



ISOMETRIC VIEW

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 ANGULAR ± 0.5°		SYSTEM ADVANCED LIGO SUB-SYSTEM SUS NEXT ASSY HLTS STRUCTURAL WELDMENT	
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-VV, S/N 001. A VIBRATORY TOOL MAY BE USED.		MATERIAL 304 SSTL FINISH 32 μinch		PART NAME LOWER FRONT GUSSET	
5. L AND LN VARIANTS OF 304 SSTL ARE ACCEPTABLE. 6. HALF OF PARTS TO HAVE CHAMFER ON OPPOSITE FACE.		DESIGNER D. BRIDGES 4 MAR 2009 DRAWN B. MOORE 25 MAR 2009 CHECKED D. BRIDGES 25 MAR 2009		SIZE DWG. NO. D070576 REV. V1 SCALE: 1:1 PROJECTION:  SHEET 1 OF 1	