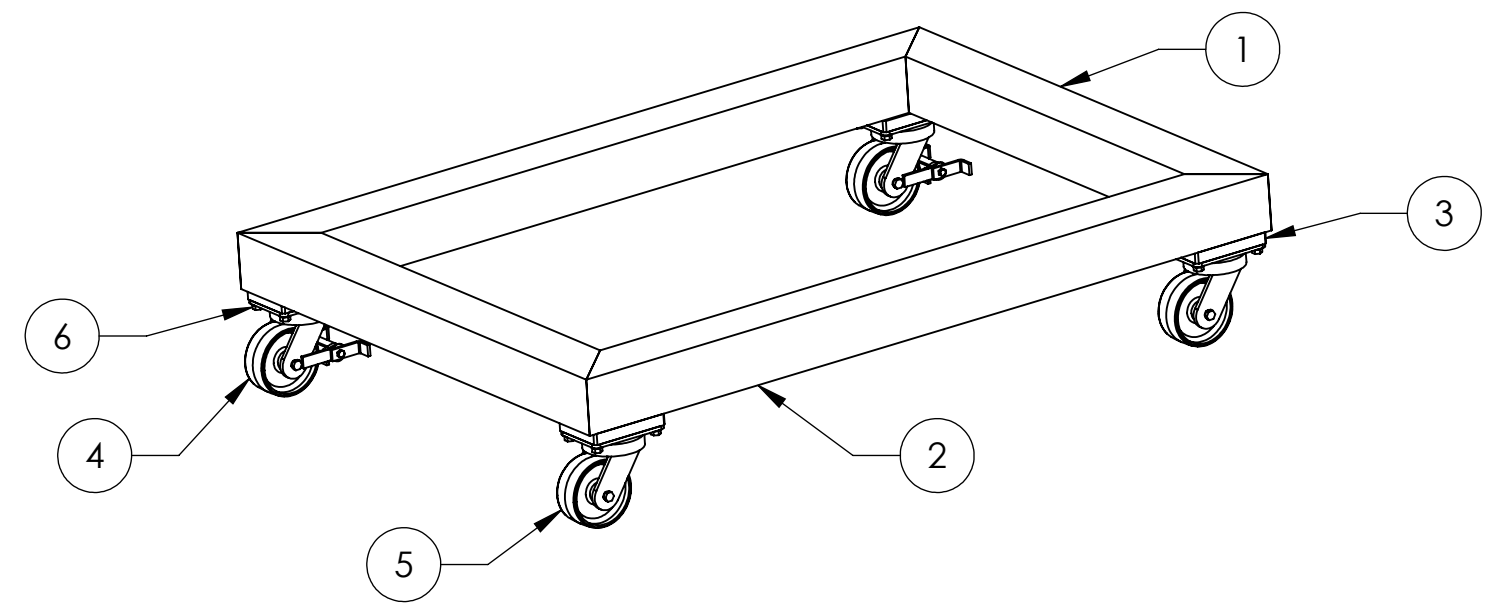
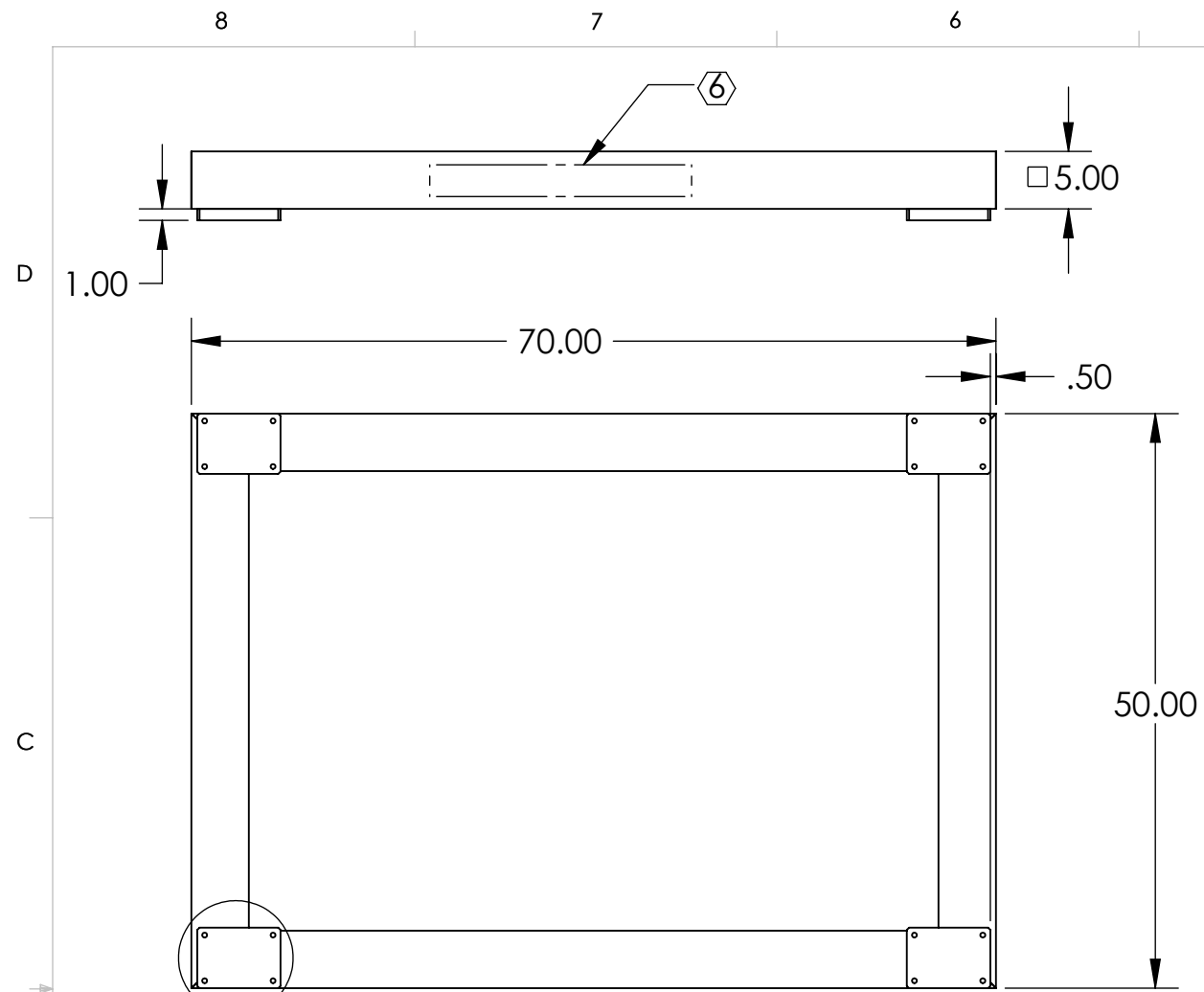


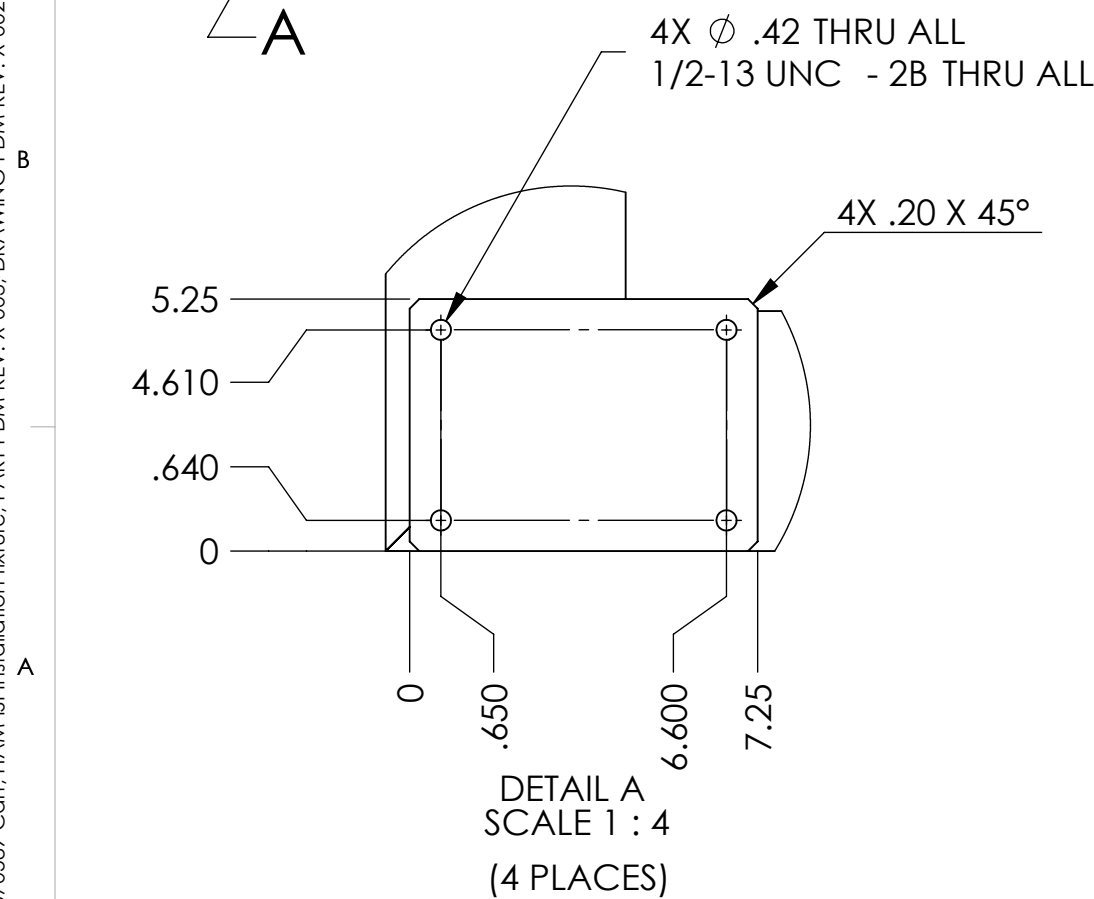
REV.	DATE	DCN #	DRAWING TREE #
X0	2007	-	-
V1	9 NOV 2010	E1000614	-
-	-	-	-



NOTES CONTINUED:

- 5. TUBE: **ASTM A500** Grade B, PLATE: **A36** STEEL
- ⑥. PART NUMBER (DRAWING NO. PLUS REVISION) TO BE CLEARLY MARKED ON THE PART NEAR LOCATION SHOWN
EXAMPLE : **D1001462-V1** (~ 1" CHARACTERS)
- 7. BEFORE FINISHING REMOVE ALL: MILL SCALE, OXYDATION, GREASE, OIL, DIRT, FINGERPRINTS, CONTAMINANTS, ETC.
- 8. PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER "**P60G2**" PER SPECIFICATION.
- 9. PAINT SMOOTH WHITE, SHERWIN WILLIAMS "**POLANE HS-PLUS**" POLYURETHANE ENAMEL P/N F63W66.

ALL TUBES: 5X5 -3/16" WALL, ASTM A-500 GRADE -B



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Default/REQ
6	McMaster 92316A712	Flange Hex Head, 1/2"-13 x 1" Grade 8	Alloy Steel	16
5	McMaster 2487T650	Stronghart Single Wheel Caster Swivel, 6" X 2-1/2" Forged Steel Wheel, 3500# Cap	Material <not specified>	2
4	McMaster 2487T980	Stronghart Single Wheel Caster Swivel, 6" X 2-1/2" Forged Steel Whl, W/Brake, 3500#Cap	Material <not specified>	2
3	Cart Wheel Adaptor	Cart Wheel Adaptor	Plain Carbon Steel	4
2	Cart Member	Cart Member	Plain Carbon Steel	2
1	Cart Member	Cart Member	Plain Carbon Steel	2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .05
.XXX ± .010
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.

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

ADVANCED LIGO SUB-SYSTEM **SEI**

PART NAME: Cart, HAM-ISI Installation Fixture

DESIGNER: FMATCHARD DEC 2007
DRAFTER: SBARNUM 9 NOV 2010
CHECKER: APPROVAL

SIZE: **B** DWG. NO. **D070589** REV. **v1**

MATERIAL: SEE NOTES FINISH: SEE NOTES NEXT ASSY: D070586-A & D070586-V1

SCALE: 1:16 PROJECTION: SHEET 1 OF 1

D070589 Cart, HAM-ISI Installation fixture, PART PDM REV: X-003, DRAWING PDM REV: X-002