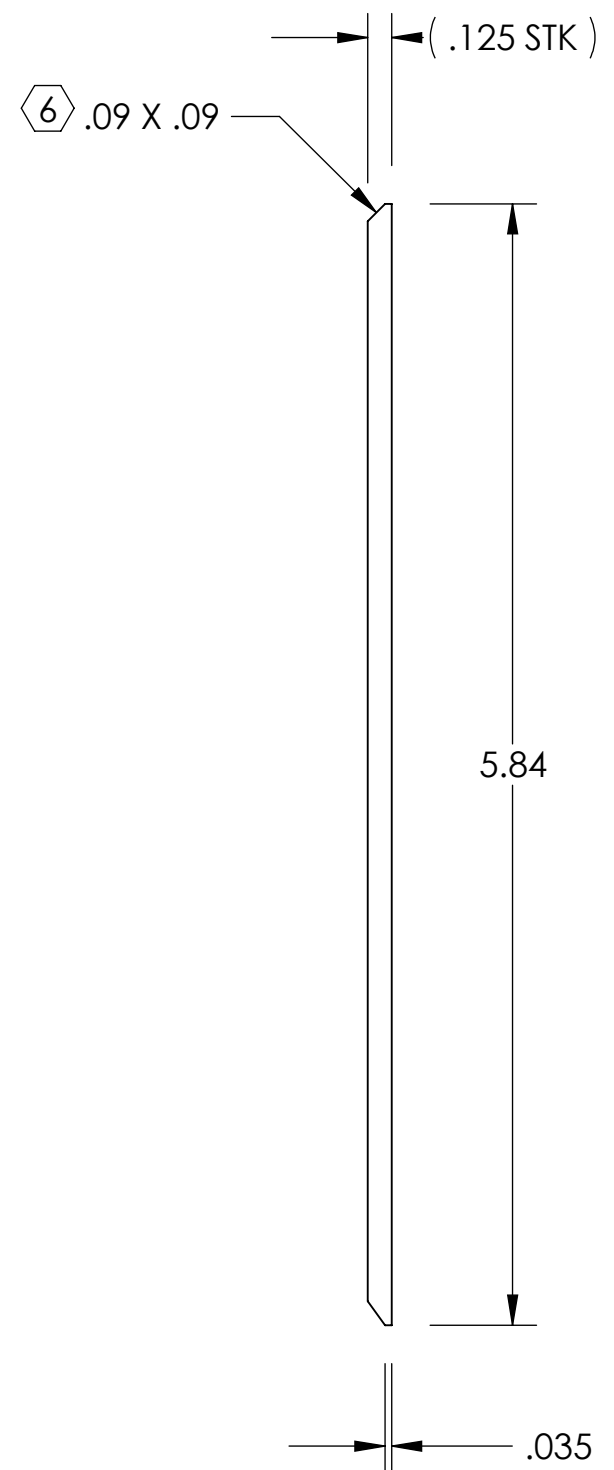
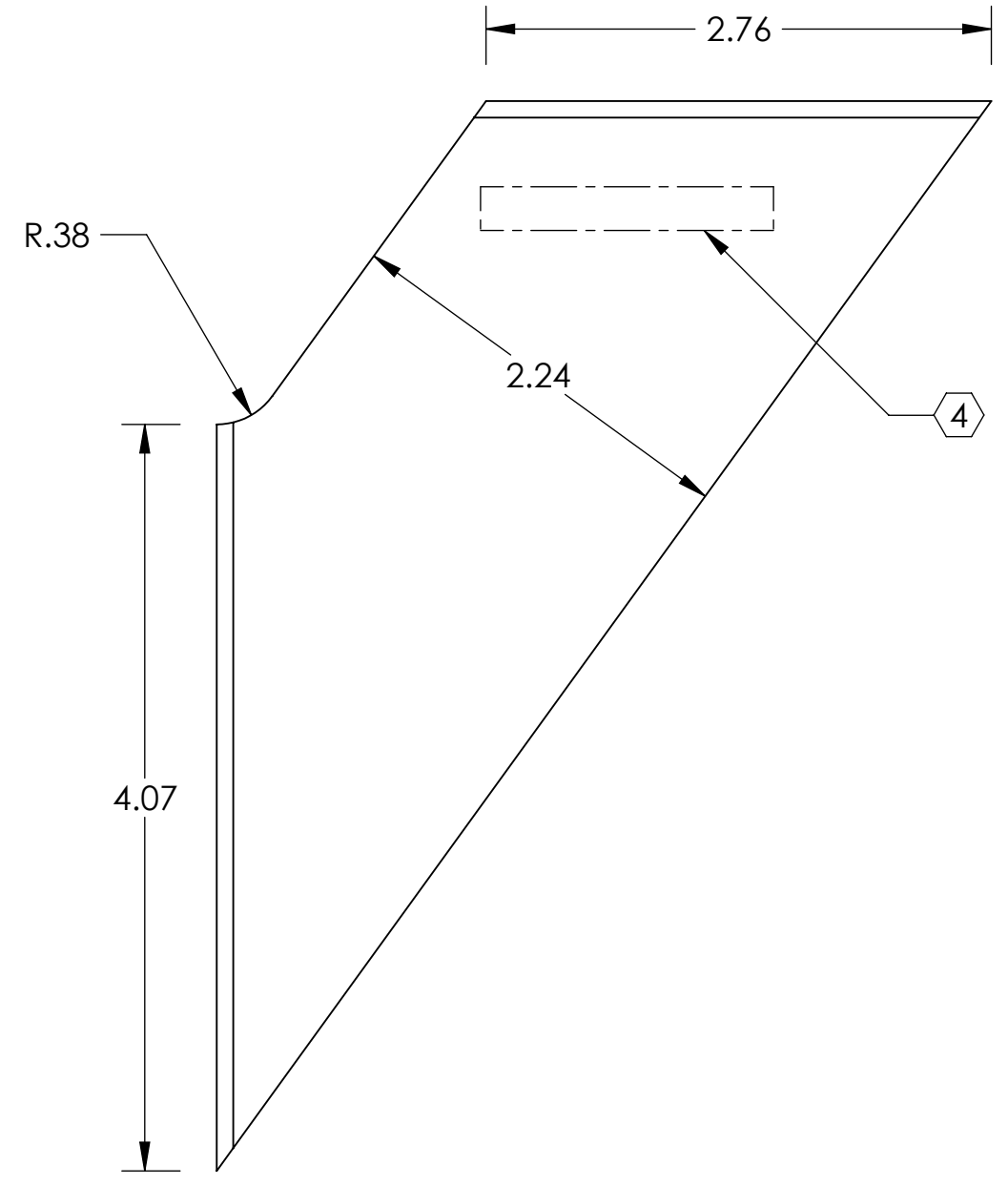


ISOMETRIC VIEW



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	
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. 5. L AND LN VARIANTS OF 304 SSTL ARE ACCEPTABLE. 6. HALF OF PARTS TO HAVE CHAMFER ON OPPOSITE FACE.		MATERIAL 304 SSTL		SUB-SYSTEM SUS		
FINISH 32 μinch		NEXT ASSY HLTS STRUCTURAL WELDMENT		PART NAME UPPER FRONT GUSSET		
DESIGNER	G. SCARBOROUGH	DATE	14 DEC 2007	SIZE	DWG. NO.	REV.
DRAWN	B. MOORE	DATE	26 MAR 2009	C	D070579	V1
CHECKED	D. BRIDGES	DATE	26 MAR 2009	SCALE:	1:1	PROJECTION:
				SHEET 1 OF 1		