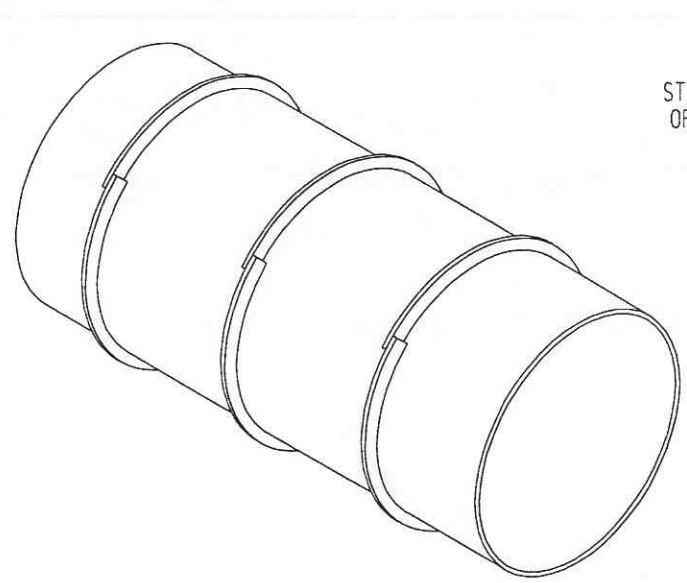
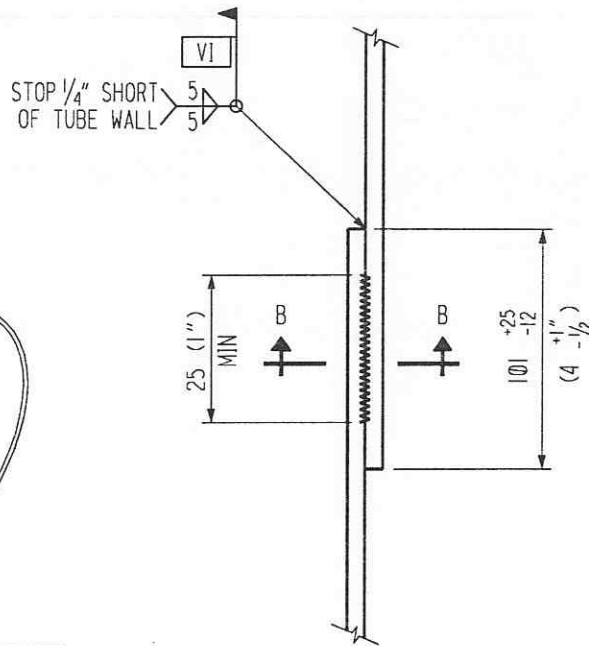


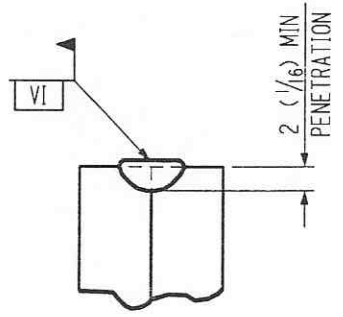
SHP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC	ID
9950	15-1		BAR SK X 5 (3/16)		M3	Ac
9874	15-1		BAR SK X 5 (3/16)		M3	Ac
			M3 = SEE SPEC C-VAC-1 (SA240-TP304L)			



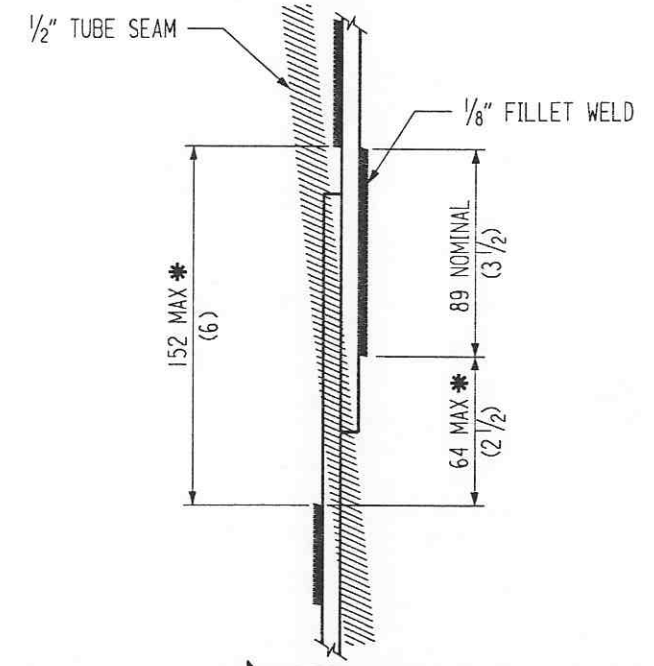
TYP STIFFENER LAYOUT  
SEE SUB-ASSEMBLY DRAWING #4 FOR EXACT SPACING



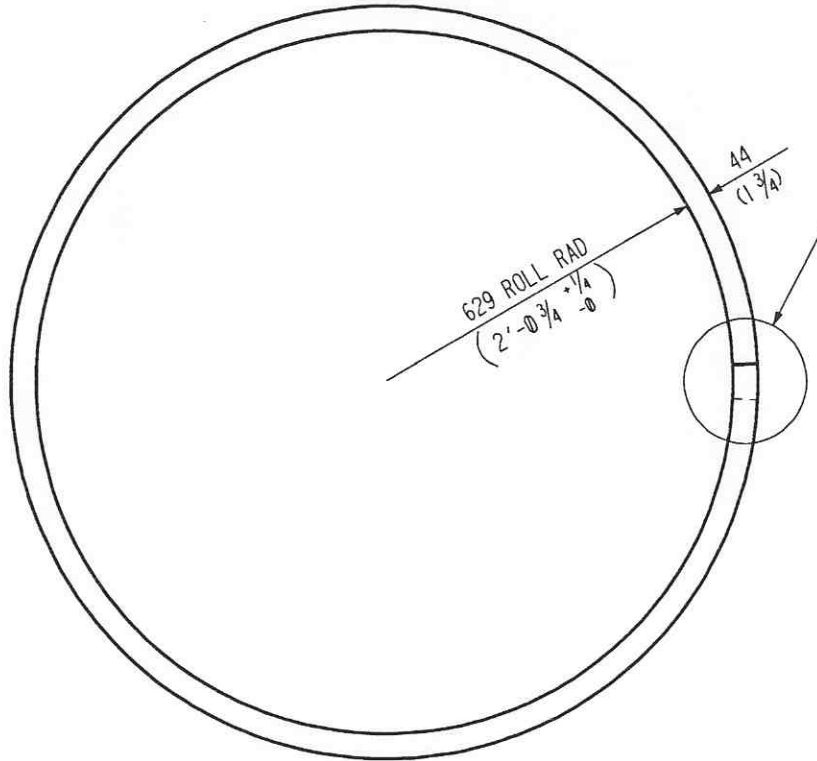
DETAIL - A  
TYP LAP WELD



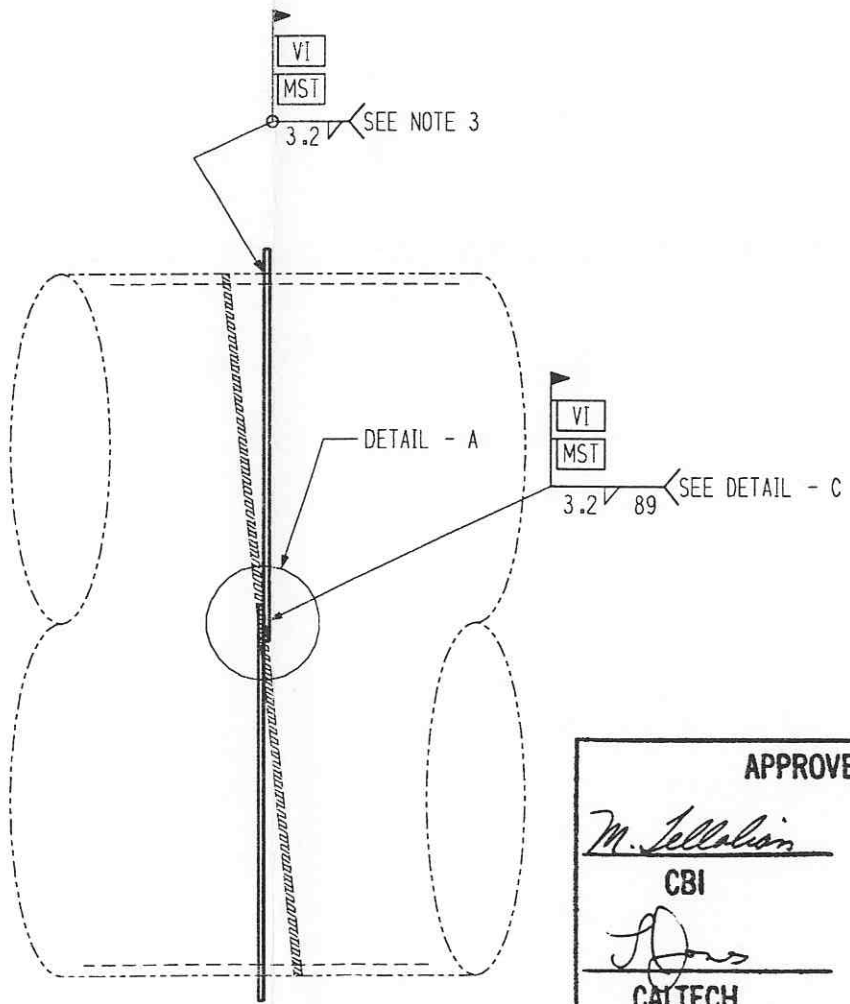
SECTION B-B



DETAIL - C  
FILLET WELD GAP



VACUUM STIFFENER ①



NOTES:

- STIFFENERS TO BE A SINGLE CONTINUOUS PIECE FORMED BY ROLLING 3/16" X 1 3/4" FLATS; ONLY THE ENDS OF THE STIFFENER TO BE CUT EDGES.
  - STIFFENERS ARE TO BE INSTALLED BY EXPANDING OVER THE TUBE AND RELEASING INTO PLACE WITH A TIGHT FIT AROUND THE TUBE.
  - DISCONTINUE FILLET WELD WHERE STIFFENER CROSSES TUBE SPIRAL WELD. SEE DETAIL - C.
  - ALLOW EXTRA LENGTH FOR FORMING SO THAT THE ENDS OF THE STIFFENERS ARE ROLLED TO 629 (2' - 0 3/4 + 1/4) RADIUS. STIFFENERS NOT FORMED AT ENDS MAY BE REJECTED.
  - WORK THIS DRAWING WITH DRAWING #4.
- \* UNWELDED AREA MAY BE DECREASED BY LOCATING SPLICE CAREFULLY WITH LAP ON RIGHT SIDE.

APPROVED  
*M. Tellalian* 9-13-96  
 CBI DATE  
*J. Jones* 9/23/96  
 CALTECH DATE

INDICATES CHANGE FROM PREVIOUS ISSUE

BY: CHKD 3 DATE 4-1-96		REV. QUANTITY AND CONTRACT #		CBI		SUPPLIER'S / PURCHASER'S NO	
BY: CHKD 4 DATE 4-1-96		REV. DETAIL C AND NOTES		LIGO BEAM TUBE		CONTRACT NO 953571	
BY: CHKD 5 DATE 9-13-96		REV. NOTE, REMOVED OWNERSHIP NOTE.		HANFORD, WA & LIVINGSTON, LA		CUSTOMER'S NO	
BY: CHKD 6 DATE 6-28-96		REVISIONS		VACUUM STIFFENER DETAILS		DWG 15 REV 5	
				M.J. TELLALIAN ENGINEERING ASSIGNED		SHT	
				BY: KJR CHKD DET DATE 3-14-94		REMARKS	
						L190-D950040-05-B	

55710015.DGN