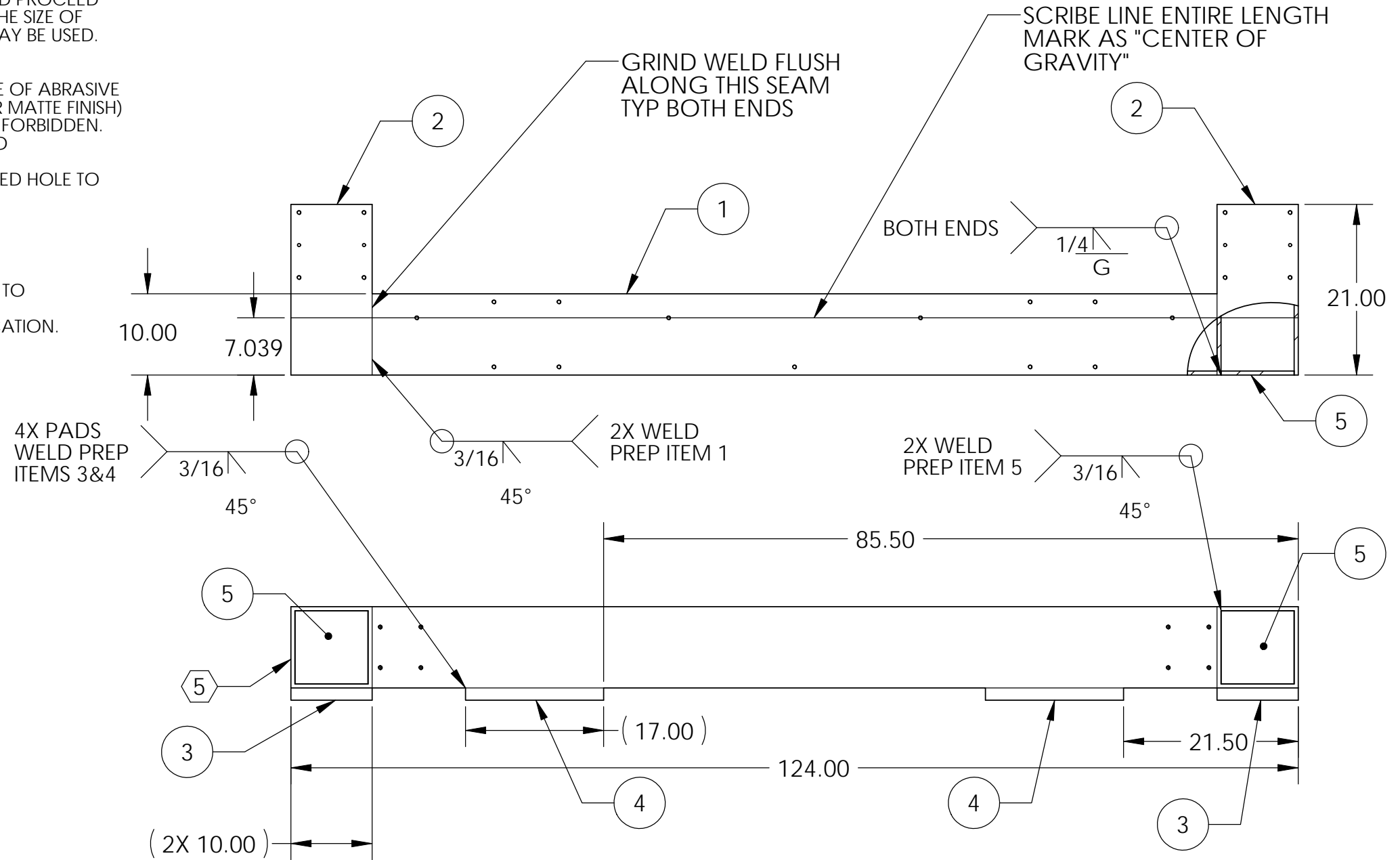


REV.	DATE	DCN #	DRAWING TREE #
v1	6 May 2011	E1100513	E1100016

NOTES CONTINUED:

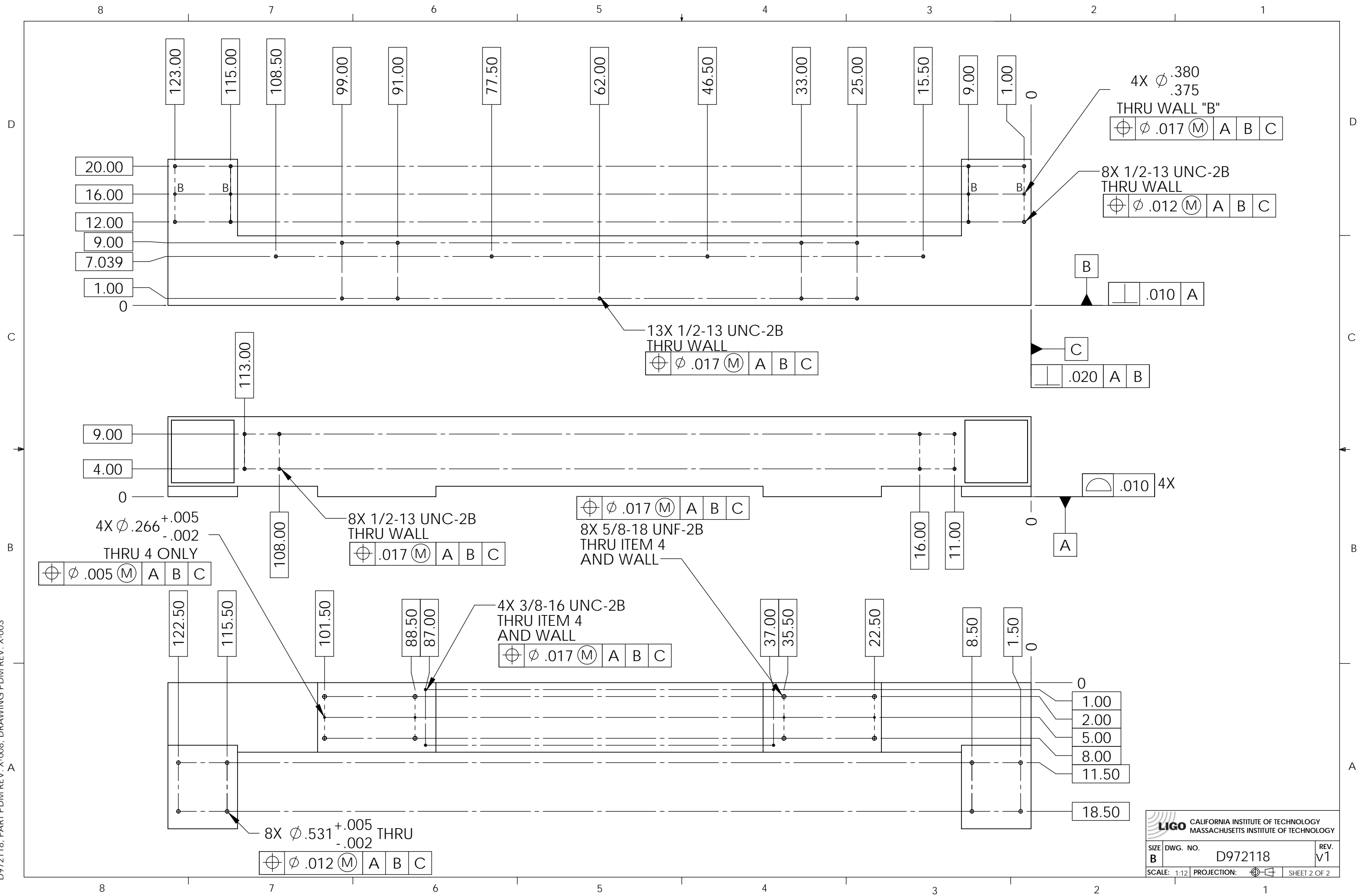
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE 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 = 1053.28706933 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. COUNTERSINK ALL TAPPED HOLES TO MAJOR DIA X 82° AND DRILLED HOLE TO .03/.06 DEEP X 82°.
10. PAINT: ALL VISIBLE SURFACES MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
11. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.



ITEM NO.	QTY	DESC	MAT'L
1	1	BOX BEAM 10 X 10 X 104 LG. X .50 WALL	A500 GRADE B STEEL
2	2	BOX BEAM 10 X 10 X 21 LG. X .50 WALL	A500 GRADE B STEEL
3	2	MOUNTING PAD 12 X 10 X 1.50	A36 STEEL
4	2	MOUNTING PAD 17 X 10 X 1.50	A36 STEEL
5	2	BOX CLOSURE PLATE .50 THK CUT TO FIT INTO BOX BEAM	A36 STEEL

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME CROSSBEAM WELDMENT, aLIGO BSC HEPI				
TOLERANCES: .XX ± .03 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .03 x 45°. 3. DO NOT SCALE FROM DRAWING.		ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER R.SMITH 28 May 1997	SIZE DWG. NO. B D972118	REV. v1
ANGULAR ± .5°		MATERIAL ASTM A36 Steel		FINISH 125 μinch		NEXT ASSY D1000513		CHECKER H.SALAZAR 14 July 1997	APPROVAL K.MASON 6 May 2011	SCALE: 1:16 PROJECTION: SHEET 1 OF 2

D972118, PART PDM REV: X-008, DRAWING PDM REV: X-003



**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D972118	V1
SCALE: 1:12	PROJECTION:	SHEET 2 OF 2