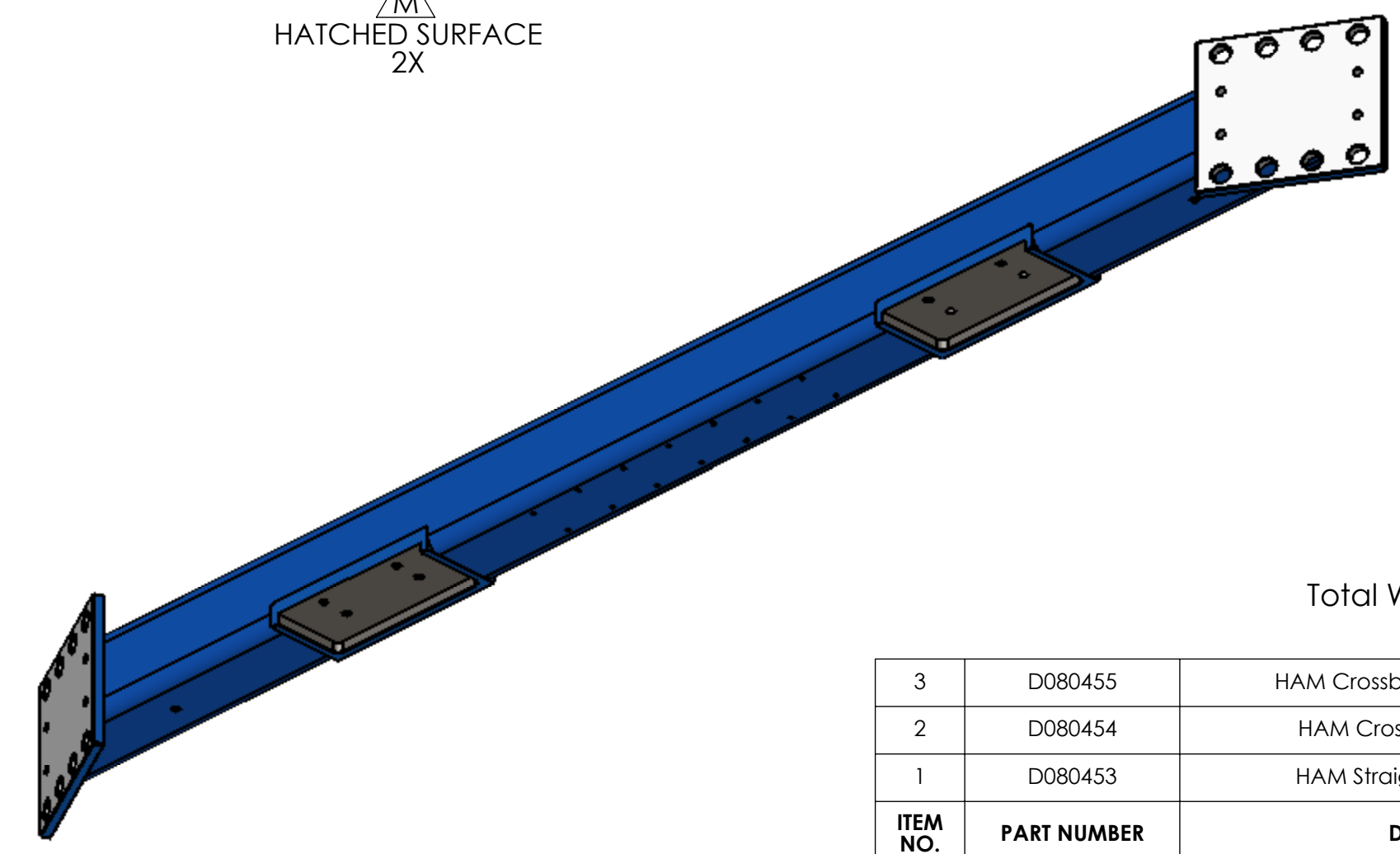
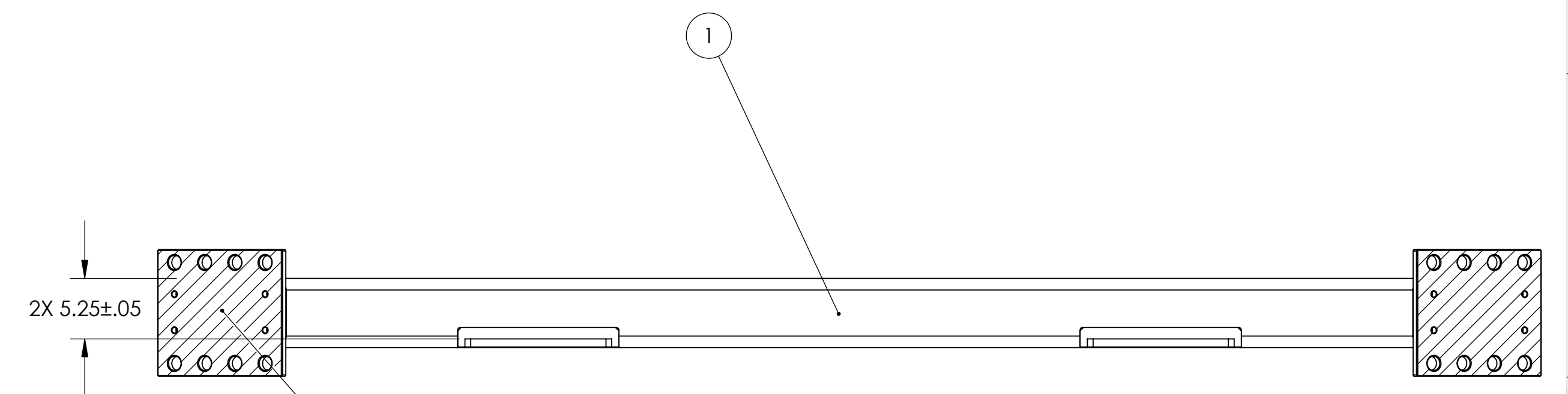
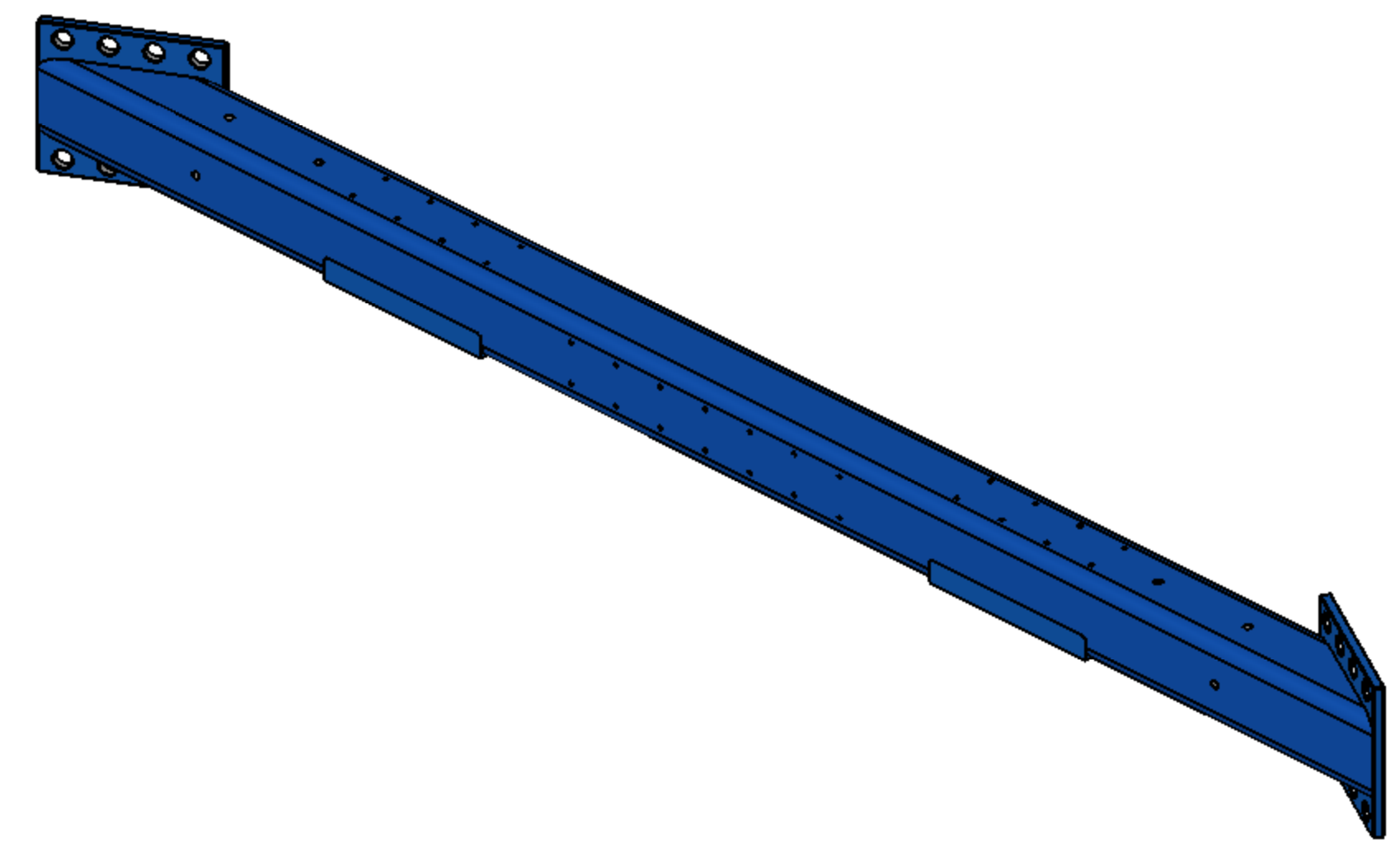
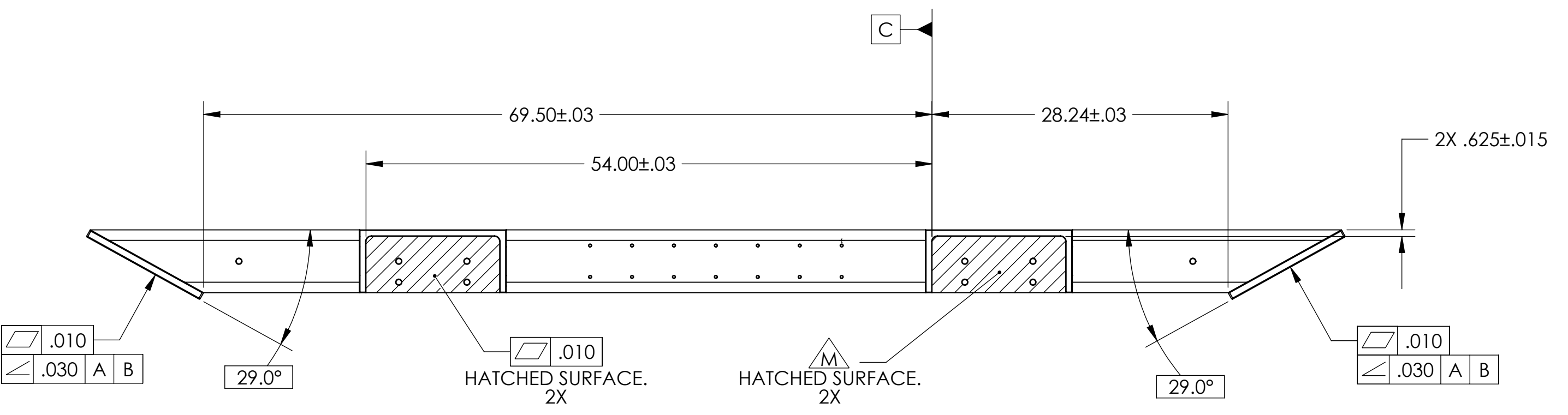
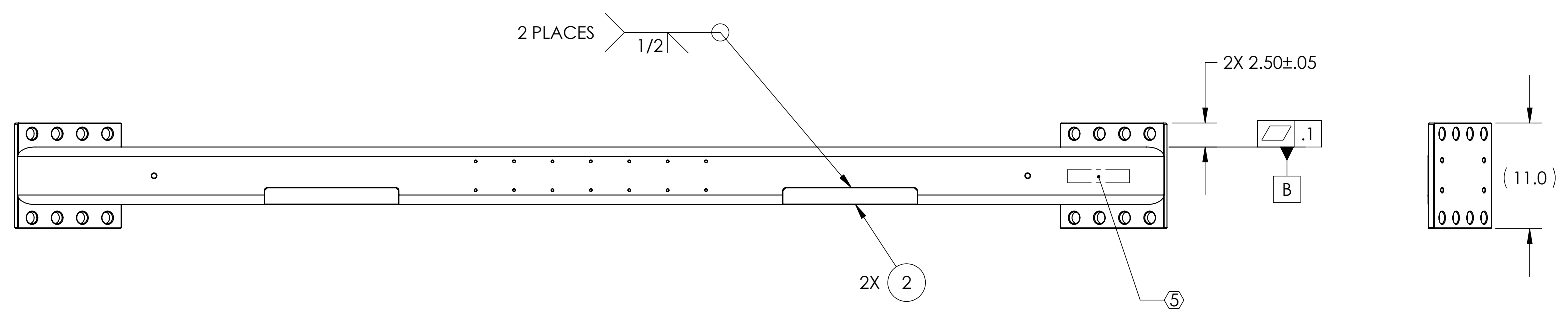
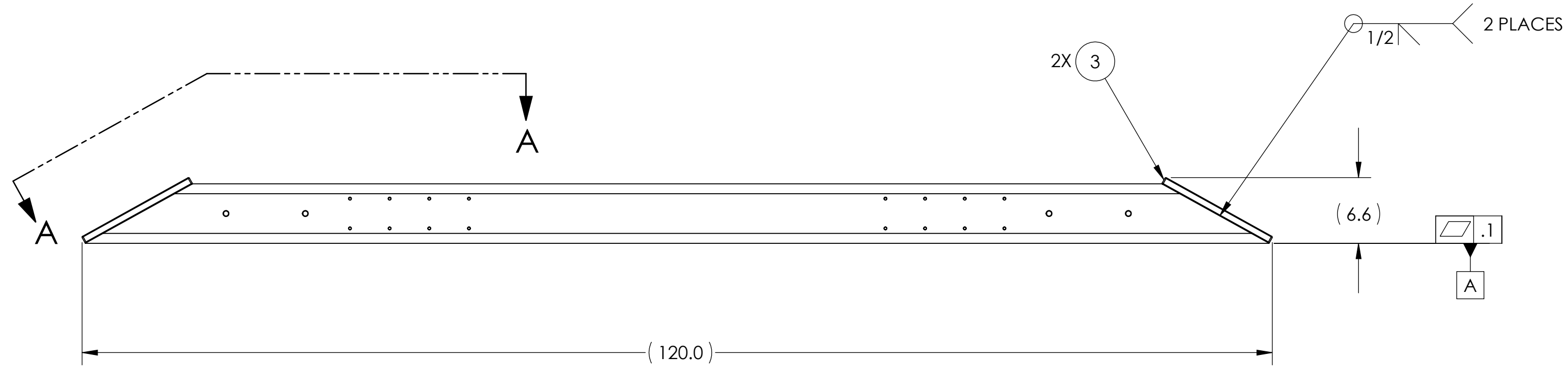
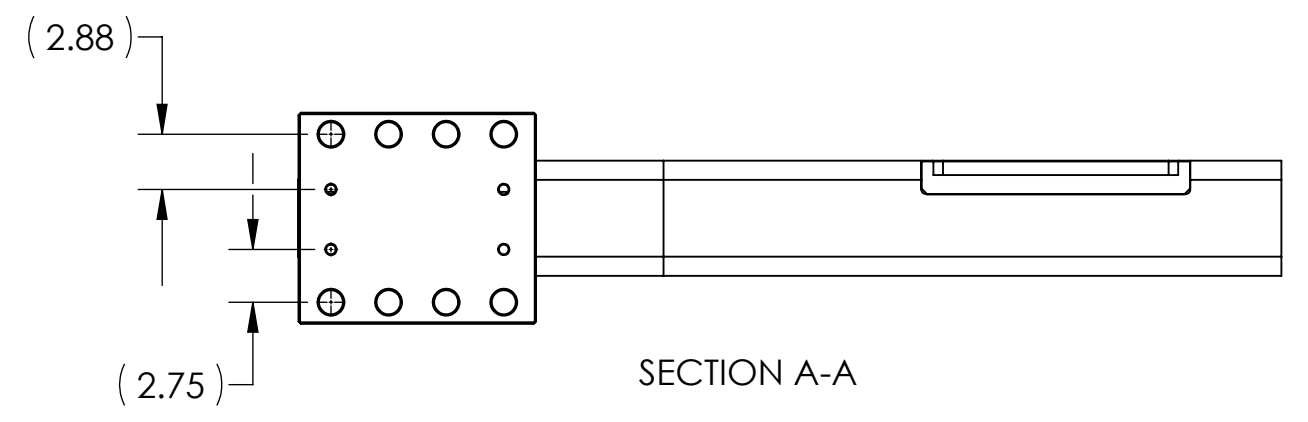


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .25" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: D080456-v2, S/N 001.
 6. STRUCTURE MUST SATISFY STATED TOLERANCES AFTER WELDING. IF NECESSARY, SURFACES ON PLATES MAY BE MACHINED AFTER WELDING.
 7. PLUG ALL SCREW HOLES, BOTH TAPPED AND THRU.
 8. PAINT ALL SURFACES, EXCEPT WHERE INDICATED BY Δ . USE MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL). PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2.
 9. APPLY "OXISOLV RUST INHIBITOR" TO ALL UNPAINTED SURFACES, PER MFG INSTRUCTIONS. REMOVE PLUGS FROM ALL HOLES.

REV.	DATE	DCN #	DRAWING TREE #
v1/ 01	04 Aug 2008	Initial release for LASTI prototype.	
v2	27 Aug 2009	E0900258	



Total Weight: 476 lbs

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Full Assy/ QTY.
3	D080455	HAM Crossbeam Mounting Flange	ASTM A36 Steel	2
2	D080454	HAM Crossbeam Clamp Plate	ASTM A36 Steel	2
1	D080453	HAM Straight Crossbeam Tube	A500 Grade B Steel	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .015
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL
See BOM

FINISH
See Notes

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SEI**

NEXT ASSY: **HAM SUPPORT STRUCTURE**

PART NAME
HAM Straight Crossbeam Weldment

DESIGNER	CHECKER	APPROVAL	DATE	SIZE	DWG. NO.	REV.
A. Stein	-	K. Mason	18 Jun 2008	D	D080456	v2
A. Stein	-	K. Mason	18 Jun 2008			
-	-	K. Mason	27 Aug 2009			

SCALE: 1:10 PROJECTION:

SHEET 1 OF 1

D080456-HAM_Straight_Crossbeam_Weldment_PART_PDM_REV-X-009_DRAWING_PDM_REV-X-006