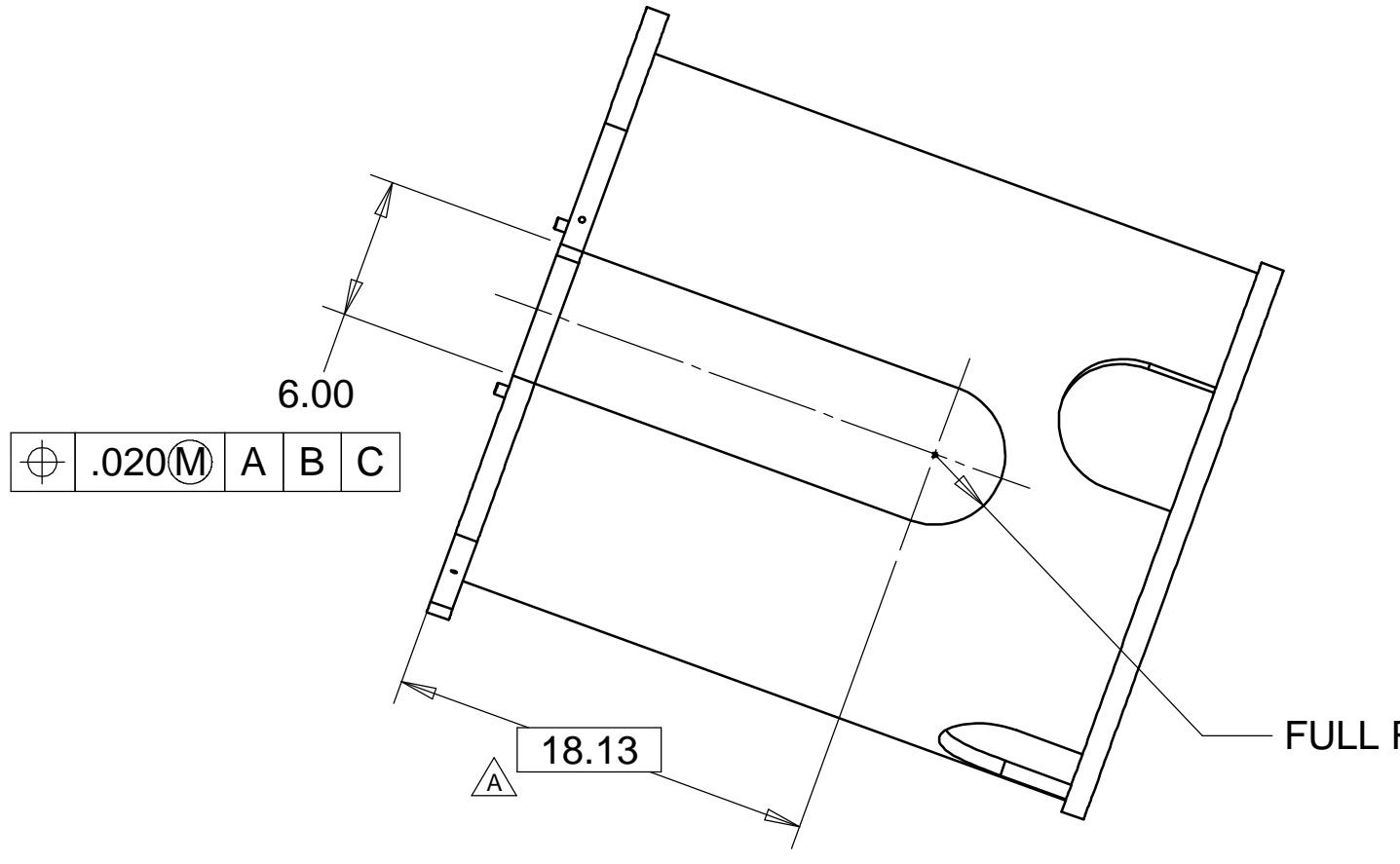
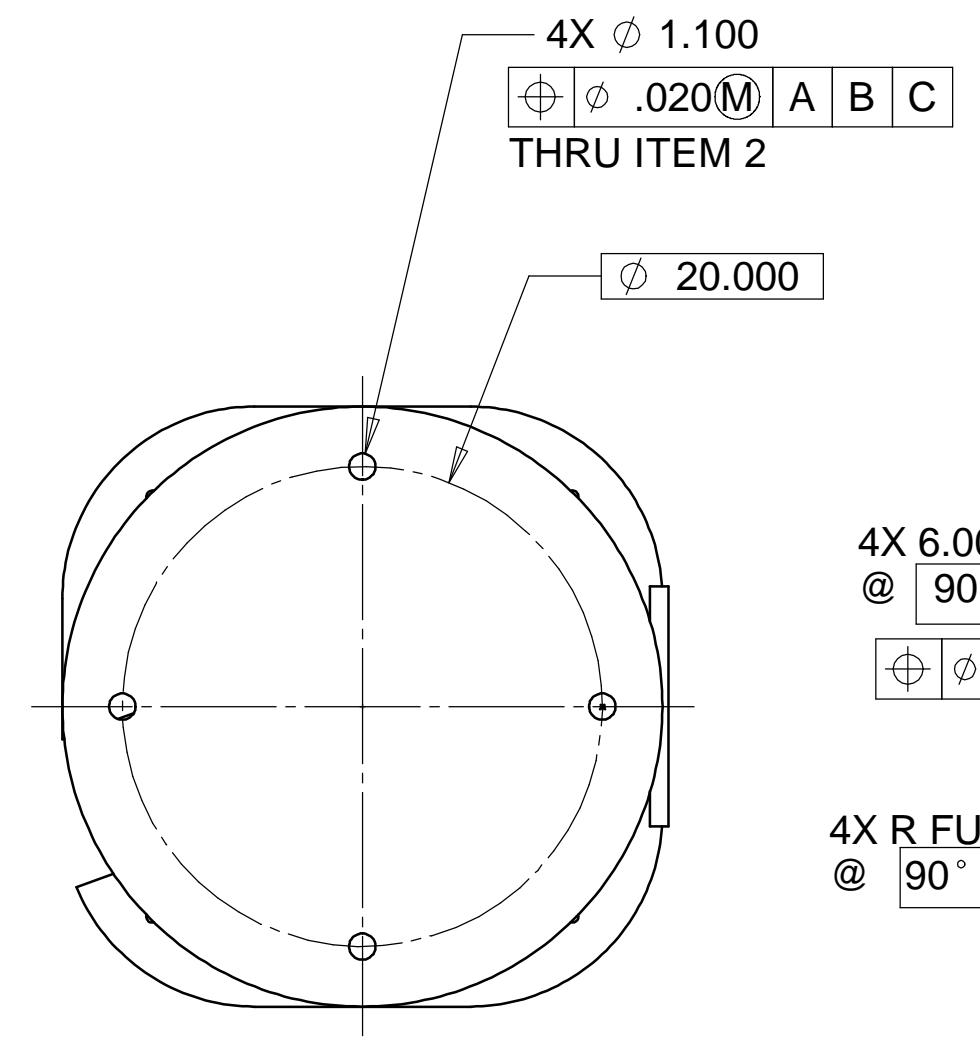


8 7 6 5 4 3 2 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN #-----FOR REVISION LIST	10-16-97	T. THOMPSON



VIEW A-A

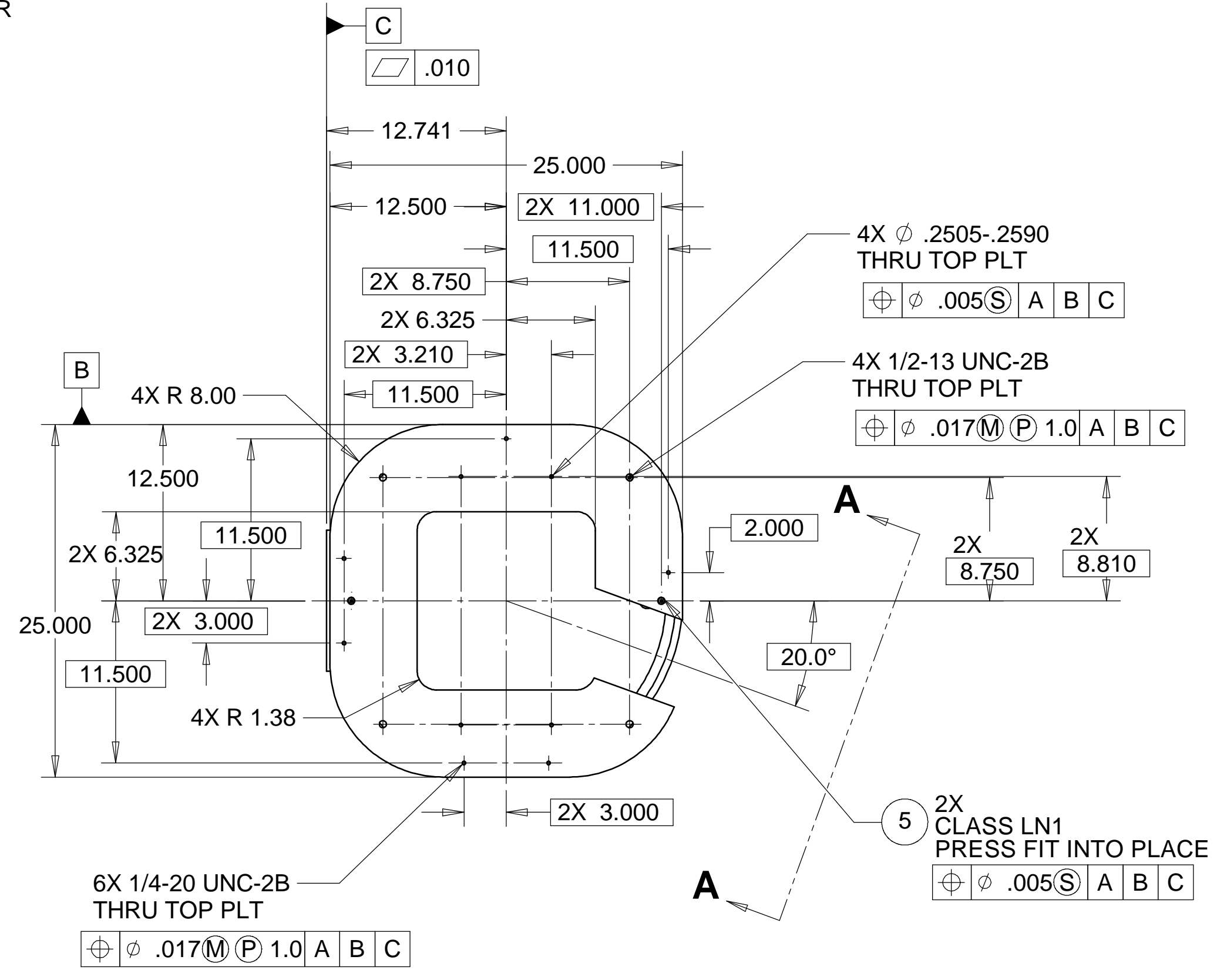
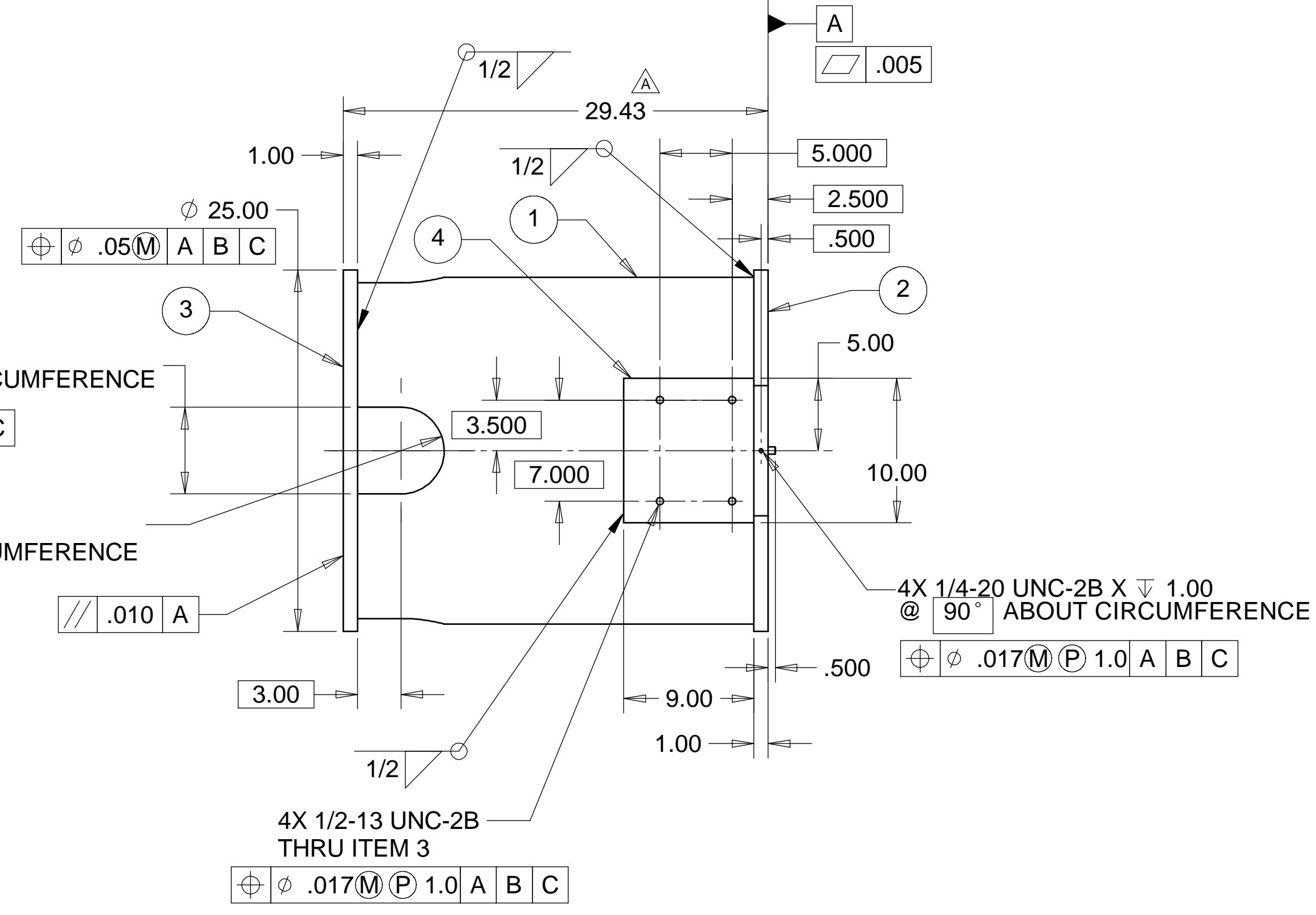


4X ϕ 1.100
 $\sqrt{\text{.020}}\text{M A B C}$
 THRU ITEM 2

ϕ 20.000

4X 6.000
 @ 90° ABOUT CIRCUMFERENCE
 $\sqrt{\text{.02}}\text{M A B C}$

4X R FULL
 @ 90° ABOUT CIRCUMFERENCE



NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION: LIGO-TS-03 CATEGORY 1.
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED STAINLESS STEEL MACHINE LUBRICANT: RELTON A-9, RELTON

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	TUBE, 24.00 DIA. X .68 WALL	A 500 GRADE B STEEL
2	1	PLATE	A 500 GRADE B STEEL
3	1	PLATE	A 500 GRADE B STEEL
4	1	PLATE	A 500 GRADE B STEEL
5	2	DOWEL PIN, .5000 DIA. X 1.00 LG.	A 500 GRADE B STEEL

PARTS LIST				HYTEC, INC	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		TITLE LIGO BSC LEFT HAND SUPPORT PIER PROTOTYPE	
DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	SIGNATURE DESIGNED: ROGER L. SMITH DRAWN: ROGER L. SMITH CHECKED: HARRY SALAZAR ENGR.: T. THOMPSON APPROVED: T. THOMPSON	DATE 5-28-97 5-28-97 8-5-97 8-6-97 8-6-97	DWG. NO. D972303	SIZE SHEET NO. D 1 of 1
PART NO. D972303-1		SCALE 1/8		REVISION A	

8 7 6 5 4 3 2 1