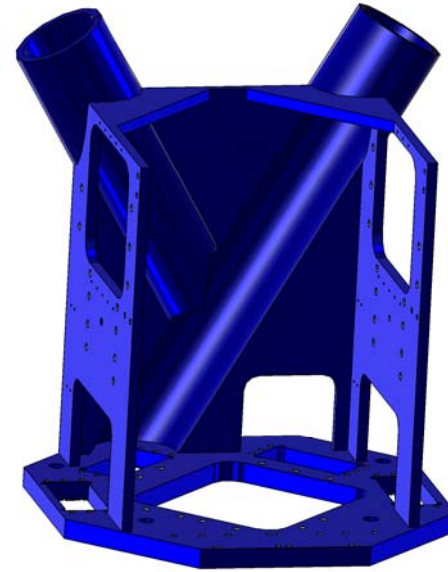


REV.	DATE	DCN #	DRAWING TREE #
v1	2 Mar 2011	E1100015	E1100016

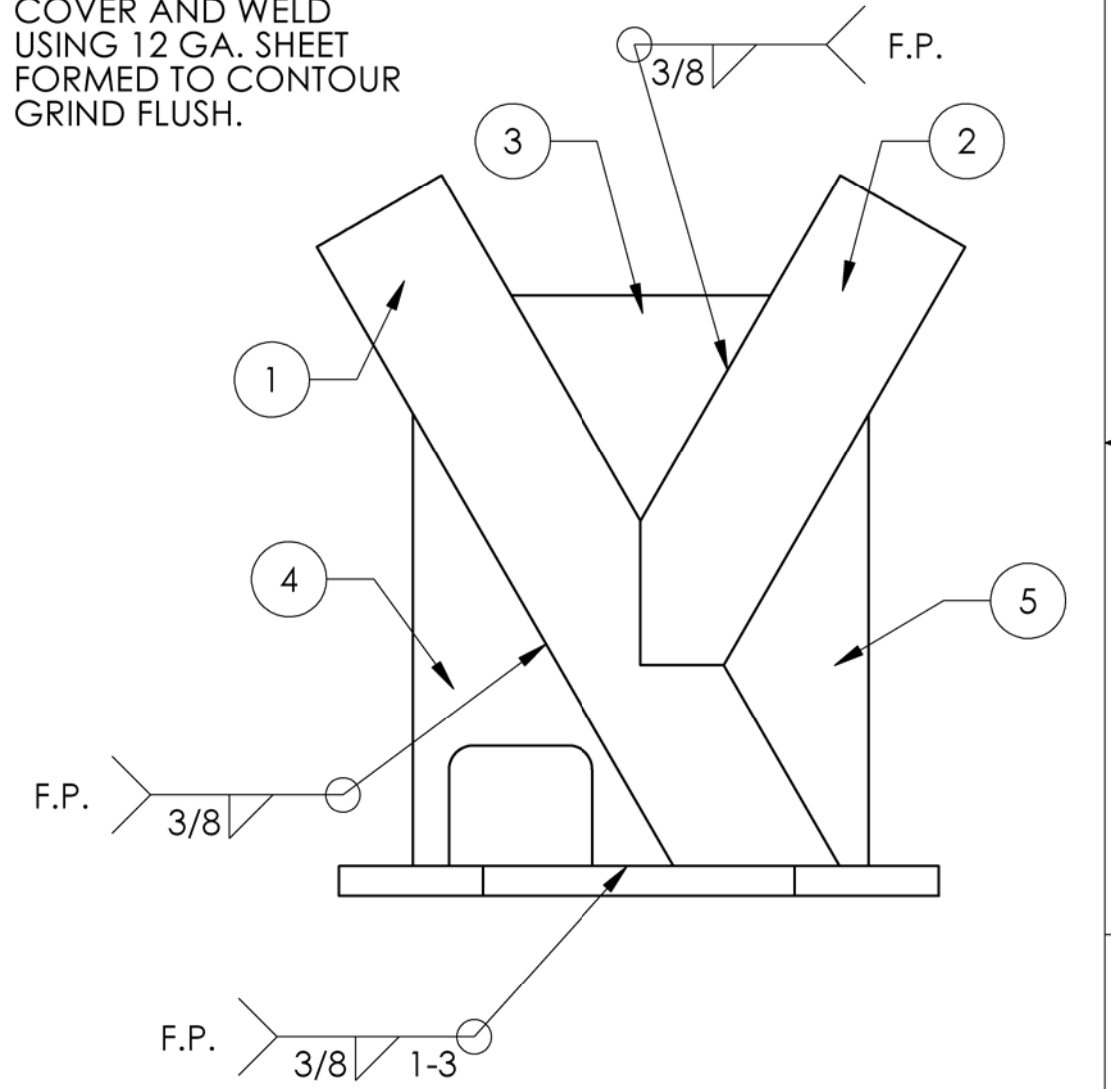
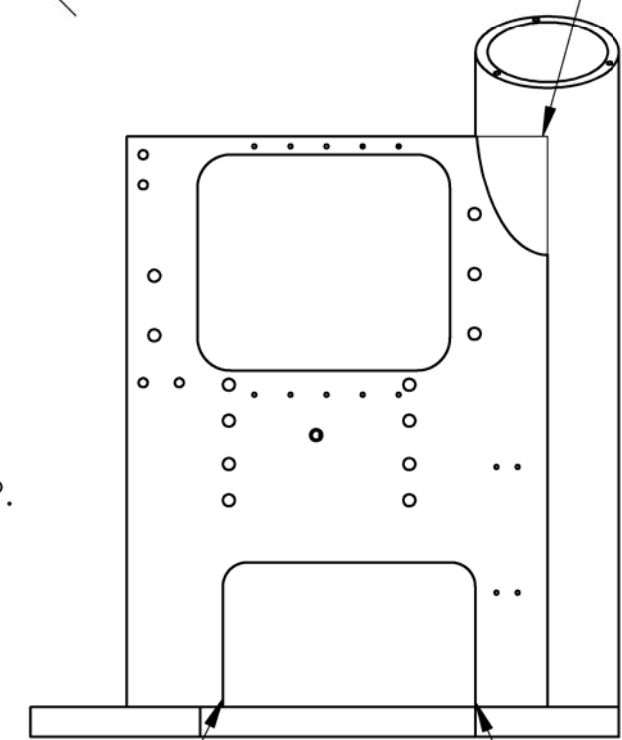
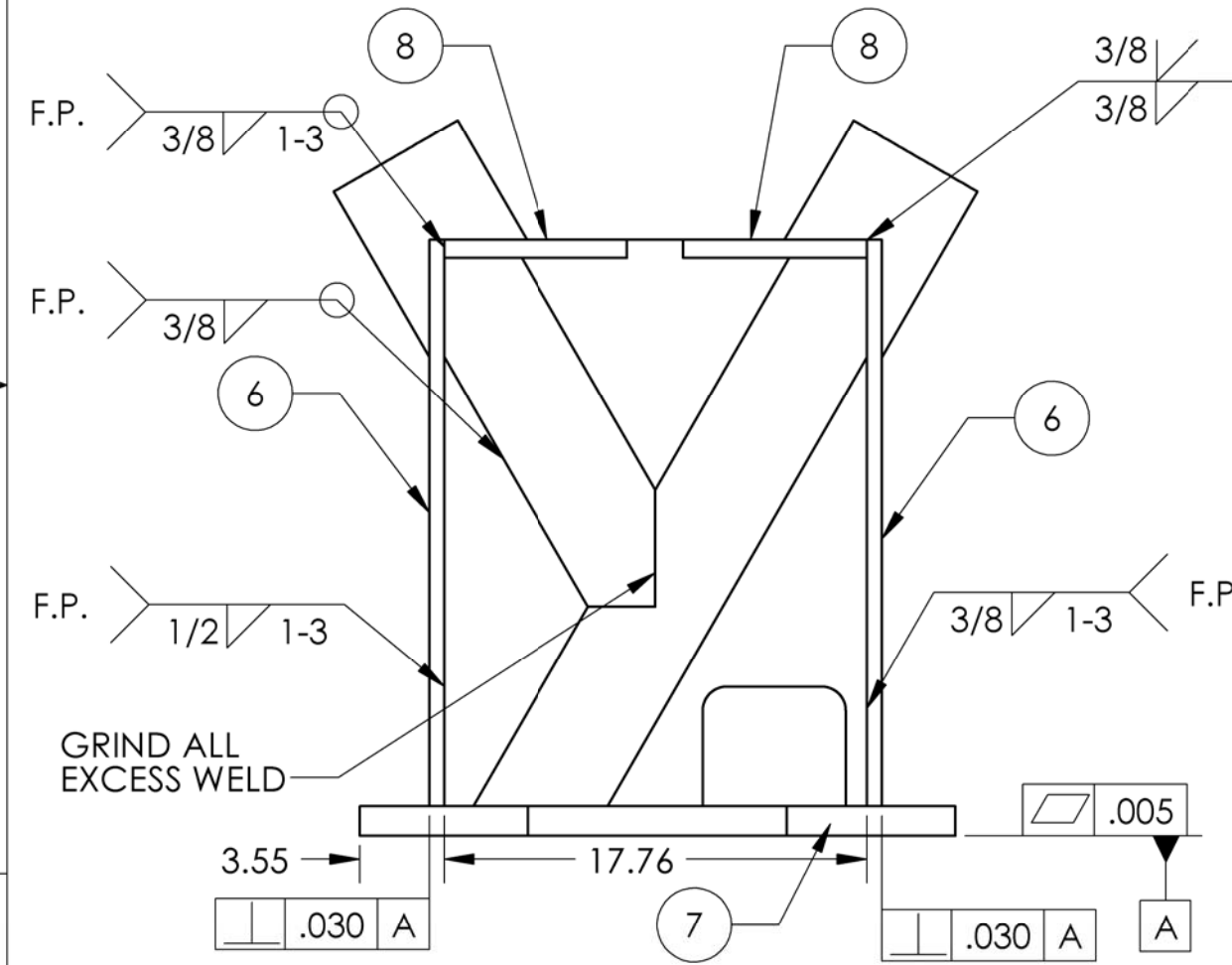
NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 = 311.5 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.
10. PLUG TAPPED HOLES AND THRU HOLES DURING PAINTING OPERATION.
11. FULL WELD CONSTRUCTION.
12. STRESS RELIEVE BEFORE FINISH MACHINING.



2X FOR CONSTRUCTION PURPOSES MACHINE WITH OPEN AREA COVER AND WELD USING 12 GA. SHEET FORMED TO CONTOUR GRIND FLUSH.

D020004_Housing_Hydraulic_Assembly, PART PDM REV: X-017, DRAWING PDM REV: X-002



ITEM NO.	QTY.	PART NO.	MATERIAL	DESCRIPTION
1	1	TUBE	STEEL, ASTM A519	TUBE, 6" DIA X .50" WALL
2	1	TUBE	STEEL, ASTM A519	TUBE, 6" DIA X .50" WALL
3	1	PLATE	STEEL, ASTM A36	BACK PLATE, .50" THK
4	1	PLATE	STEEL, ASTM A36	BACK PLATE, .50" THK
5	1	PLATE	STEEL, ASTM A36	BACK PLATE, .50" THK
6	2	PLATE	STEEL, ASTM A36	SIDE PLATE, .625" THK
7	1	PLATE	STEEL, ASTM A36	BASE PLATE, 1.25" THK
8	2	GUSSET	STEEL, ASTM A36	GUSSETS, .75" THK
9	2	GUARD	STEEL, ASTM A366	ROLLED GUARD, 12 GA

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .03
 .XXX ± .015
 ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .03 x 45°.
 3. DO NOT SCALE FROM DRAWING.

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SYSTEM: ADVANCED LIGO SUB-SYSTEM: SEI

MATERIAL: ASTM A36 Steel FINISH: 63 μinch

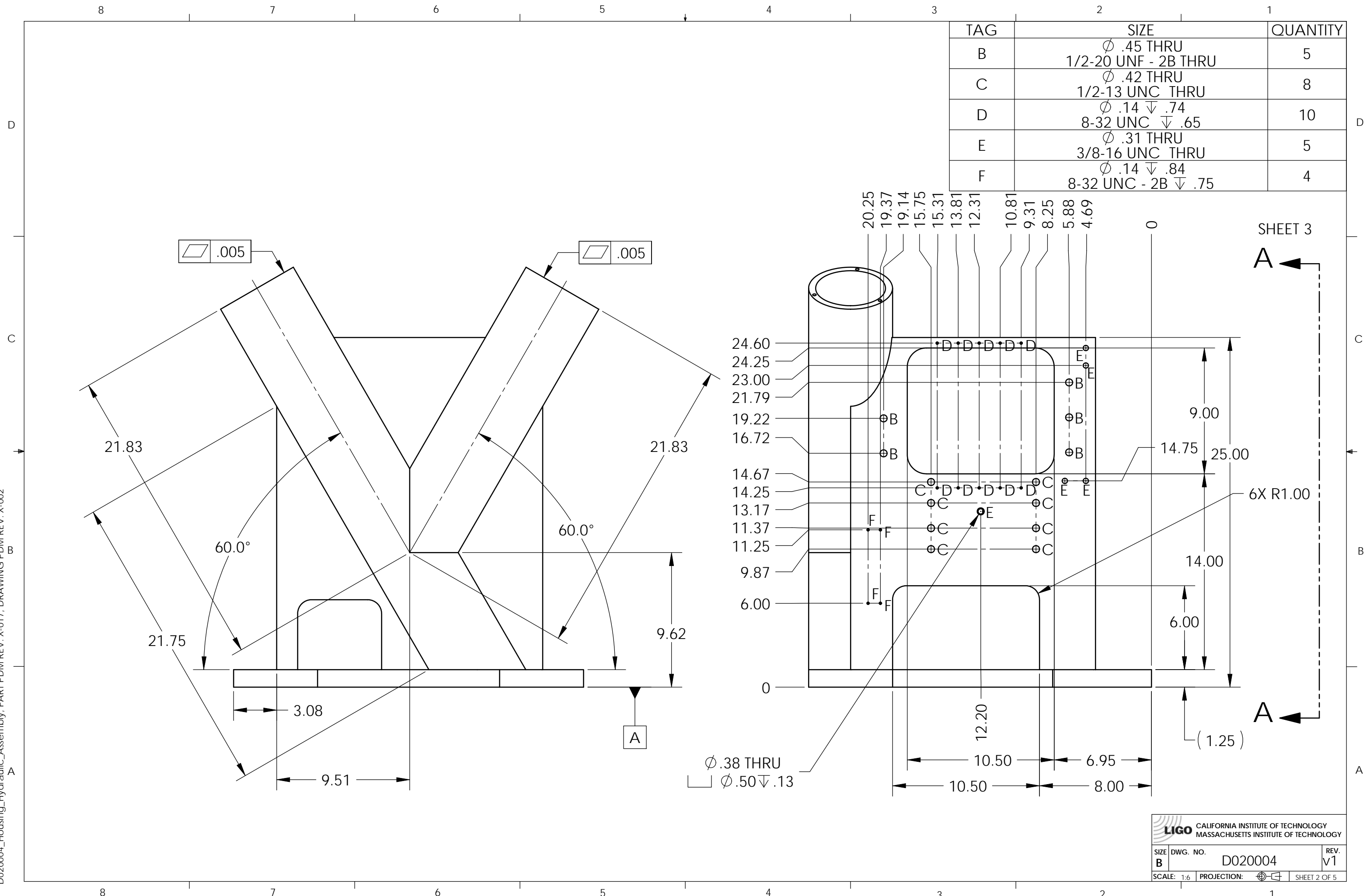
PART NAME: HOUSING HYDRAULIC ASSEMBLY

DESIGNER: K.MASON 11 Jan 2002
 DRAFTER: M.HILLARD 2 Mar 2011
 CHECKER: K.MASON 11 Jan 2002
 APPROVAL: K.MASON 2 Mar 2011

SIZE: B DWG. NO.: D020004 REV.: v1

SCALE: 1:8 PROJECTION: SHEET 1 OF 5

D020004_Housing_Hydraulic_Assembly_PART PDM REV: X-017, DRAWING PDM REV: X-002



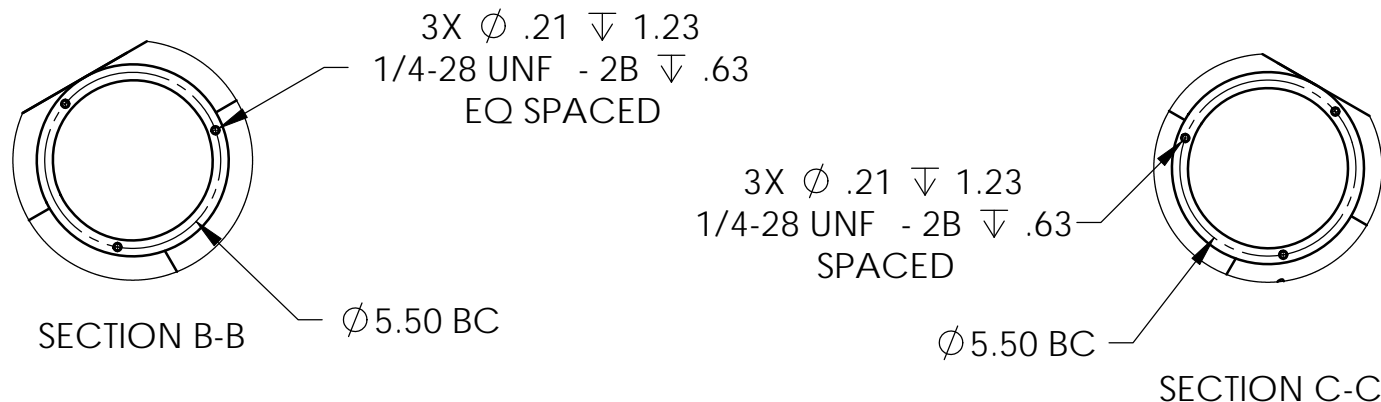
TAG	SIZE	QUANTITY
B	∅ .45 THRU 1/2-20 UNF - 2B THRU	5
C	∅ .42 THRU 1/2-13 UNC THRU	8
D	∅ .14 ∇ .74 8-32 UNC ∇ .65	10
E	∅ .31 THRU 3/8-16 UNC THRU	5
F	∅ .14 ∇ .84 8-32 UNC - 2B ∇ .75	4

SHEET 3

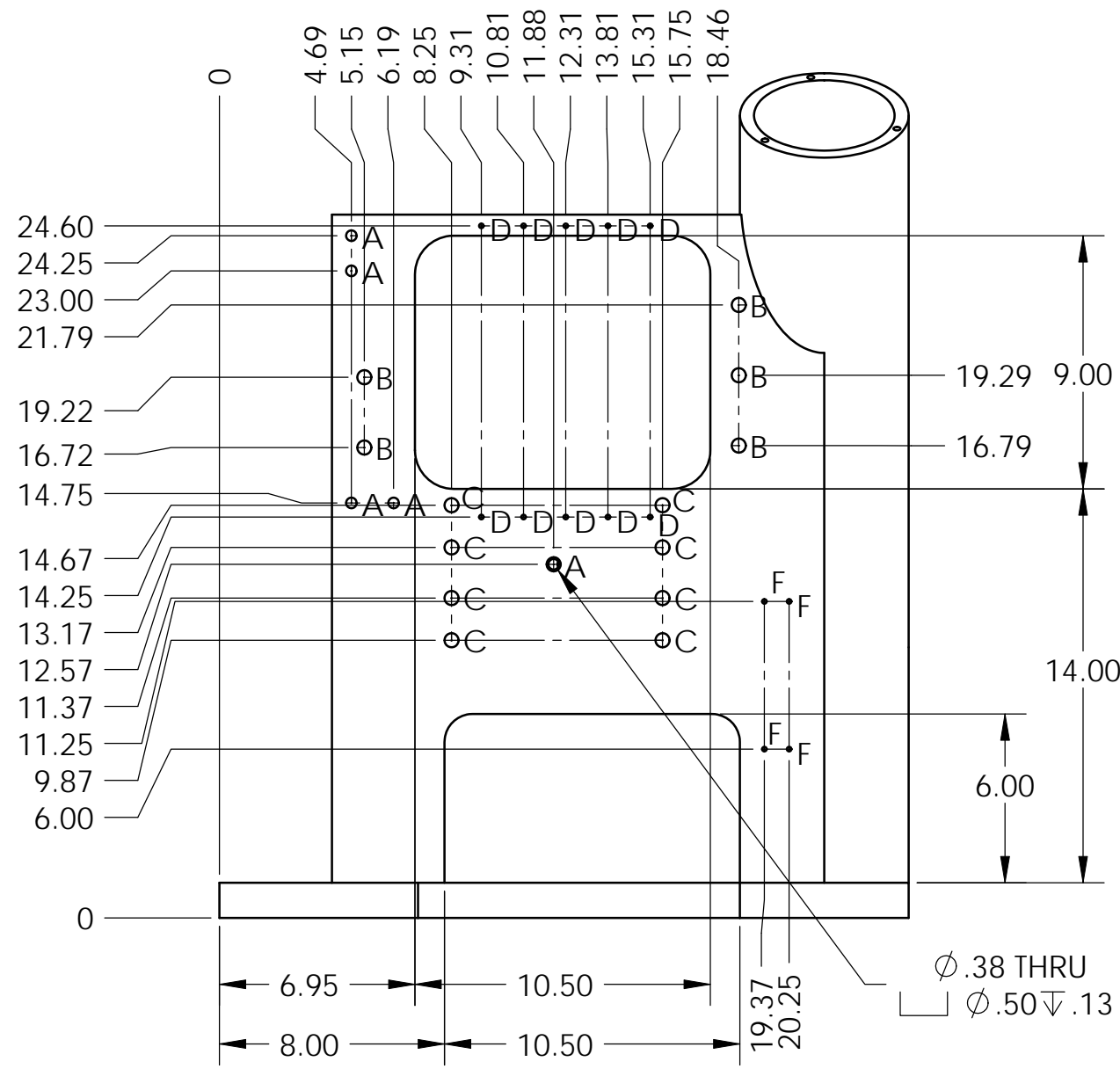
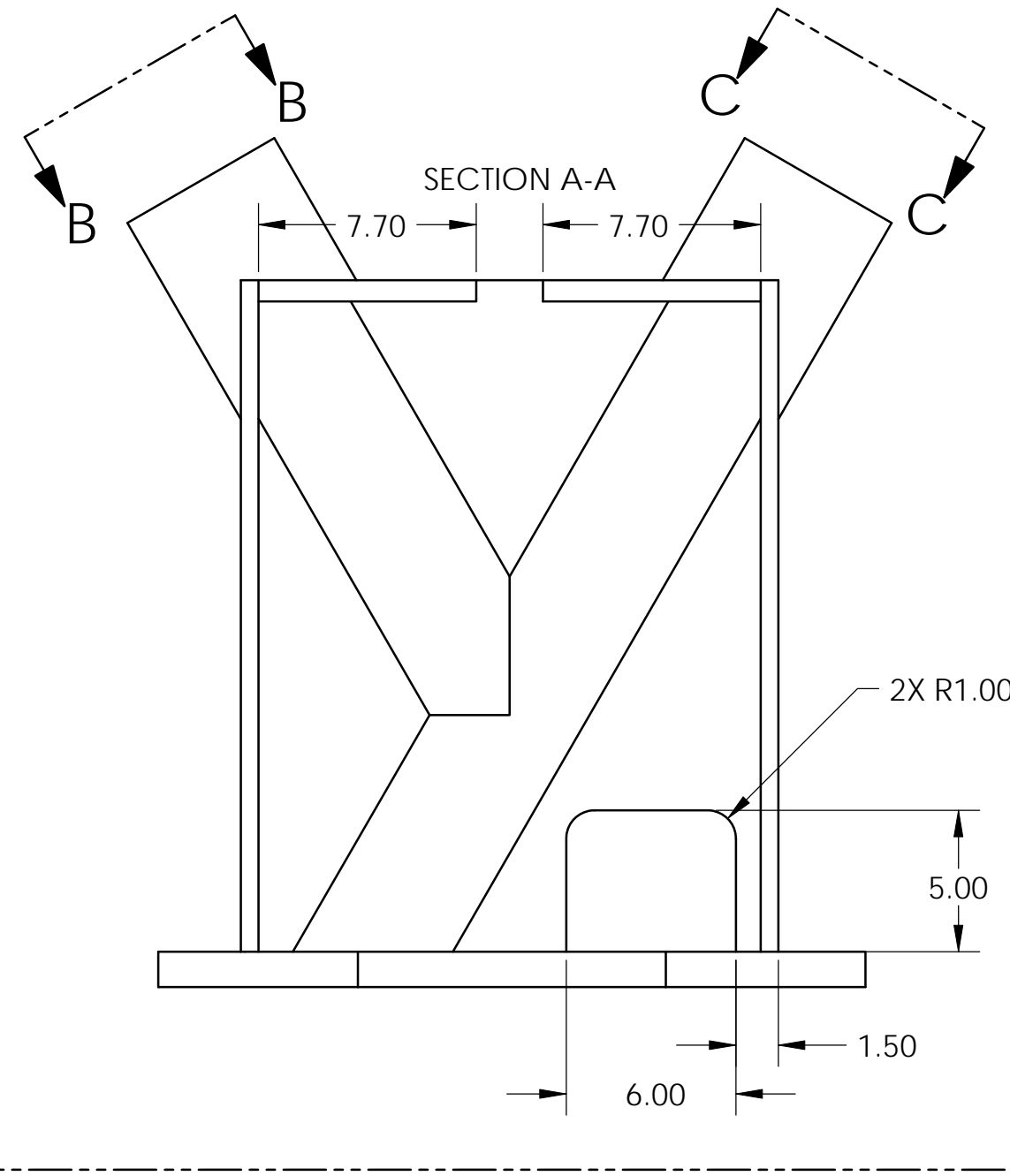
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SIZE	DWG. NO.	REV.
B	D020004	V1
SCALE: 1:6	PROJECTION:	SHEET 2 OF 5

D020004_Housing_Hydraulic_Assembly_PART PDM REV: X-017, DRAWING PDM REV: X-002



TAG	SIZE	QUANTITY
A	$\phi .31 \text{ THRU}$ $3/8-16 \text{ UNC} - 2B \text{ THRU}$	5
B	$\phi .45 \text{ THRU}$ $1/2-20 \text{ UNF THRU}$	5
C	$\phi .42 \text{ THRU}$ $1/2-13 \text{ UNC} - 2B \text{ THRU}$	8
D	$\phi .14 \nabla .74$ $8-32 \text{ UNC} - 2B \nabla .65$	10
F	$\phi .14 \nabla .84$ $8-32 \text{ UNC} - 2B \nabla .75$	4

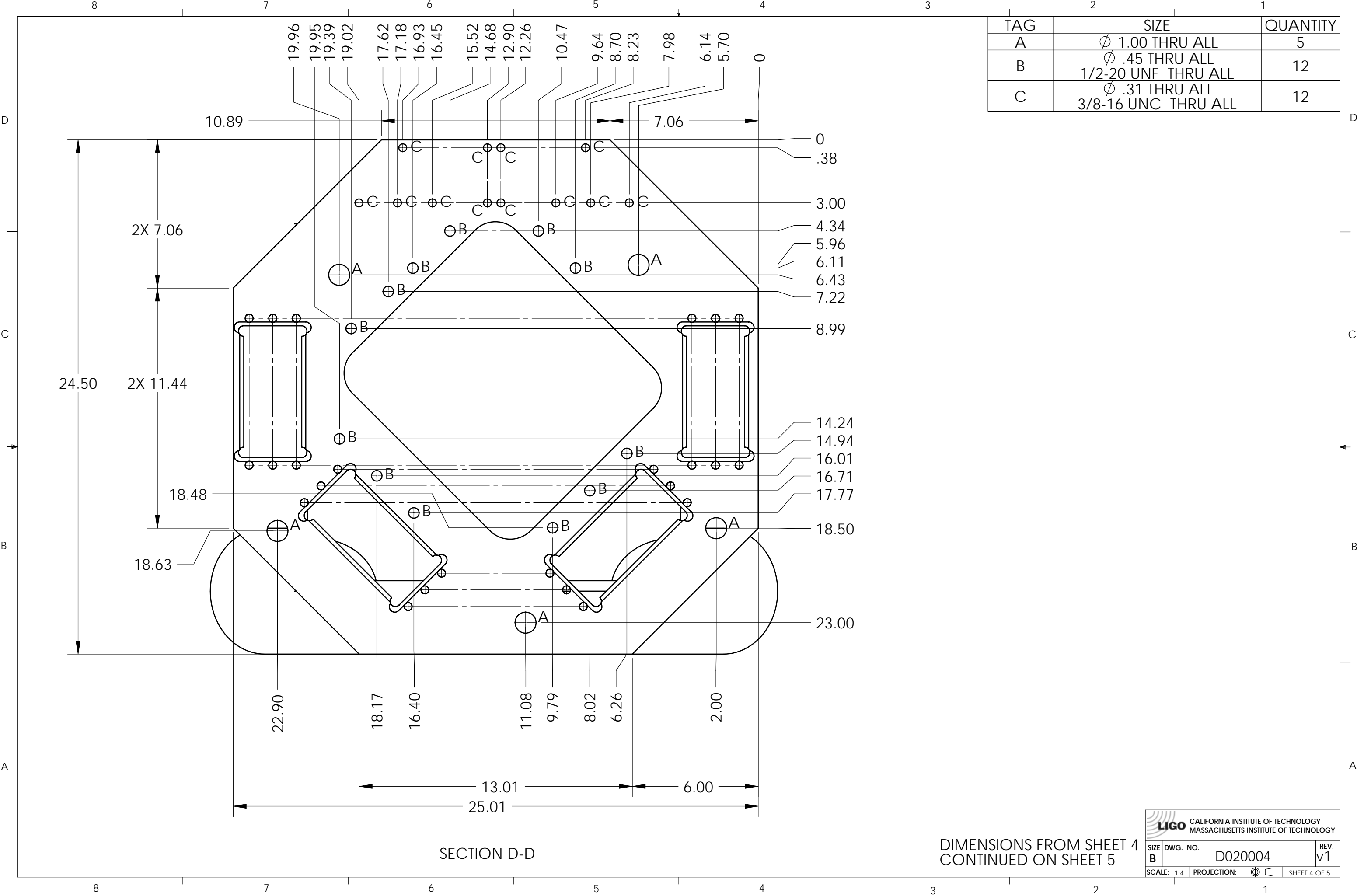


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SIZE	DWG. NO.	REV.
B	D020004	V1

SCALE: 1:6 PROJECTION: SHEET 3 OF 5

D020004_Housing_Hydraulic_Assembly_PART PDM REV: X-017, DRAWING PDM REV: X-002



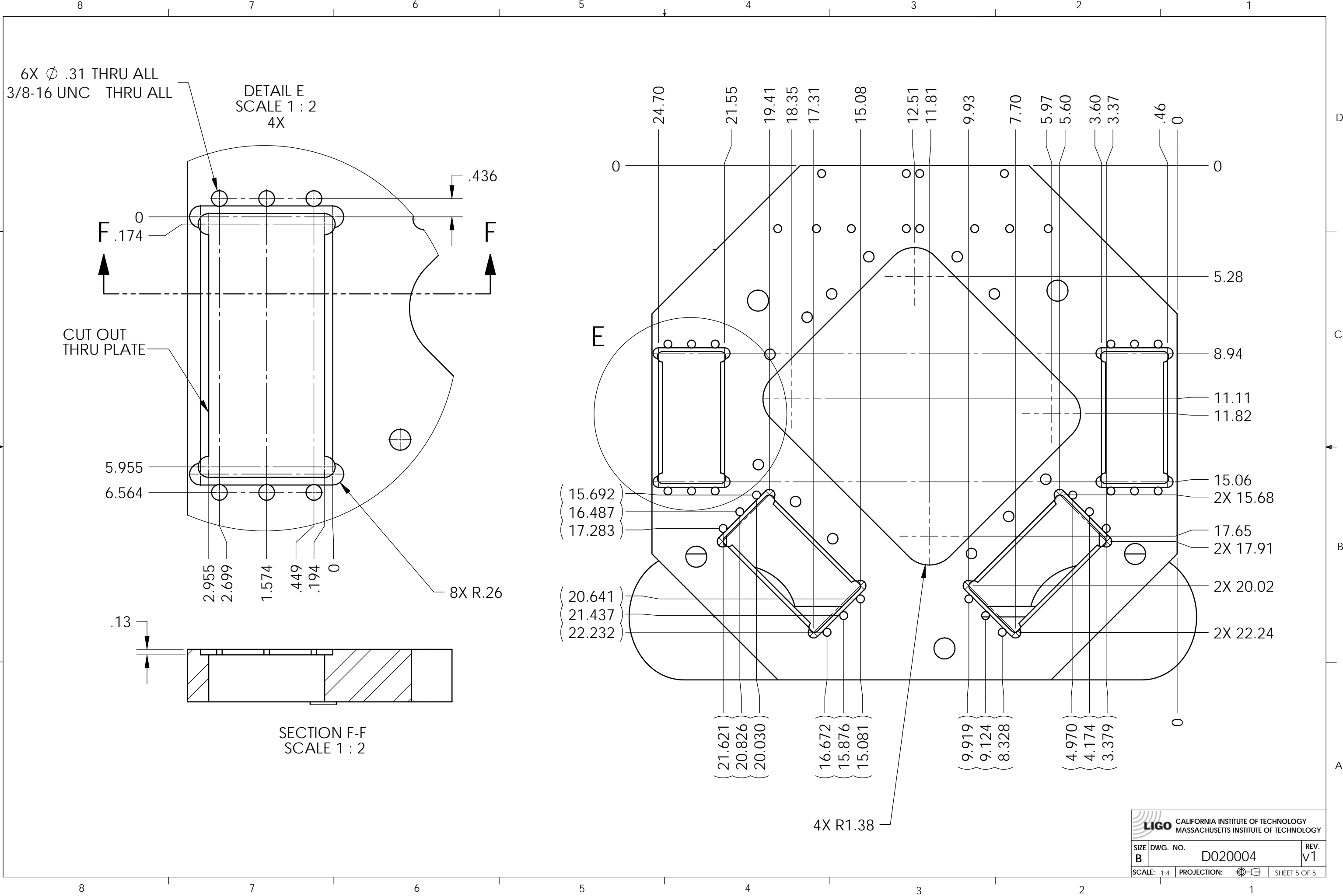
TAG	SIZE	QUANTITY
A	∅ 1.00 THRU ALL	5
B	∅ .45 THRU ALL 1/2-20 UNF THRU ALL	12
C	∅ .31 THRU ALL 3/8-16 UNC THRU ALL	12

SECTION D-D

DIMENSIONS FROM SHEET 4
CONTINUED ON SHEET 5

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SIZE	DWG. NO.	REV.
B	D020004	V1
SCALE: 1:4	PROJECTION:	SHEET 4 OF 5

D020004_Housing_Hydraulic_Assembly_PART PDM REV: X-017, DRAWING PDM REV: X-002



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SIZE	DWG. NO.	REV.
B	D020004	V1
SCALE: 1:4	PROJECTION:	SHEET 5 OF 5