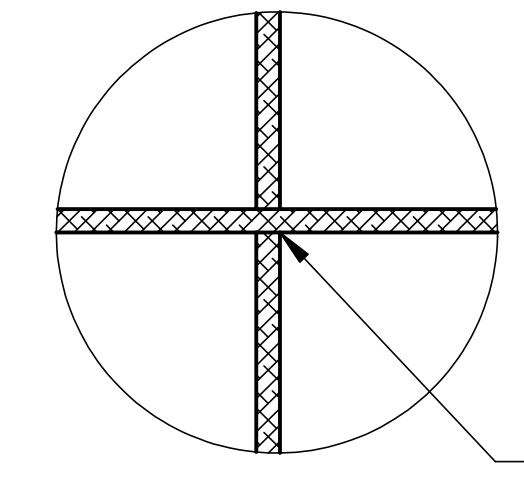
D

D



SECTION B-B FROM SHEET D1

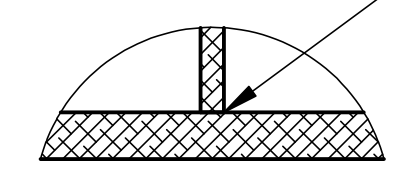
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DETAIL F SCALE 1:2

SEE WELD CONFIGURATION #4 ON D972202

△ △ △



DETAIL G SCALE 1:2

SEE WELD CONFIGURATION #17 ON D972202

C

C

B

B

A

A

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PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES- DECIMALS ANGULAR = +/- .30° .X = +/- .1 .XX = +/- .03 .XXX = +/- .010 SURFACE FINISH = 250	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC TITLE LIGO BSC SUPPORT TABLE WELDMENT
			FINISH ALL MACHINED SURFACES 64 RMS
PART NO. D972212-1	SCALE 1/8	REVISION D	