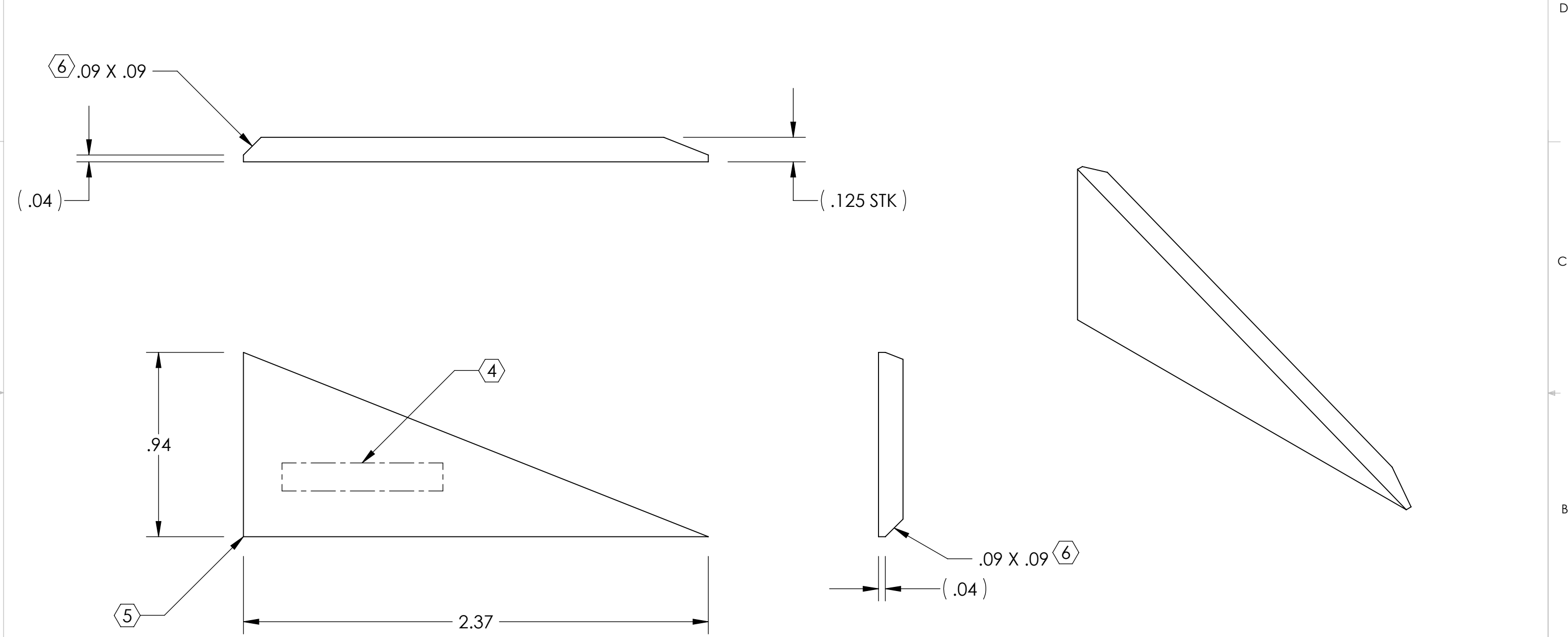




REV.	DATE	DCN #	DRAWING TREE #
V1	03 MAR 2009	E080446	E080191



This piece is part of a weldment. Dimensions shown are approximate; weld induced shrinkage or fill, and post weld annealing and machining considerations are not included. See D070442-v1 for required dimensions of structure after welding.

NOTES: (UNLESS OTHERWISE SPECIFIED)			DIMENSIONS ARE IN INCHES		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP														
1. REMOVE ALL SHARP EDGES, R.02 MIN. 2. DO NOT SCALE FROM DRAWING. 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (SSTL)			TOLERANCES: .XX ± .01 .XXX ± .005			SYSTEM ADVANCED LIGO													
④ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.			ANGULAR ± 0.5°		SUB-SYSTEM SUS														
⑤ WELDER TO CHAMFER CORNER TO FIT WELD BEAD. ⑥ HALF OF PARTS TO HAVE CHAMFER ON OPPOSITE FACE. 7. L AND LN VARIANTS OF 304 SSTL ARE ACCEPTABLE.			MATERIAL 304 SSTL		NEXT ASSY HLTS STRUCTURAL WELDMENT														
			FINISH 32 μinch		PART NAME TOP GUSSET, SHORT														
			<table border="1"> <tr> <th></th> <th>NAME</th> <th>DATE</th> </tr> <tr> <td>DESIGNER</td> <td>D. BRIDGES</td> <td>4 MAR 2009</td> </tr> <tr> <td>DRAWN</td> <td>B. MOORE</td> <td>26 MAR 2009</td> </tr> <tr> <td>CHECKED</td> <td>D. BRIDGES</td> <td>26 MAR 2009</td> </tr> </table>			NAME	DATE	DESIGNER	D. BRIDGES	4 MAR 2009	DRAWN	B. MOORE	26 MAR 2009	CHECKED	D. BRIDGES	26 MAR 2009	SIZE B	DWG. NO. D070582	REV. V1
	NAME	DATE																	
DESIGNER	D. BRIDGES	4 MAR 2009																	
DRAWN	B. MOORE	26 MAR 2009																	
CHECKED	D. BRIDGES	26 MAR 2009																	
			SCALE: 2:1 PROJECTION: 		SHEET 1 OF 1														

D070582_Advanced_LIGO_SUS_HLTS_Structure_Short_Top_Gusset, PART PDM REV: X-001, DRAWING PDM REV: X-002