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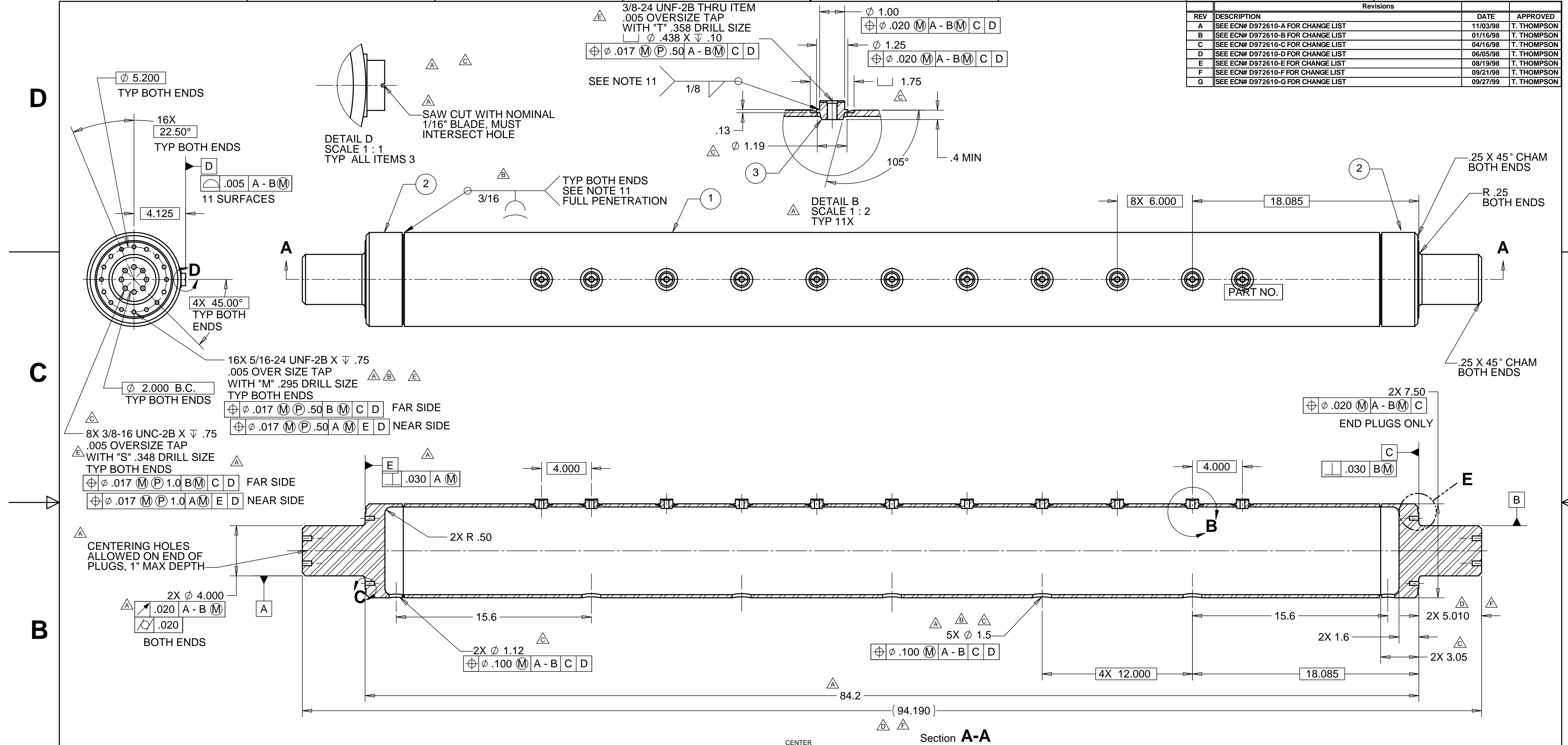
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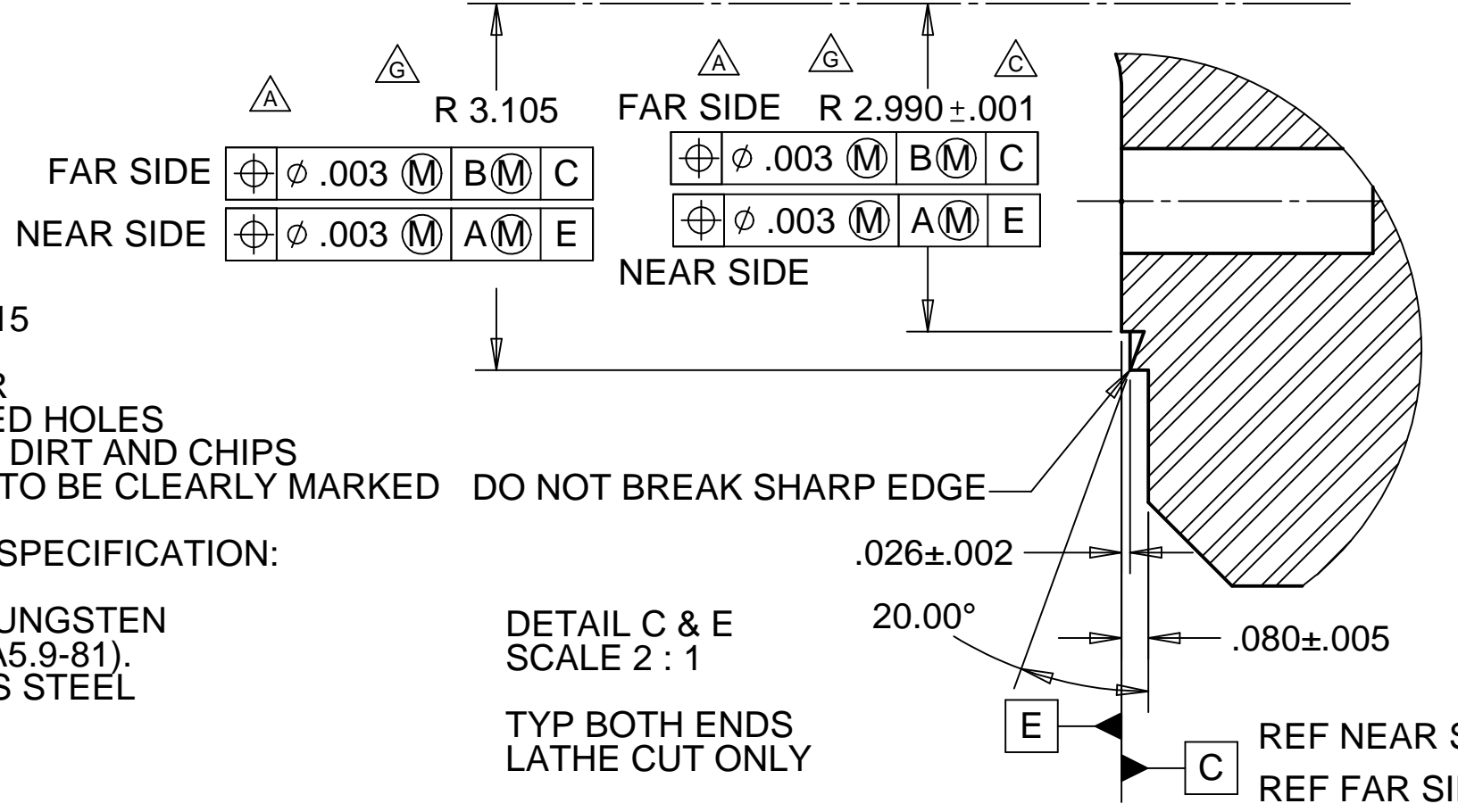
Revisions			
REV	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972610-A FOR CHANGE LIST	11/03/98	T. THOMPSON
B	SEE ECN# D972610-B FOR CHANGE LIST	01/16/98	T. THOMPSON
C	SEE ECN# D972610-C FOR CHANGE LIST	04/16/98	T. THOMPSON
D	SEE ECN# D972610-D FOR CHANGE LIST	06/05/98	T. THOMPSON
E	SEE ECN# D972610-E FOR CHANGE LIST	08/19/98	T. THOMPSON
F	SEE ECN# D972610-F FOR CHANGE LIST	09/21/98	T. THOMPSON
G	SEE ECN# D972610-G FOR CHANGE LIST	09/27/99	T. THOMPSON



WEIGHT: 201.34 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., DASH NO., REVISION NO., 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	7.50 O.D. X .25 WALL TUBE	304 SST
2	2	END PLUG	304 SST TFT 372
3	11	INSERT	304 SST

PARTS LIST

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		<p>HYTEC, INC</p> <p>TITLE: LIGO HAM SUPPORT TUBE WELDMENT</p>	
DECIMALS	ANGULAR = +/- .30°				
.X = +/- .1					
.XX = +/- .03	SURFACE FINISH = 250				
.XXX = +/- .010					
FINISH	ALL MACHINED SURFACES 64 RMS				
PART NO.	D972610-1				
DESIGNED	ROGER L. SMITH	DATE	5-28-97		
DRAWN	ROGER L. SMITH	DATE	5-28-97		
CHECKED	HARRY SALAZAR	DATE	6-6-97		
ENGR.	T. THOMPSON	DATE	6-16-97		
APPROVED	T. THOMPSON	DATE	6-16-97		
				SCALE	1/4
				DWG. NO.	D972610
				SIZE	D
				SHEET NO.	1 of 1
				REVISION	G

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