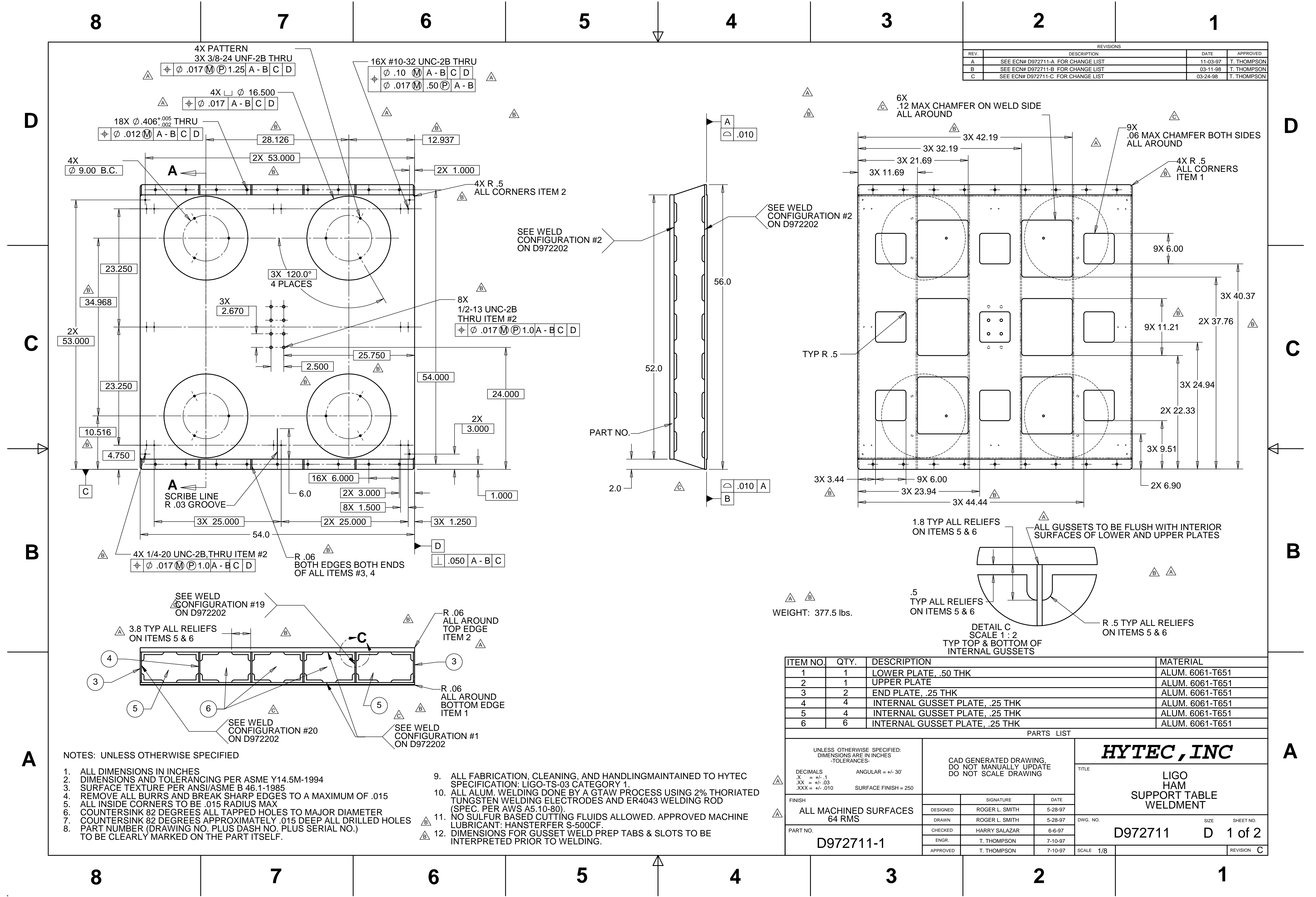


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972711-A FOR CHANGE LIST	11-03-97	T. THOMPSON
B	SEE ECN# D972711-B FOR CHANGE LIST	03-11-98	T. THOMPSON
C	SEE ECN# D972711-C FOR CHANGE LIST	03-24-98	T. THOMPSON



ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	LOWER PLATE, .50 THK	ALUM. 6061-T651
2	1	UPPER PLATE	ALUM. 6061-T651
3	2	END PLATE, .25 THK	ALUM. 6061-T651
4	4	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651
5	4	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651
6	6	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T651

- 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
 - 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.
 - ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN WELDING ELECTRODES AND ER4043 WELDING ROD (SPEC. PER AWS A5.10-80).
 - NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: HANSTERFER S-500CF.
 - DIMENSIONS FOR GUSSET WELD PREP TABS & SLOTS TO BE INTERPRETED PRIOR TO WELDING.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-

DECIMALS: .X = +/- .1, .XX = +/- .03, .XXX = +/- .010

ANGULAR: +/- .30'

SURFACE FINISH = 250

CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE, DO NOT SCALE DRAWING

HYTEC, INC

TITLE: LIGO HAM SUPPORT TABLE WELDMENT

DWG. NO. D972711 SIZE D 1 of 2 SHEET NO.

SCALE 1/8 REVISION C

FINISH: ALL MACHINED SURFACES 64 RMS

PART NO. D972711-1

DESIGNED	SIGNATURE	DATE
ROGER L. SMITH		5-28-97
DRAWN	ROGER L. SMITH	5-28-97
CHECKED	HARRY SALAZAR	6-6-97
ENGR.	T. THOMPSON	7-10-97
APPROVED	T. THOMPSON	7-10-97

8

7

6

5

4

3

2

1

REVISIONS		
REV.	DESCRIPTION	DATE
C	SEE ECN# D972711-C FOR CHANGE LIST	03-24-98
		T. THOMPSON

D

D

C

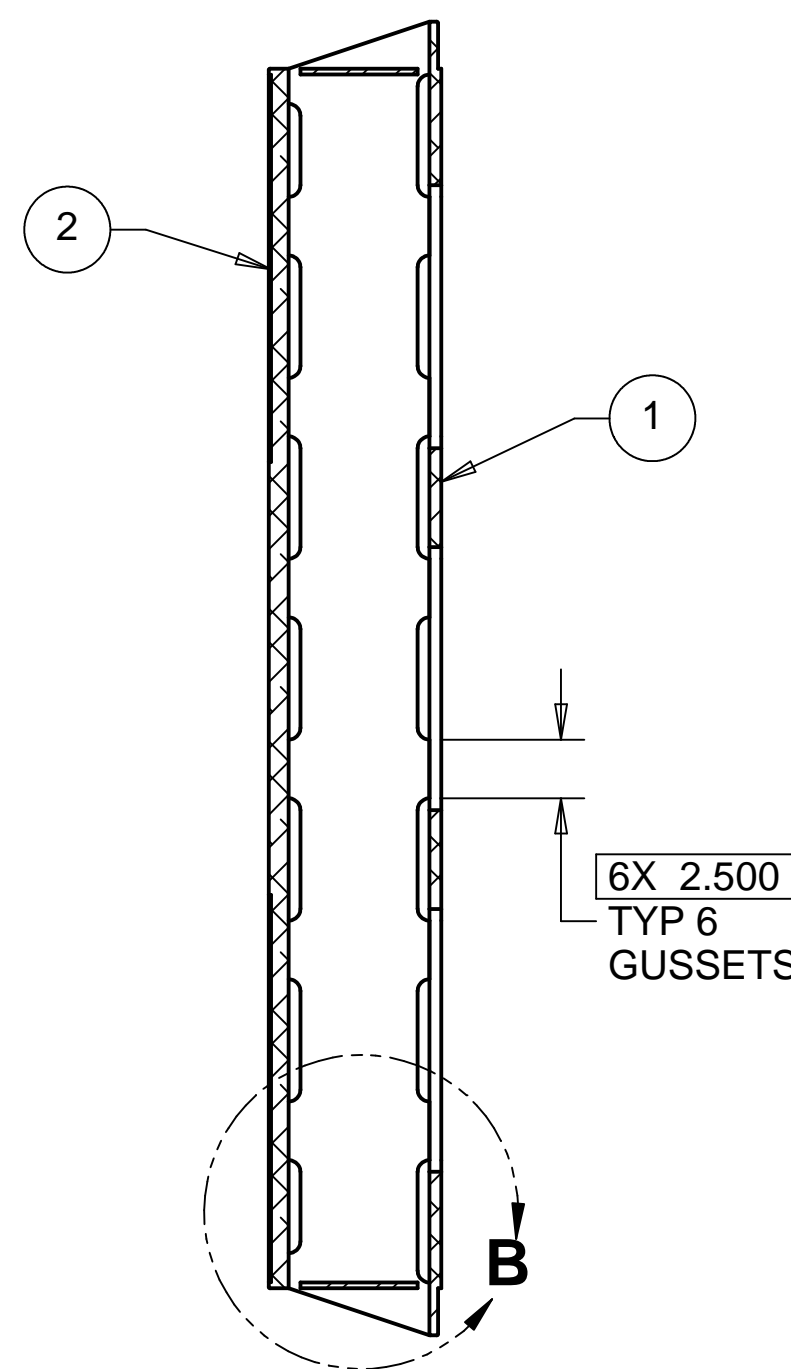
C

B

B

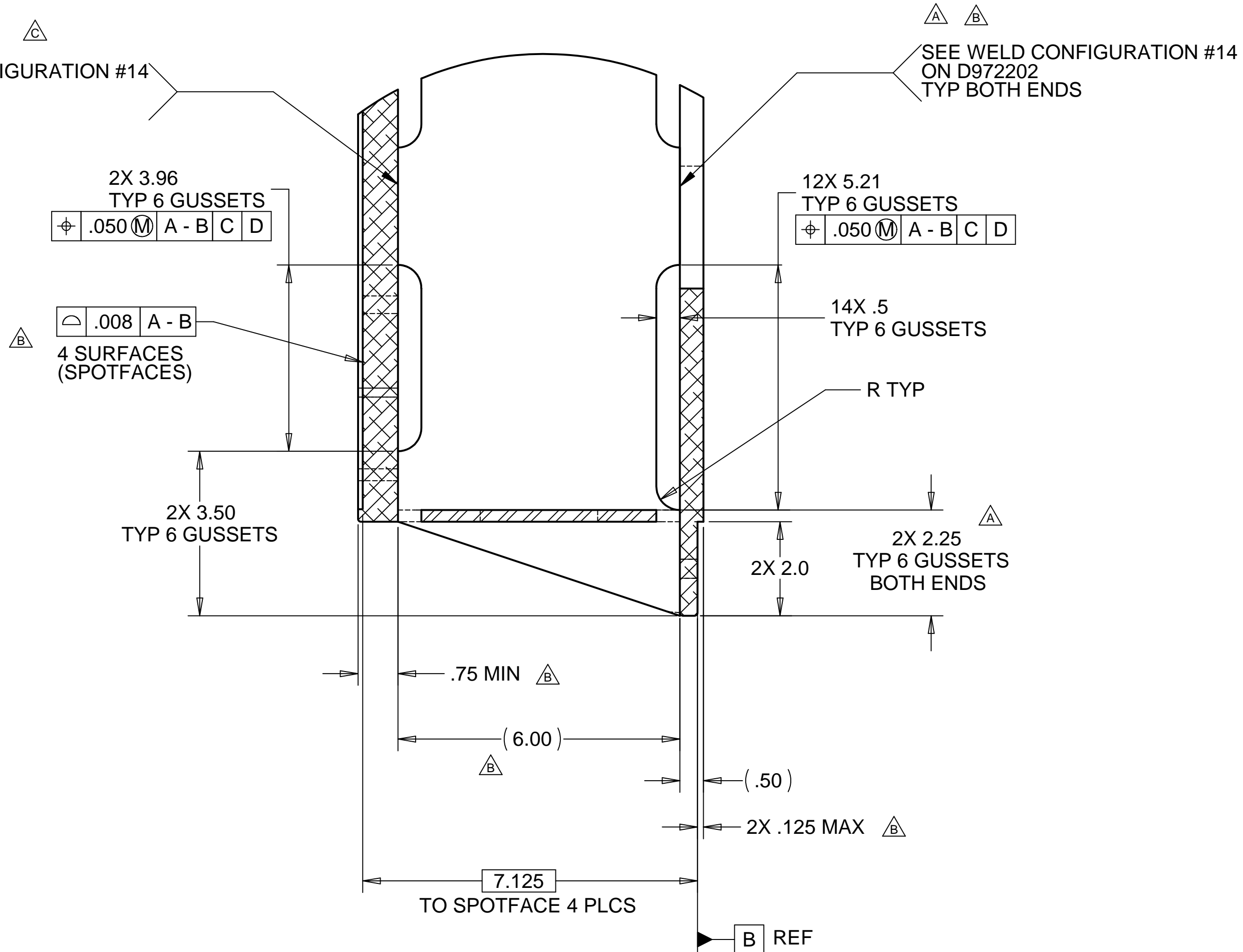
A

A



SECTION A-A FROM SHEET D1

SEE WELD CONFIGURATION #14 ON D972202 TYP BOTH ENDS



DETAIL B SCALE 1 : 2

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010		ANGULAR = +/- .30' SURFACE FINISH = 250	
FINISH ALL MACHINED SURFACES 64 RMS		SIGNATURE DATE	
DESIGNED ROGER L. SMITH 05-28-97		DRAWN ROGER L. SMITH 05-28-97	
CHECKED HARRY SALAZAR 06-06-97		ENGR. T. THOMPSON 07-10-97	
APPROVED T. THOMPSON 07-10-97		SCALE 1/8	
PART NO. D972711-1		DWG. NO. D972711	
		SIZE D	
		SHEET NO. 2 of 2	
		REVISION C	

HYTEC, INC

TITLE
LIGO
HAM
SUPPORT TABLE
WELDMENT

D972711

D 2 of 2

8

7

6

5

4

3

2

1