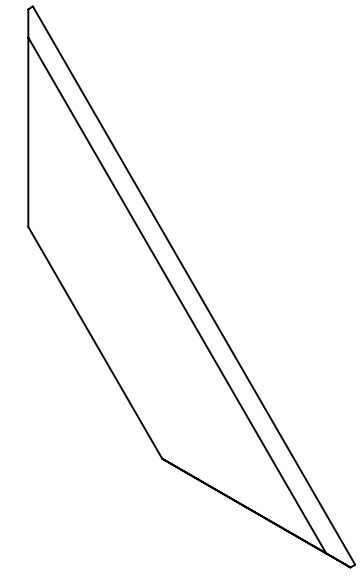
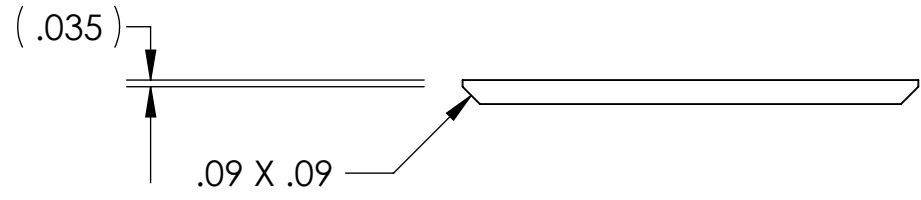


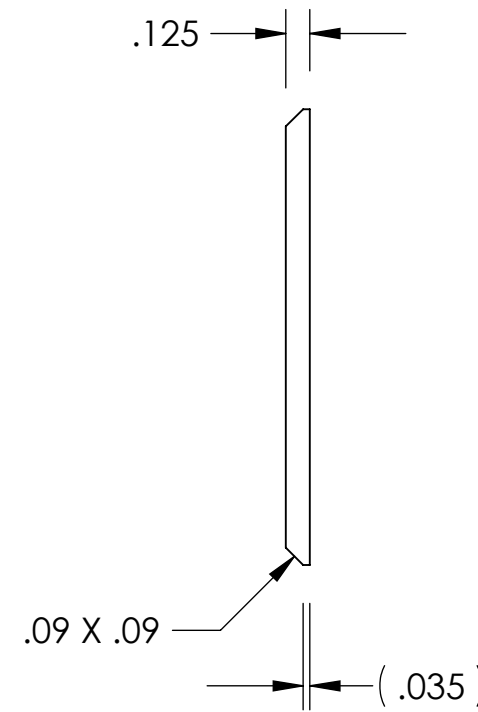
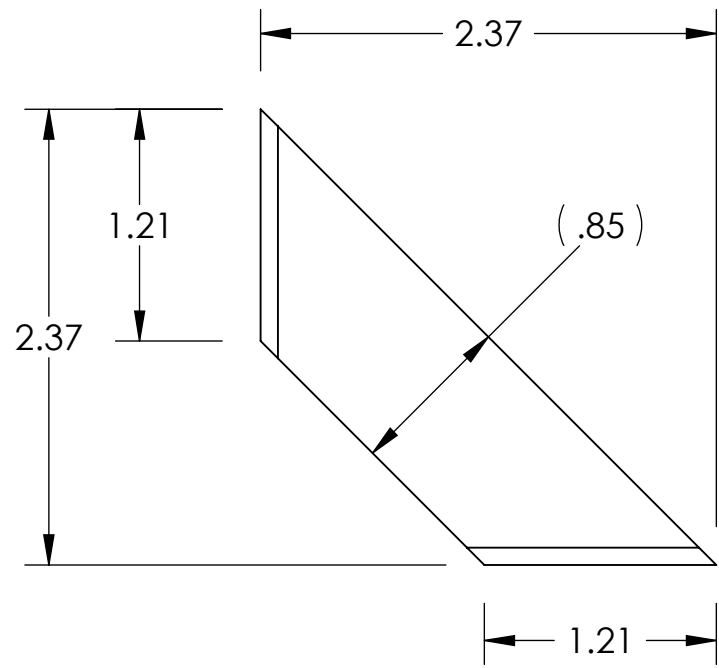
D070580_Advanced_LIGO_SUS_HLTS_Structure_Top_Gusset, PART PDM REV: V1-003, DRAWING PDM REV: V1-001

NOTES CONTINUED:
 5. THIS PIECE IS ONE 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 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				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.		TOP GUSSET	
						MATERIAL 304 OR 304L SSSL FINISH 63 μinch	
SYSTEM ADVANCED LIGO SUB-SYSTEM SUS NEXT ASSY STRUCTURAL WELDMENT, HLTS				DESIGNER D. BRIDGES 29 AUG 2010 DRAFTER D. BRIDGES 29 AUG 2010 CHECKER M. MEYER 30 AUG 2010 APPROVAL		SIZE DWG. NO. B D070580 REV. v2	
				SCALE: 1:1 PROJECTION:			