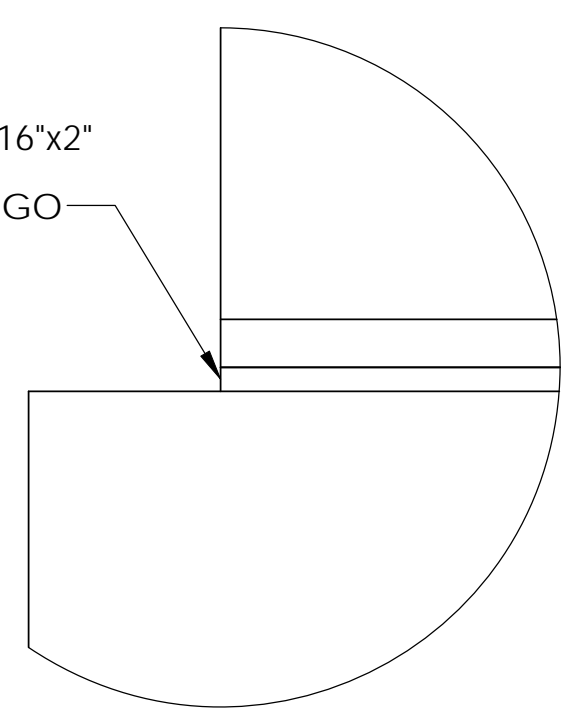
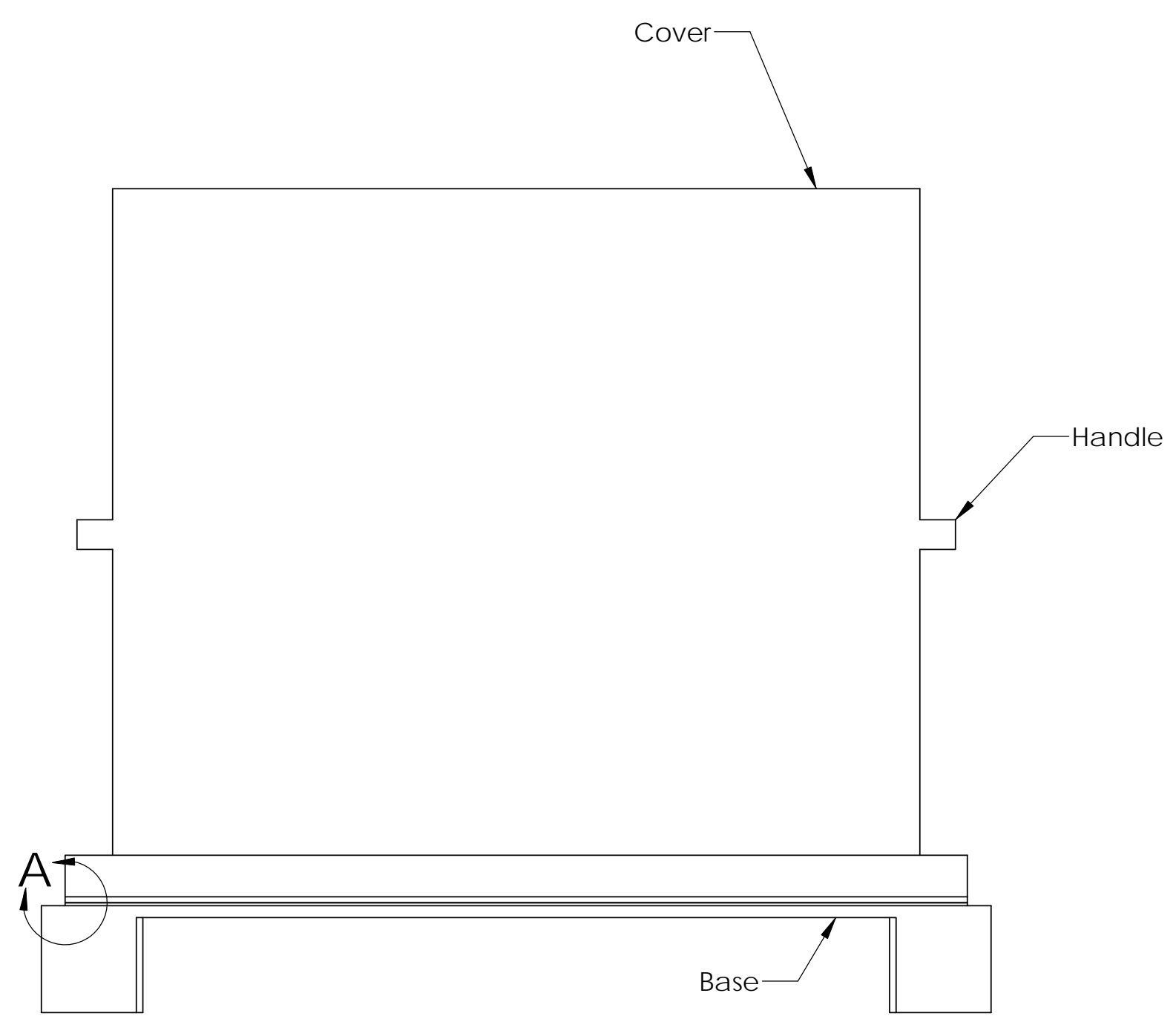
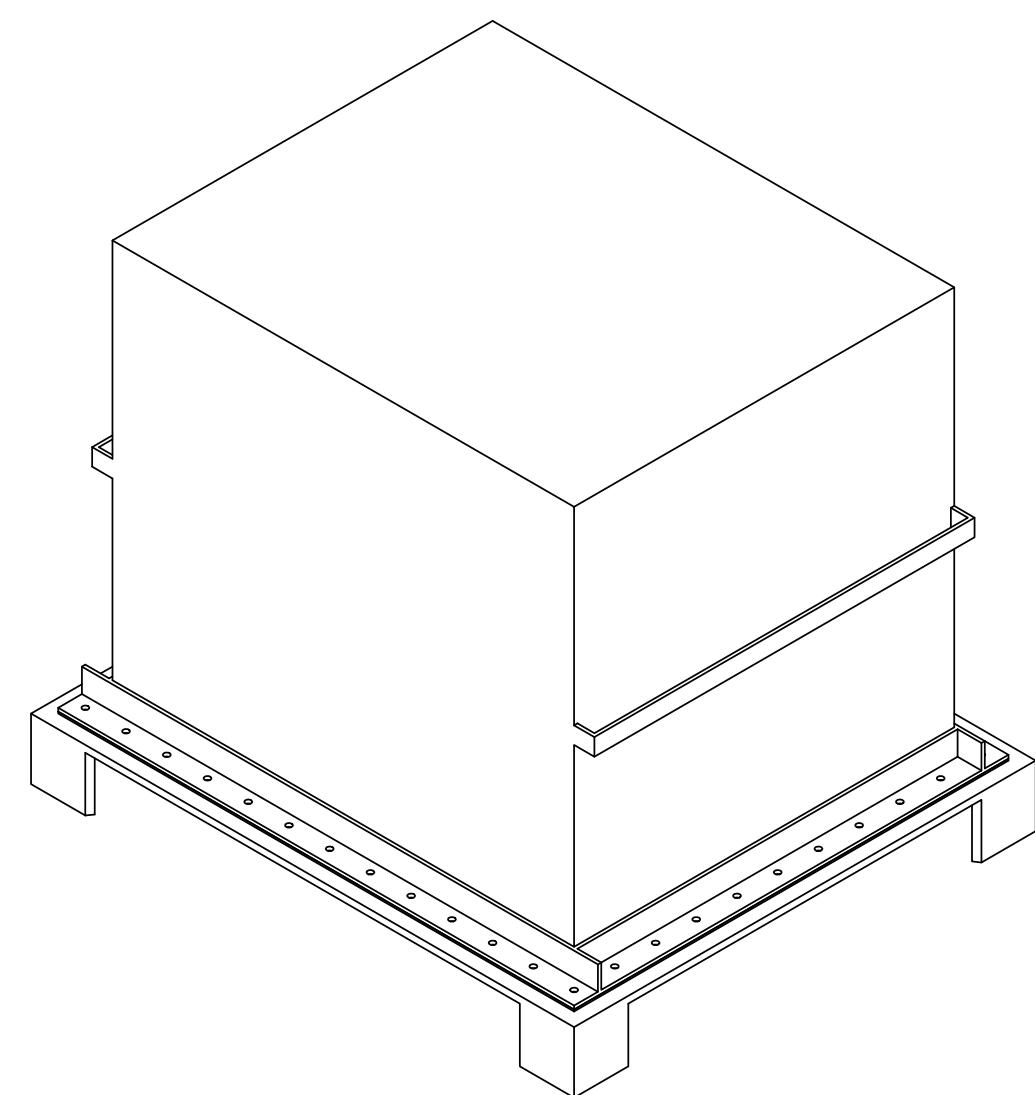


REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-

Storage Container Assembly



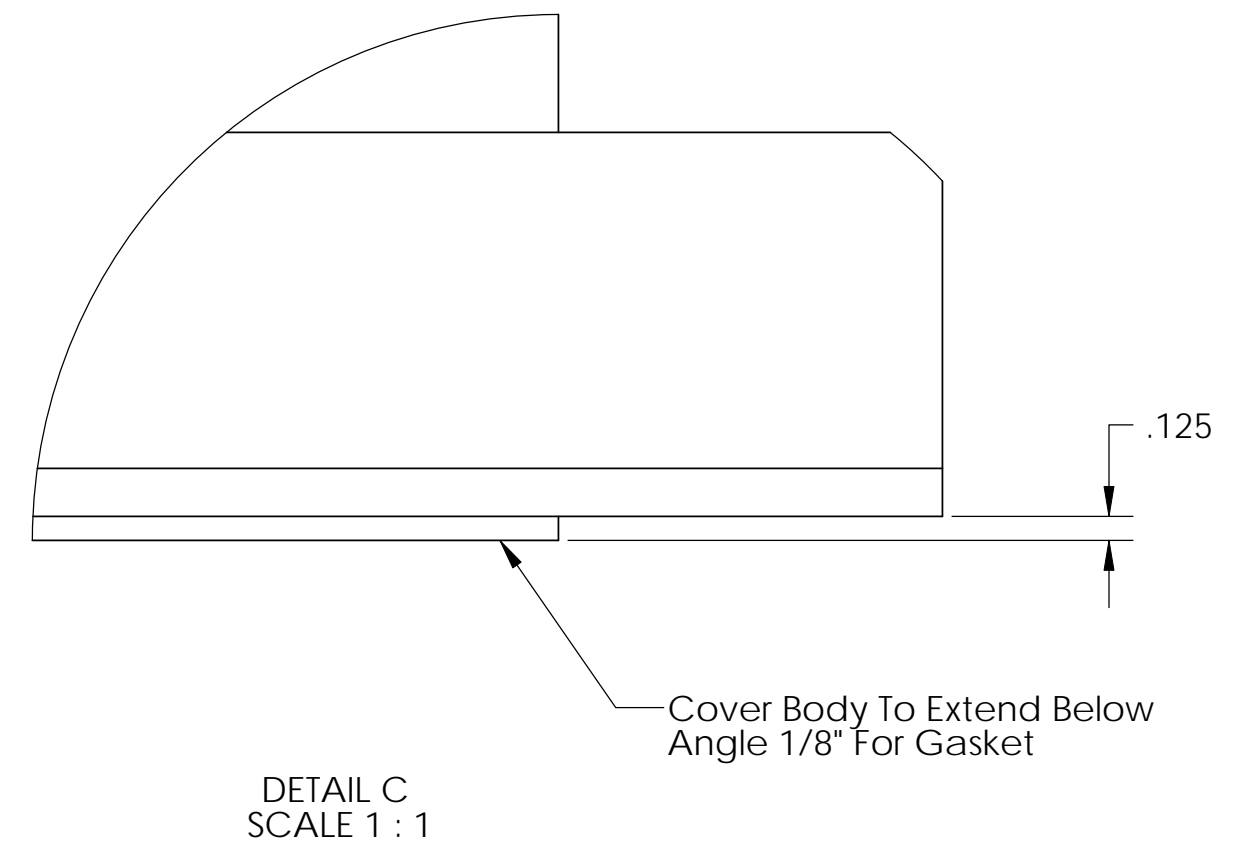
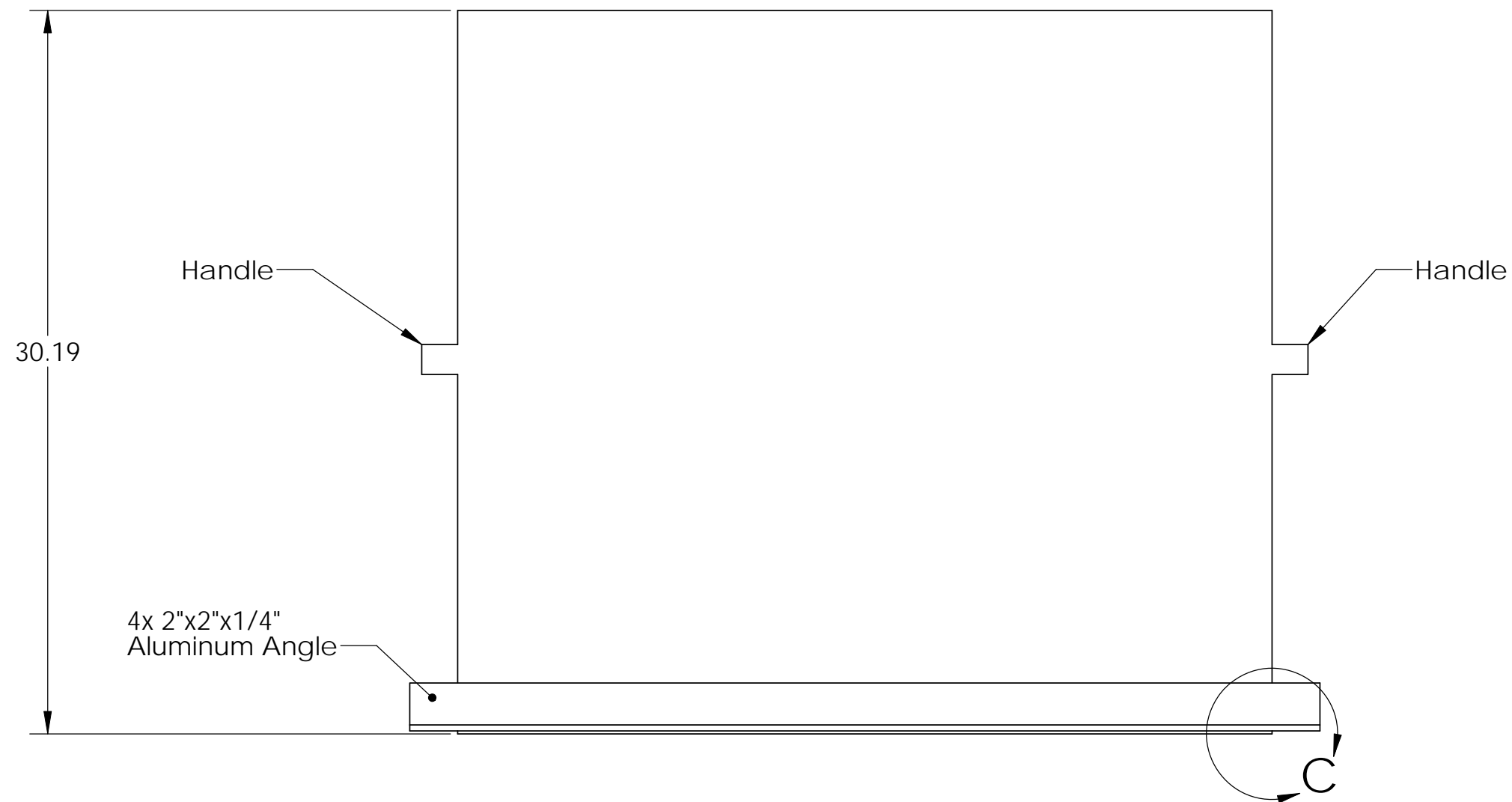
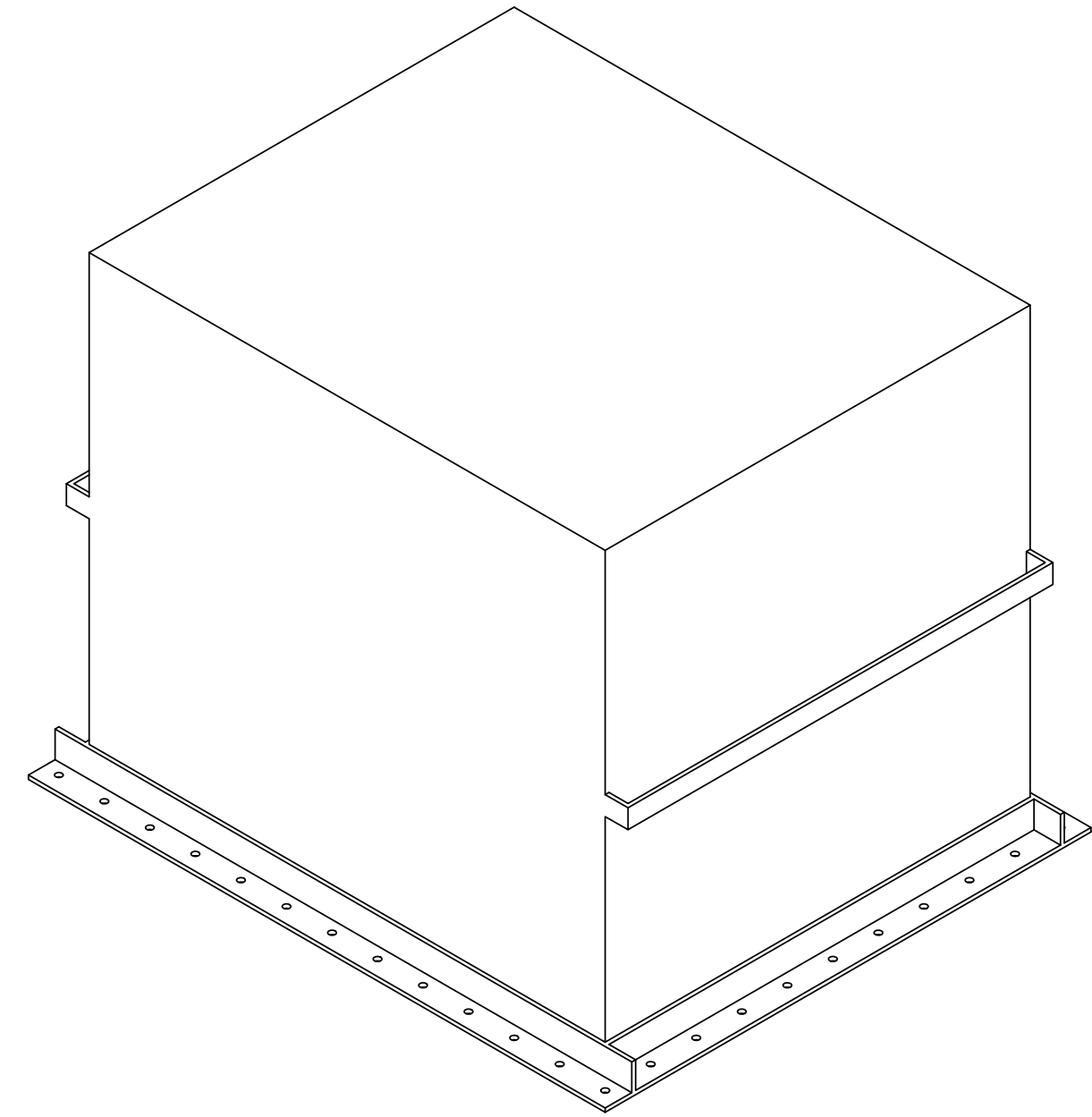
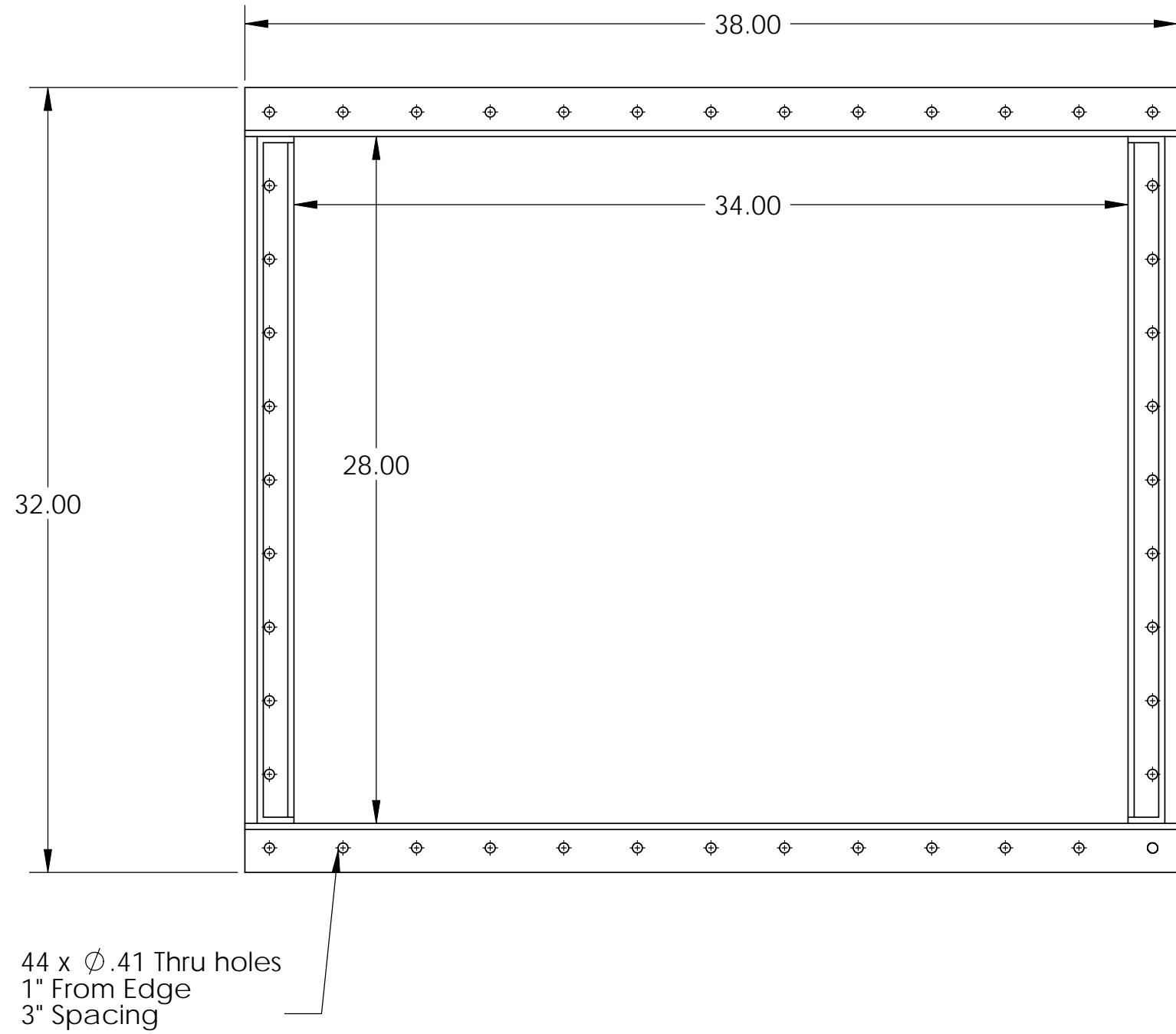
DETAIL A
SCALE 1 : 1

Removable 3/16"x2"
Viton Gasket
Provided by LIGO

ITEM NO.	PART NUMBER	QTY.
1	Upper Structure Cover	1
2	Upper Structure Base Plate	1
3	Flat Viton Gasket	1

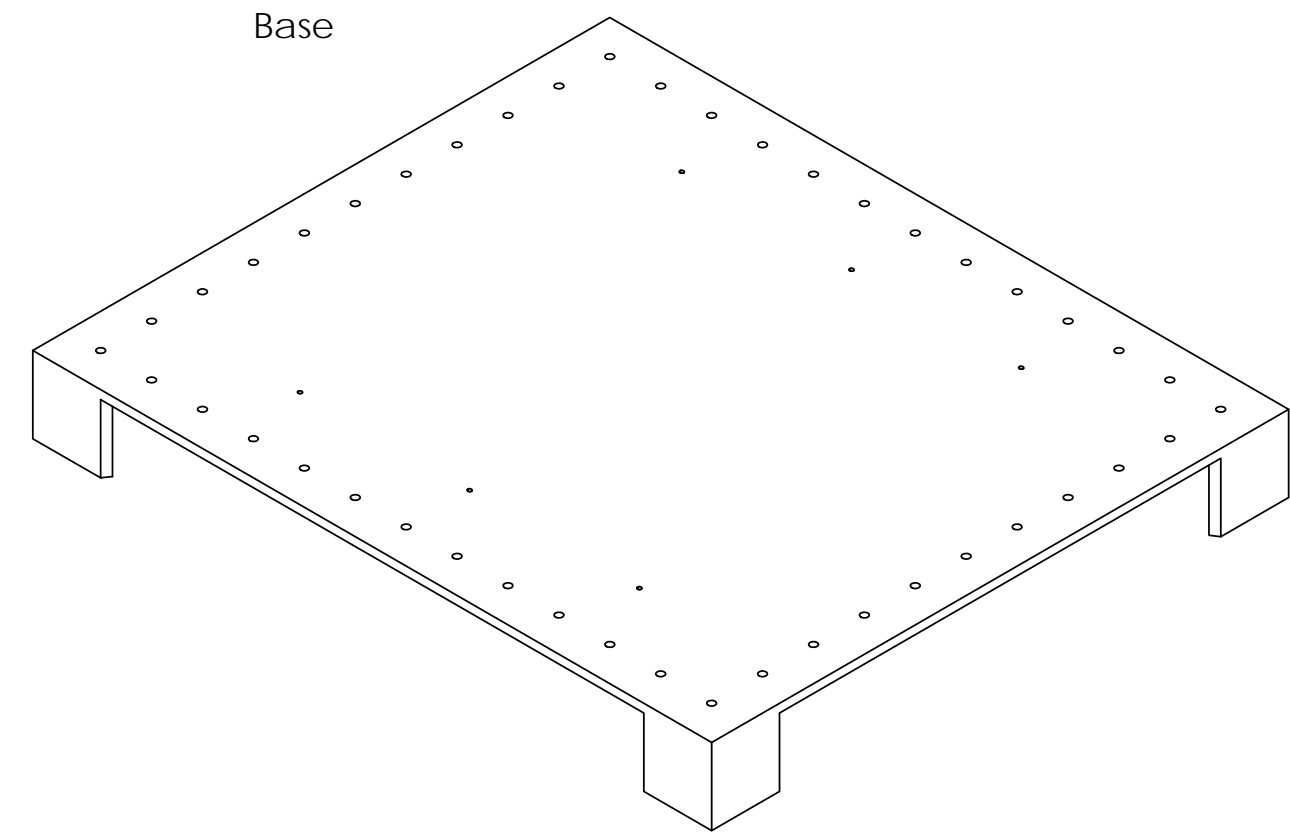
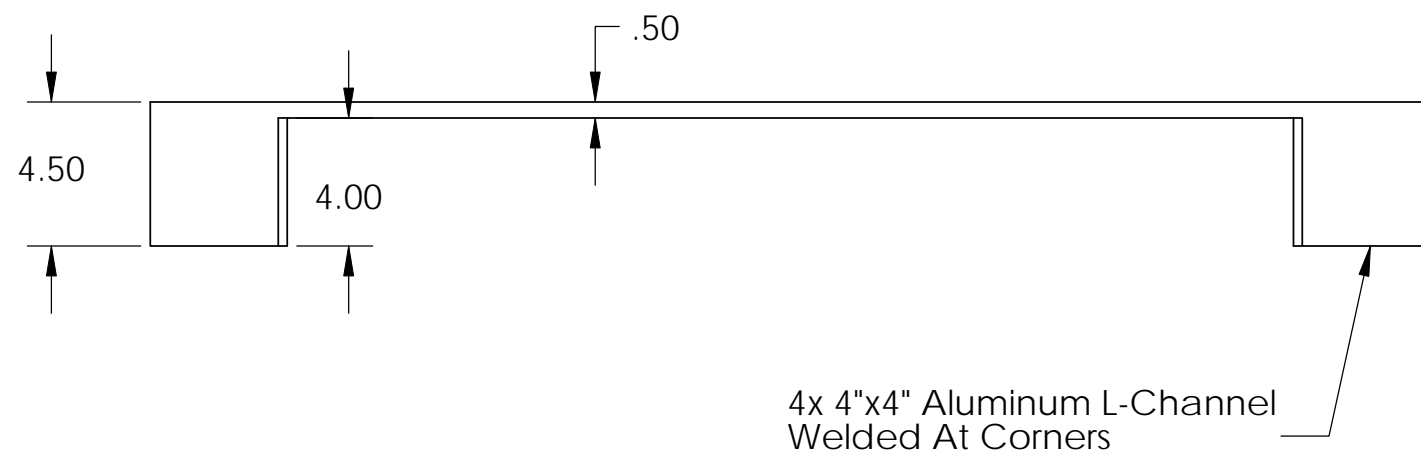
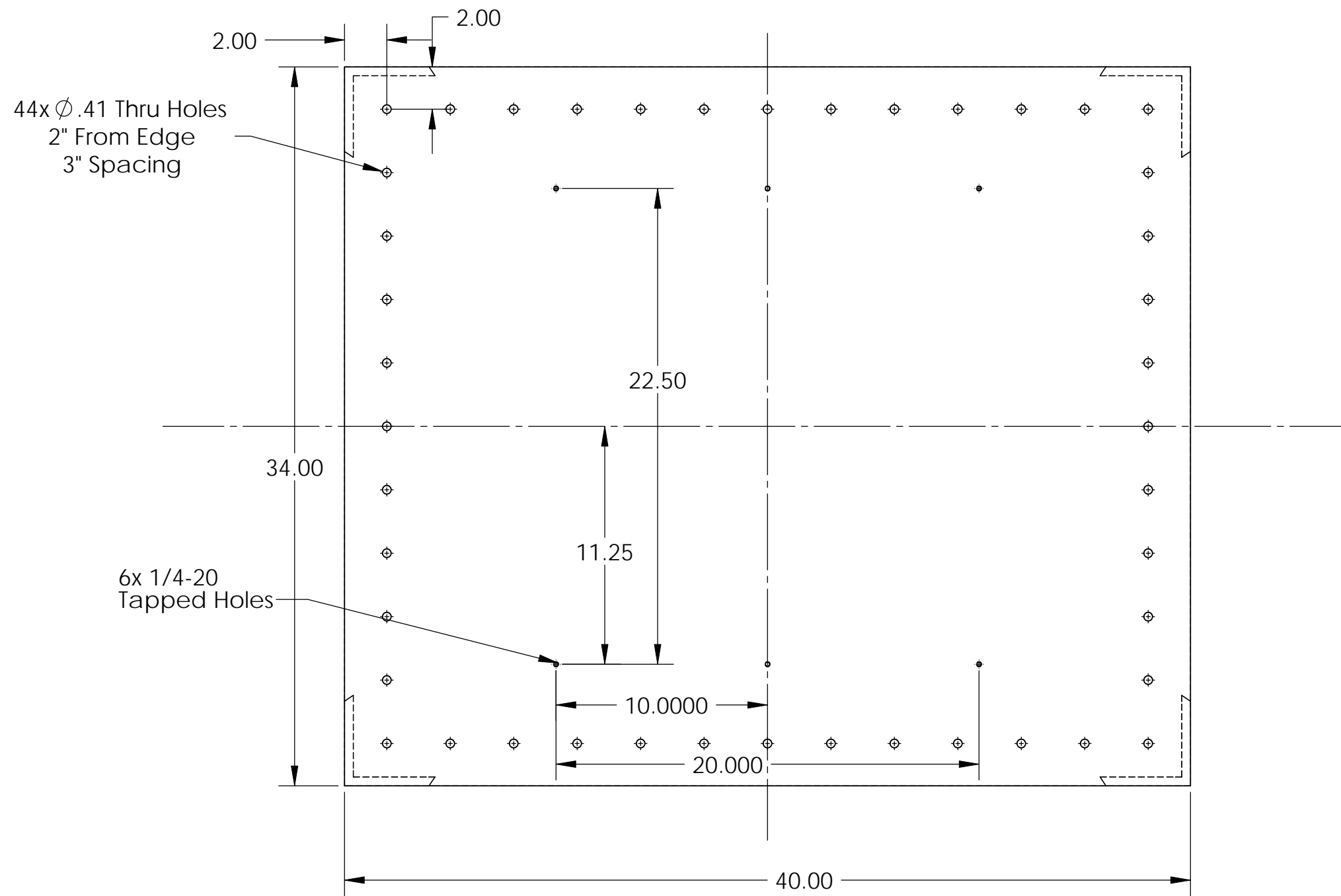
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME Upper Structure Storage Container				
DIMENSIONS ARE IN TOLERANCES: .XX ± .XXX ± ANGULAR ± °	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, 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.		SYSTEM	SUB-SYSTEM SUS	DESIGNER Jim Warner	SIZE c	DWG. NO. D1002222	REV. 2
	MATERIAL 6061 or 5052 Aluminum	FINISH 32 μinch	NEXT ASSY		CHECKER	APPROVAL	SCALE: 1:8	PROJECTION:

1. Use 1/16" 6061 or 5052 Aluminum Sheet for 5-sided cover.
2. Use 4x 2"x2"x1/4" Aluminum angle for cover flange.
3. 32 micor-inch finish as rec from supplier. If surface finish is higher than the standard 32 Ra micro-inch, the surface finish shall be discussed with LIGO officer prior to acceptance.
4. Material to be chosen such that localized digs, scratches and blemishes is minimized.
5. Brite dip might be a required step post-fabrication as per E090364, sec. 4.5
6. Full seal welds on cover to be done from interior of cover.
7. Minimum of 2 handles to be welded at midpoint of the cover such that seal is unaffected, location not critical.
8. All interior dims +/- 0.010", exterior dims are +/- .125"



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE C	DWG. NO. Cover	1
SCALE: 1:8	PROJECTION:	SHEET 2 OF 3

1. Machine all surfaces of 1/2" plate.
2. Use 5052 1/2" Aluminum Plate
3. Use 4x 4"x4"x1/2" Aluminum angle for feet.
4. 32 micor-inch finish as rec from supplier. If surface finish is higher than the standard 32 Ra micro-inch, the surface finish shall be discussed with LIGO officer prior to acceptance.
5. Material to be chosen such that localized digs, scratches and blemishes is minimized.
6. Brite dip might be a required step post-fabrication as per E090364, sec. 4.5
7. All interior dims +/- 0.010", exterior dims are +/- .125"



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE C	DWG. NO. Base Plate	REV.
SCALE: 1:8	PROJECTION: 	SHEET 3 OF 3