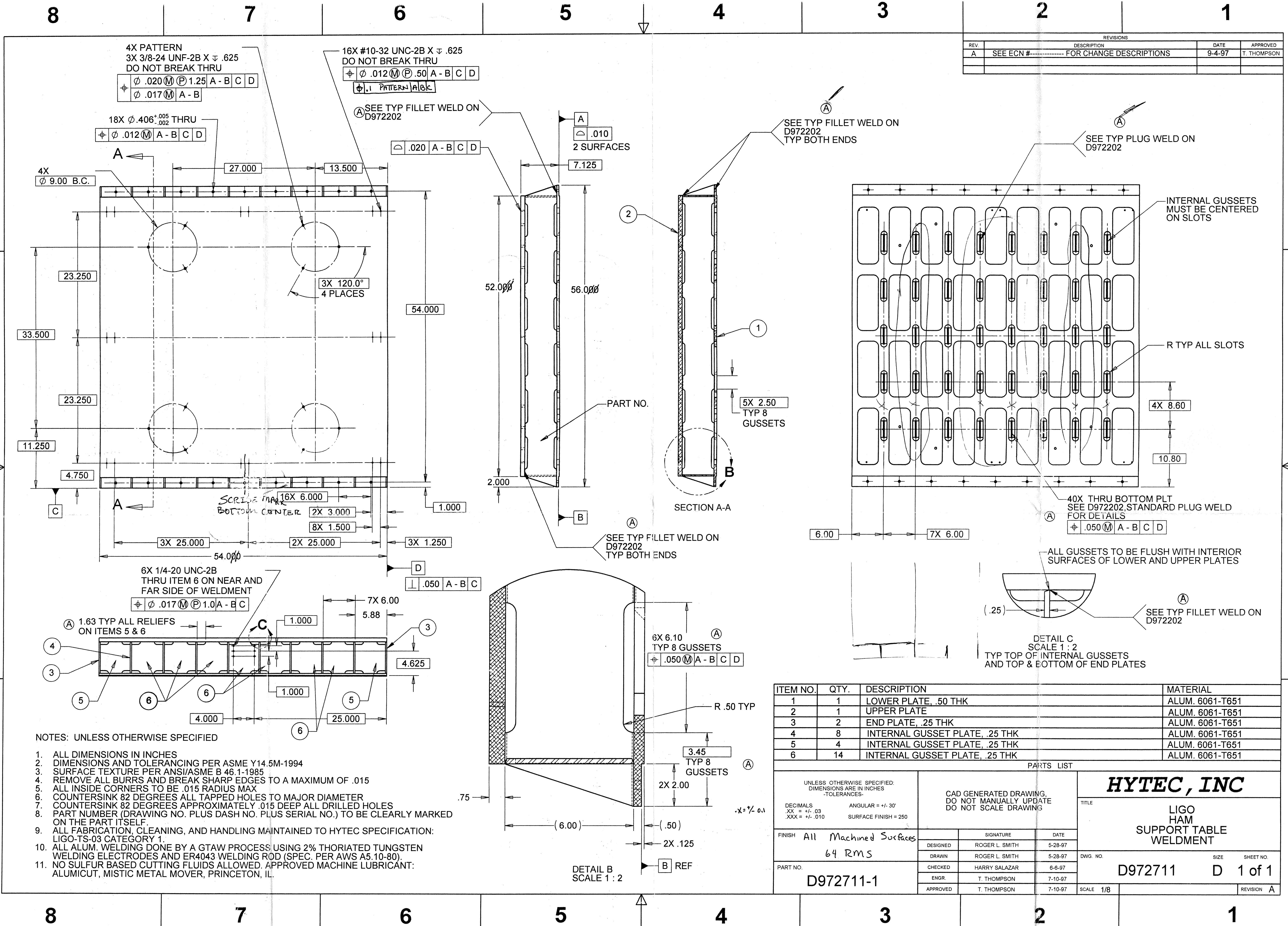


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN #..... FOR CHANGE DESCRIPTIONS	9-4-97	T. THOMPSON



4X PATTERN
3X 3/8-24 UNF-2B X .625
DO NOT BREAK THRU
 $\phi .020 \text{ (M)} \text{ (P)} 1.25 \text{ A - B C D}$
 $\phi .017 \text{ (M)} \text{ A - B}$

16X #10-32 UNC-2B X .625
DO NOT BREAK THRU
 $\phi .012 \text{ (M)} \text{ (P)} .50 \text{ A - B C D}$
 $\phi .1 \text{ PATTERN A/B/C/D}$

18X $\phi .406^{+.005}_{-.002}$ THRU
 $\phi .012 \text{ (M)} \text{ A - B C D}$

4X $\phi 9.00$ B.C.

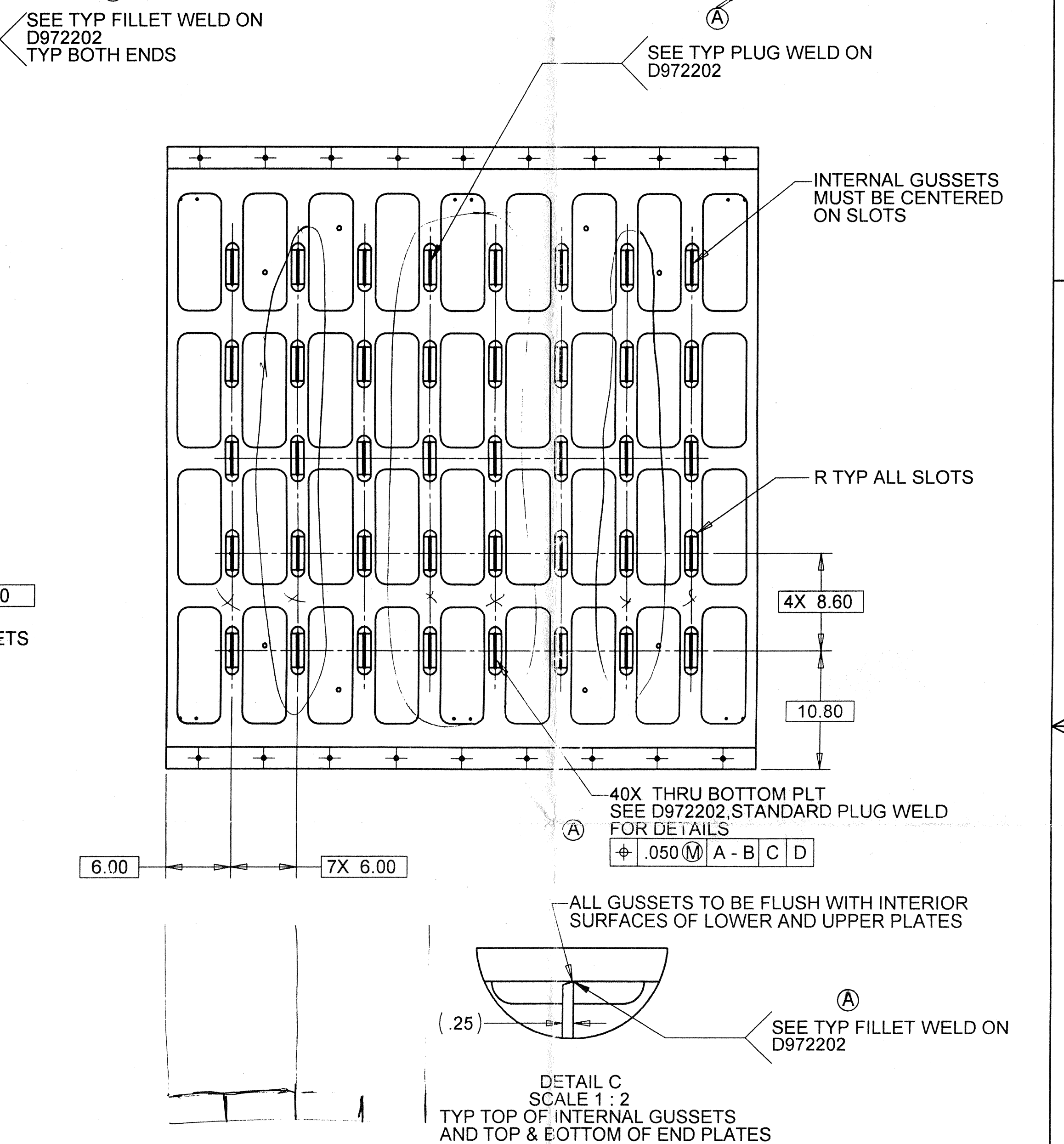
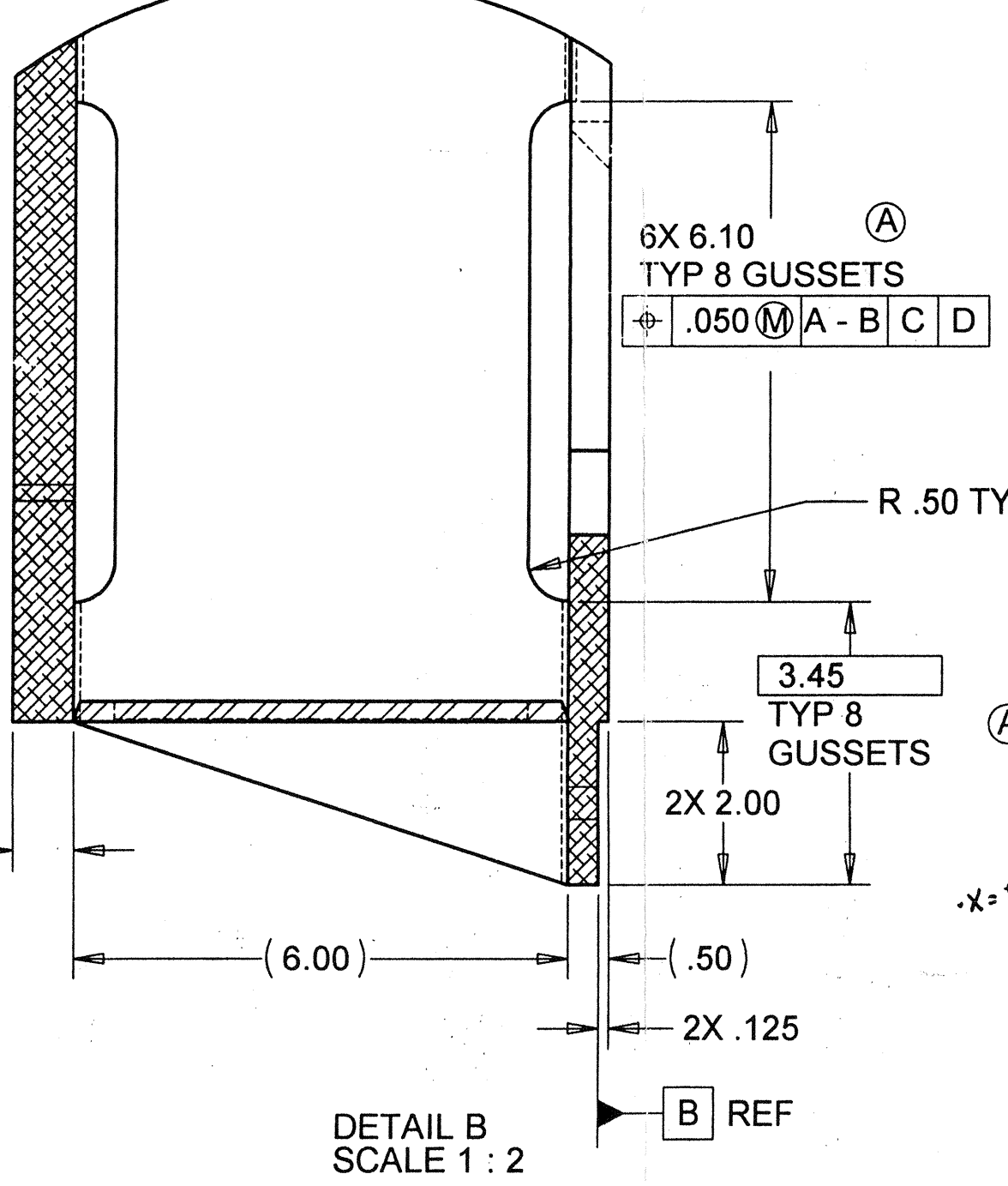
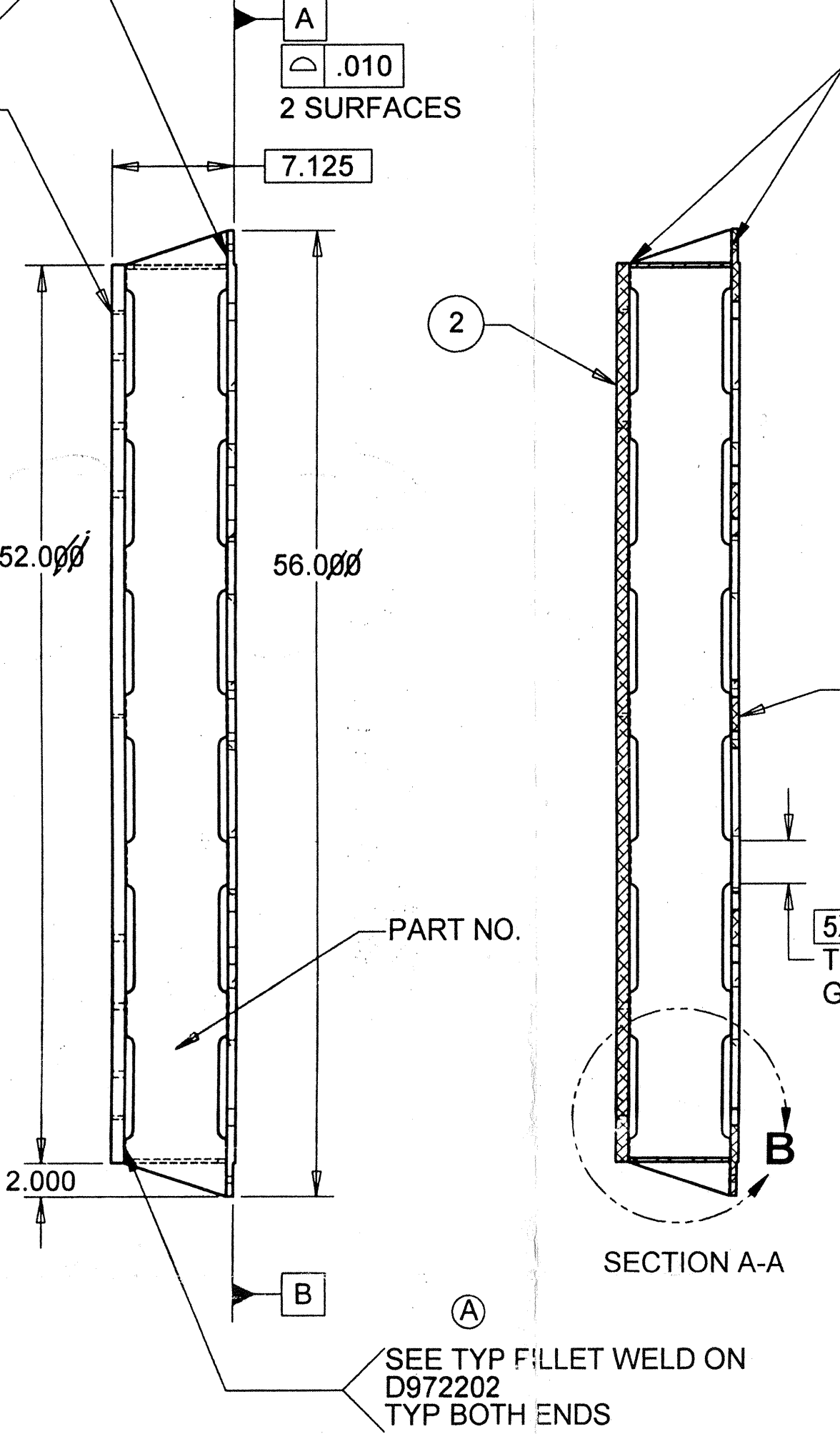
3X 120.0°
4 PLACES

16X 6.000
2X 3.000
8X 1.500
3X 1.250

6X 1/4-20 UNC-2B
THRU ITEM 6 ON NEAR AND
FAR SIDE OF WELDMENT
 $\phi .017 \text{ (M)} \text{ (P)} 1.0 \text{ A - B C}$

1.63 TYP ALL RELIEFS
ON ITEMS 5 & 6

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



ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	LOWER PLATE, .50 THK	ALUM. 6061-T651
2	1	UPPER PLATE	ALUM. 6061-T651
3	2	END PLATE, .25 THK	ALUM. 6061-T651
4	8	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651
5	4	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651
6	14	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES-			HYTEC, INC	
DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		
FINISH All Machined Surfaces 64 RMS	SIGNATURE ROGER L. SMITH	DATE 5-28-97	TITLE LIGO HAM SUPPORT TABLE WELDMENT	
DRAWN HARRY SALAZAR	DATE 5-28-97	DWG NO.		
CHECKED T. THOMPSON	DATE 7-10-97	SIZE		
APPROVED T. THOMPSON	DATE 7-10-97	SHEET NO.		
PART NO. D972711-1	SCALE 1/8		D972711	D 1 of 1
			REVISION	A