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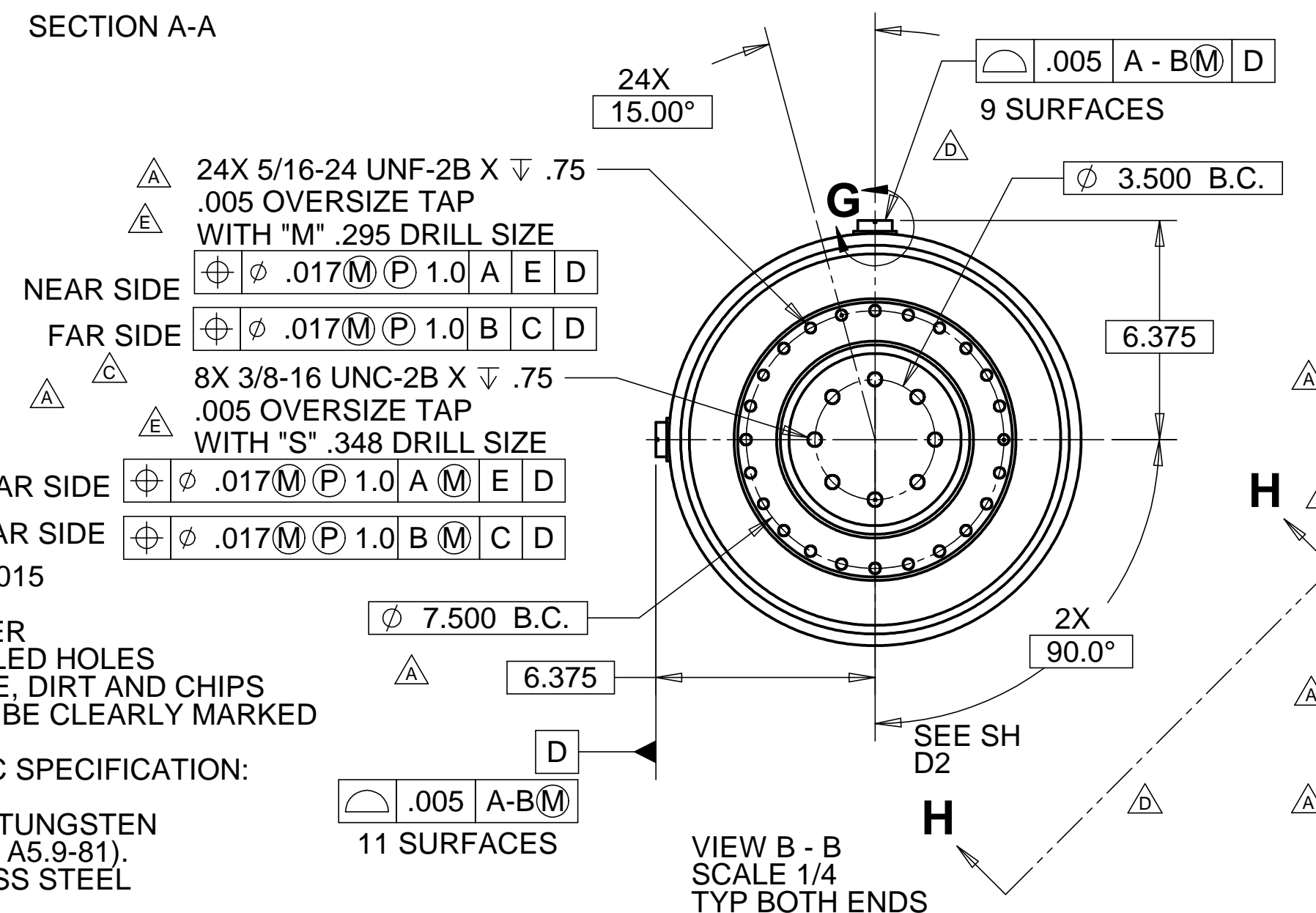
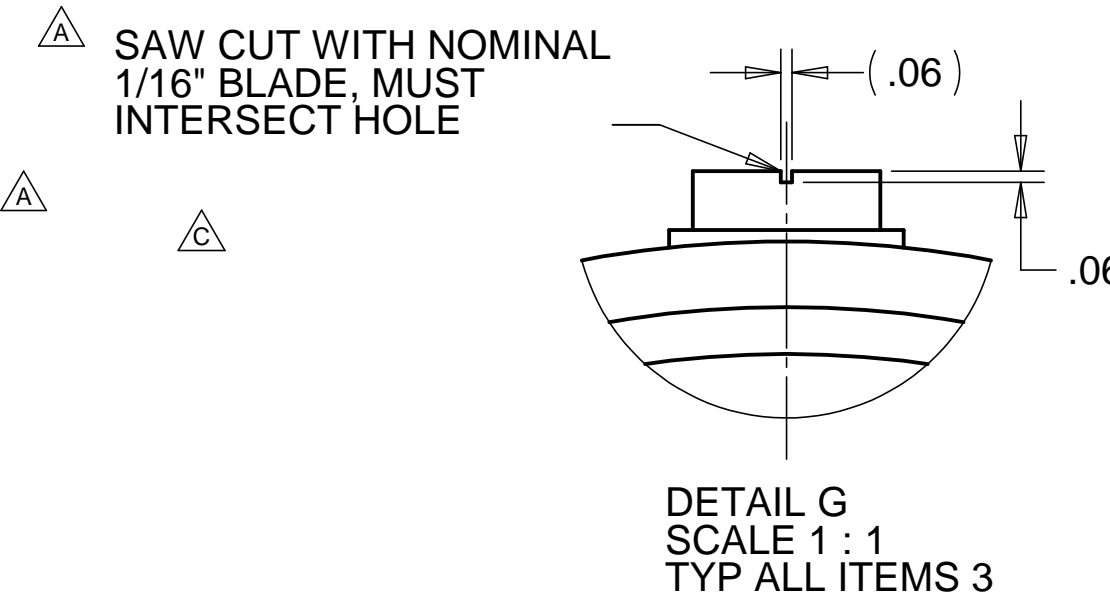
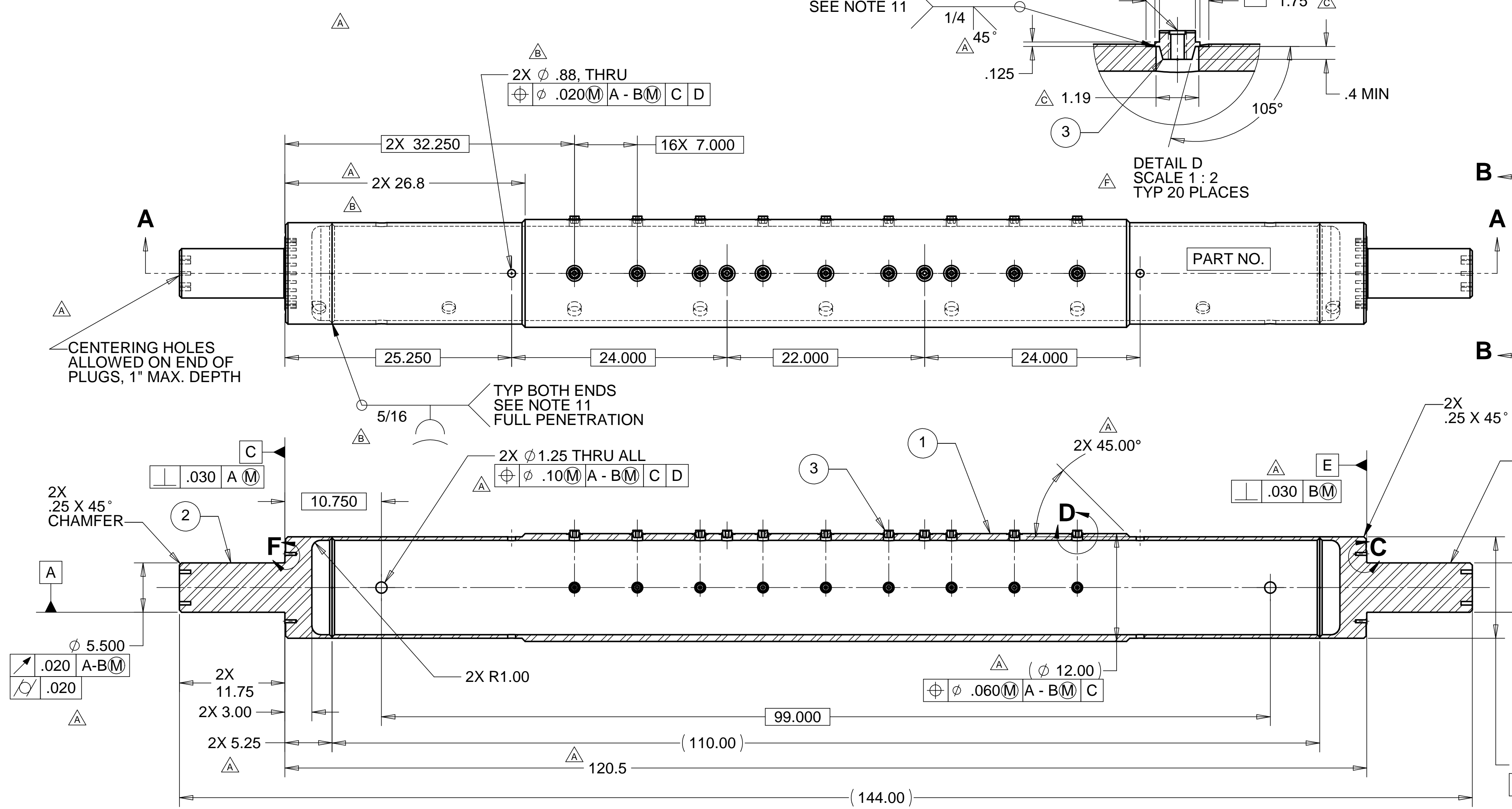
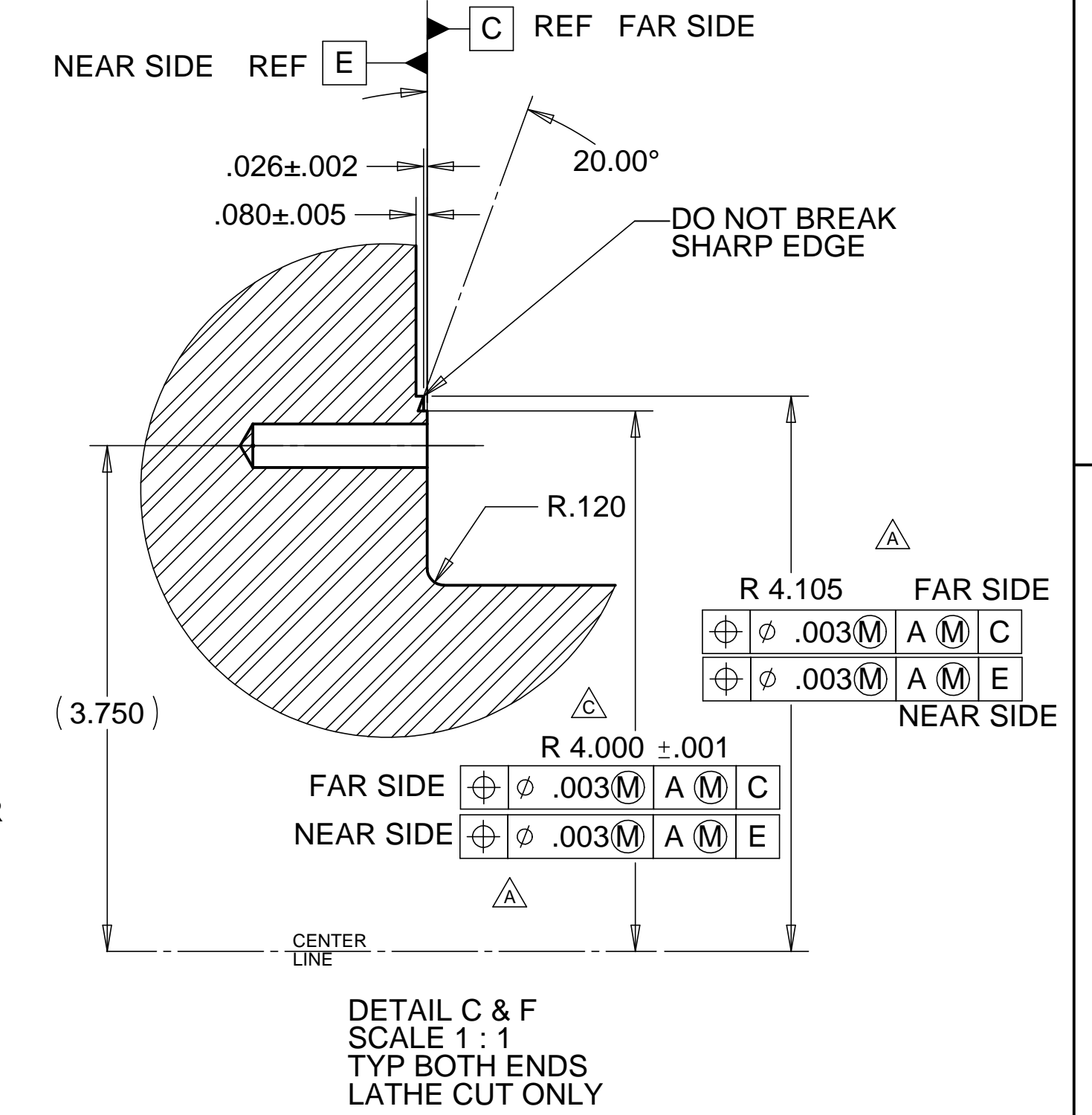
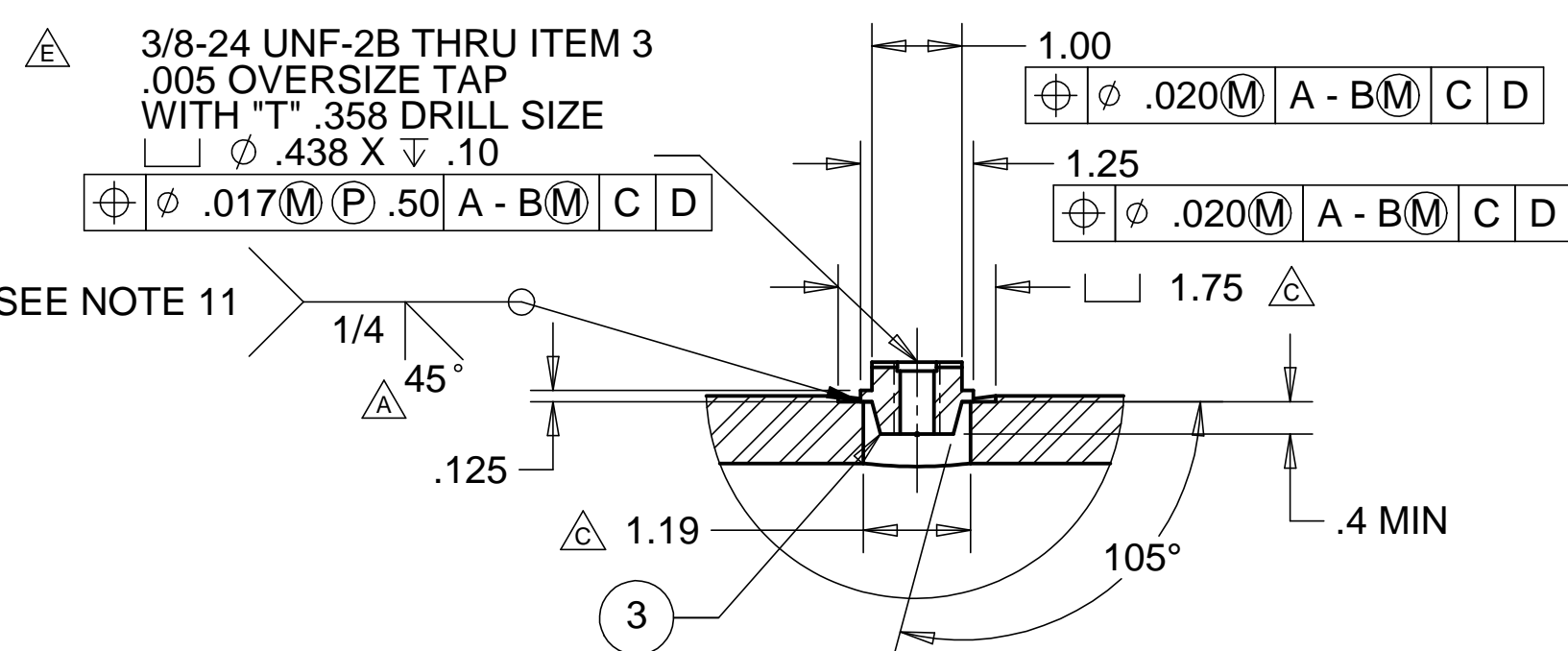
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972121-A FOR CHANGE LIST	01/03/97	T. THOMPSON
B	SEE ECN# D972121-B FOR CHANGE LIST	01/15/98	T. THOMPSON
C	SEE ECN# D972121-C FOR CHANGE LIST	04/16/98	T. THOMPSON
D	SEE ECN# D972121-D FOR CHANGE LIST	06/05/98	T. THOMPSON
E	SEE ECN# D972121-E FOR CHANGE LIST	08/19/98	T. THOMPSON
F	SEE ECN# D972121-F FOR CHANGE LIST	04/23/99	T. THOMPSON



WEIGHT: 1040.5 lbs.

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .03/.06 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION: LIGO-TS-03 CATEGORY 1.
- ALL STAINLESS STEEL WELDING DONE BY A GTAW PROCESS USING TUNGSTEN WELDING ELECTRODES AND ER308L WELDING ROD (SPEC. PER AWS A5.9-81).
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED STAINLESS STEEL MACHINE LUBRICANT: HANSTERFER S-500CF.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	12.00 OD X .75 WALL TUBE	304 SST
2	2	END PLUGS	304 SST TIFT 372
3	20	1.25 DIA. X 225 LG INSERT	304 SST

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		<p align="center">HYTEC, INC</p> <p align="center">LIGO BSC SUPPORT TUBE WELDMENT</p>		
DECIMALS X = +/- .1 XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250					
FINISH ALL MACHINED SURFACES 64 RMS	SIGNATURE		DATE	TITLE		
PART NO. D972121-1	DESIGNED	ROGER L. SMITH	5-28-97	DWG. NO.	D972121	
	DRAWN	ROGER L. SMITH	5-28-97	SIZE		D
	CHECKED	HARRY SALAZAR	6-6-97	SHEET NO.		
ENGR.	T. THOMPSON	6-16-97	SCALE	1/8		
APPROVED	T. THOMPSON	6-16-97	REVISION		F	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972121-A FOR CHANGE LIST	01/03/97	T. THOMPSON
B	SEE ECN# D972121-B FOR CHANGE LIST	01/15/98	T. THOMPSON
C	SEE ECN# D972121-C FOR CHANGE LIST	04/16/98	T. THOMPSON
D	SEE ECN# D972121-D FOR CHANGE LIST	06/05/98	T. THOMPSON
E	SEE ECN# D972121-E FOR CHANGE LIST	08/19/98	T. THOMPSON
F	SEE ECN# D972121-F FOR CHANGE LIST	04/23/99	T. THOMPSON

D

D

C

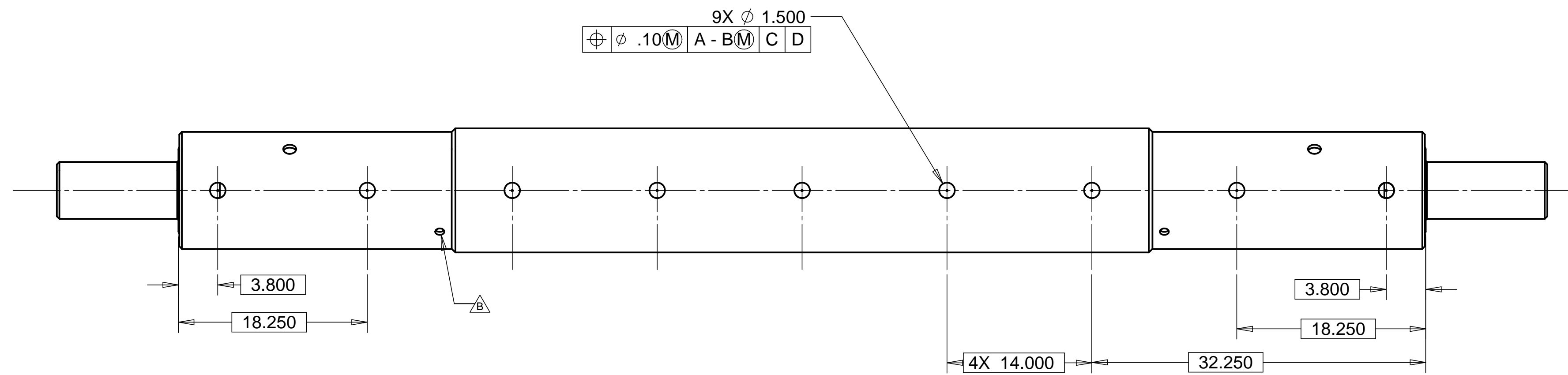
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VIEW **H-H**
FROM SHEET 1

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES- DECIMALS ANGULAR = +/- .30° .X = +/- .1 .XX = +/- .03 .XXX = +/- .010 SURFACE FINISH = 250	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC <small>TITLE</small> LIGO BSC SUPPORT TUBE WELDMENT
			<small>FINISH</small> ALL MACHINED SURFACES 64 RMS
<small>PART NO.</small> D972121-1	<small>DESIGNED</small> ROGER L. SMITH <small>CHECKED</small> HARRY SALAZAR <small>ENGR.</small> T. THOMPSON <small>APPROVED</small> T. THOMPSON	<small>DATE</small> 10-31-97 10-31-97 10-31-97	<small>SCALE</small> <small>REVISION</small> 1/8 F

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