NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

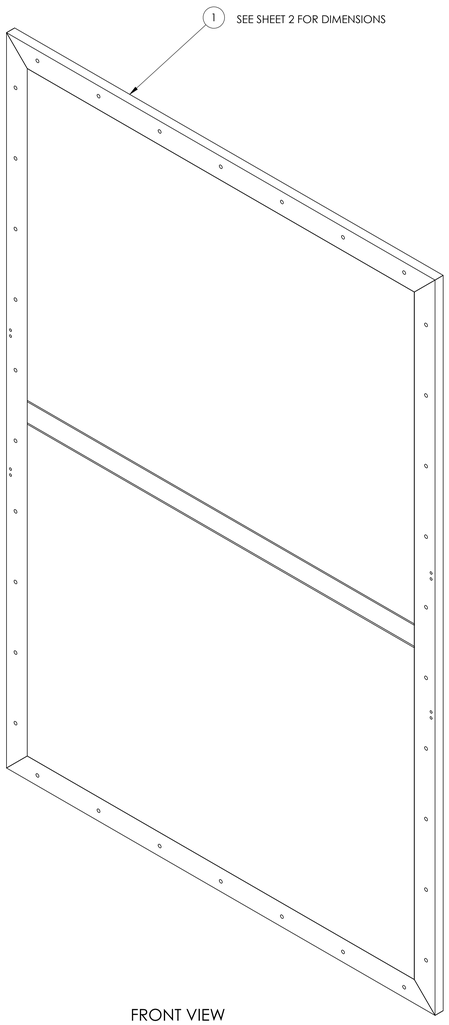
6. APPROXIMATE WEIGHT = 59 LB.

⑦ MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

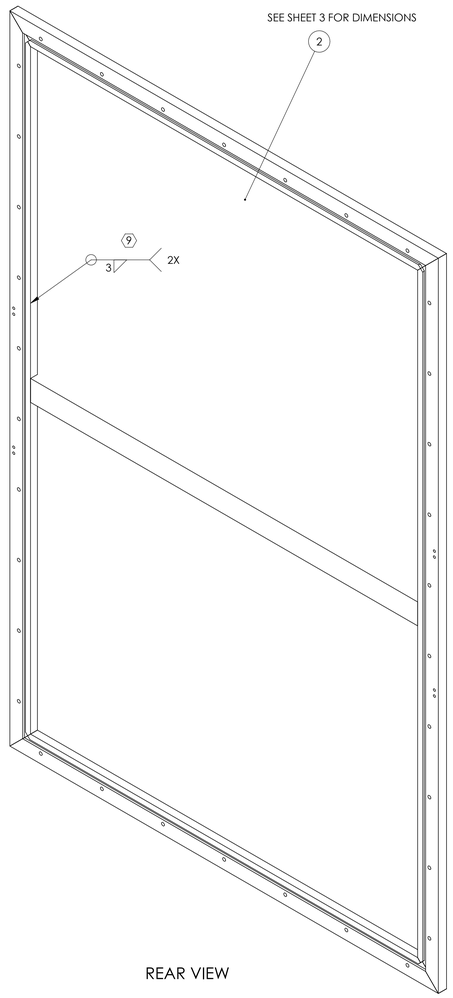
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

⑨ WELDING:
ALL DIMENSIONS APPLY AFTER WELDING.
ALL WELDS SHALL BE DONE ON THE INTERIOR OF THE CONTAINER SUCH THAT NO SEAMS ARE EXPOSED ON THE INTERIOR OF THE BOX.
ALL WELDS MUST BE CONTINUOUS.
SEAMS WILL TRAP CONTAMINATION AND BE HARD TO CLEAN.
ALL WELDS MUST BE COMPLETE JOINT PENETRATION WELDS OR PARTIAL PENETRATION WELDS. THE CONTAINER SHOULD FULLY SEAL AT THE WELDS, SUCH THAT THE CONTAINER IS AIR TIGHT.
NO TRAPPED VOLUMES ARE PERMITTED.
WELDMENTS WITH CREVICES ARE CONSIDERED NON-CLEANABLE SINCE THESE CREVICES ACT AS TRAPS FOR CLEANING SOLUTIONS.
ALL WELDERS SHOULD BE CERTIFIED TO AMERICAN WELDING SOCIETY (AWS).

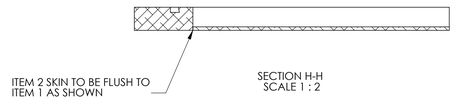
REV.	DATE	DCN #	DRAWING TREE #
V1	18 AUG 2010		
V2	20 AUG 2010		
V3	29 SEPT 2010		
V4	12 OCT 2010	E1000577	



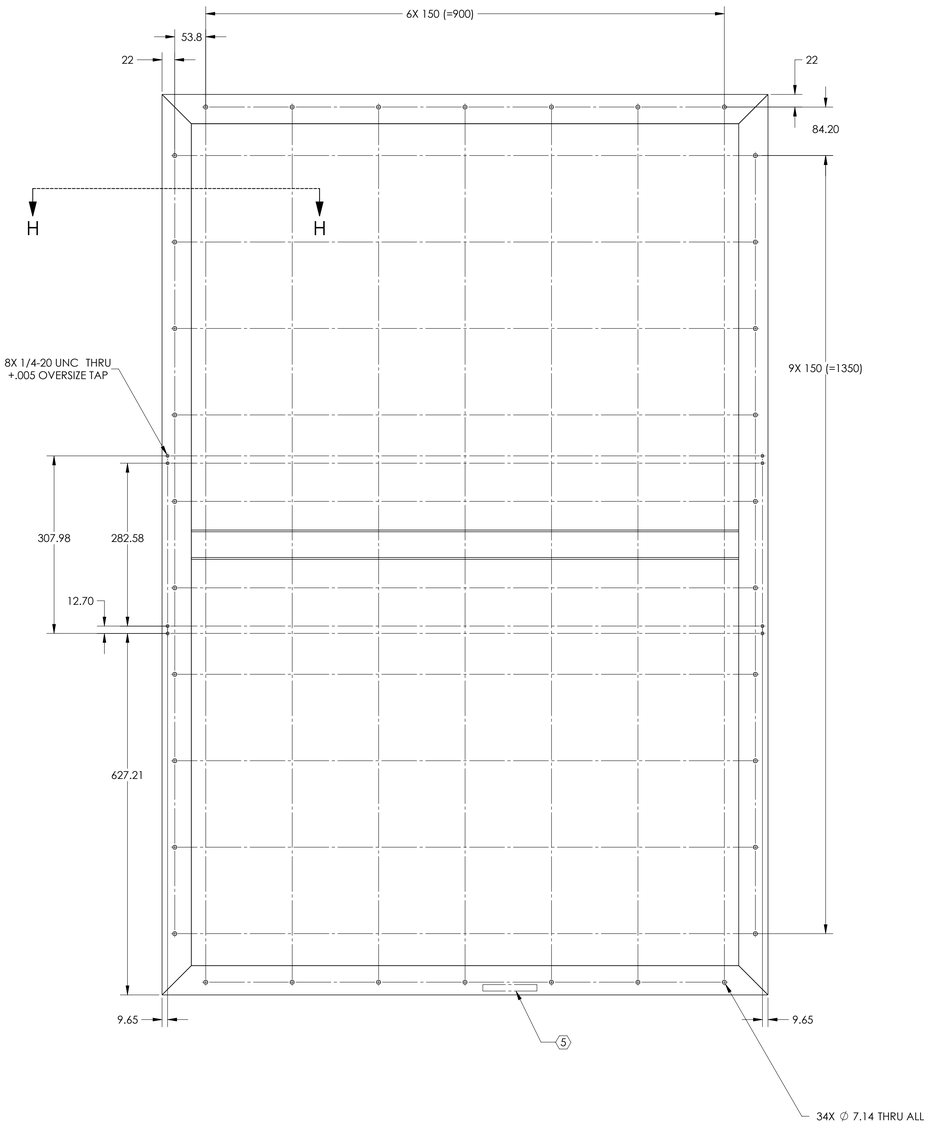
FRONT VIEW



REAR VIEW



SECTION H-H
SCALE 1 : 2



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
2	BACK SKIN	LOWER QUAD STORAGE CONTAINER BACK SKIN	6061-T6 Al	2		2
1	FRONT PANEL	LOWER QUAD STORAGE CONTAINER FRONT PANEL	6061-T6 Al	1		1

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:
.XX ± .25
.XXX ± .13

ANGULAR ± .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.

MATERIAL: N/A
FINISH: N/A µinch

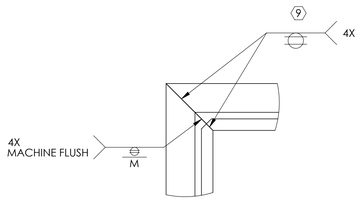
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: D1002118

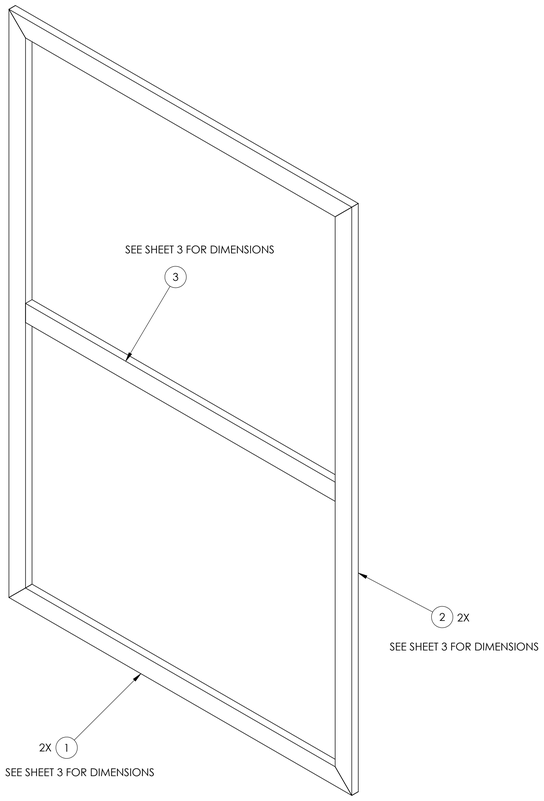
PART NAME: LOWER STRUCTURE STORAGE CONTAINER FRONT PANEL

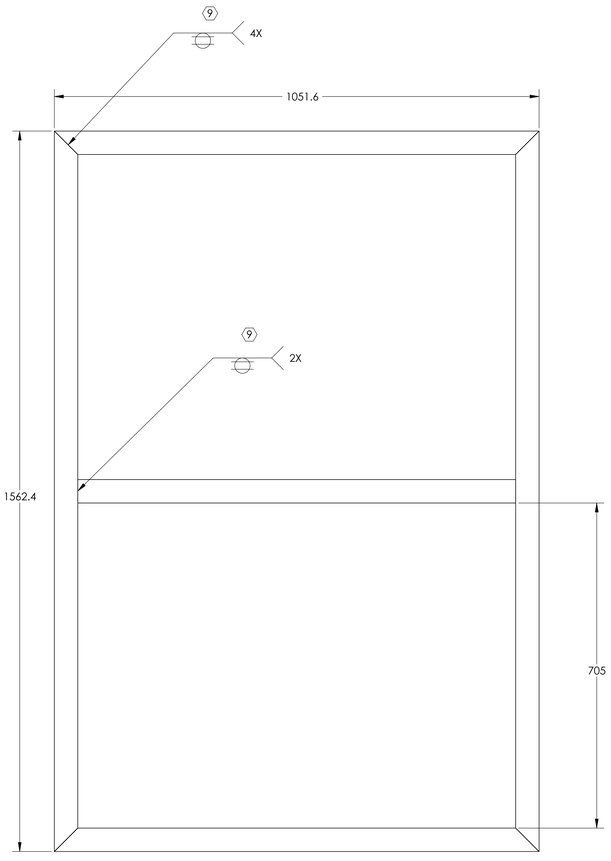
DESIGNER	K. BUCKLAND	6 AUG 2010	
DRAFTER	K. BUCKLAND	18 AUG 2010	
CHECKER			
APPROVAL			

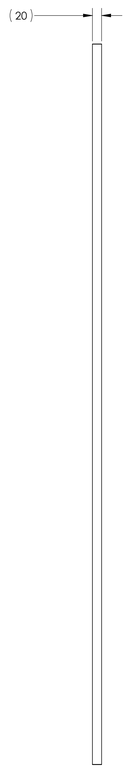
SIZE: E
DWG. NO.: D1002120
REV.: v4
SCALE: 1:4
PROJECTION:
SHEET 1 OF 3

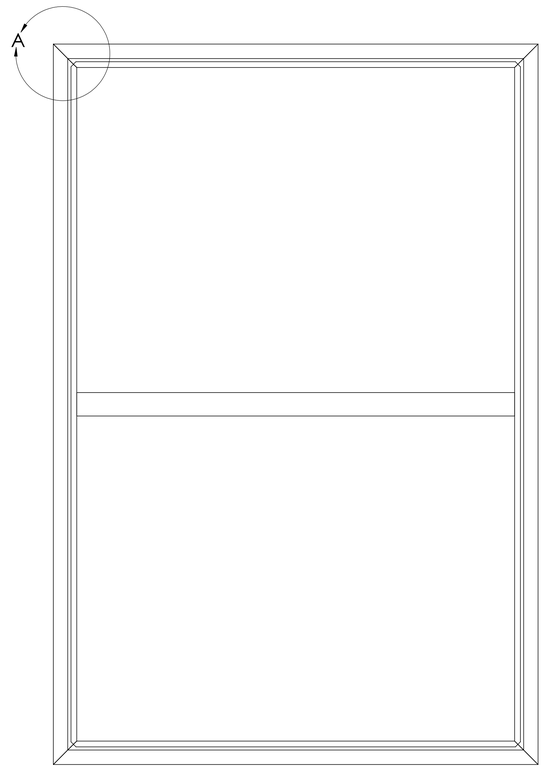


DETAIL A
SCALE 2 : 5









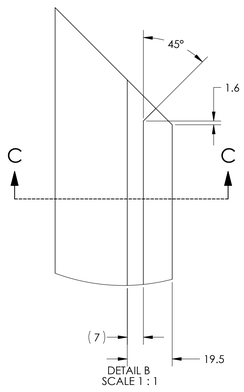
ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	2	C CHANNEL, 50.80 X 5	1051.6
2	2	C CHANNEL, 50.80 X 5	1562.4
3	1	C CHANNEL, 50.80 X 5	950

D1002120-isiLIGO, SUS, LOWER STRUCTURE STORAGE CONTAINER FRONT PANEL, PART PDM REV: X-004, DRAWING PDM REV: X-008

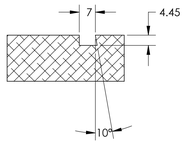
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
E	D1002120	v4

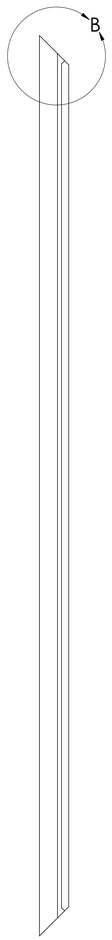
SCALE: 1:4 PROJECTION: SHEET 2 OF 3

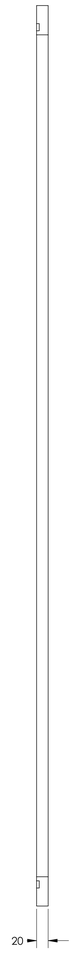


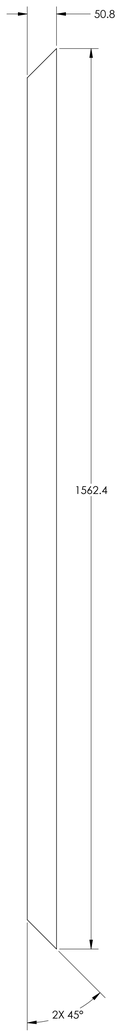
DETAIL B
SCALE 1 : 1



SECTION C-C
SCALE 1 : 1



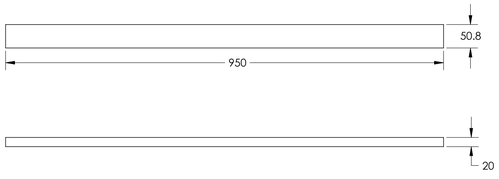




SIDE
MATERIAL: 6061-T6 ALUM ALLOY

SURFACE FINISH: 63 uINCH ⟨7⟩

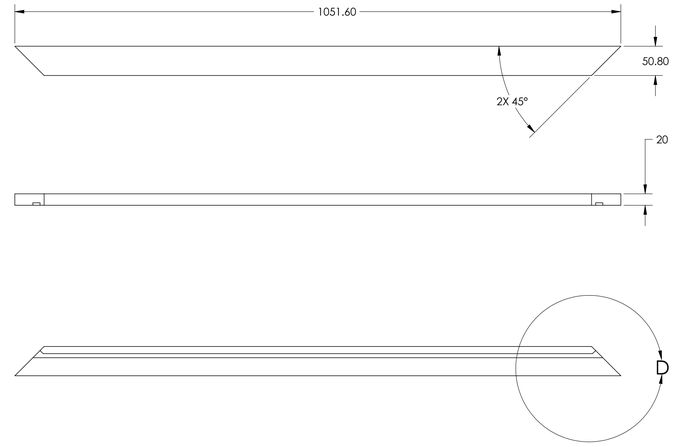
2 REQ'D

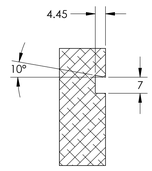


MIDDLE
MATERIAL: 6061-T6 ALUM ALLOY

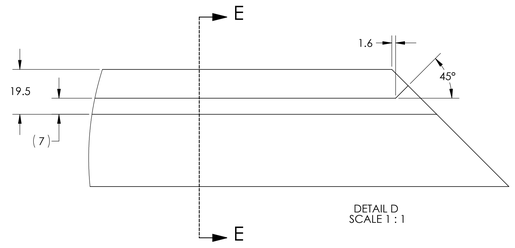
SURFACE FINISH: 63 uINCH ⟨7⟩

1 REQ'D





SECTION E-E
SCALE 1 : 1



DETAIL D
SCALE 1 : 1

TOP AND BOTTOM
MATERIAL: 6061-T6 ALUM ALLOY

SURFACE FINISH: 63 uINCH ⟨7⟩

2 REQ'D

FRONT PANEL SKIN

MATERIAL: .12 THICK
6061 OR 5052 ALUM ALLOY

SURFACE FINISH: 32 µinch

2 REQ'D

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
E	D1002120	v4
SCALE: 1:4	PROJECTION:	SHEET 3 OF 3