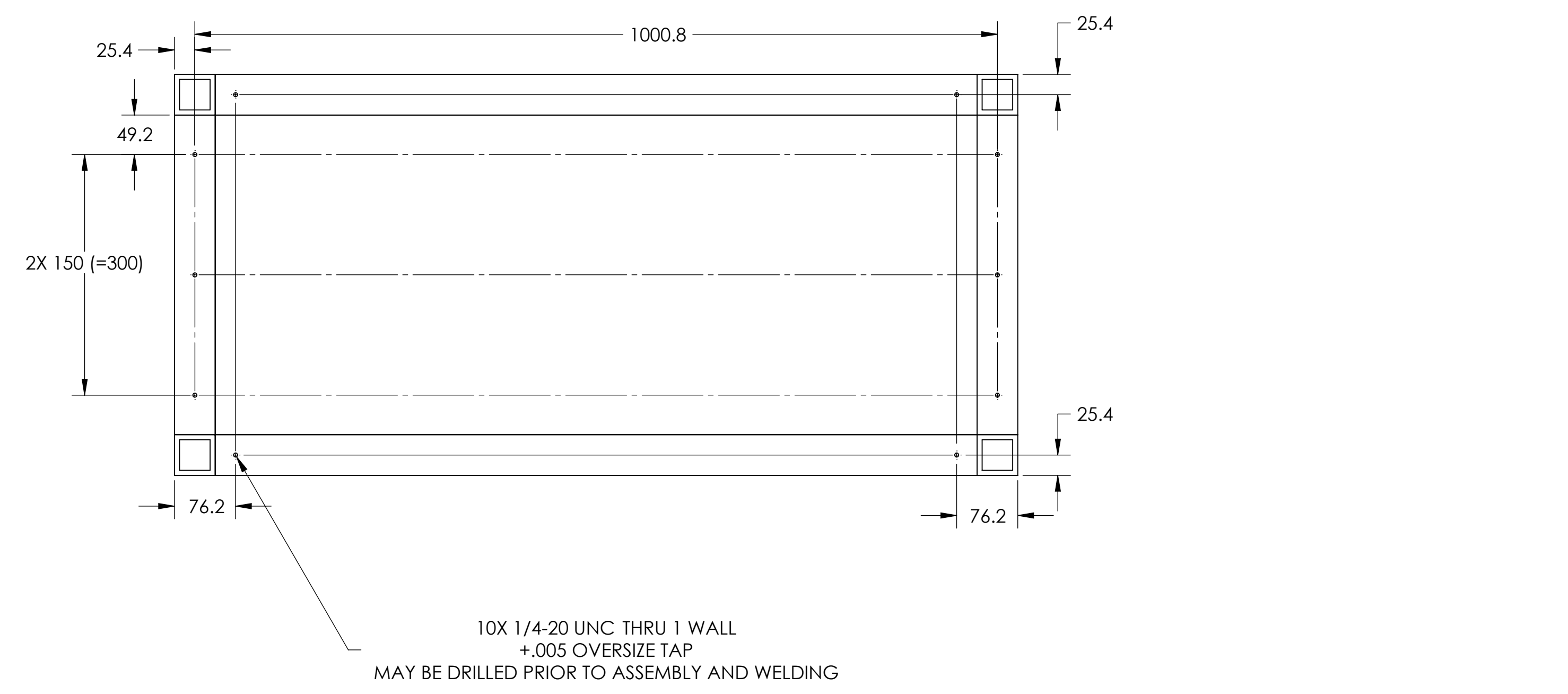
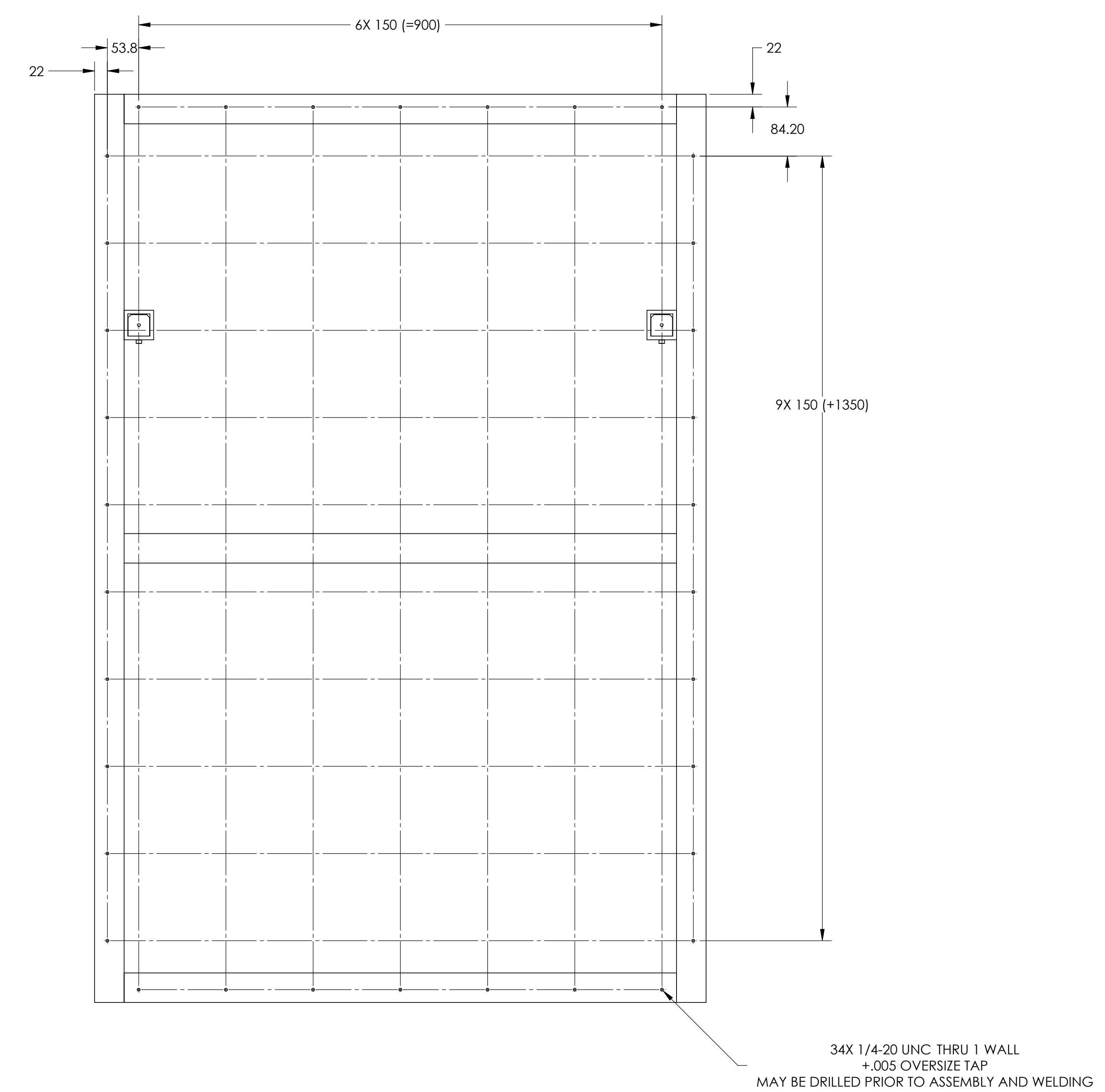
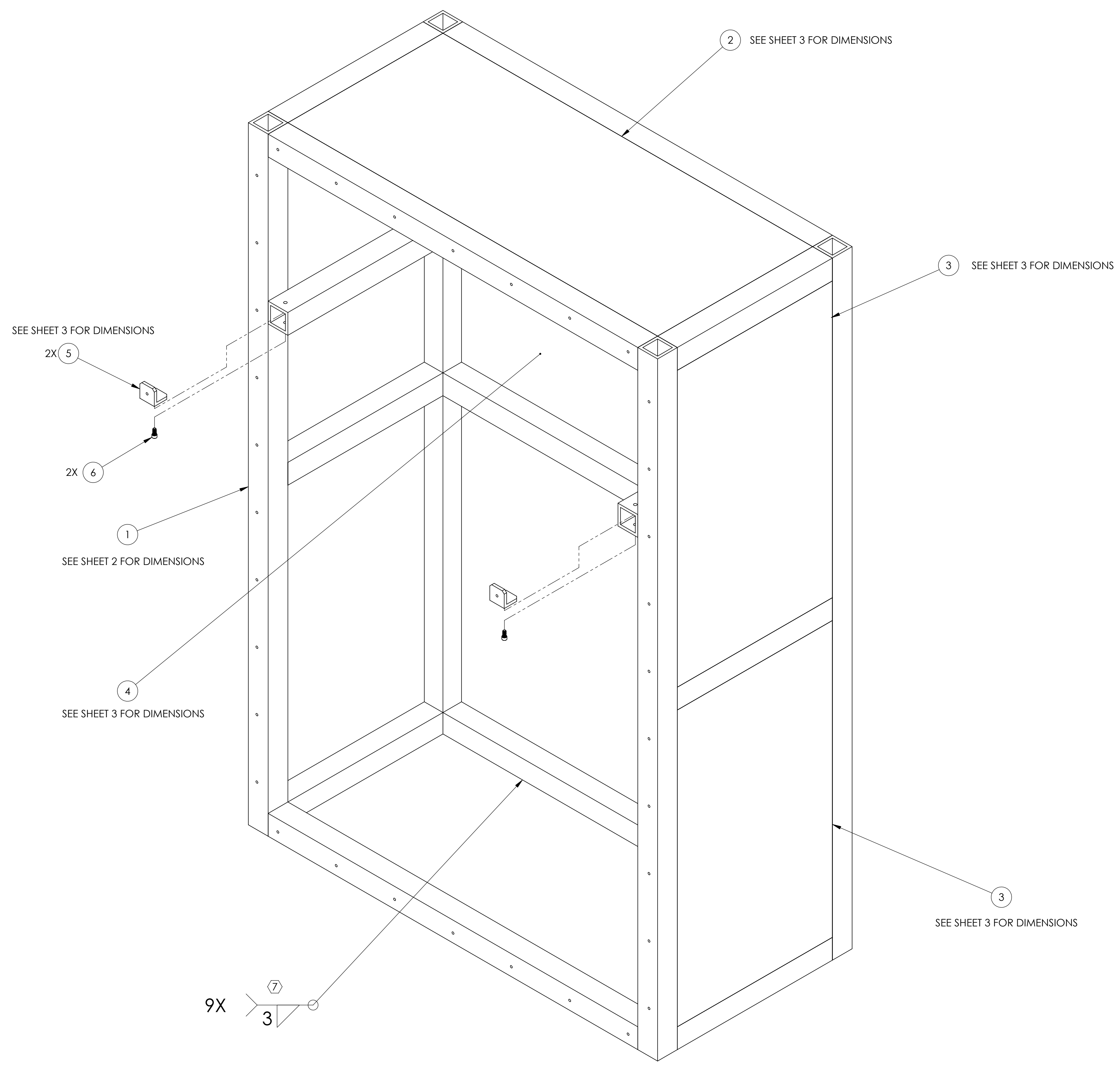
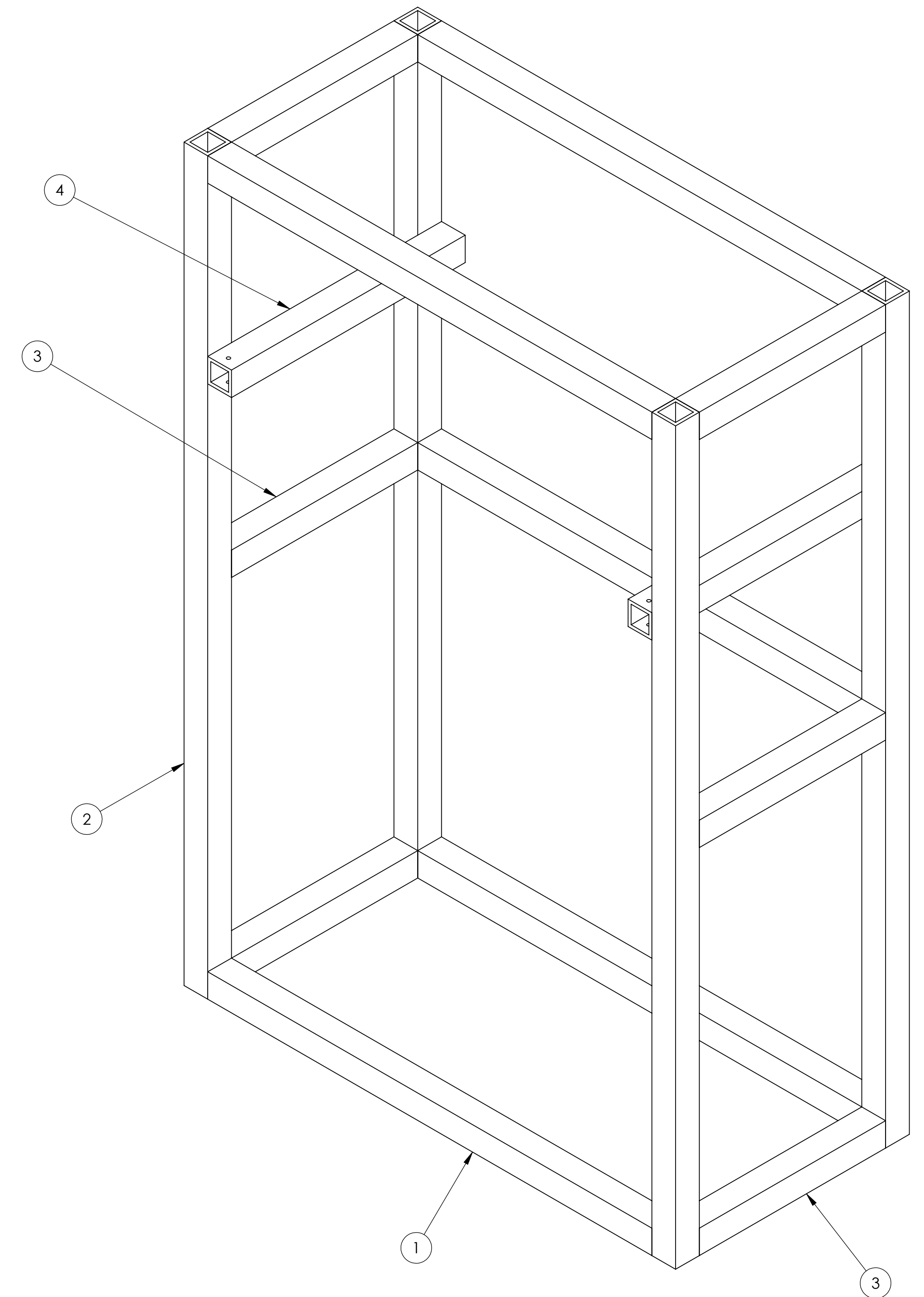
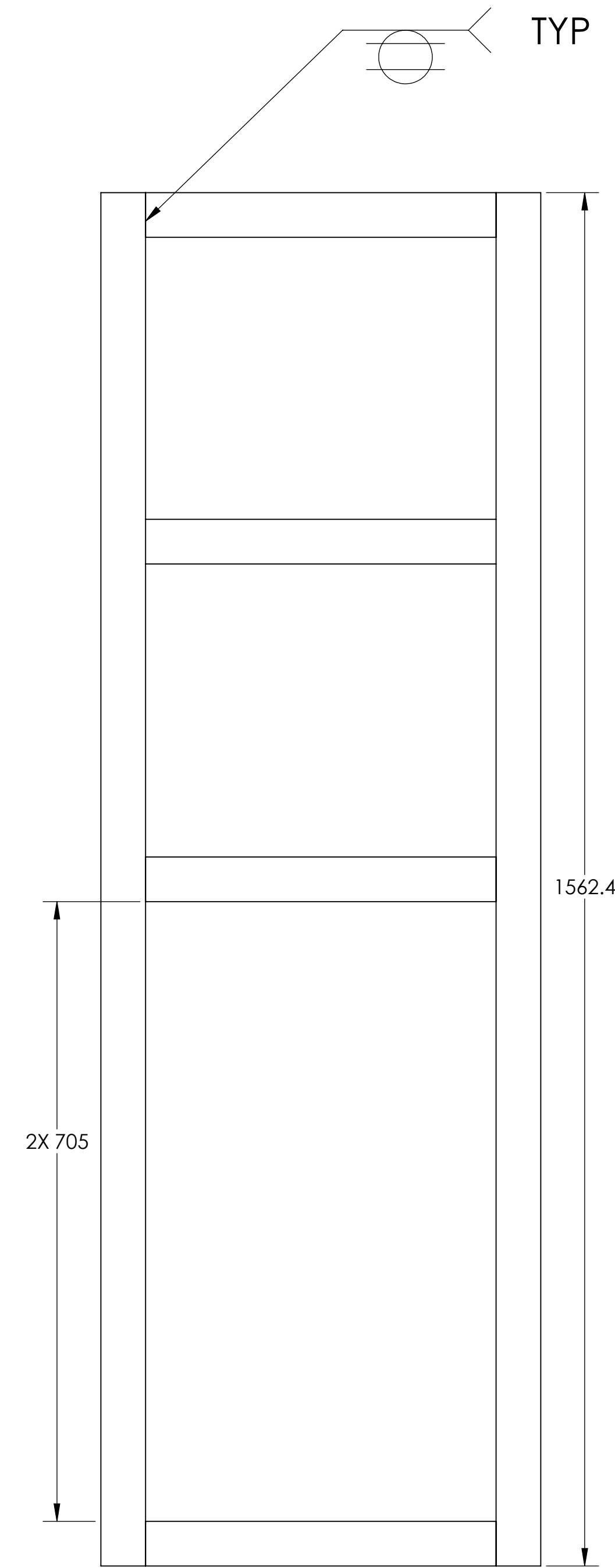
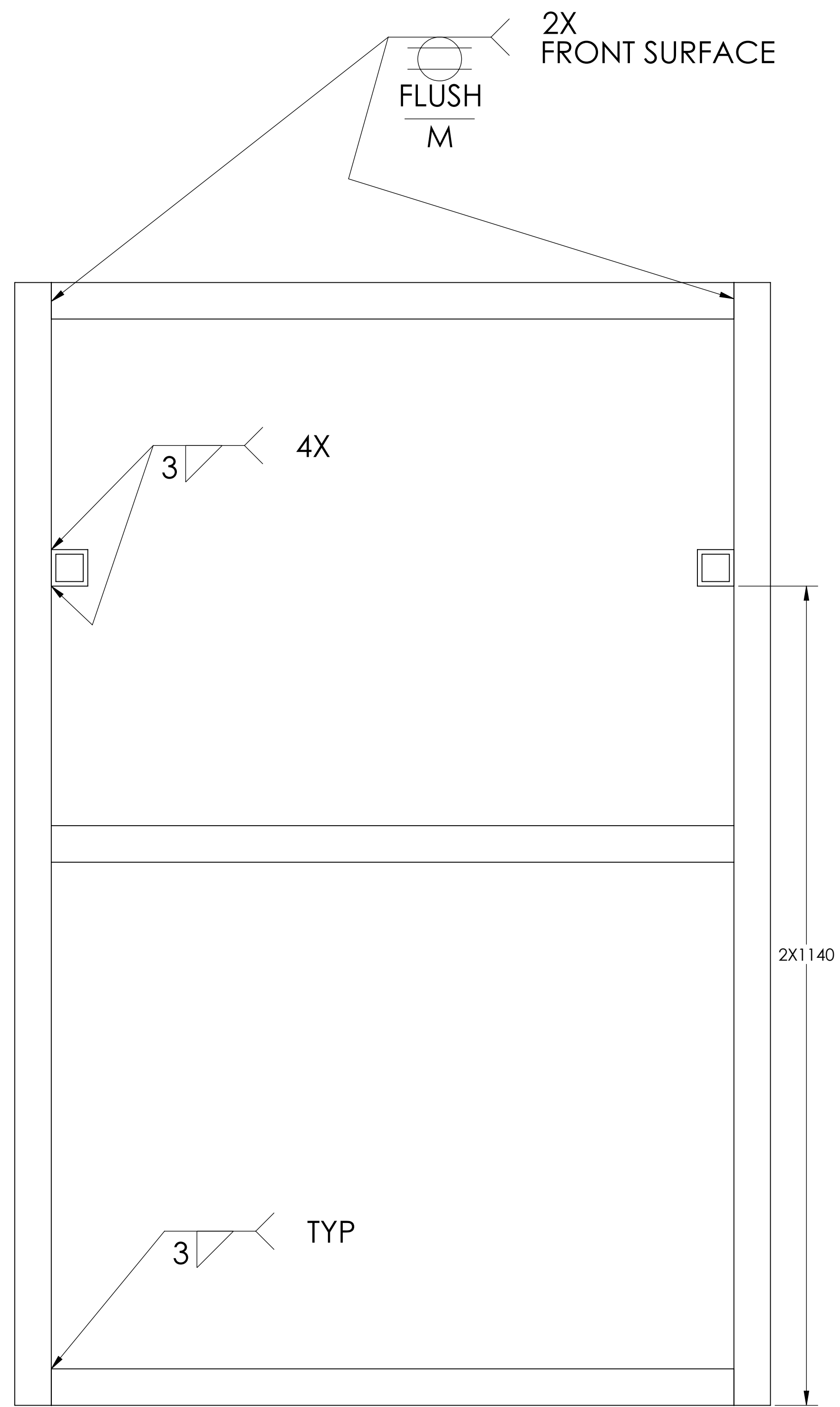
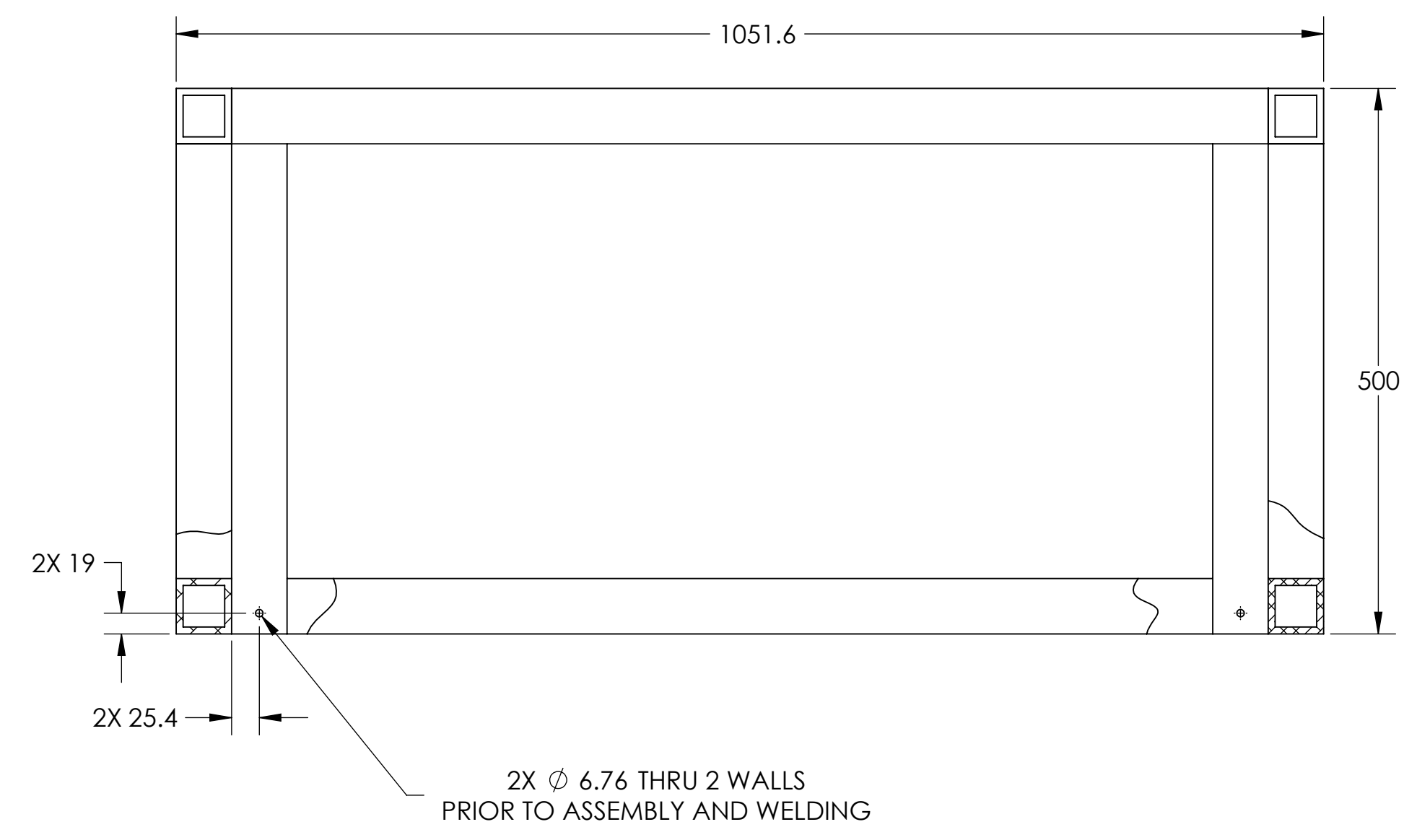


REV.	DATE	DCN #	DRAWING TREE #
V1	17 AUG 2010		
V2	20 AUG 2010		
V3	29 SEPT 2010		



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	92200A537	SCREW, SHC, 1/4-20 x 1/2, MS16995-48, MC #92200A537	300 SSFL	2		2
5	END PLUG	END PLUG	6061-T6 AL	2		2
4	BACK SKIN	LOWER QUAD STORAGE CONTAINER BACK SKIN	6061-T6 AL	2		2
3	SIDE SKIN	LOWER QUAD STORAGE CONTAINER SIDE SKIN	6061-T6 AL	4		4
2	TOP AND BOTTOM SKIN	LOWER QUAD STORAGE CONTAINER TOP AND BOTTOM SKIN	6061-T6 AL	2		2
1	BASIC WELDMENT	LOWER QUAD STORAGE CONTAINER WELDMENT	6061-T6 AL	1		1

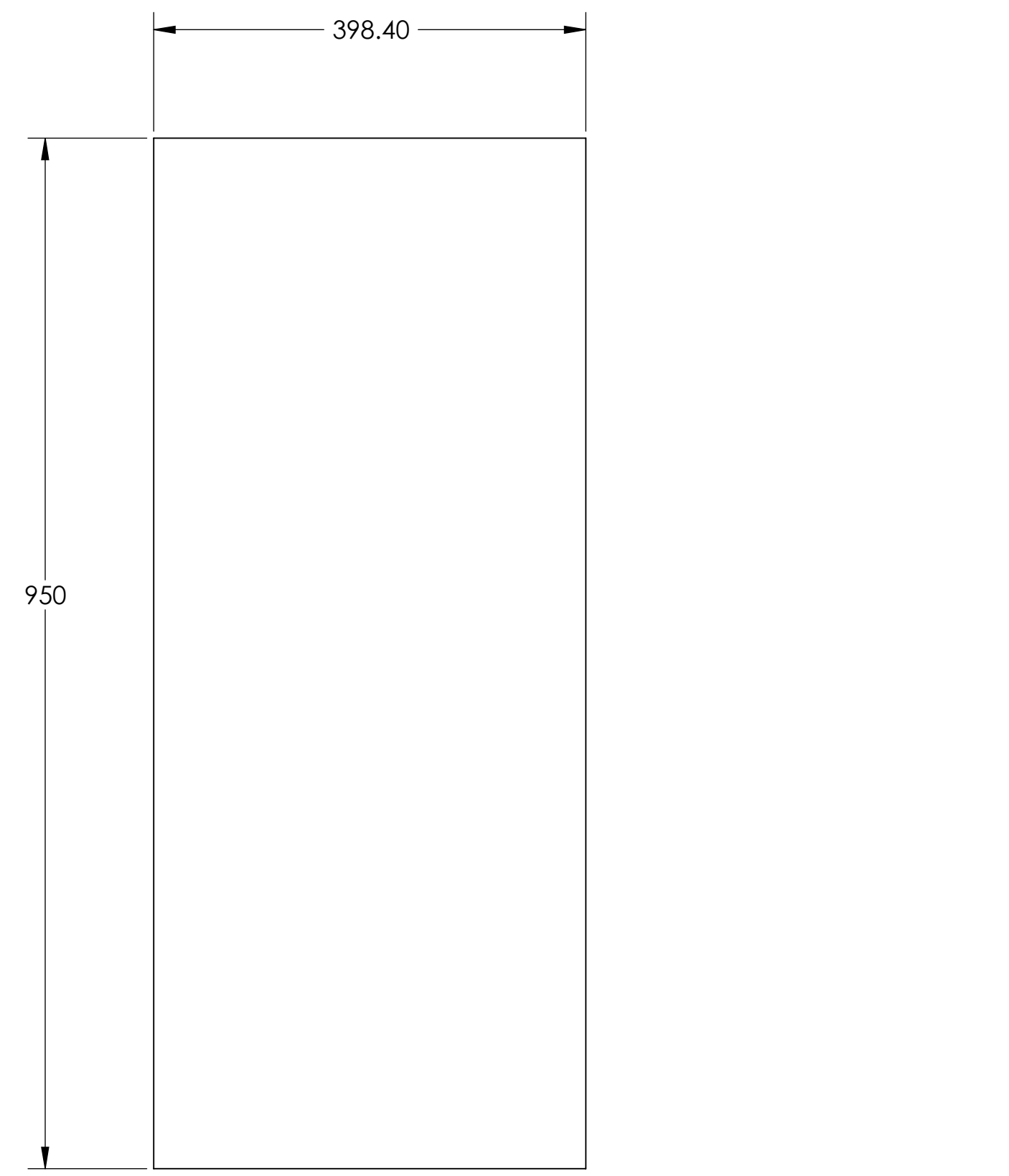
<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>1. INTERPRET DRAWING PER ASME Y14.5-1994.</p> <p>2. REMOVE ALL SHARP EDGES, R.02 MIN.</p> <p>3. DO NOT SCALE FROM DRAWING.</p> <p>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.</p>		<p>CA CALIFORNIA INSTITUTE OF TECHNOLOGY MIT MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p> <p>ADVANCED LIGO SUB-SYSTEM SUS</p>		<p>PART NAME LOWER STRUCTURE STORAGE CONTAINER WELDMENT</p>	
<p>DIMENSIONS ARE IN MILLIMETERS</p> <p>TOLERANCES: .X ± .25 .XX ± .13 ANGULAR ± .5°</p>		<p>MATERIAL: N/A FINISH: N/A μinch</p>		<p>DESIGNER: K. BUCKLAND DRAFTER: K. BUCKLAND CHECKER: APPROVAL:</p>	
<p>DATE: 16 AUG 2010</p>		<p>SIZE: E DWG. NO.: D1002119</p>		<p>REV.: V3</p>	
<p>SCALE: 1:4</p>		<p>PROJECTION:</p>		<p>SHEET 1 OF 3</p>	



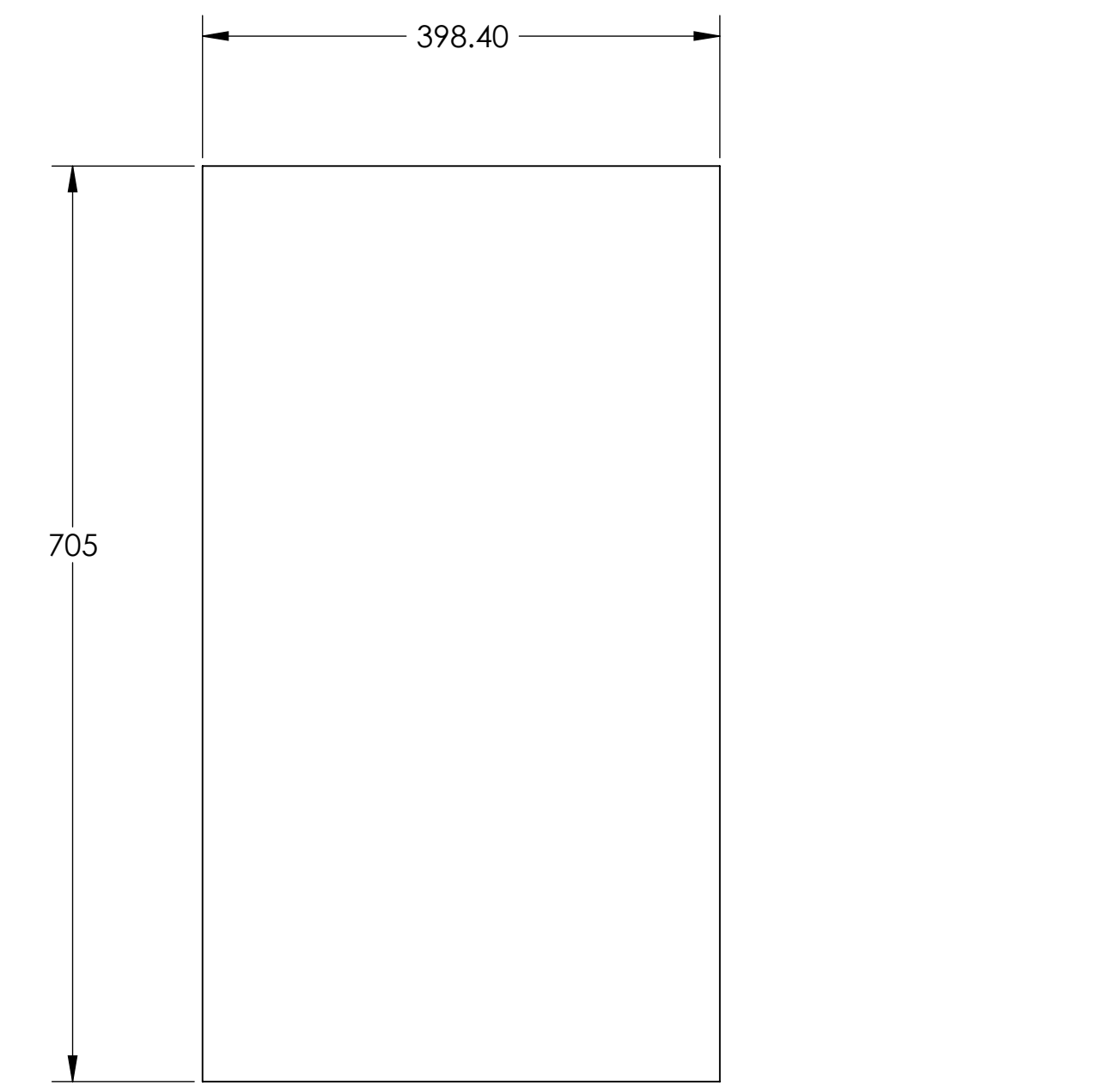
CUT LIST

ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	5	50.8X50.8X6.35 TUBE	950
2	4	50.8X50.8X6.35 TUBE	1562.4
3	6	50.8X50.8X6.35 TUBE	398.4
4	2	50.8X50.8X6.35 TUBE	500

BASIC WELDMENT
 MATERIAL: 2" SQUARE X .25" WALL
 6061 ALUM ALLOY TUBING



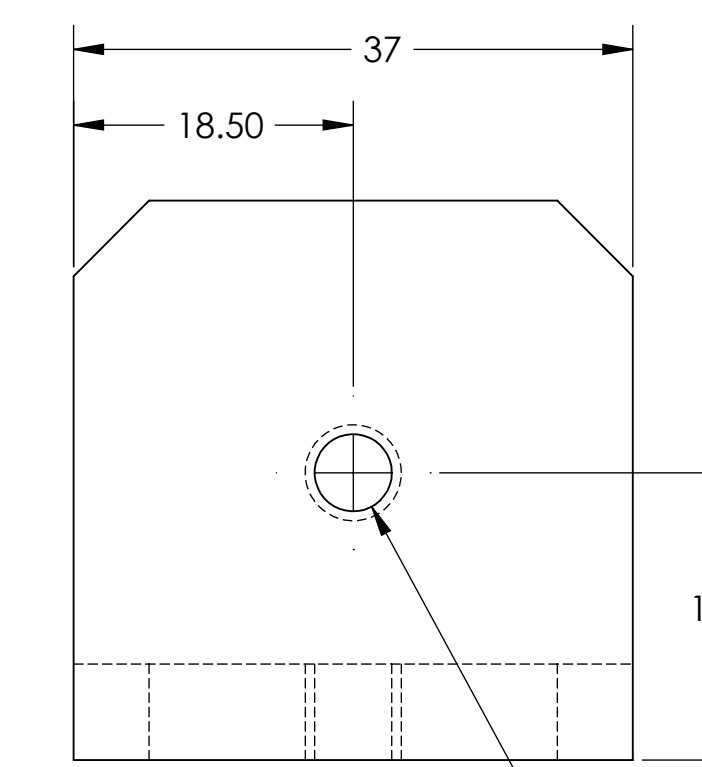
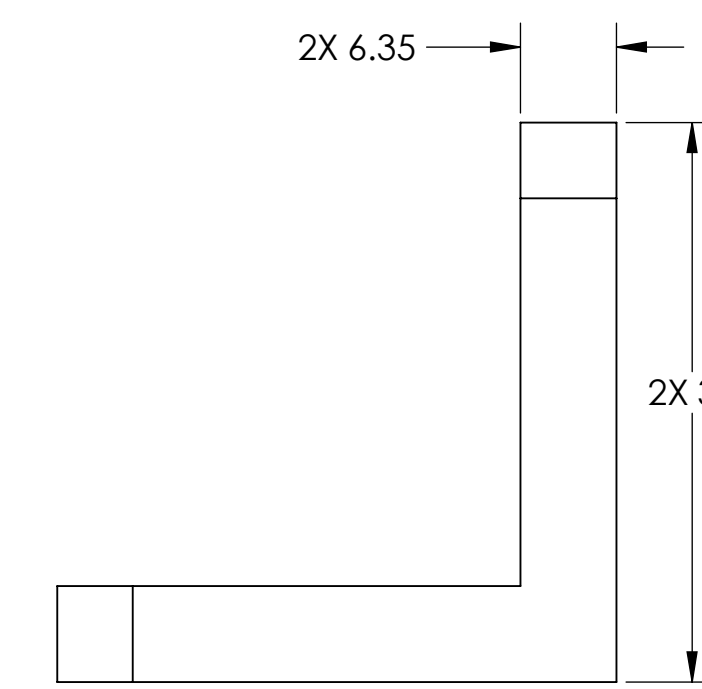
TOP AND BOTTOM SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 2 REQ'D



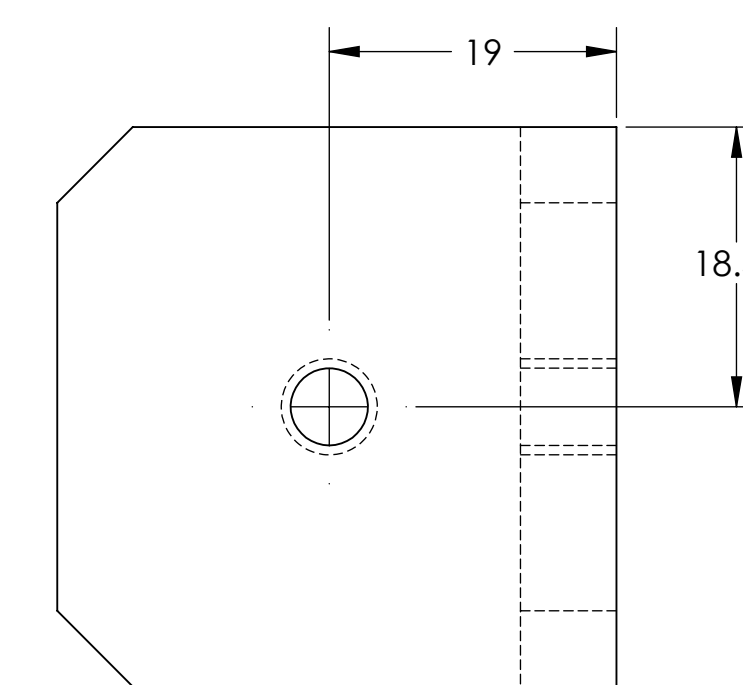
SIDE SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 4 REQ'D



BACK SKIN
 MATERIAL: .12 THICK
 6061 OR 5052 ALUM ALLOY
 2 REQ'D



2X 1/4-20 UNC. THRU ALL
 +.005 OVERSIZE TAP



END PLUG
 MATERIAL: 6061-T6 ALUM ALLOY
 2 REQ'D