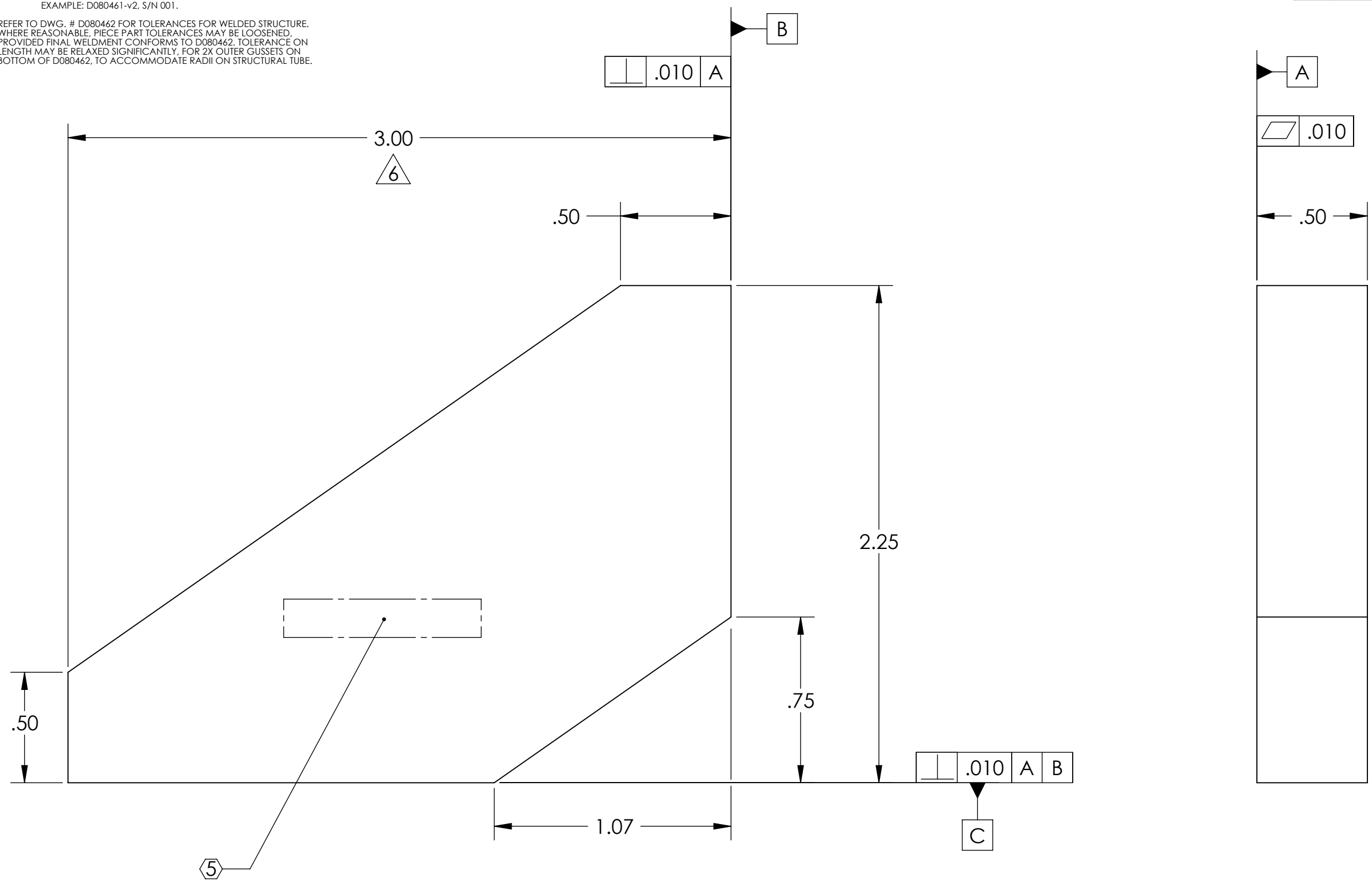


D080461_HAM_Crossbeam_Connector_Gusset, PART PDM REV: X-009, DRAWING PDM REV: X-005

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 .07" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: D080461-v2, S/N 001.
 6 REFER TO DWG. # D080462 FOR TOLERANCES FOR WELDED STRUCTURE. WHERE REASONABLE, PIECE PART TOLERANCES MAY BE LOOSENED, PROVIDED FINAL WELDMENT CONFORMS TO D080462. TOLERANCE ON LENGTH MAY BE RELAXED SIGNIFICANTLY, FOR 2X OUTER GUSSETS ON BOTTOM OF D080462, TO ACCOMMODATE RADII ON STRUCTURAL TUBE.

| REV. | DATE | DCN # | DRAWING TREE # |
|---------|-------------|--------------------------------------|----------------|
| v1 / 01 | 05 Aug 2008 | Initial release for LASTI prototype. | |
| v2 | 28 Aug 2009 | E0900261 | |



Total Weight: 0.6 lbs

| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) | | | | LIGO | | PART NAME | |
|--|--|-------------------------------------|--|---|--|--------------------------------|--|
| DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5° | | | | CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | HAM Crossbeam Connector Gusset | |
| 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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. | | | | SYSTEM ADVANCED LIGO | | SUB-SYSTEM SEI | |
| MATERIAL ASTM A36 Steel | | | | FINISH 125 μinch | | NEXT ASSY D080462 | |
| | | DESIGNER A. Stein 18 Jun 2008 | | SIZE B | | DWG. NO. D080461 | |
| | | DRAFTER A. Stein 18 Jun 2008 | | REVISION v2 | | SCALE: 2:1 | |
| | | CHECKER - | | SHEET 1 OF 1 | | PROJECTION: | |
| | | APPROVAL K. Mason 26 Aug 2009 | | SHEET 1 OF 1 | | SHEET 1 OF 1 | |