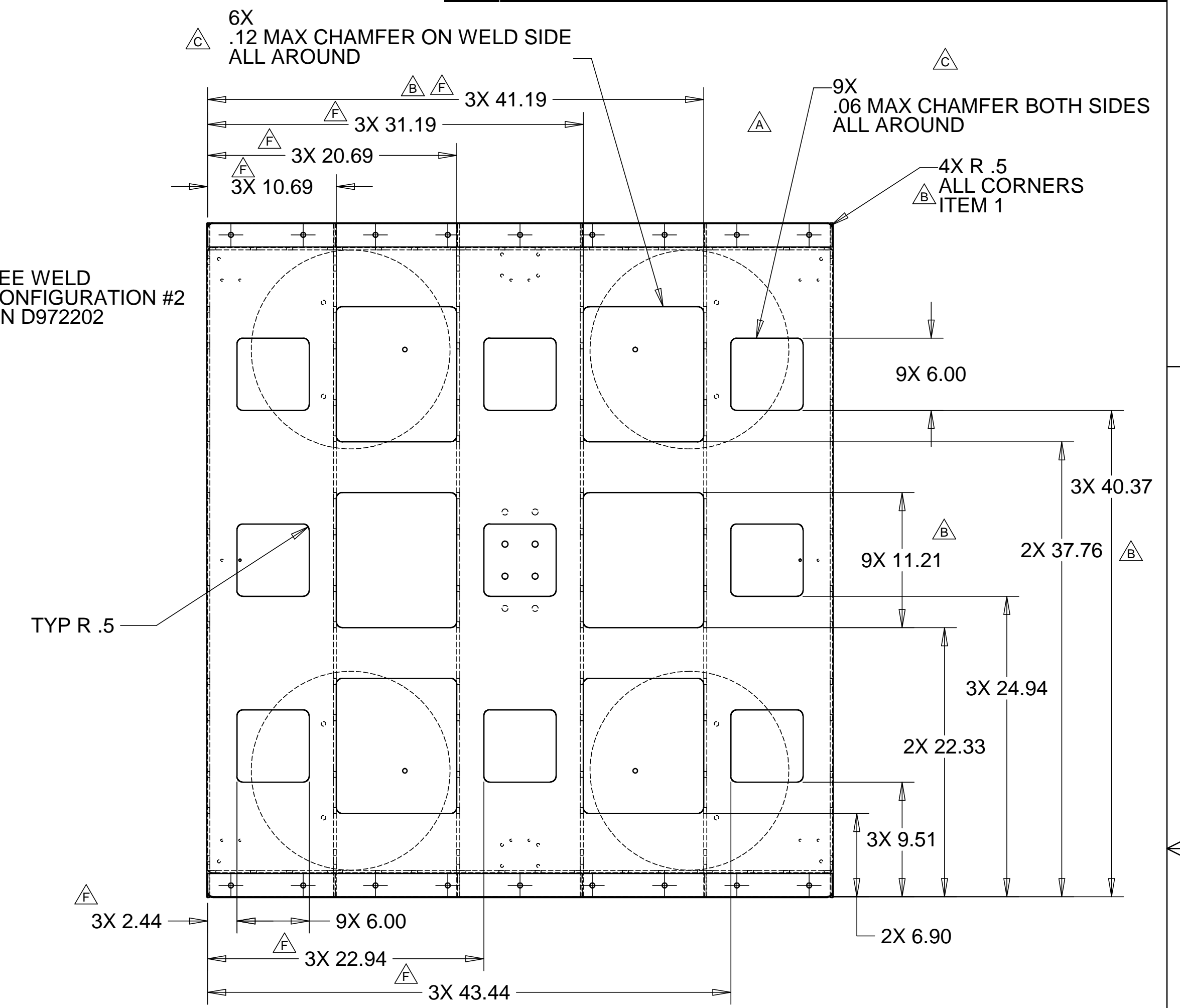
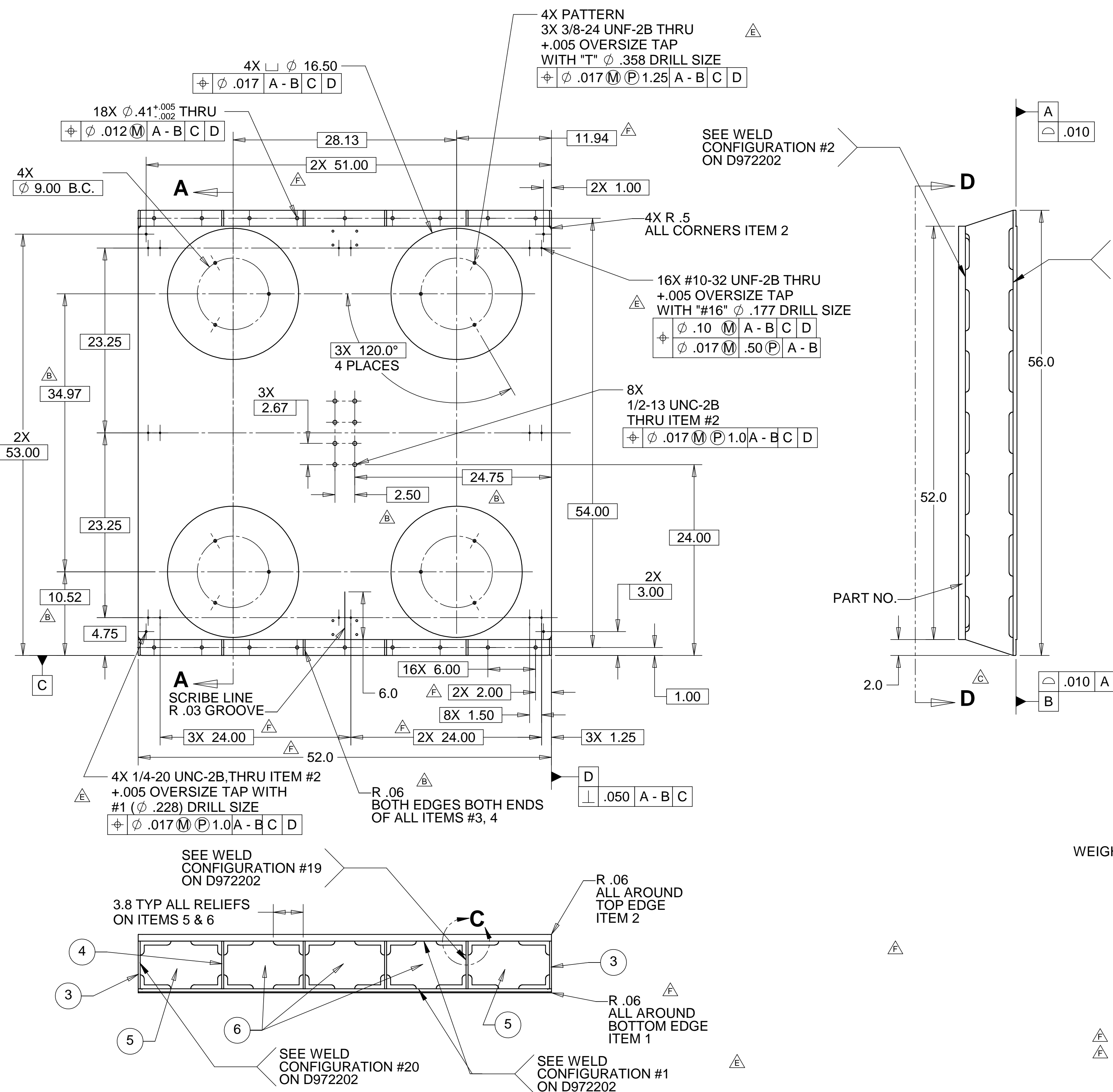


REVISIONS		DATE	APPROVED
REV	DESCRIPTION		
A	SEE ECN# D972711-A FOR CHANGE LIST	11/03/97	T. THOMPSON
B	SEE ECN# D972711-B FOR CHANGE LIST	03/11/98	T. THOMPSON
C	SEE ECN# D972711-C FOR CHANGE LIST	03/24/98	T. THOMPSON
D	SEE ECN# D972711-D FOR CHANGE LIST	05/21/98	T. THOMPSON
E	SEE ECN# D972711-E FOR CHANGE LIST	09/01/98	T. THOMPSON
F	SEE ECN# D972711-F FOR CHANGE LIST	10/13/98	T. THOMPSON



1.8 TYP ALL RELIEFS ON ITEMS 5 & 6

ALL GUSSETS TO BE FLUSH WITH INTERIOR SURFACES OF LOWER AND UPPER PLATES

.5 TYP ALL RELIEFS ON ITEMS 5 & 6

R .5 TYP ALL RELIEFS ON ITEMS 5 & 6

DETAIL C SCALE 1 : 3

WEIGHT: 370.5 lbs.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	LOWER PLATE, .50 THK	ALUM. 6061-T651
2	1	UPPER PLATE	ALUM. 6061-T652
3	2	END PLATE, .25 THK	ALUM. 6061-T653
4	4	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T654
5	4	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T655
6	6	INTERNAL GUSSET PLATE, .25 THK	ALUM. 6061-T656
7			
8			

- 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 .03/.06 DEEP ALL DRILLED HOLES
 - PART NUMBER (DRAWING NO., DASH NO., REVISION NO., 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

SHEET NO: 1 of 2

SCALE: 1/8

REVISION: F

FINISH: ALL MACHINED SURFACES 64 RMS

PART NO: D972711-1

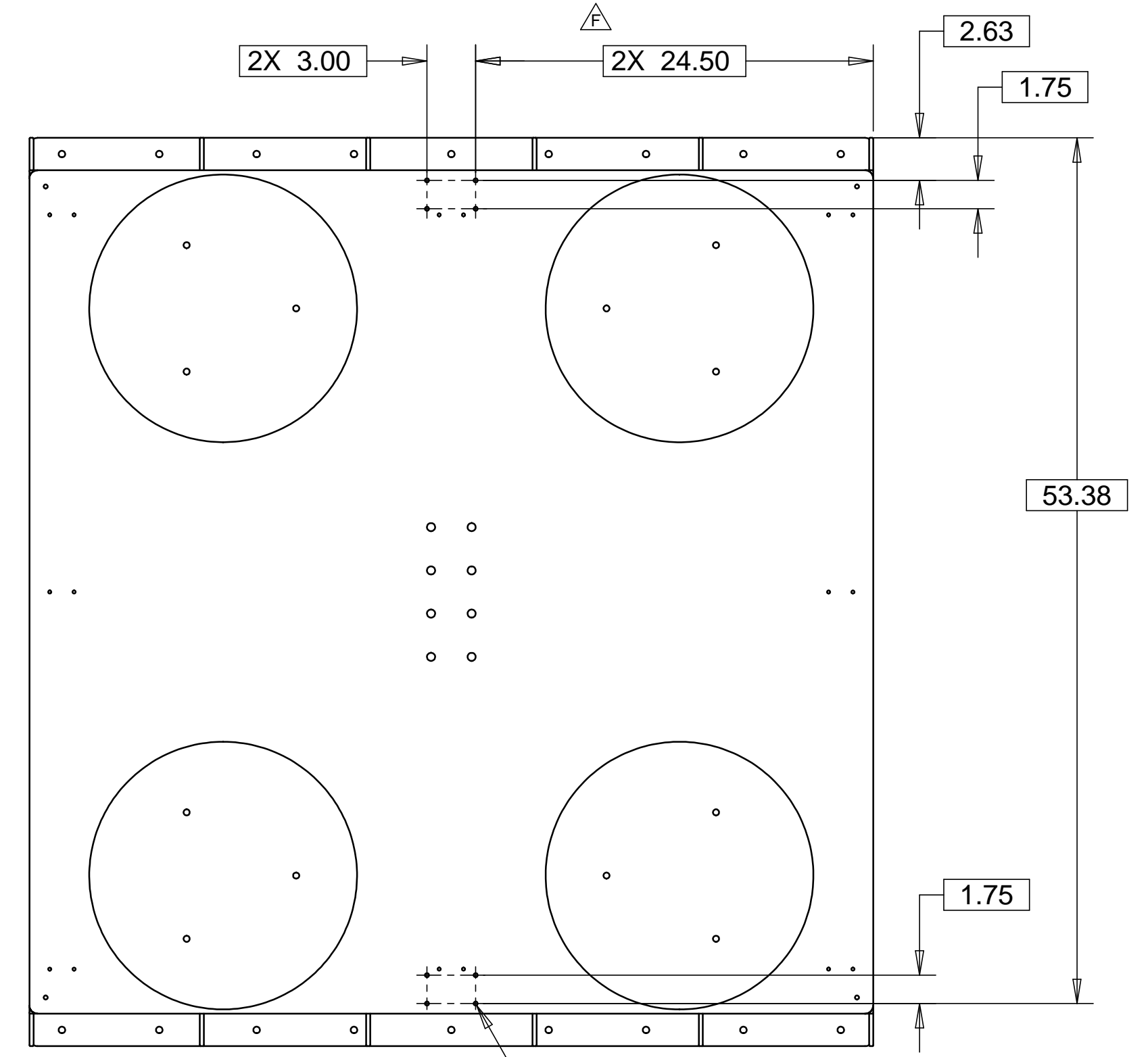
DESIGNED	SIGNATURE	DATE
ROGER L. SMITH		5-28-97
DRAWN	ROGER L. SMITH	5-28-97
CHECKED	HARRY SALAZAR	6-6-97
ENGR.	T. THOMPSON	7-10-97
APPROVED	T. THOMPSON	7-10-97

8 7 6 5 4 3 2 1

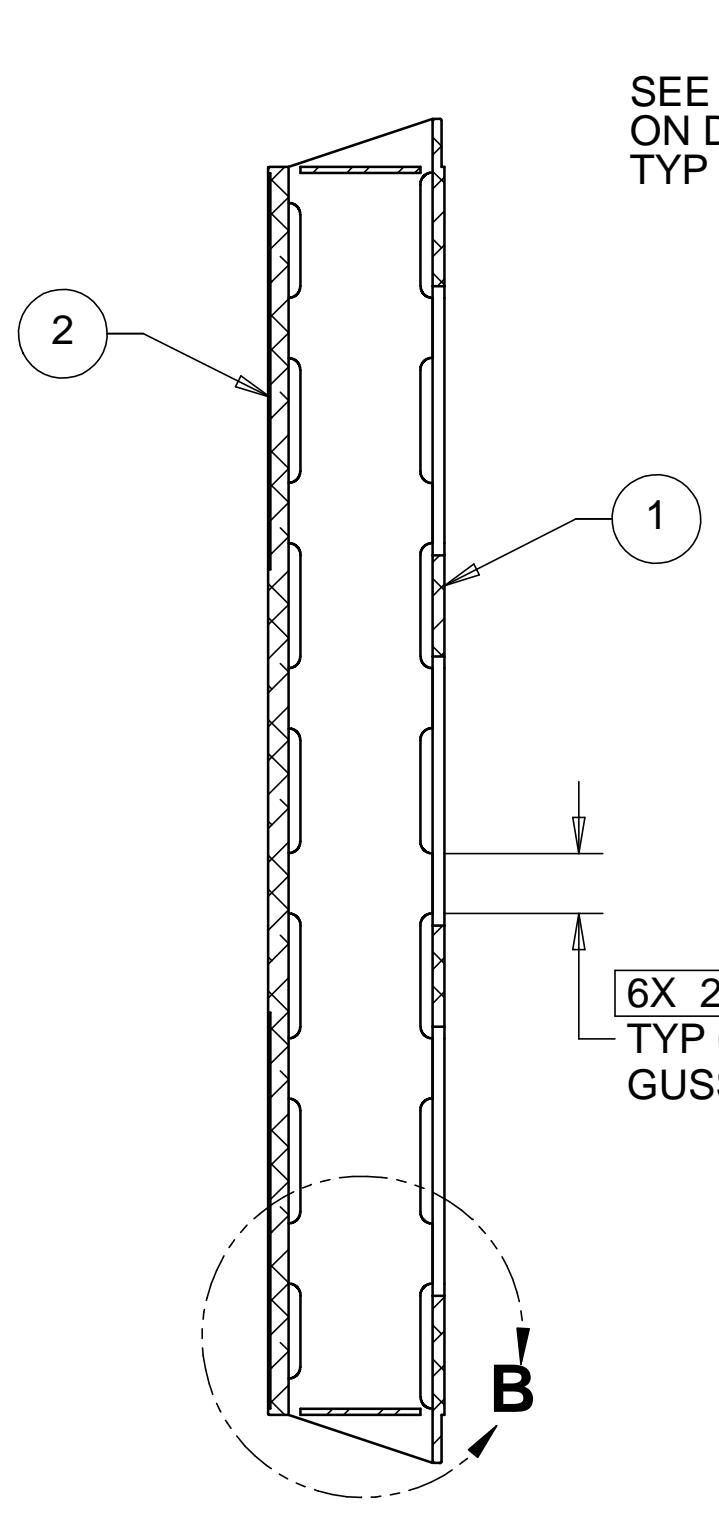
REVISIONS		DATE	APPROVED
REV	DESCRIPTION		
A	SEE ECN# D972711-A FOR CHANGE LIST	11/03/97	T. THOMPSON
B	SEE ECN# D972711-B FOR CHANGE LIST	03/11/98	T. THOMPSON
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F	SEE ECN# D972711-F FOR CHANGE LIST	10/13/98	T. THOMPSON

D
C
B
A

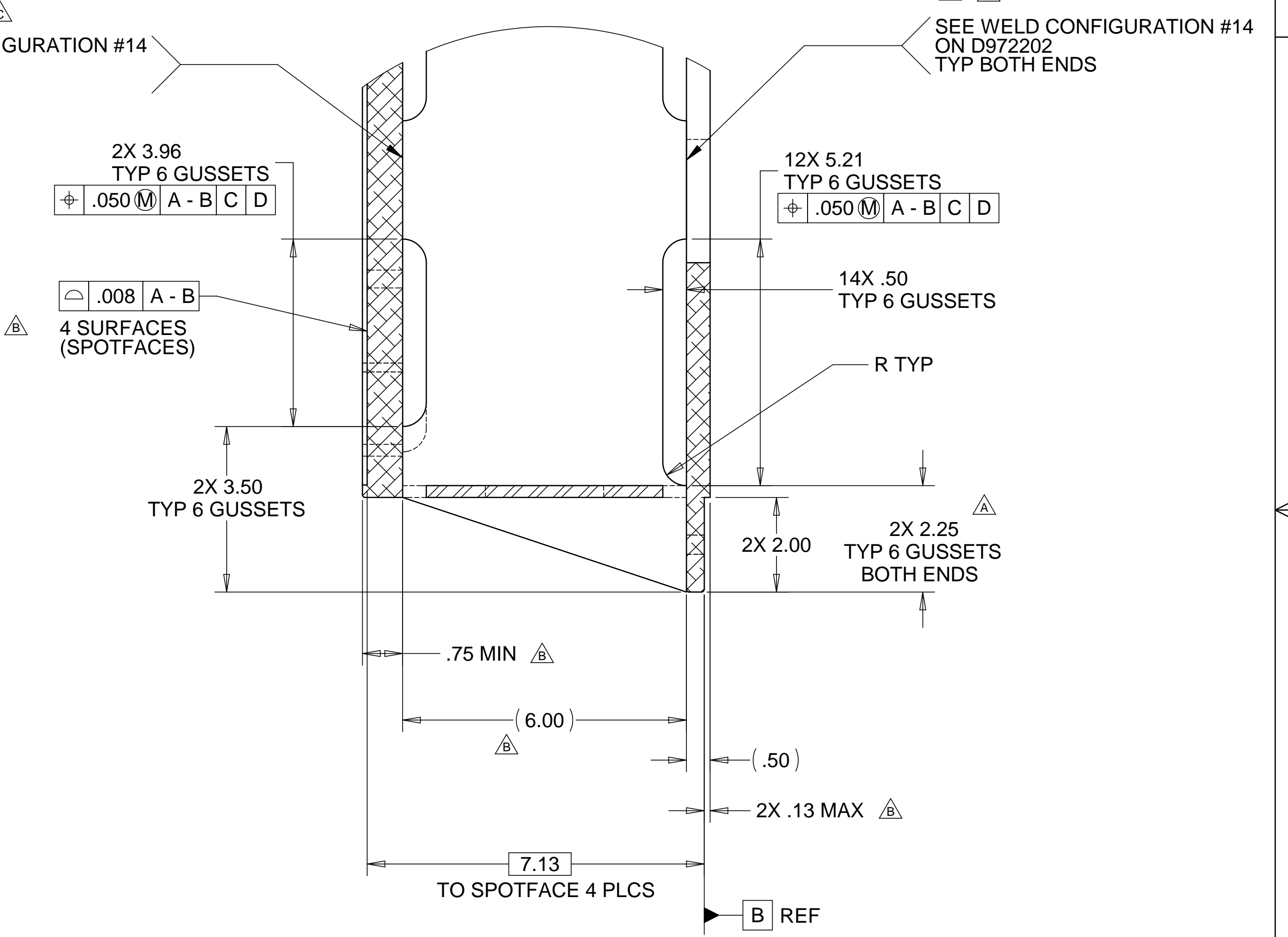
D
C
B
A



SECTION D-D
8X 1/4-20 UNC-2B, THRU ITEM #2
+.005 OVERSIZE TAP WITH
#1 (Ø .228) DRILL SIZE
Ø .017 M P .75 A B C



SECTION A-A FROM SHEET D1



DETAIL B SCALE 1 : 2

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 HAM SUPPORT TABLE WELDMENT	
DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30'	SIGNATURE ROGER L. SMITH	DATE 05-28-97	DWG. NO. D972711	SIZE SHEET NO. D 2 of 2
FINISH ALL MACHINED SURFACES 64 RMS	PART NO. D972711-1	DRAWN ROGER L. SMITH	CHECKED HARRY SALAZAR	SCALE 1/8	REVISION F
		ENGR. T. THOMPSON	APPROVED T. THOMPSON		

8 7 6 5 4 3 2 1