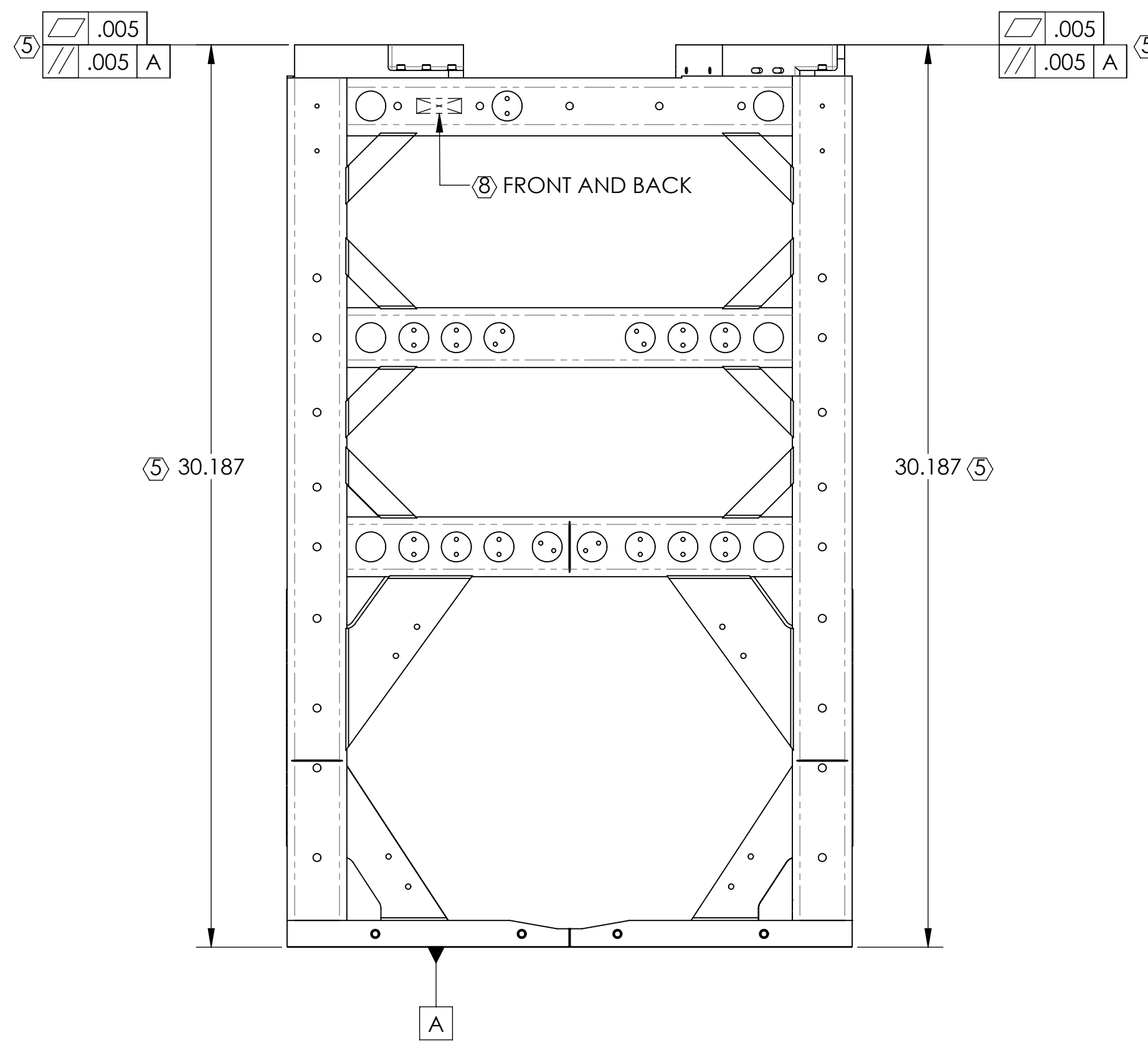
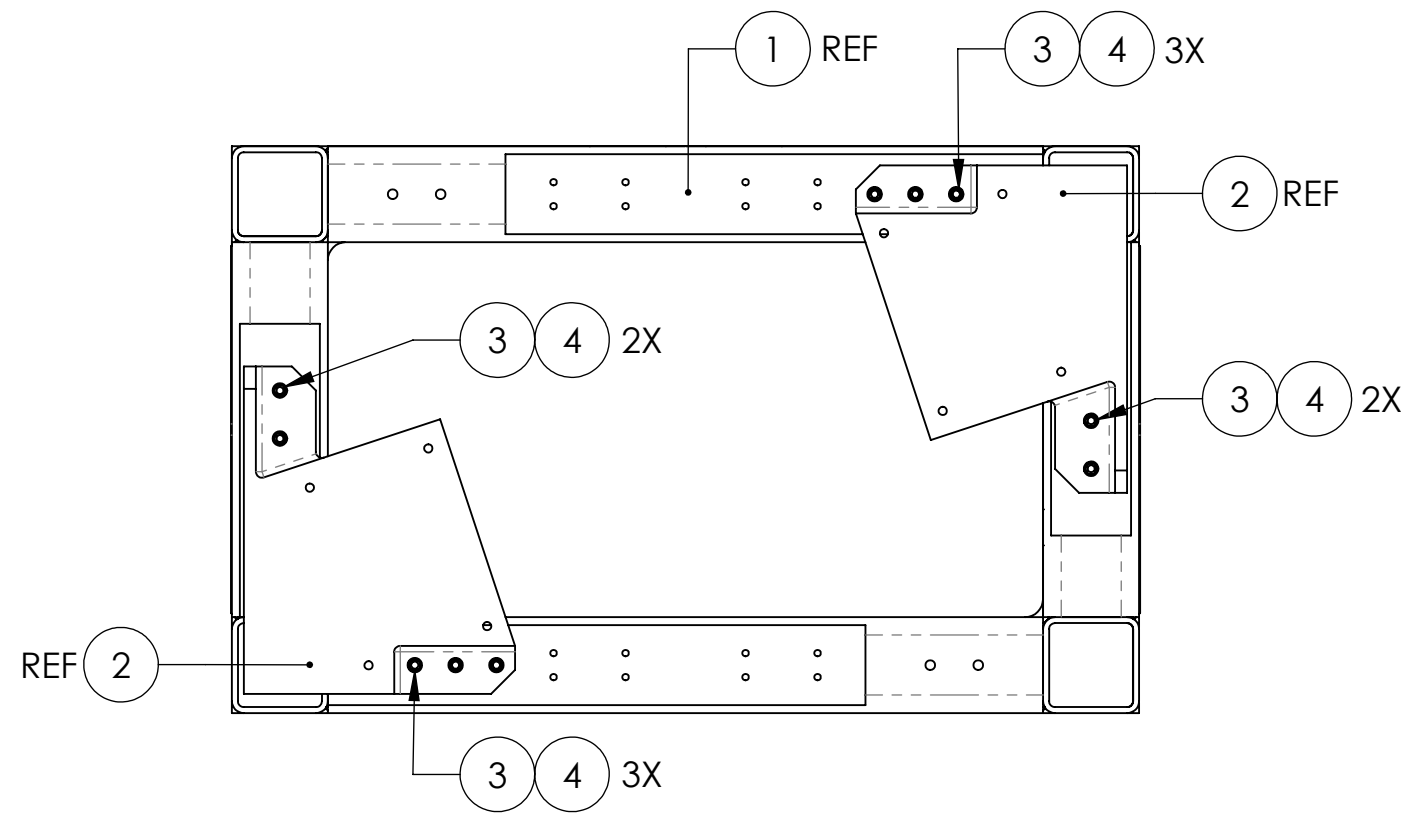
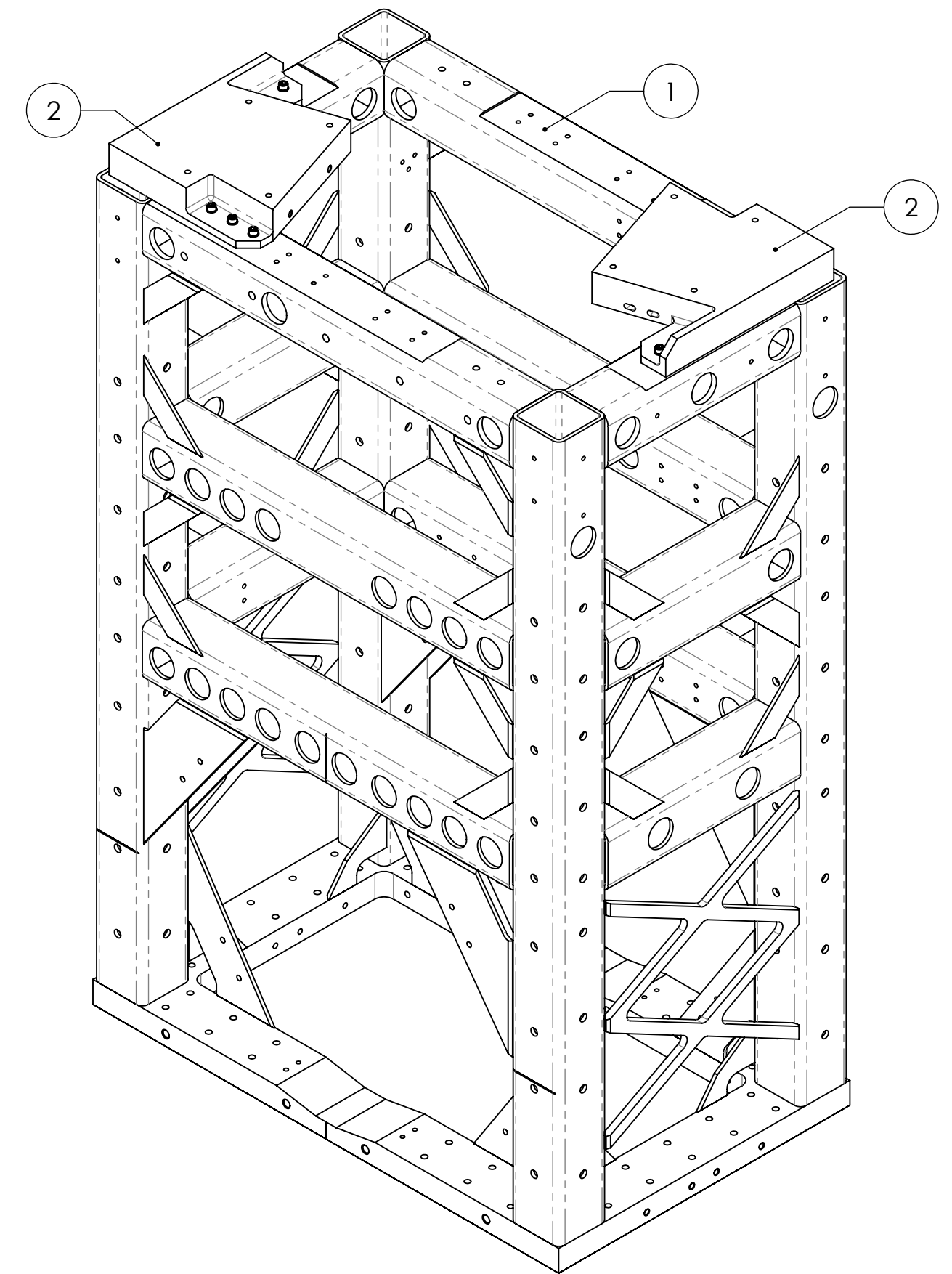


- NOTES CONTINUED:**
- ⑤ FLY CUT INDICATED SURFACES TO ACHIEVE DESIRED DIMENSIONS, PARALLELISM AND FLATNESS.
 - 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ⑧ SCRIBE OR ENGRAVE (NO INKS OR DYES) SERIAL NUMBER OF CORRESPONDING MOUNTING PAD BODY (D070374) ON STRUCTURAL WELDMENT (D070442) AFTER MACHINING.



FLY CUTTING LAYOUT

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E0900066	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	-	WASHER, FLAT, VENTED, #8 (U-C COMPONENTS P/N WFV-08 OR EQUIVALENT)	300 SSTL	10	2	12
3	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	Ag-PLATED 300 SSTL	10	2	12
2	D070374	MOUNTING PAD BODY	6061-T6 Al	2	0	0
1	D070442	STRUCTURAL WELDMENT, HLTS	-	1	0	0

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL N/A **FINISH** 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS

NEXT ASSY HLTS OVERALL ASSY

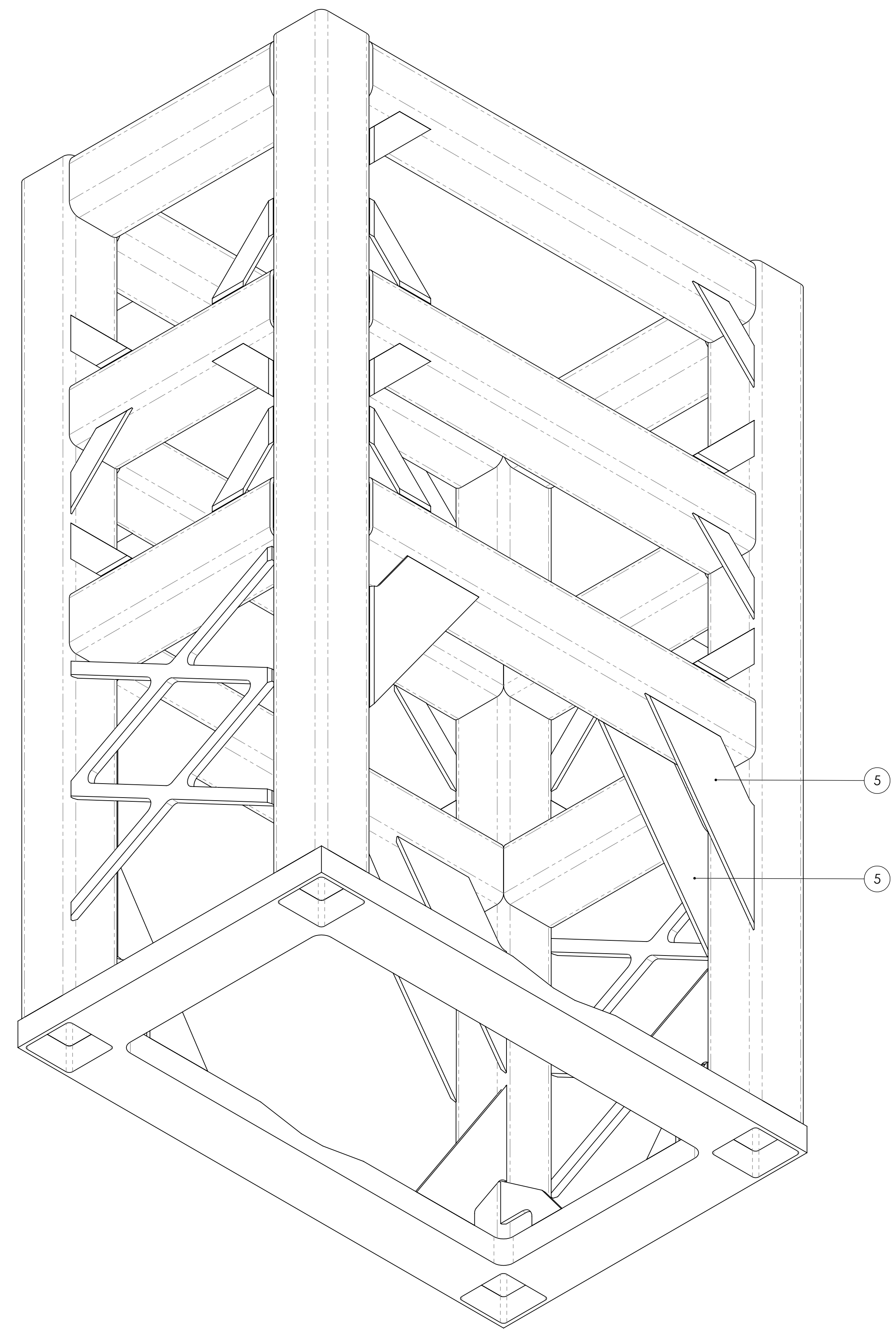
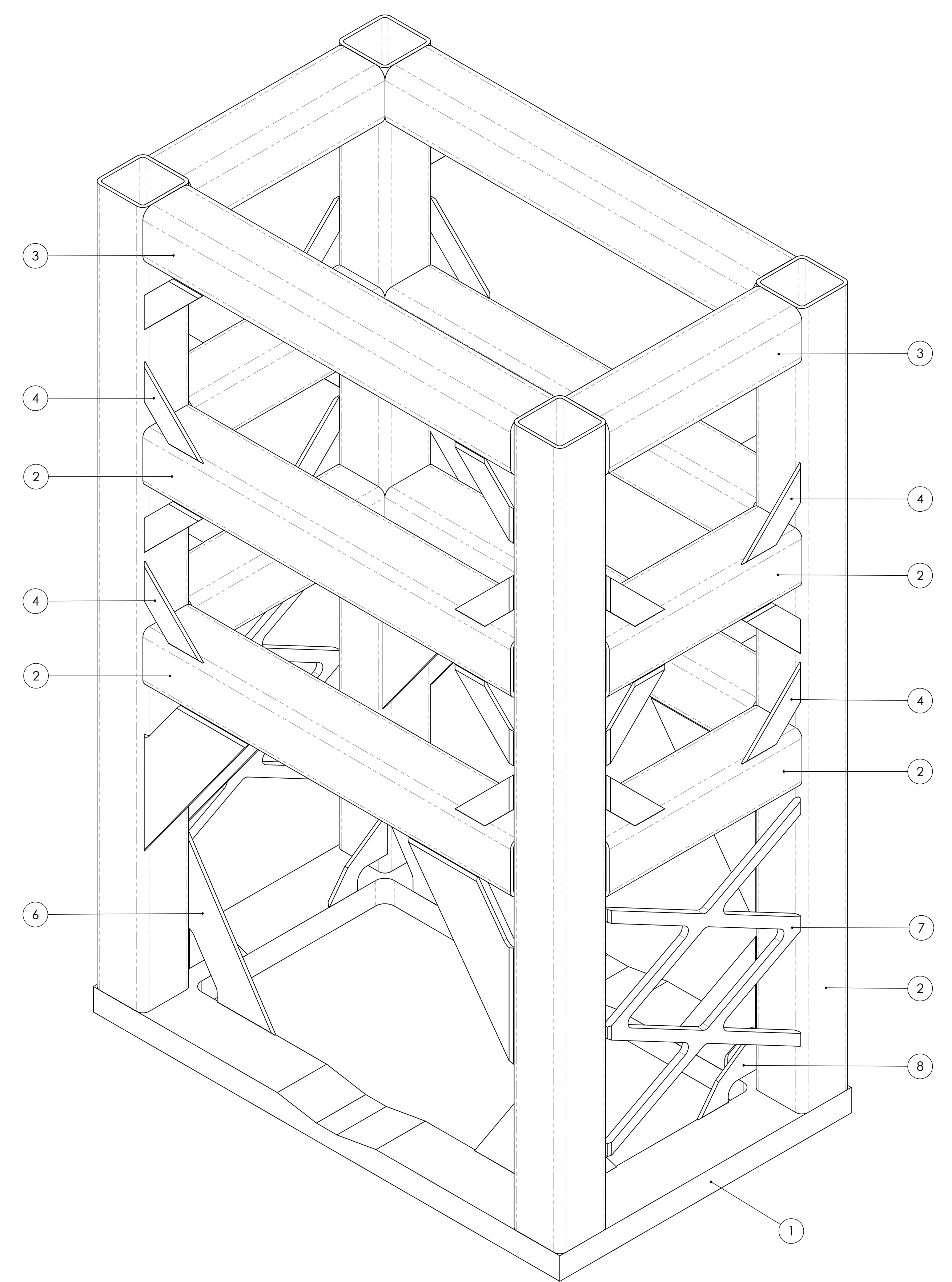
PART NAME

STRUCTURE, HLTS

DESIGNER	D. BRIDGES	27 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	c	D070537	v2
CHECKER	M. MEYER	31 AUG 2010	SCALE: 1:4	PROJECTION:	SHEET 1 OF 1
APPROVAL					

- NOTES CONTINUED:
- 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: DXXXXXX-VY TYPE XX S/N XXX
 - 6. ALL SURFACES OF ALL PARTS ARE TO BE MACHINED (AS RECEIVED), AS ROLLED, AS WELDED SURFACES WILL BE ACCEPTED, EXCEPT INNER SURFACES AND OUTER RADII OF TUBING. NO GRINDING OR LAPING WITH ABRASIVE WHEELS, CLOTH OR STONES IS PERMITTED. NO PARTS SHALL BE CAST OR MOLDED (NO TOOLING PLATE IS PERMITTED). BLANCHARD GRINDING IS ACCEPTABLE IF ALL GROUND SURFACES ARE MACHINED AFTERWARDS.
 - 7) ALL WELDING SHALL BE PERFORMED IN ACCORDANCE WITH LIGO SPECIFICATION EDP000048.
 - 8) TUBING IS 2.00" SQUARE WITH WALL THICKNESS OF .12" ± .01".
 - 9) TUBING IS 2.00" SQUARE WITH WALL THICKNESS OF .188" ± .01".
 - 10) AFTER WELDING, STRESS RELIEF AND HEAT TREATMENT FLY-CUT INDICATED SURFACE TO MEET REQUIRED DIMENSION.
 - 11) INDICATED FEATURES ARE TO BE ADDED AFTER ALL WELDING, HEAT TREATMENT AND ALL OTHER MACHINING OPERATIONS, INCLUDING FLY-CUTTING, ARE COMPLETED.
 - 12) SCRIBE LINE WHERE INDICATED. LINE SHOULD BE .04" WIDE X .02" DEEP AND RUN THE LENGTH OF THE FACE AS SHOWN.
 - 13) HOLE THROUGH OUTER WALL OF TUBE ONLY.
 - 14) HOLE THROUGH BOTH WALLS OF TUBE.
 - 15) HOLE THROUGH INNER WALL OF TUBE ONLY.
 - 16) ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
 - 17) ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

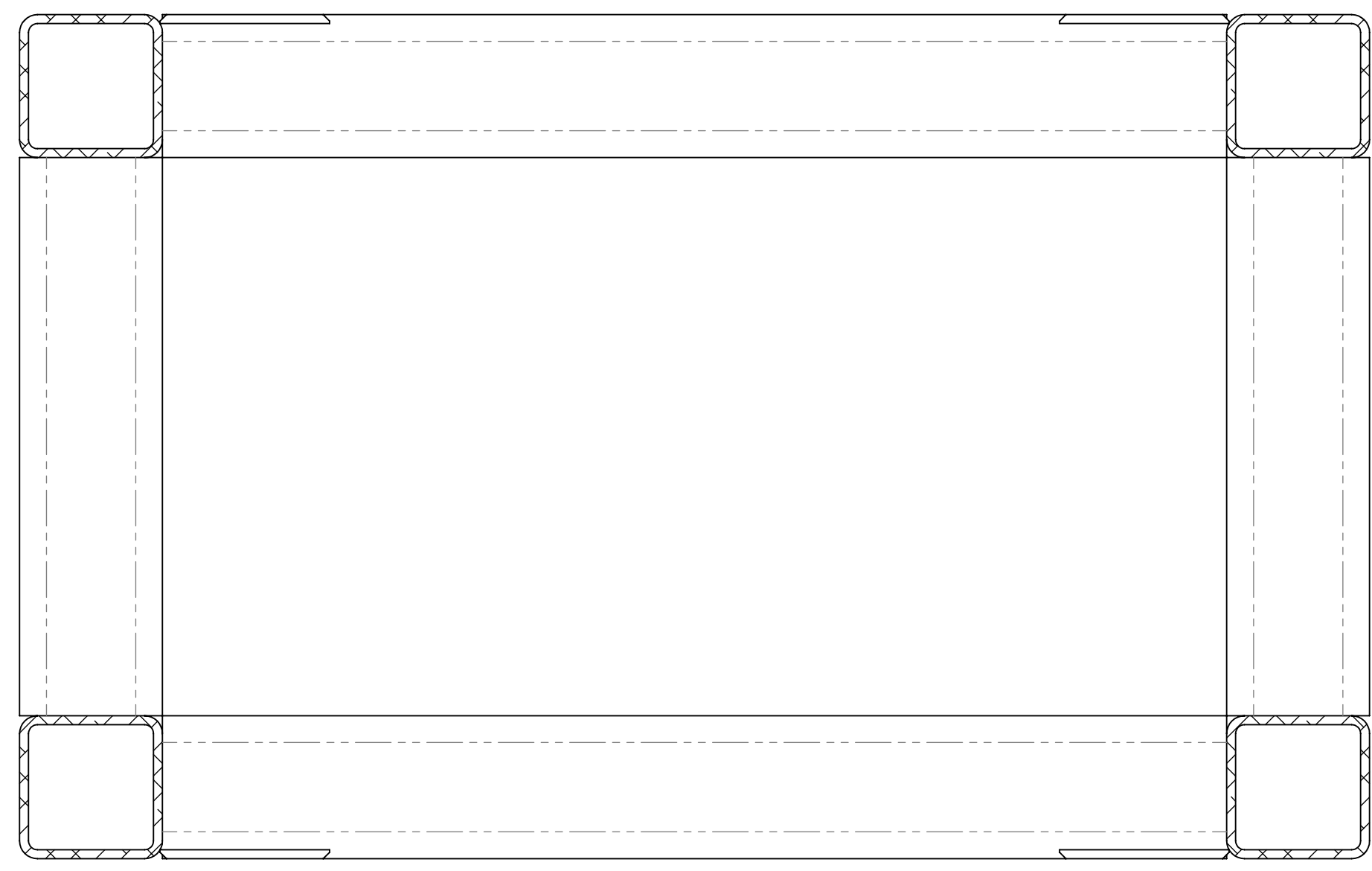
REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	02 DEC 2009	E0900446	E080191
v3	-	INTERNAL REVISION	-
v4	29 AUG 2010	E1000371	E080191
v5	11 OCT 2010	E1000570	E080191



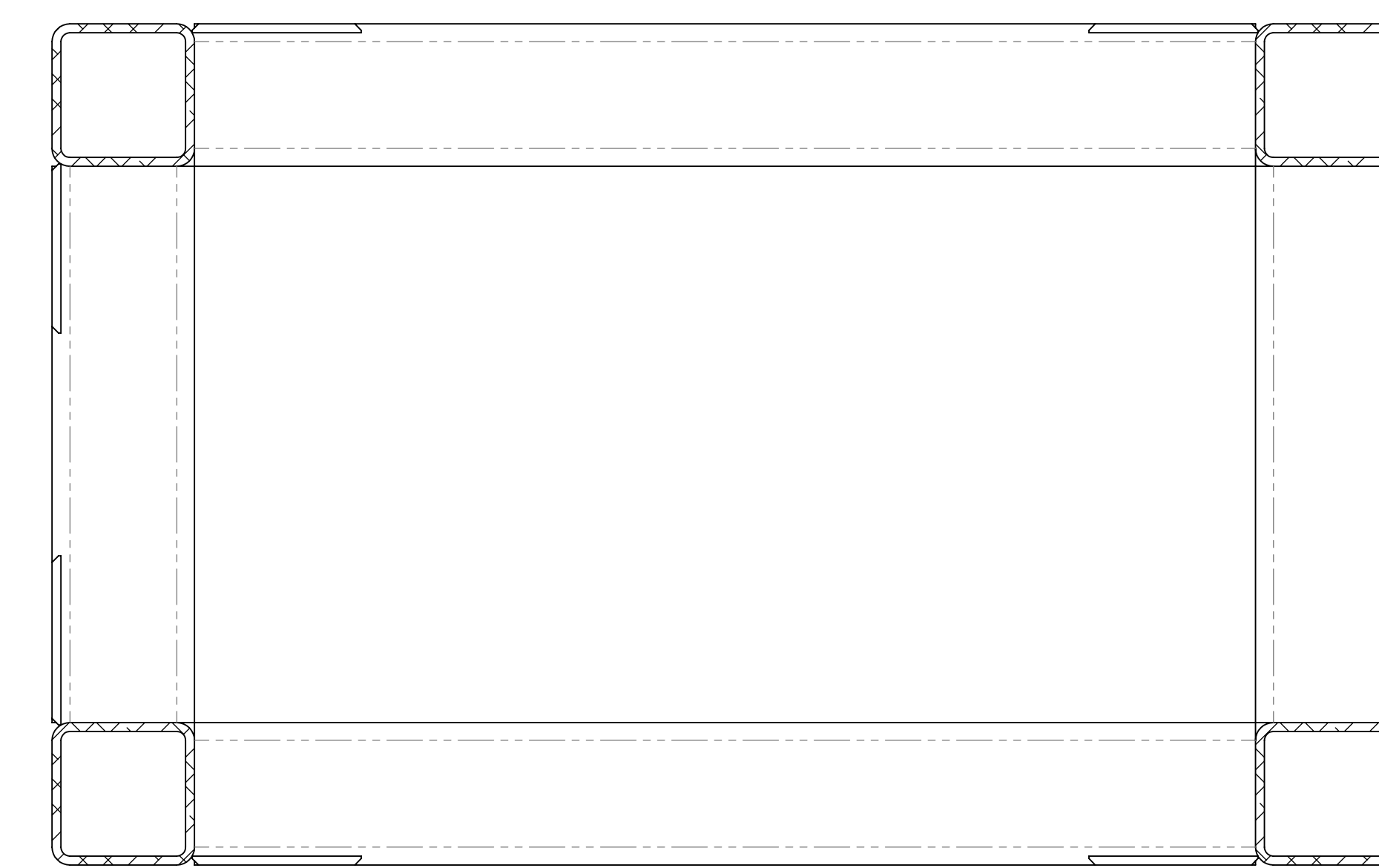
WELDMENT ISOMETRIC VIEWS

ITEM NO.	PART NUMBER	DESCRIPTION	TOTAL
8	D070577	SIDE GUSSET	4
7	D070578	SIDE STRUT	2
6	D070576	LOWER FRONT GUSSET	4
5	D070579	UPPER FRONT GUSSET	8
4	D070580	TOP GUSSET	28
3	-	2.00" SQUARE TUBE - .188" WALL THICKNESS (8)	-
2	-	2.00" SQUARE TUBE - .12" WALL THICKNESS (8)	-
1	D070575	BASE PLATE	1
PARTS LIST			TOTAL

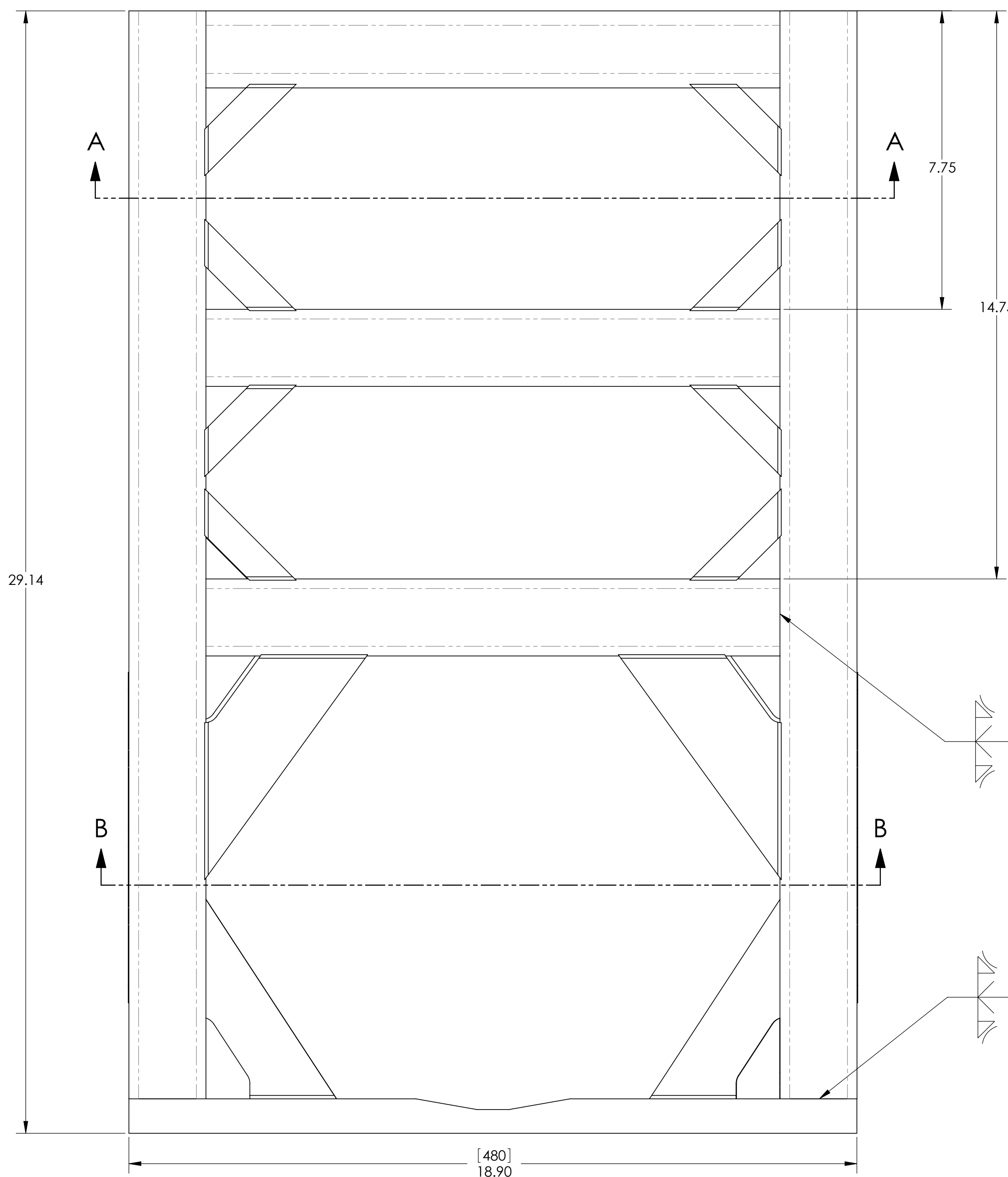
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		STRUCTURAL WELDMENT, HLTS	
DIMENSIONS ARE IN INCHES [MM] TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°		ADVANCED LIGO SUB-SYSTEM SUS		DESIGNER: D. BRIDGES 26 AUG 2010 DRAFTER: D. BRIDGES 08 OCT 2010 CHECKER: J. ROMIE 11 OCT 2010 APPROVAL:	
MATERIAL: 304 OR 304L SSTL FINISH: N/A μinch		NEXT ASSY: STRUCTURE, HLTS		SCALE: 1:2 PROJECTION:	
				SHEET 1 OF 8	



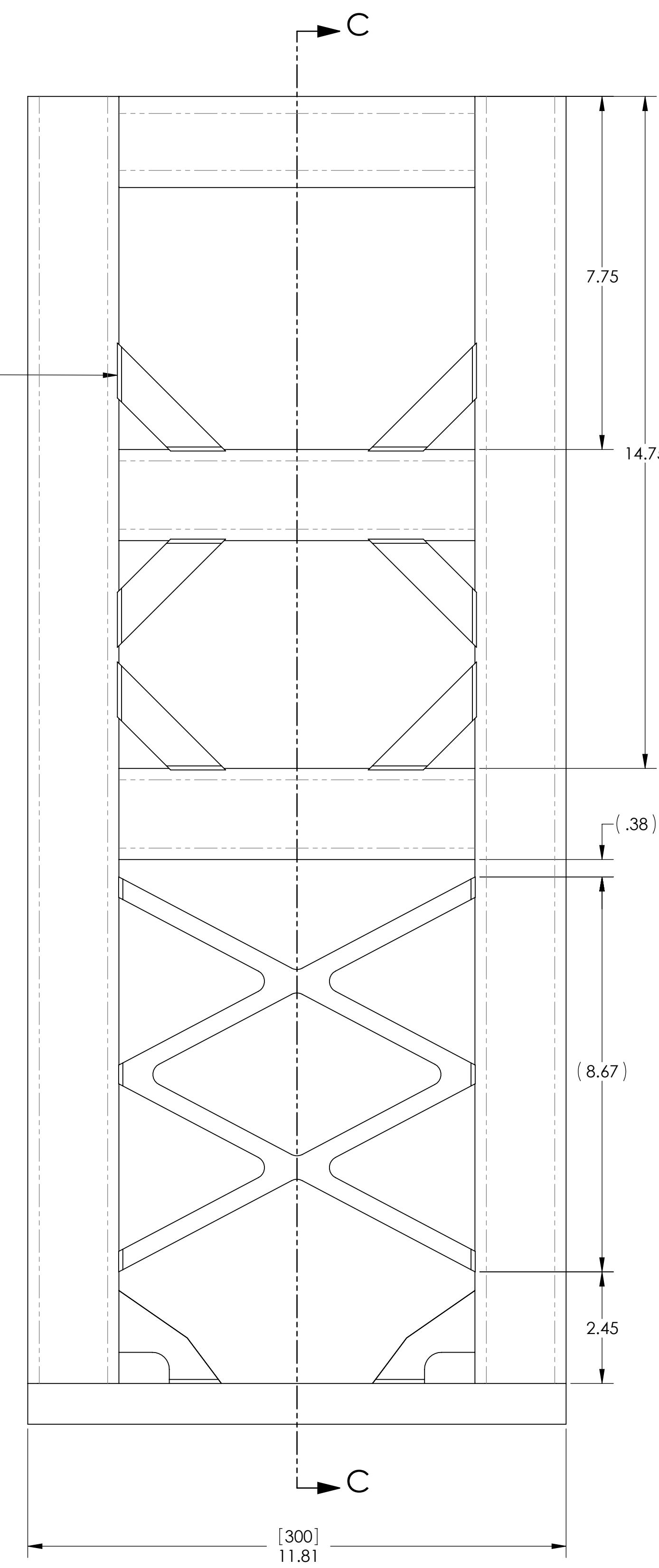
SECTION A-A



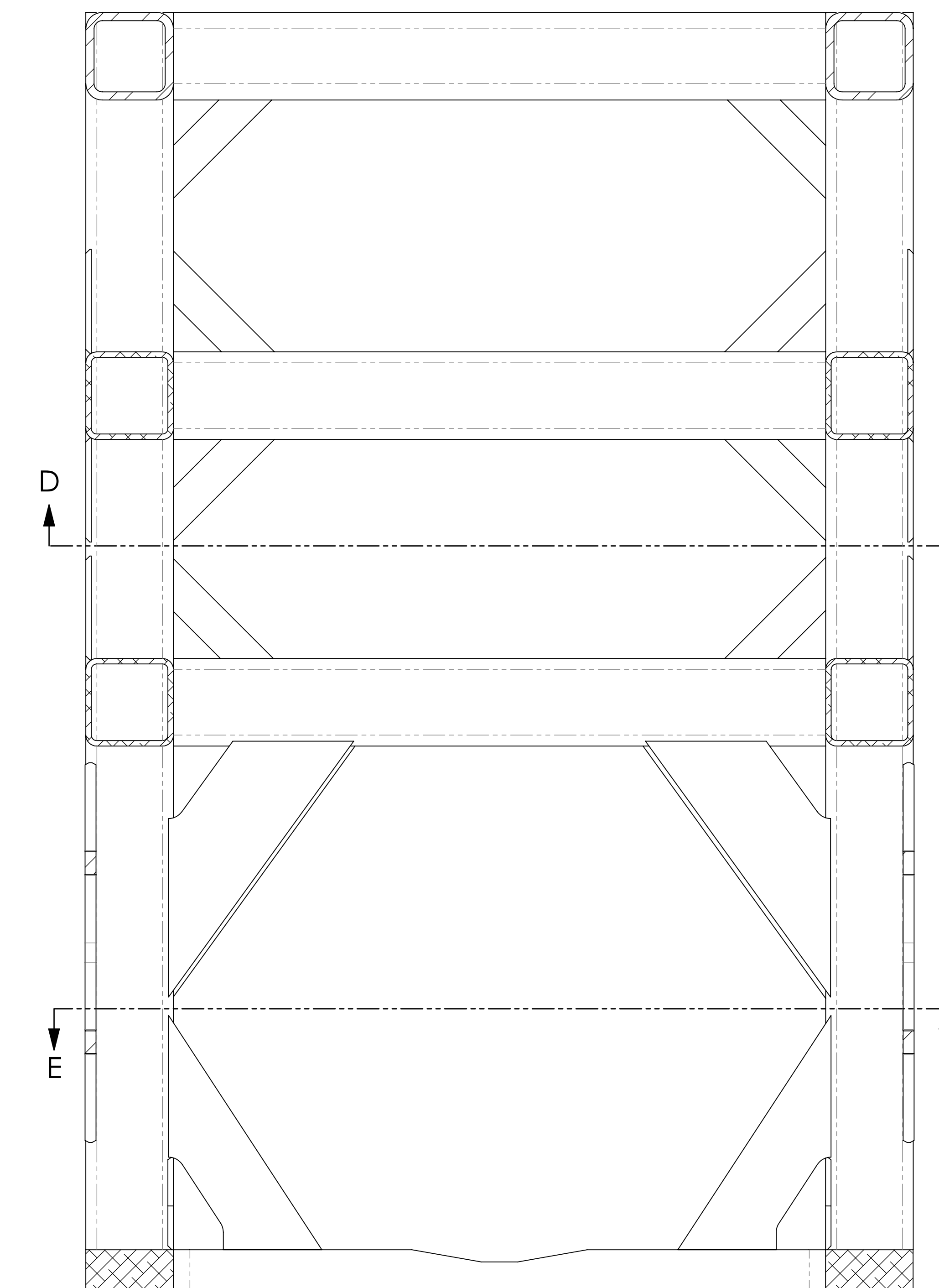
SECTION D-D



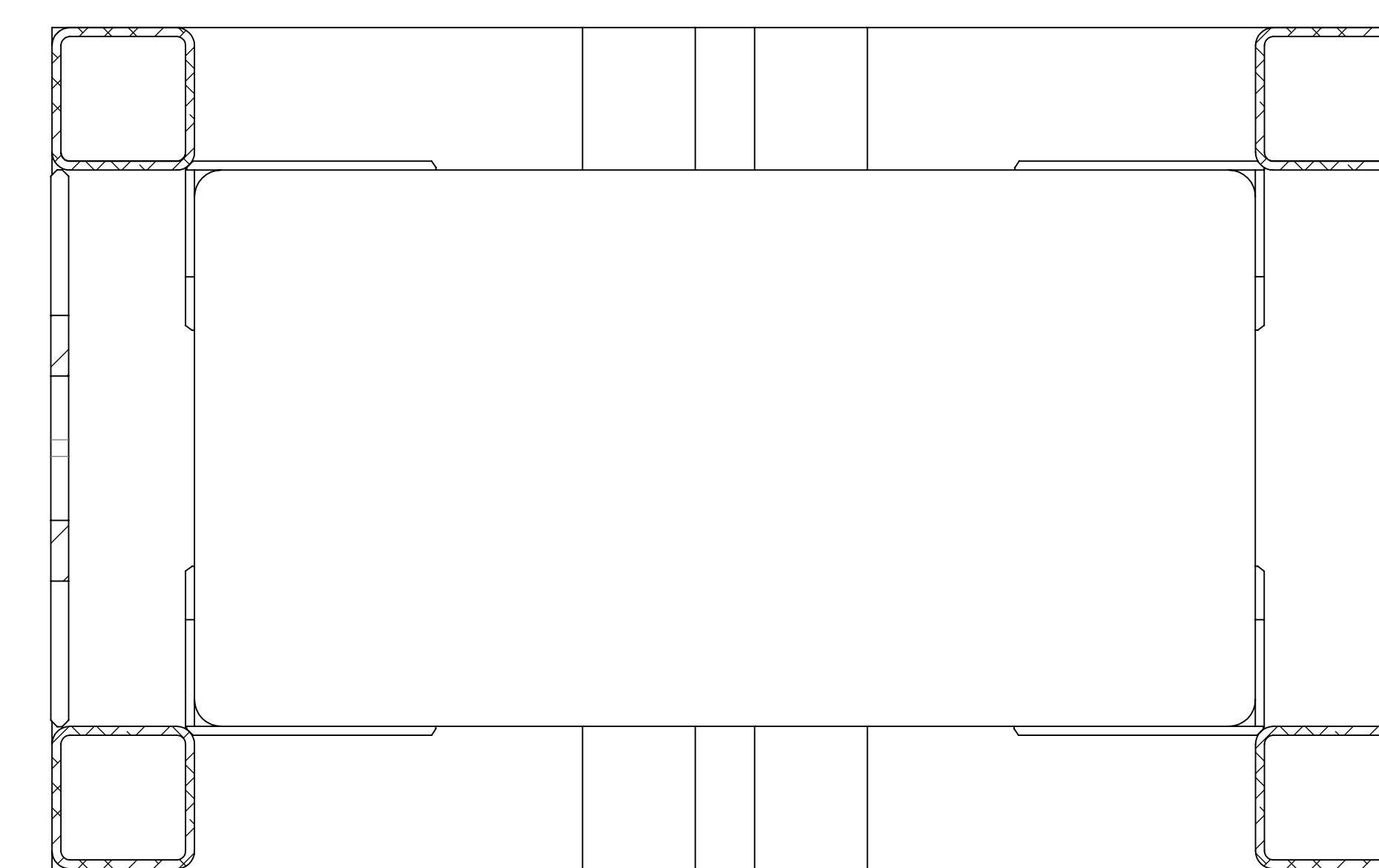
SECTION B-B



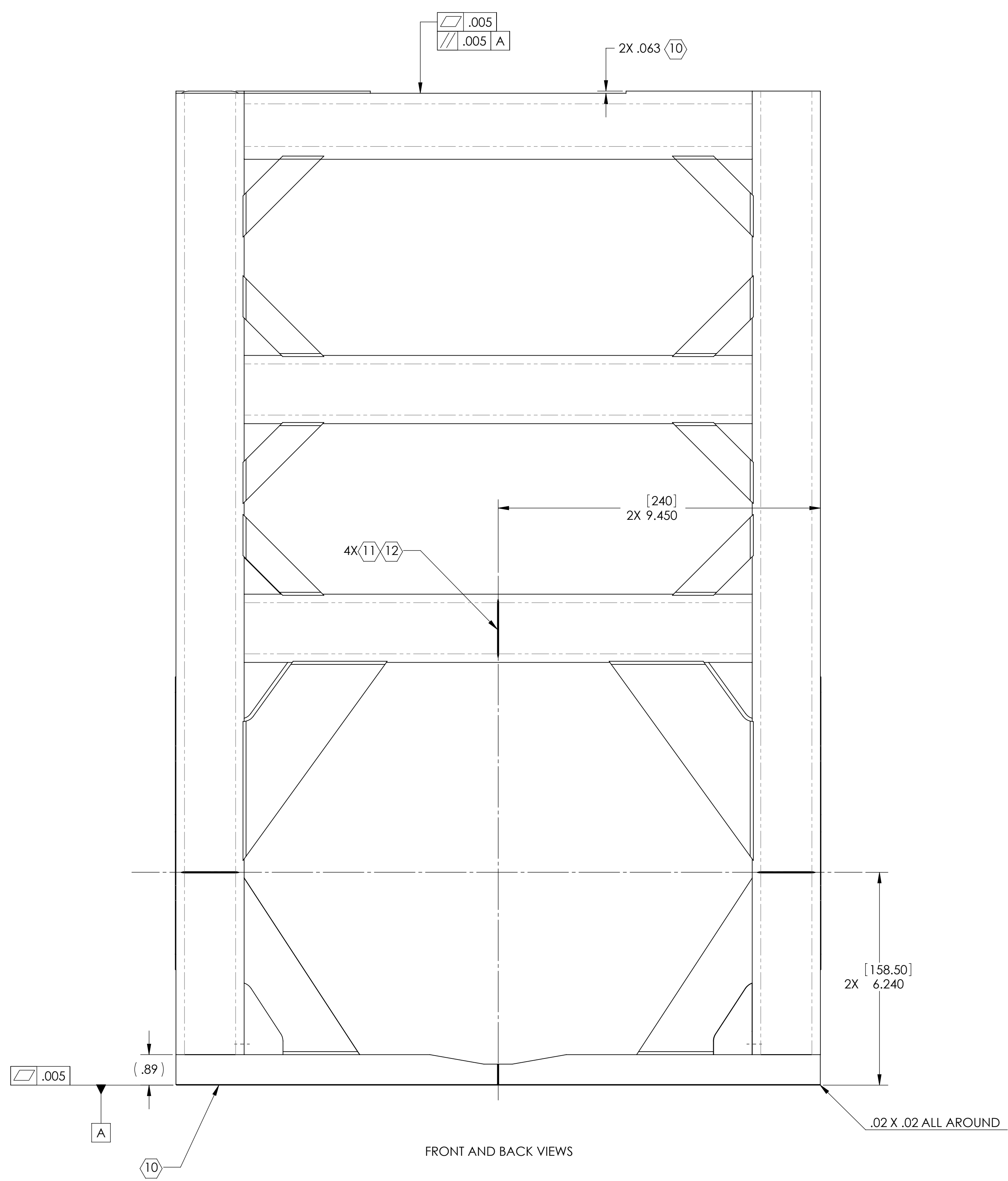
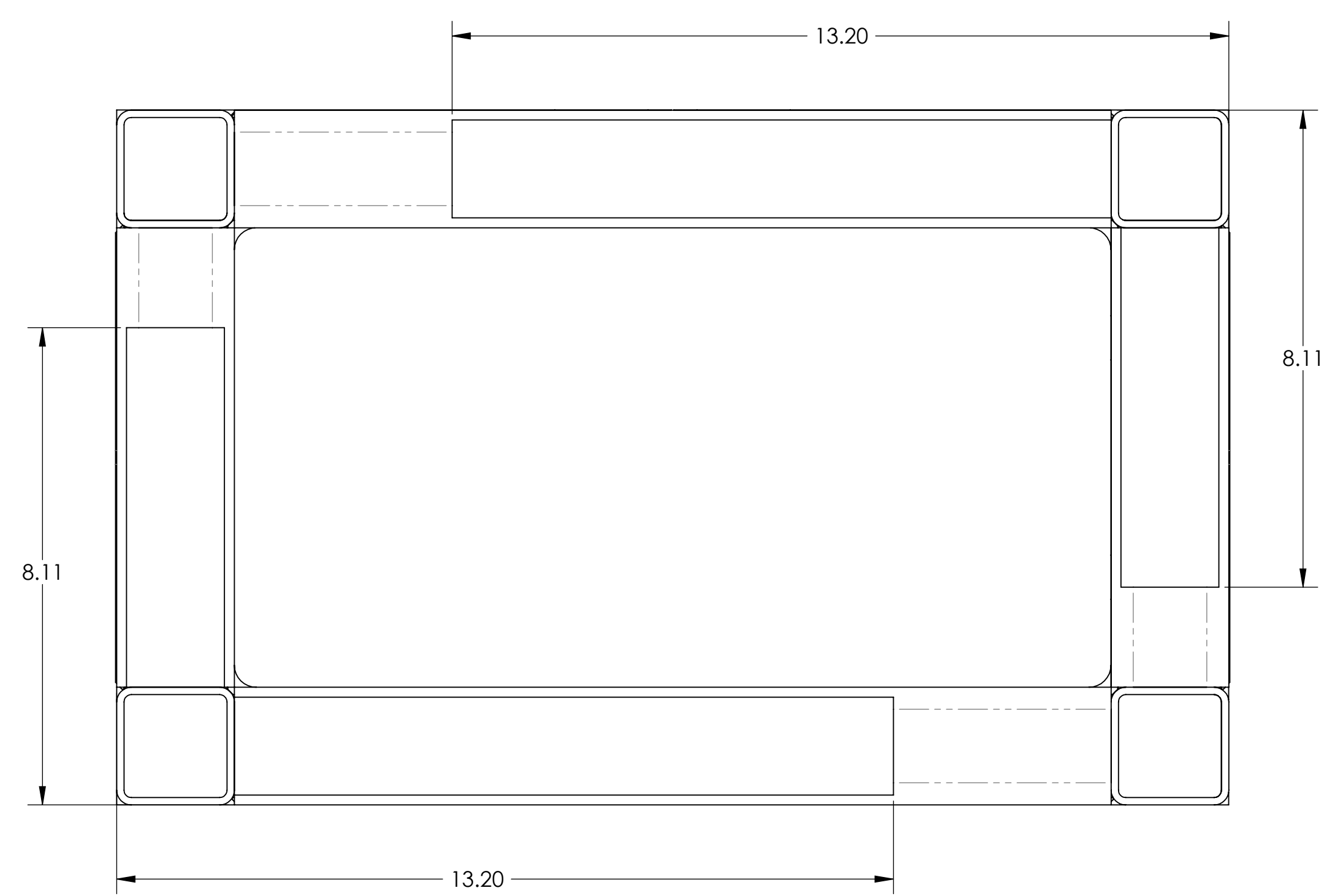
WELDMENT LAYOUT



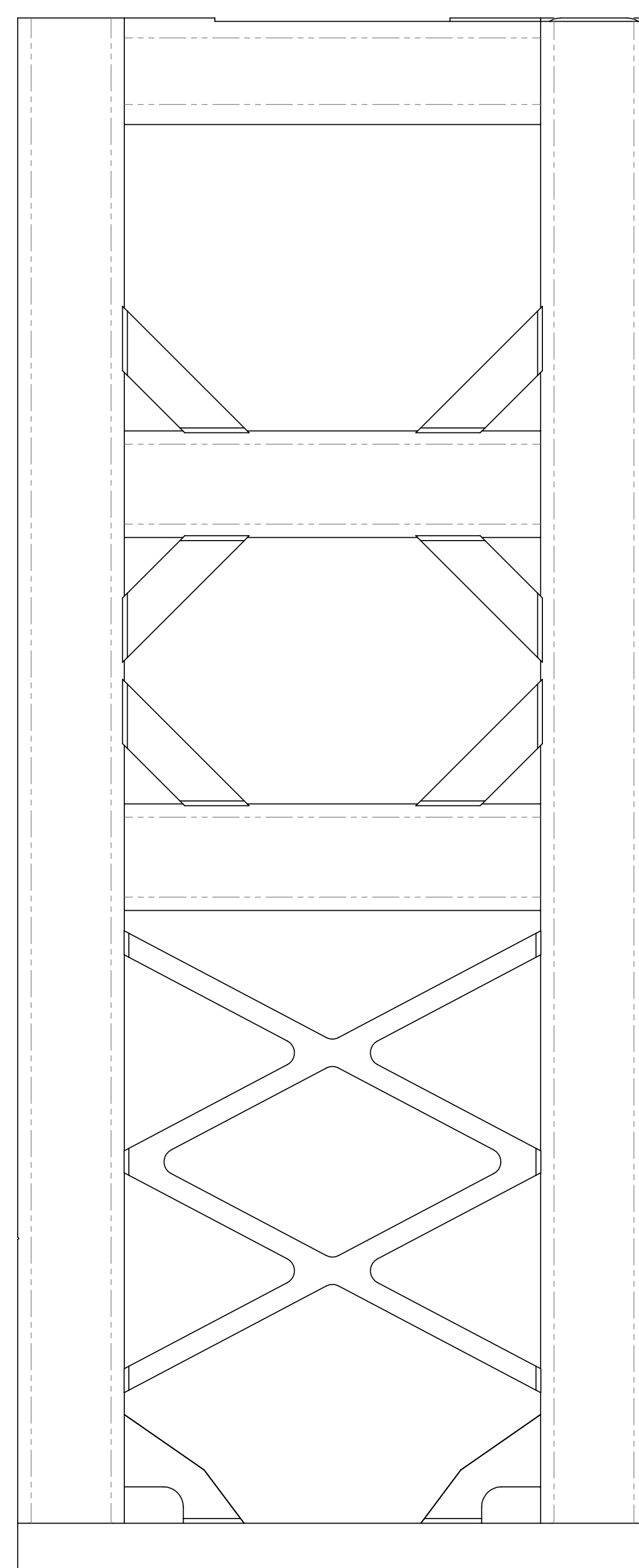
SECTION C-C



SECTION E-E

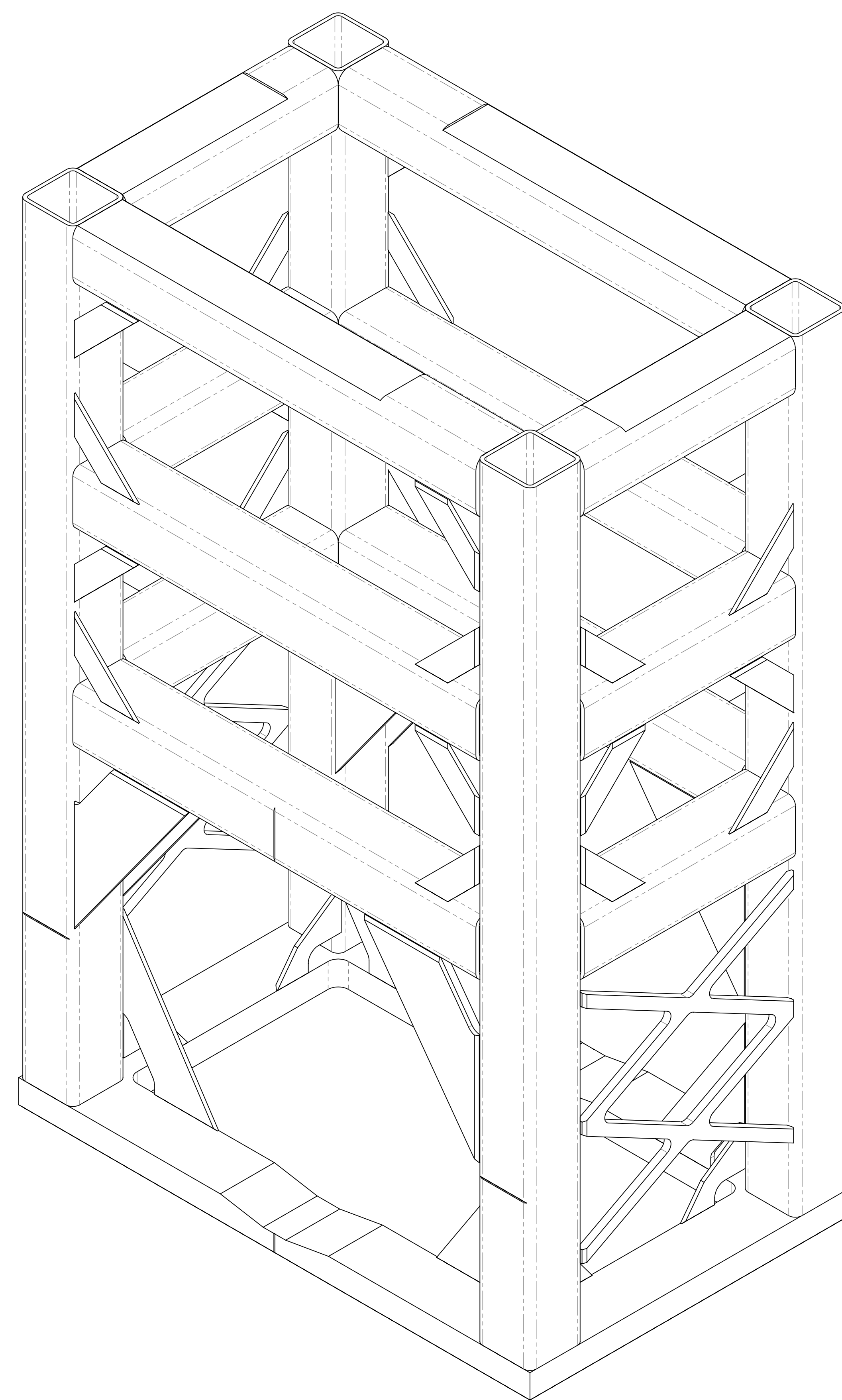


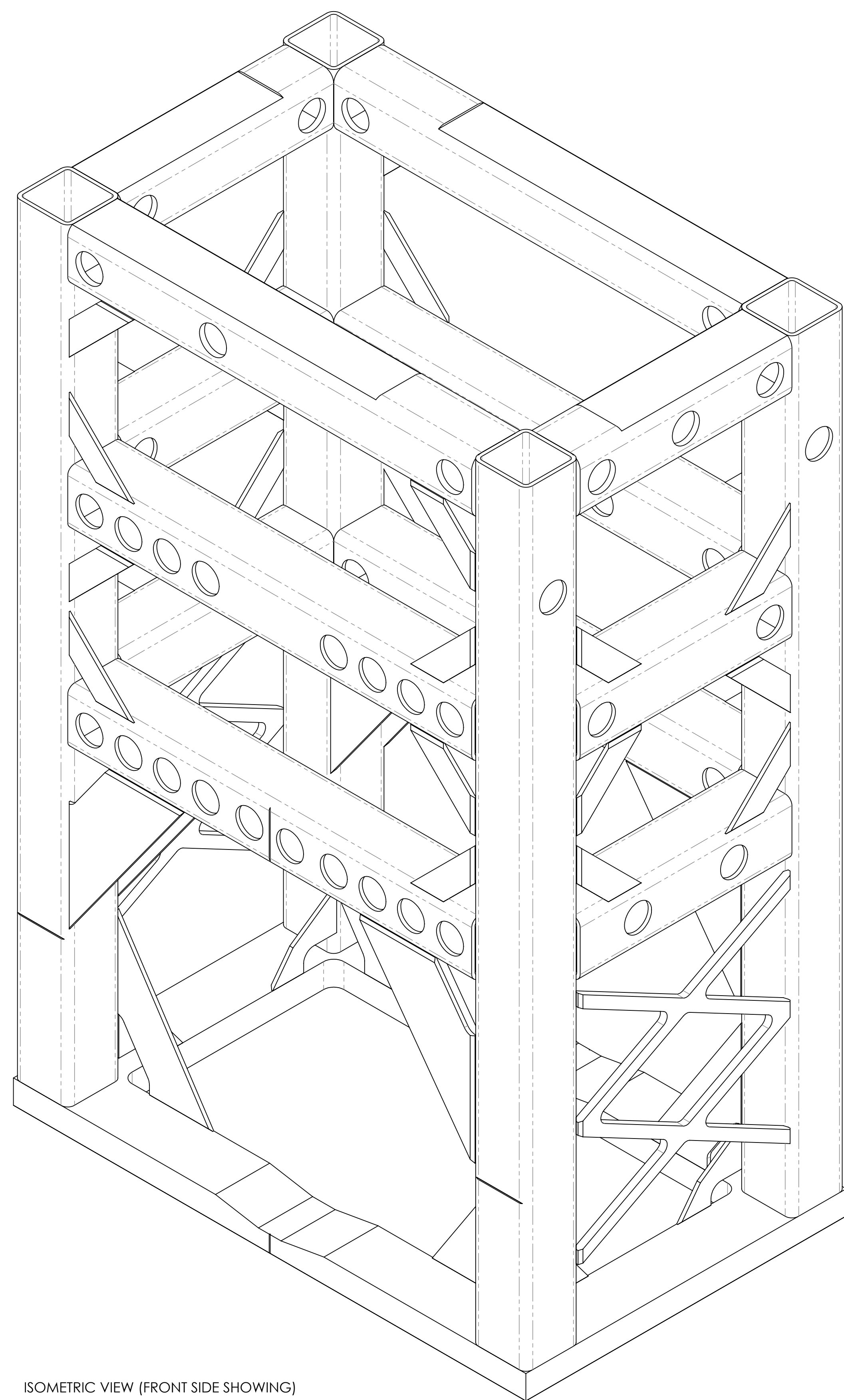
FRONT AND BACK VIEWS



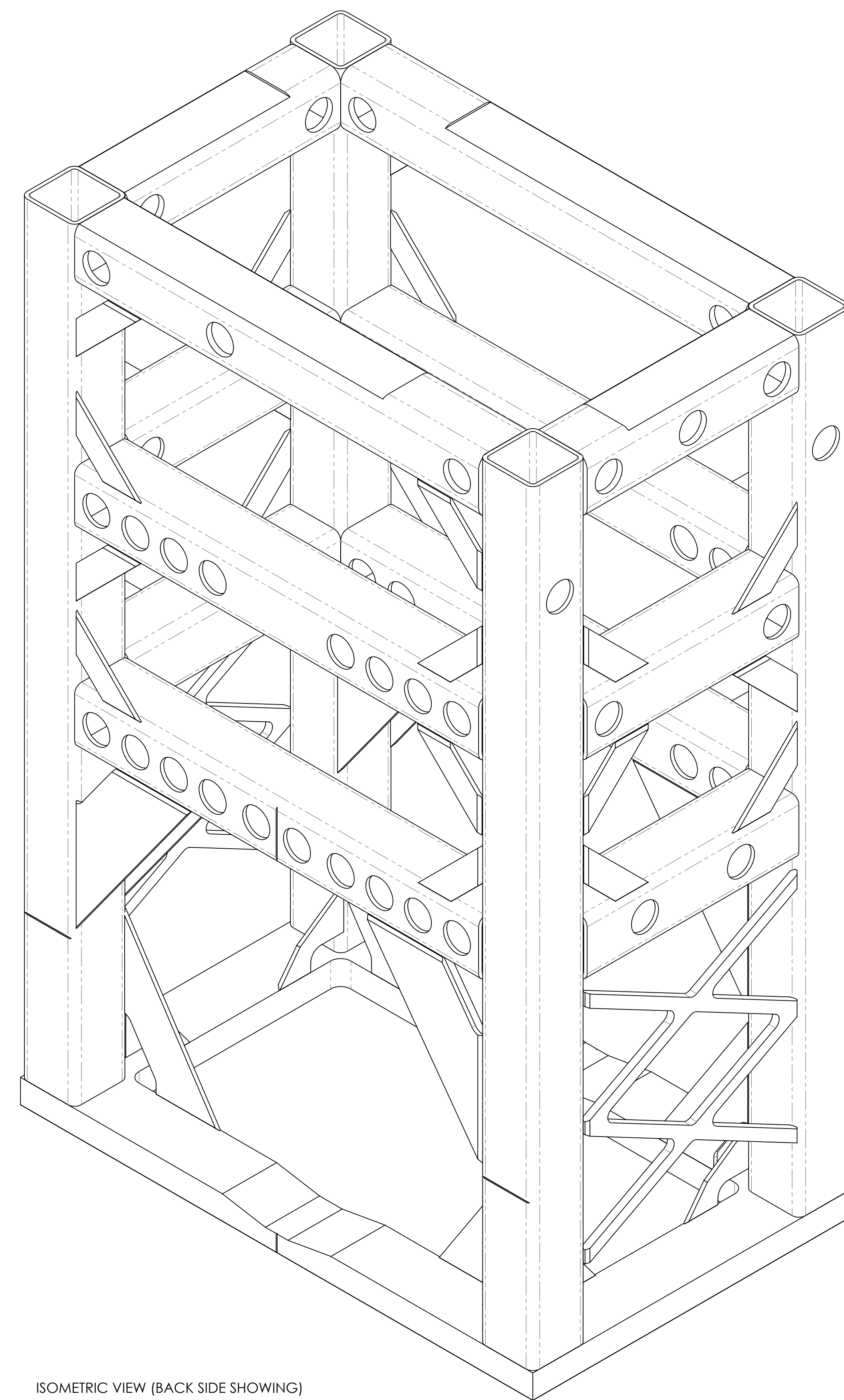
RIGHT AND LEFT VIEWS

MACHINING LAYOUT





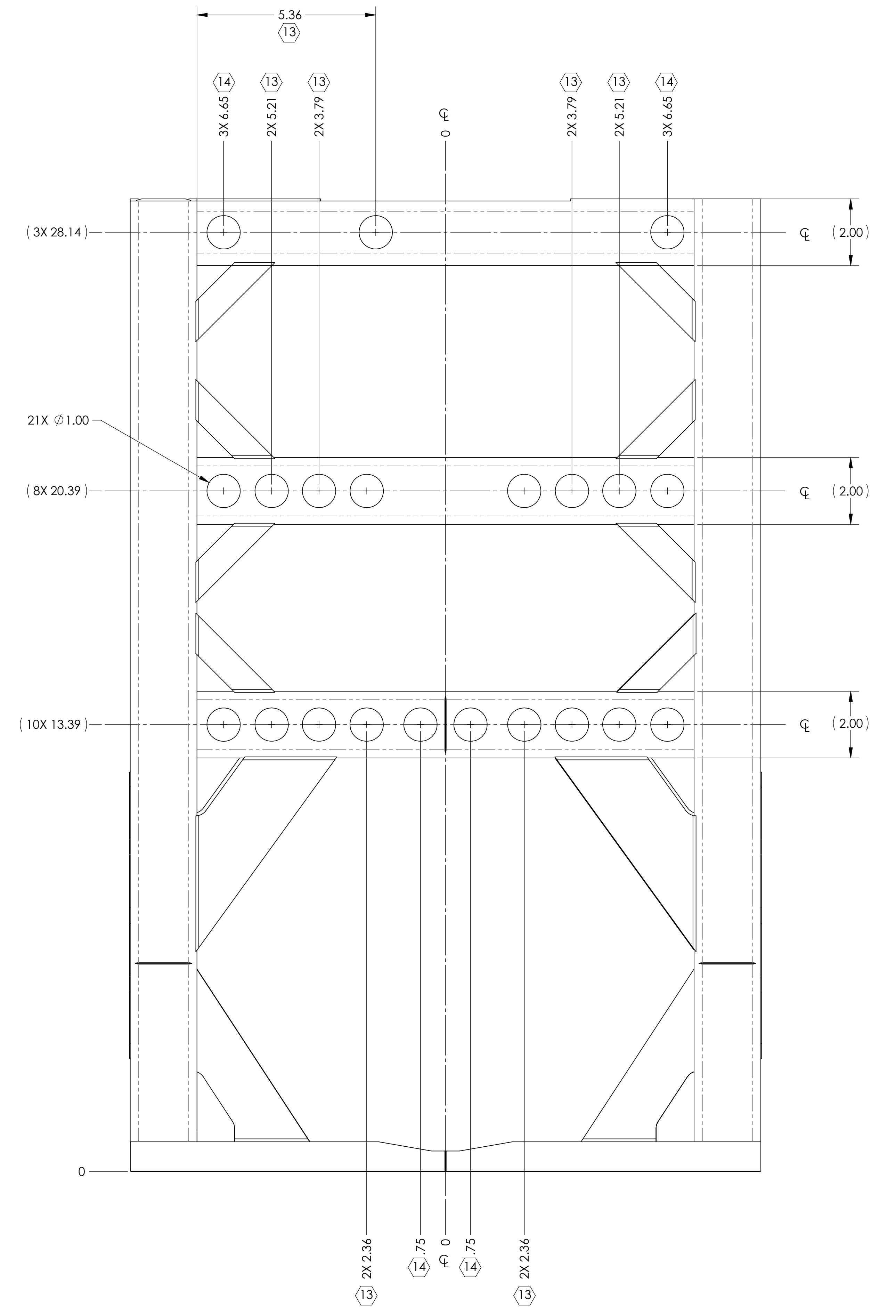
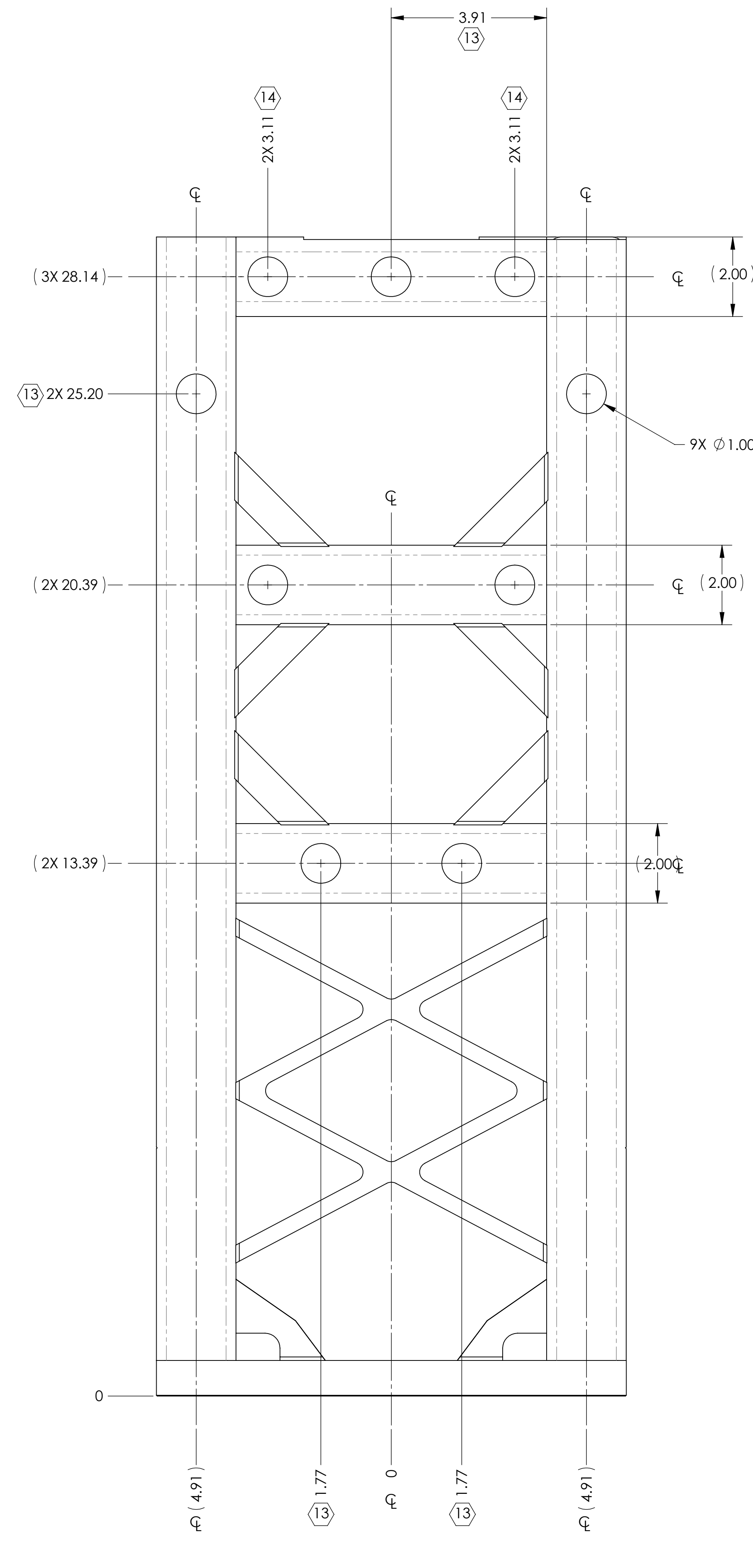
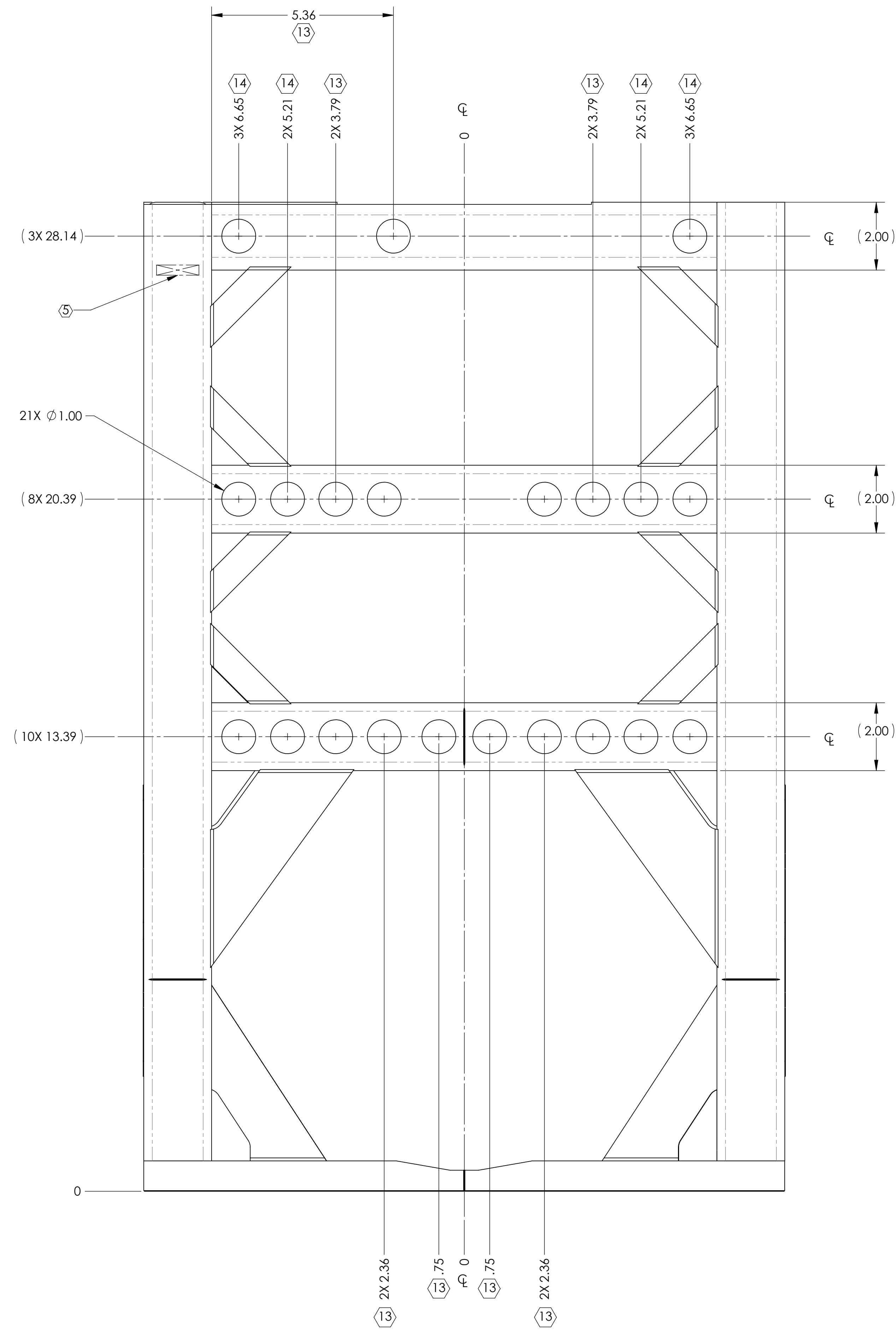
ISOMETRIC VIEW (FRONT SIDE SHOWING)



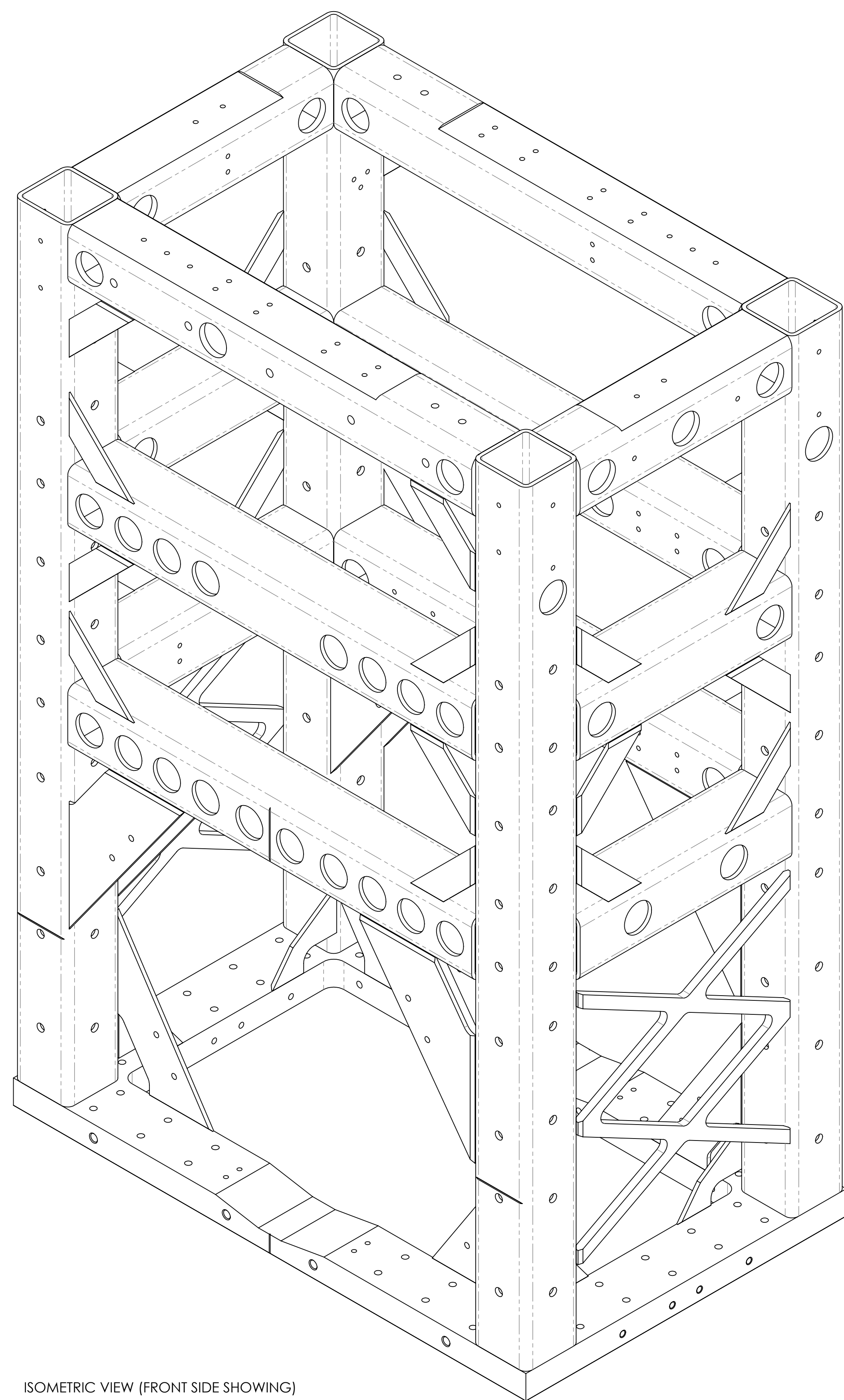
ISOMETRIC VIEW (BACK SIDE SHOWING)

ISOMETRIC VIEWS FOR LARGE HOLE PLACEMENT

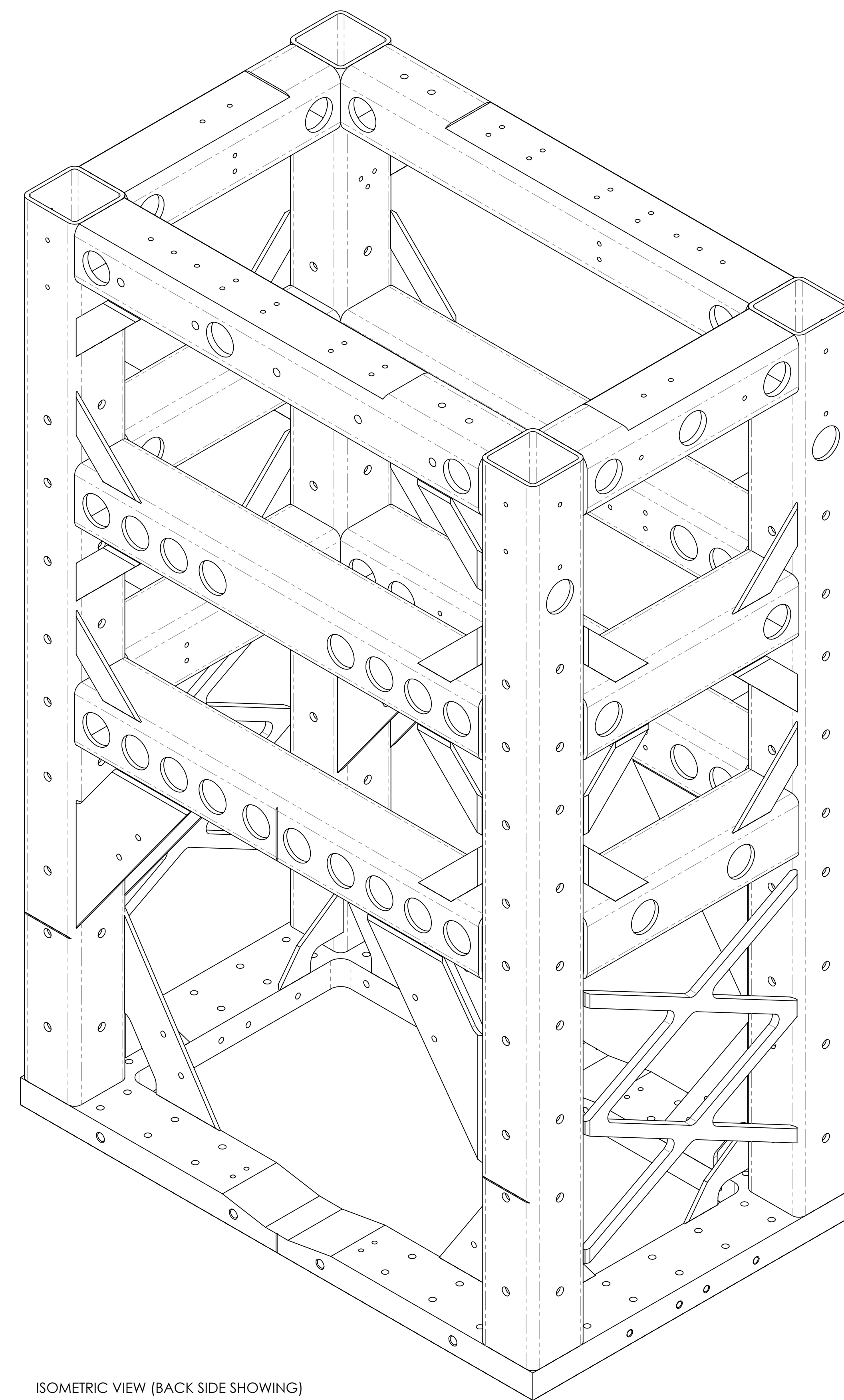
D:\BME\Advanced_LIGO_SILE\Buckled_Installation_Plan\DWG\REV\14000_DRAWING\FRONT REV-13



LARGE HOLE LAYOUT

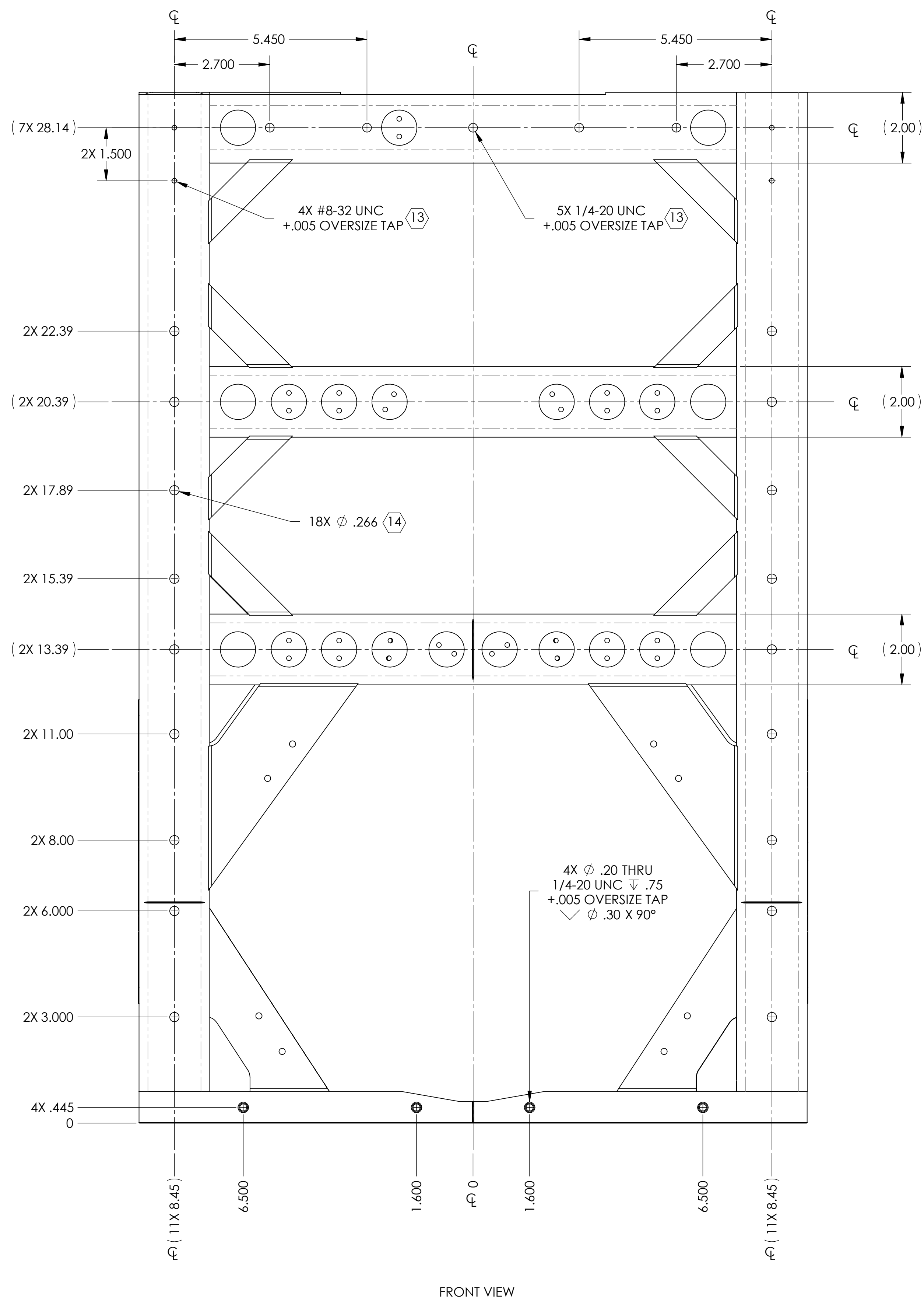
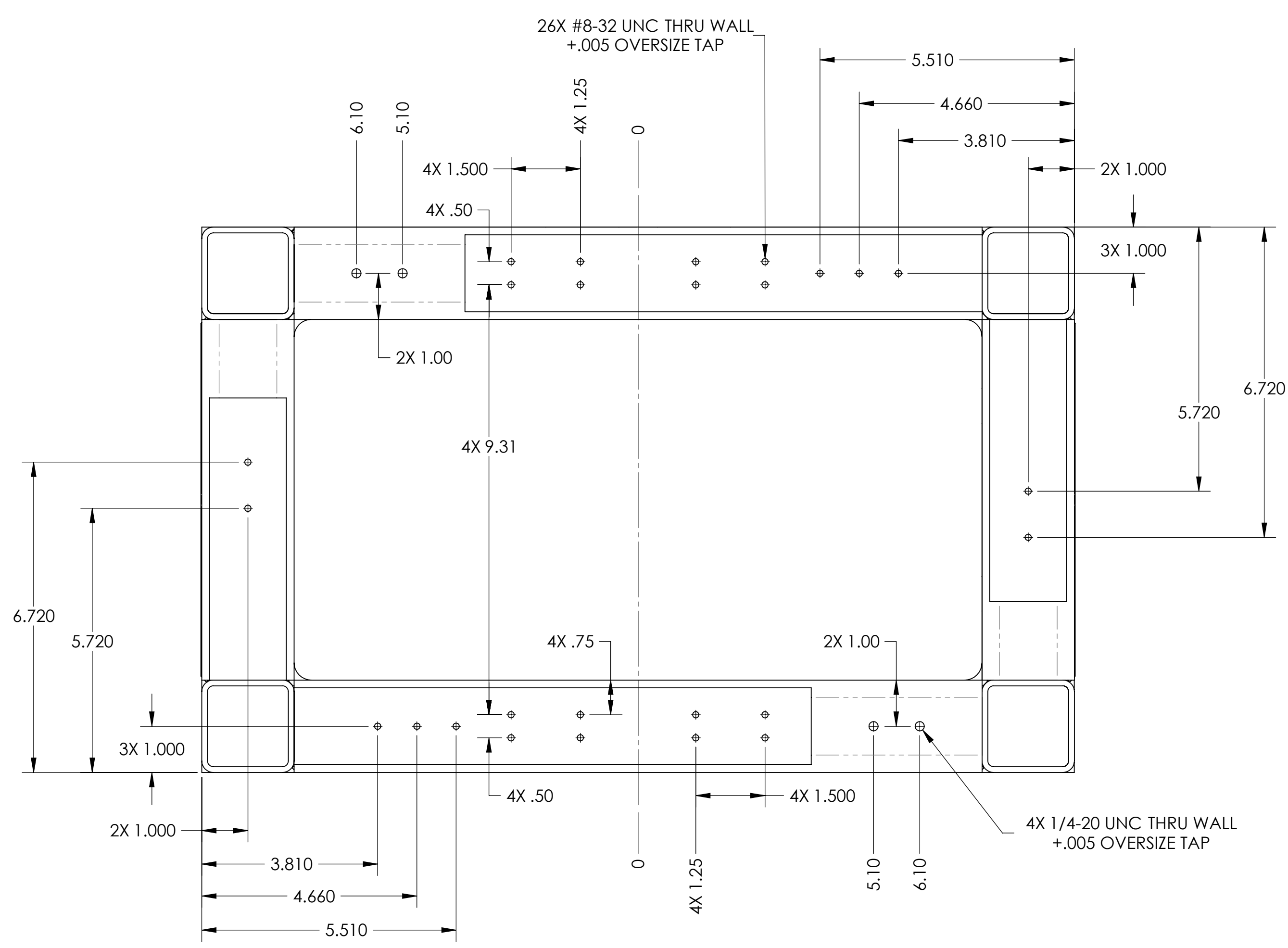


ISOMETRIC VIEW (FRONT SIDE SHOWING)

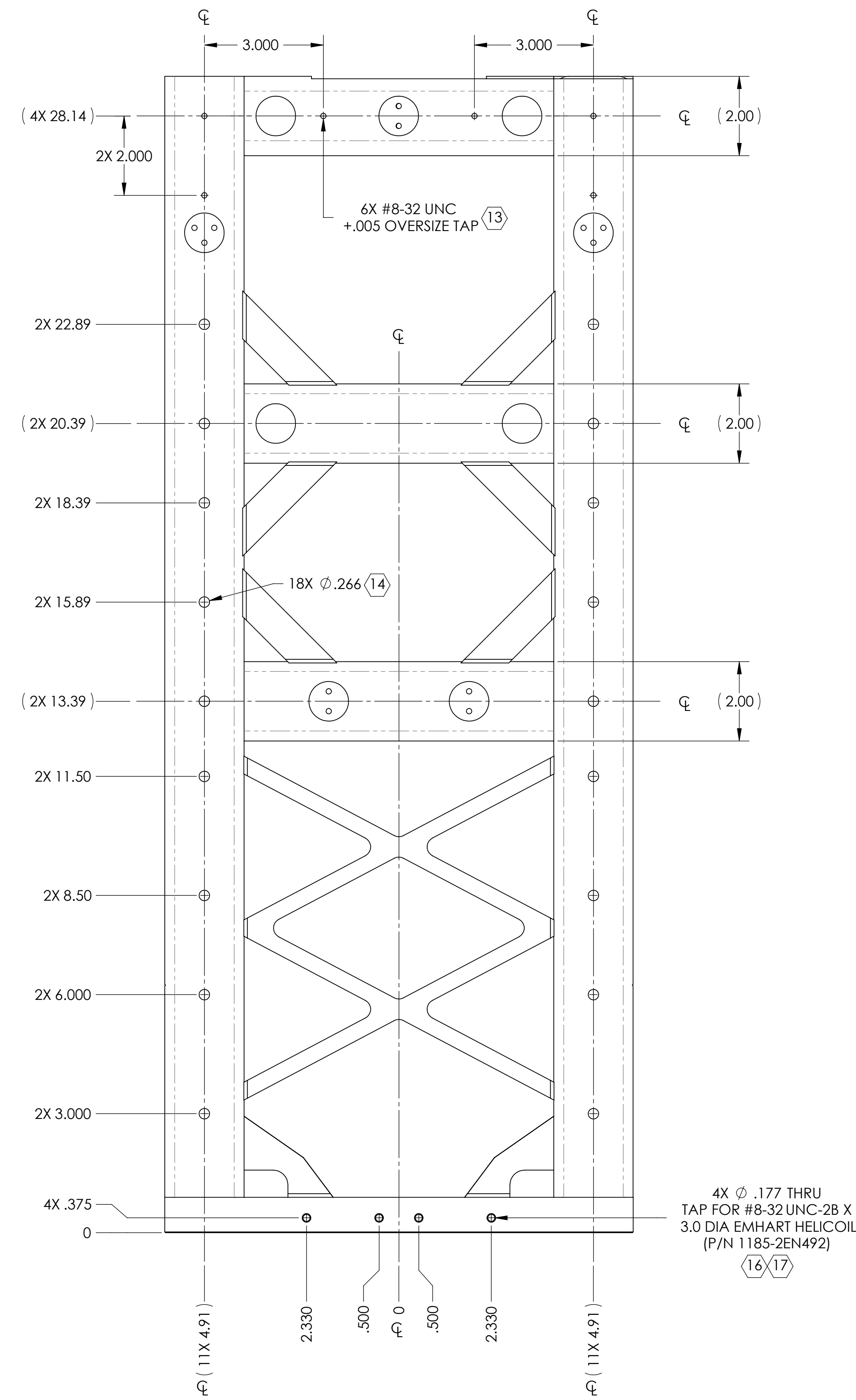


ISOMETRIC VIEW (BACK SIDE SHOWING)

ISOMETRIC VIEWS FOR LARGE HOLE PLACMENT

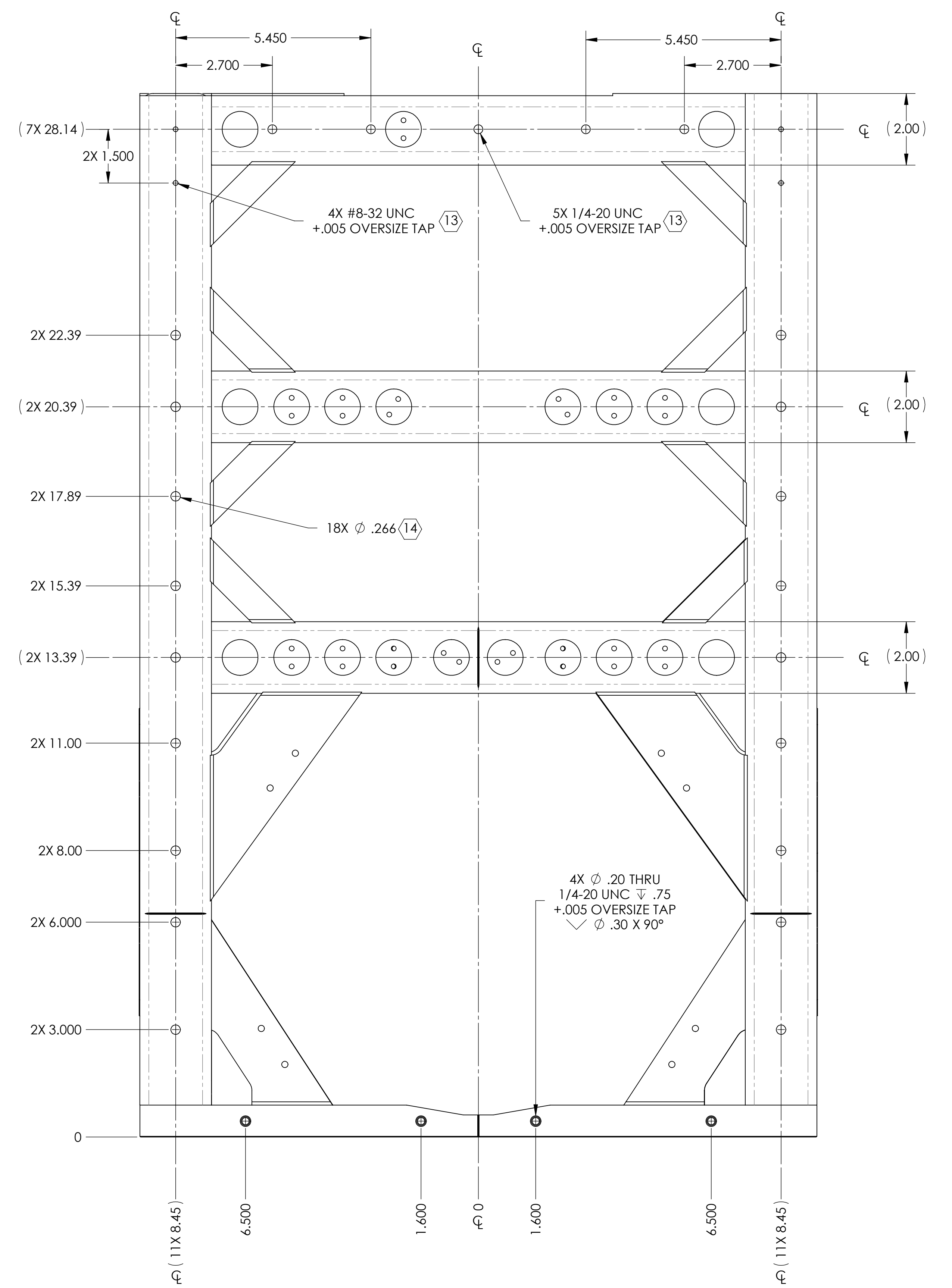


FRONT VIEW

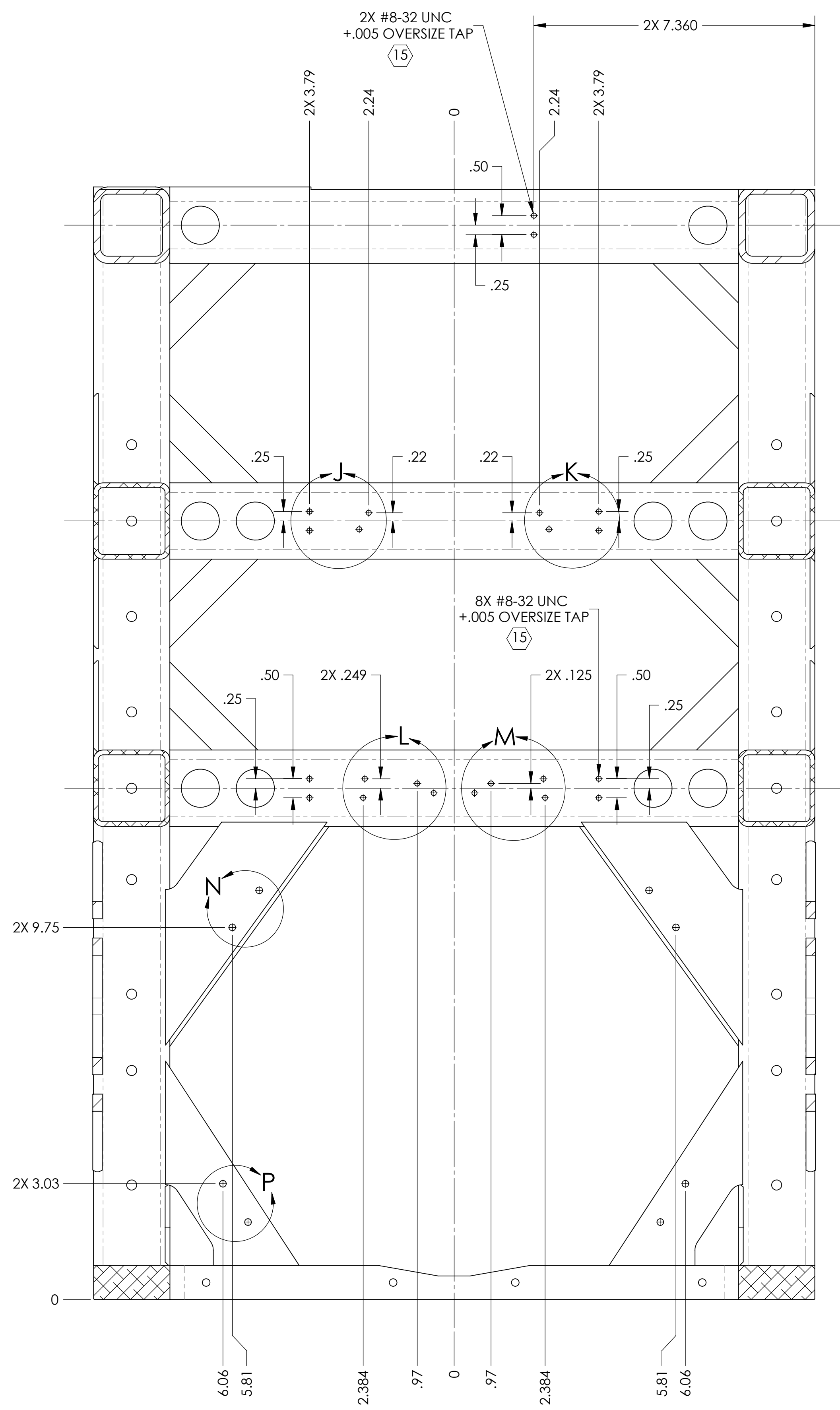


RIGHT AND LEFT VIEWS

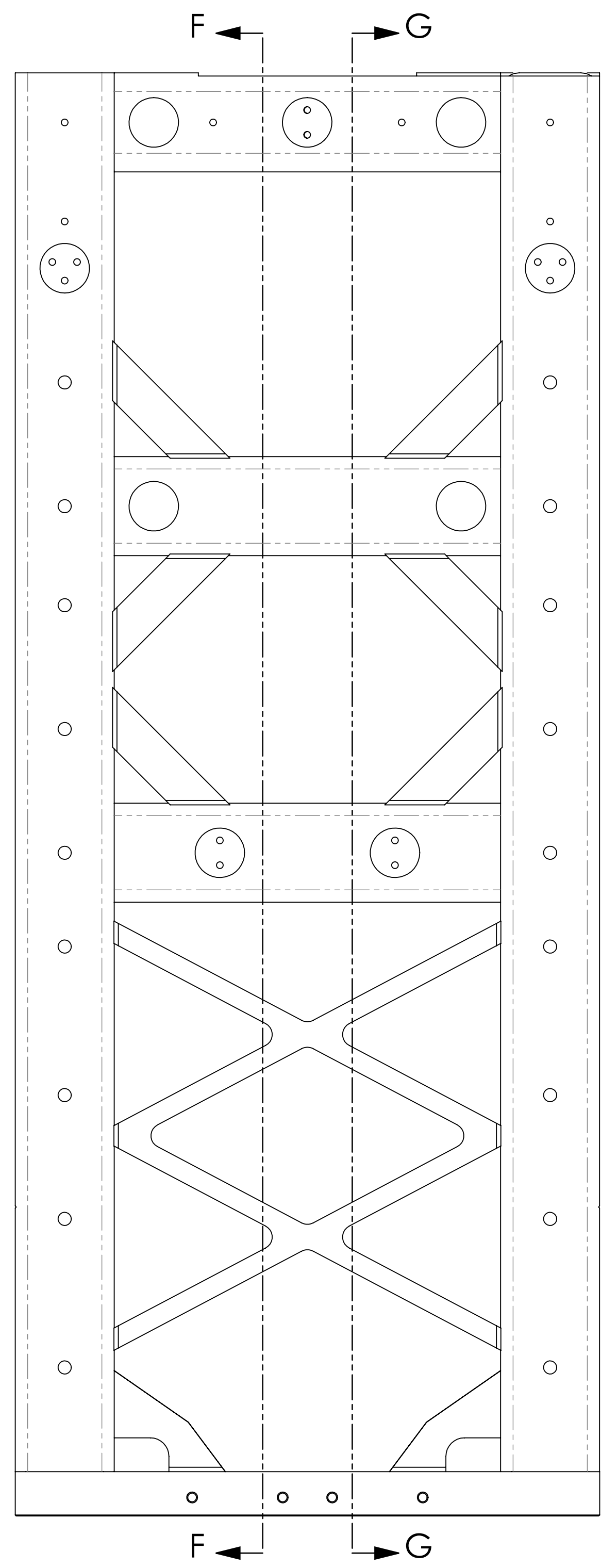
SMALL HOLE LAYOUT



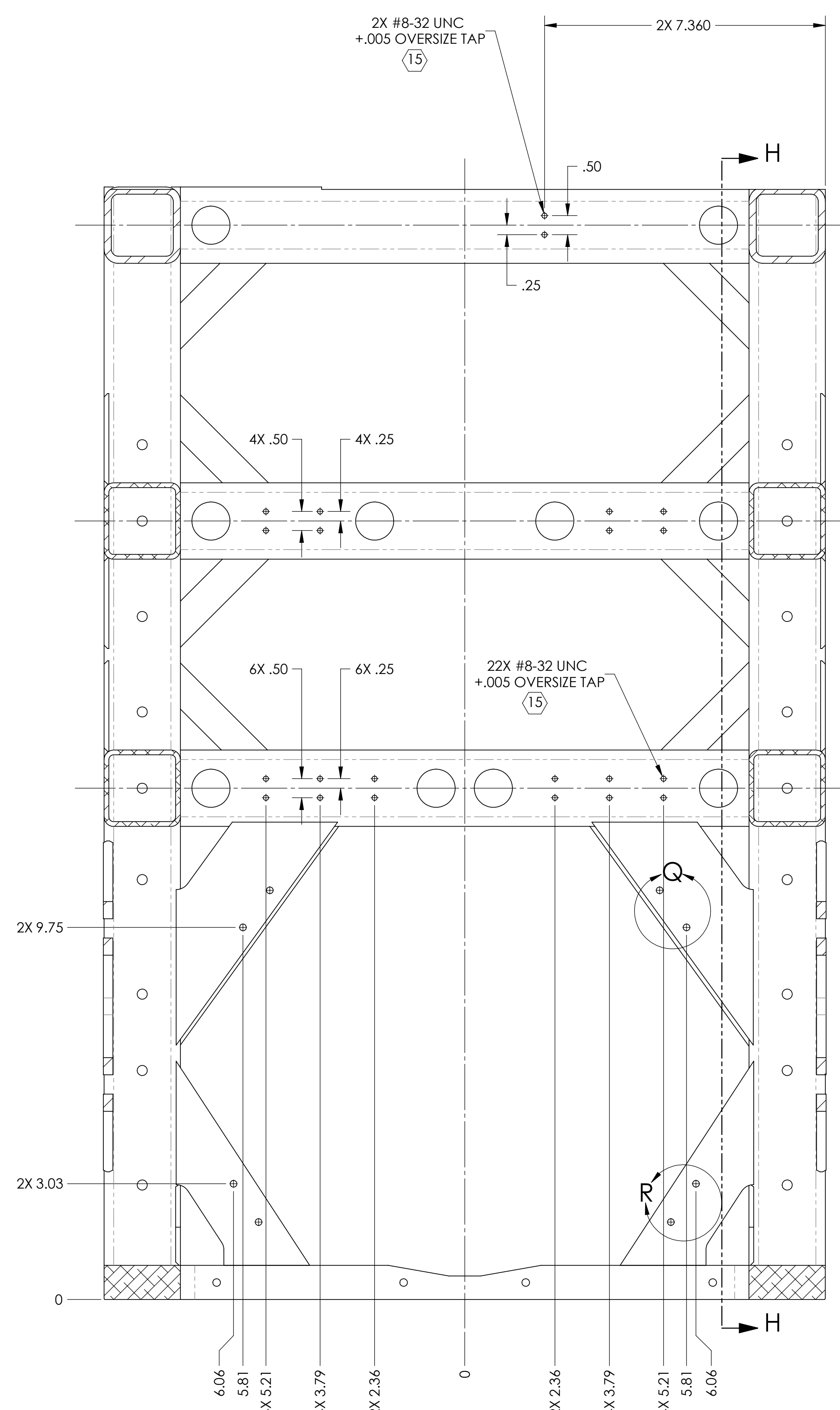
BACK VIEW



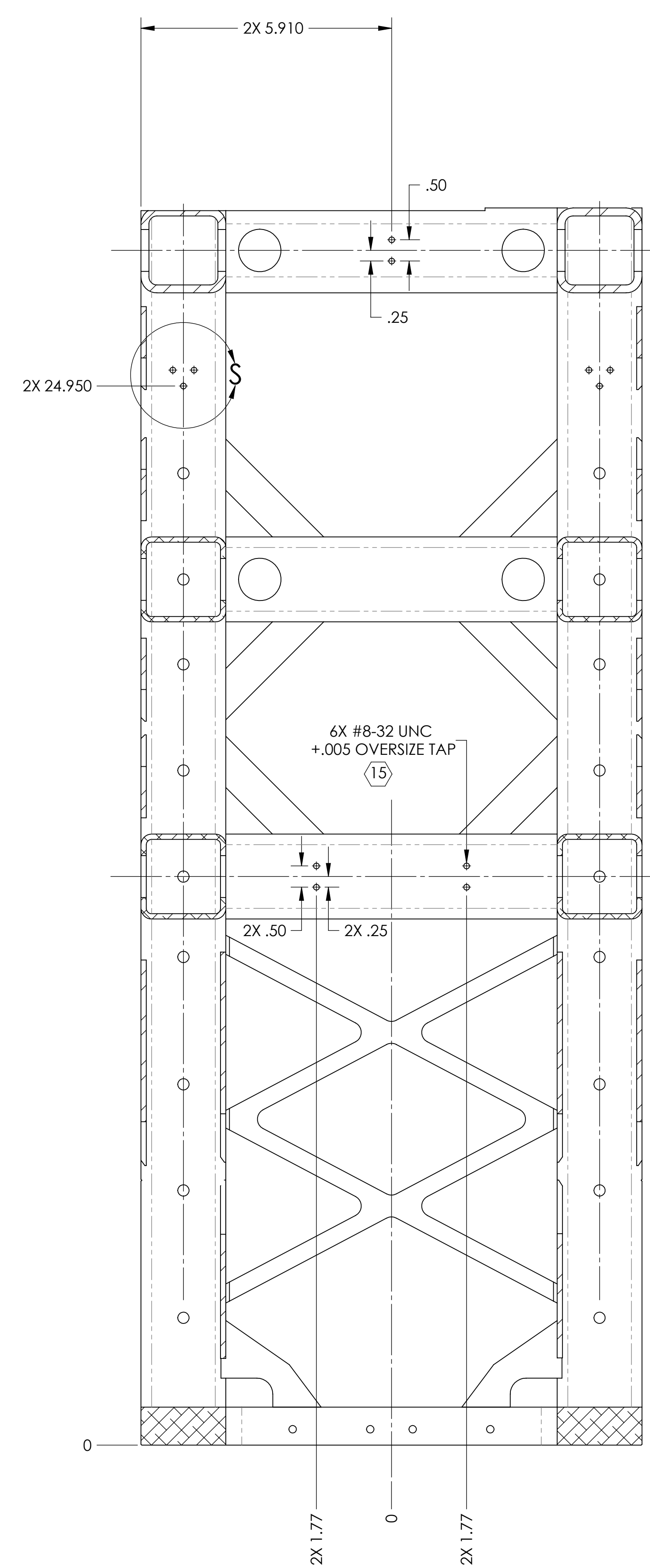
SECTION F-F
FRONT INSIDE VIEW



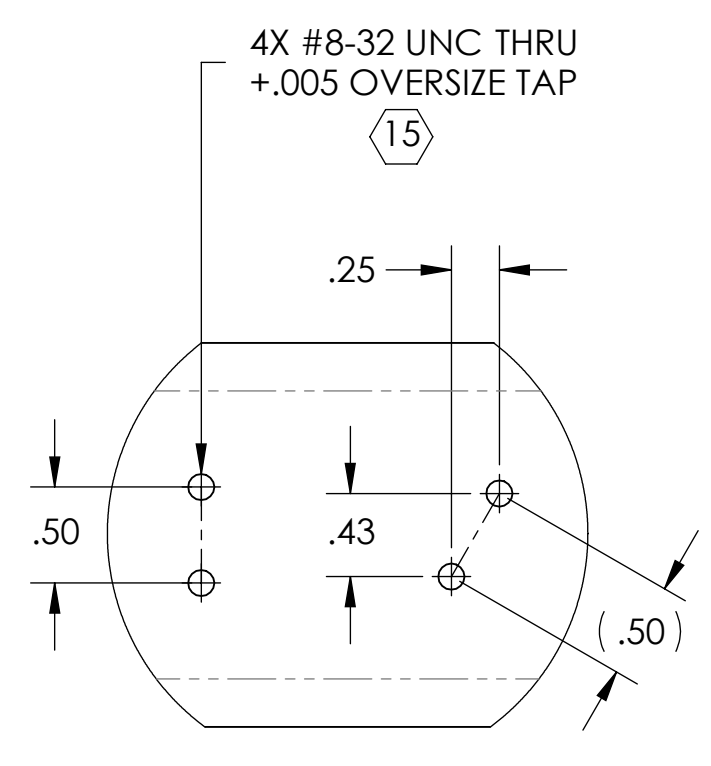
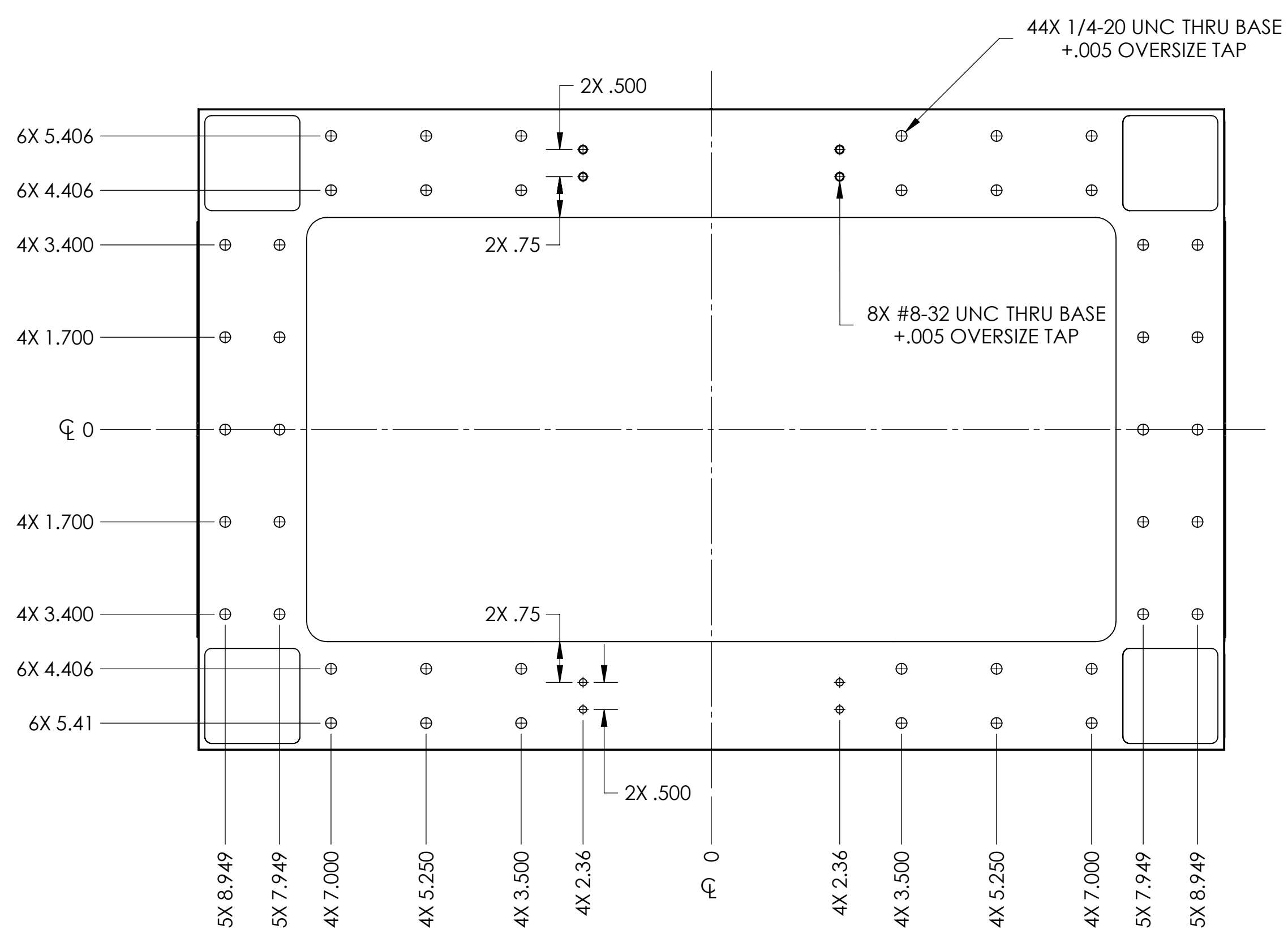
LEFT AND RIGHT VIEWS



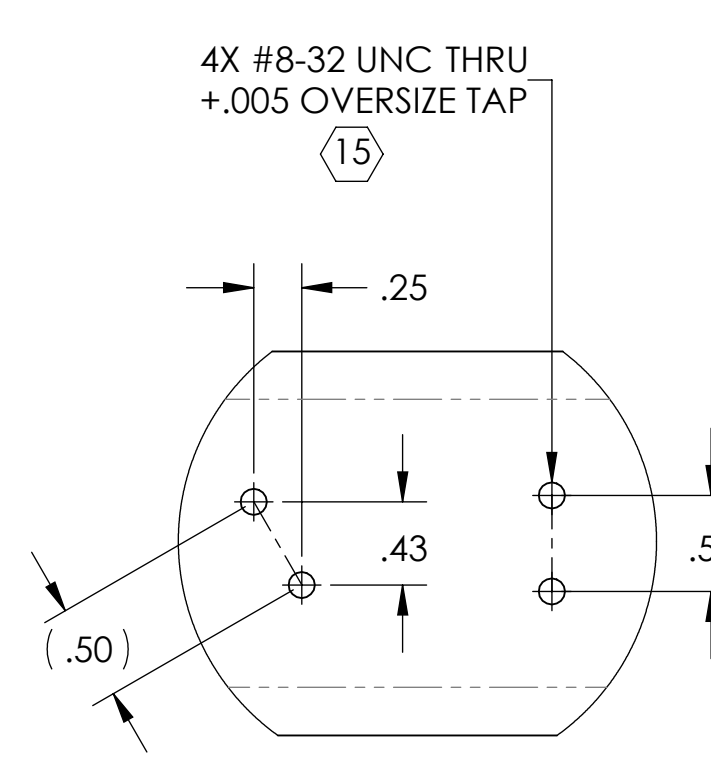
SECTION G-G
BACK INSIDE VIEW



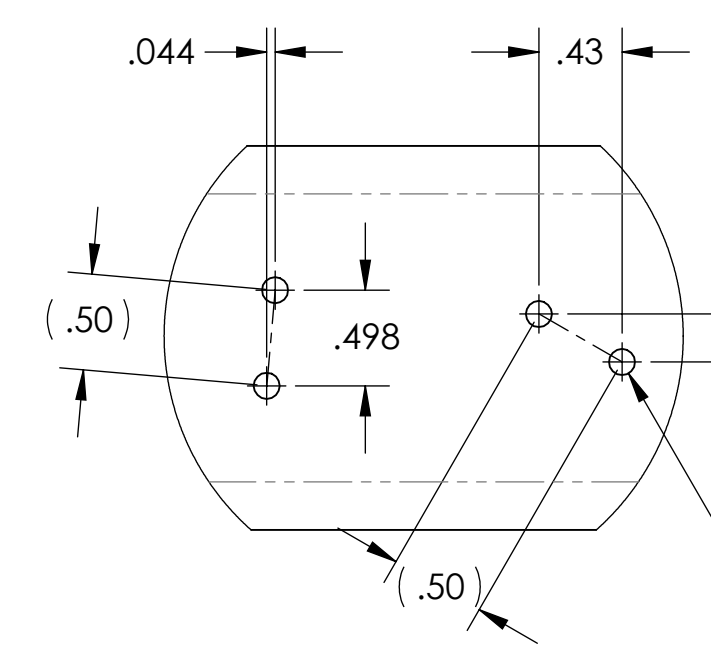
SECTION H-H
LEFT AND RIGHT INSIDE VIEWS



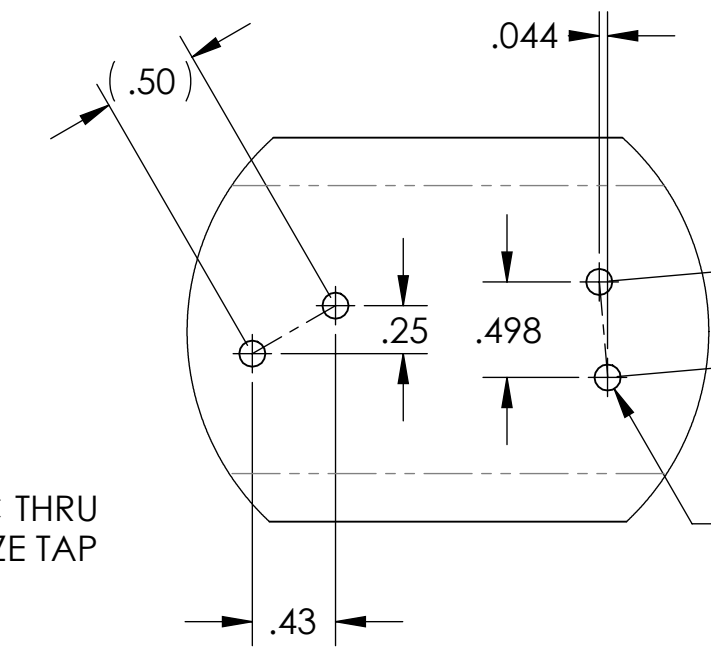
DETAIL J
SCALE 1 : 1



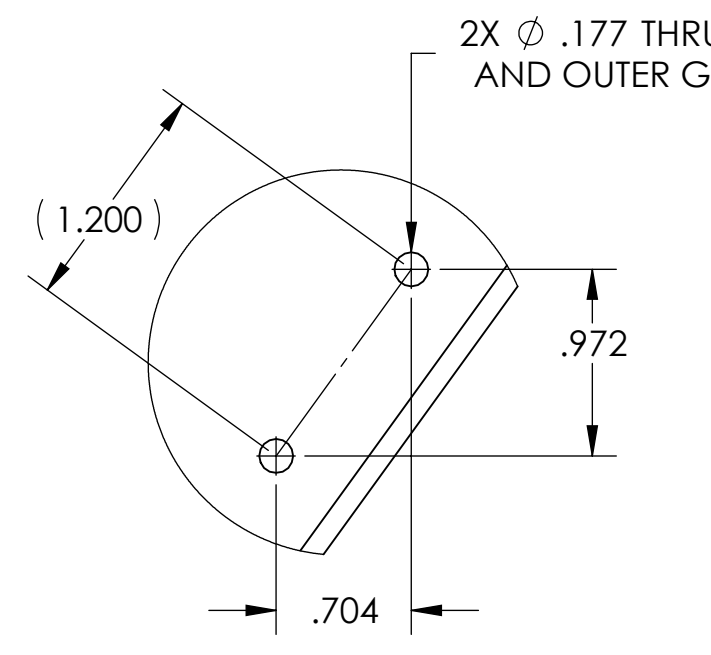
DETAIL K
SCALE 1 : 1



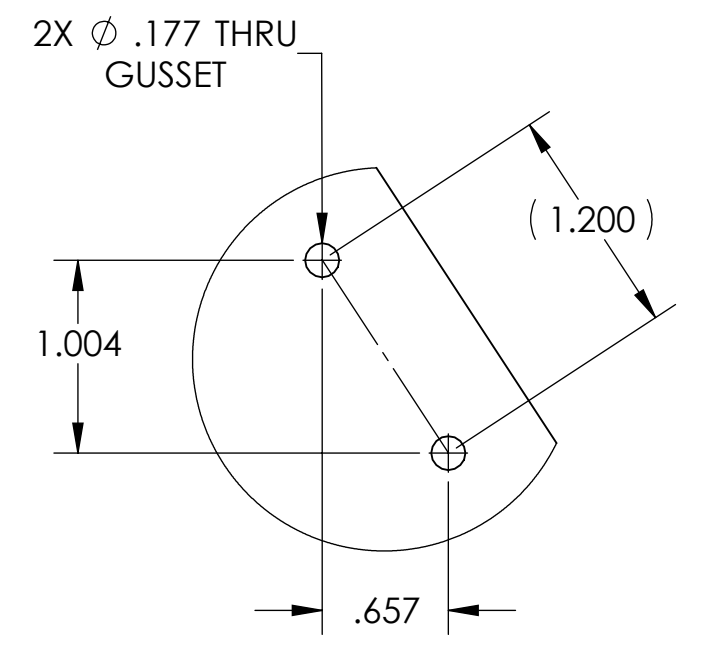
DETAIL L
SCALE 1 : 1



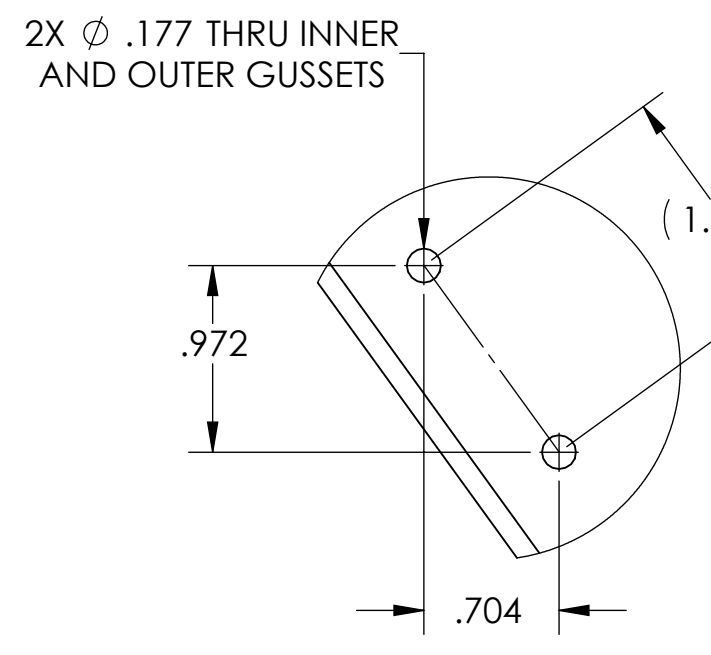
DETAIL M
SCALE 1 : 1



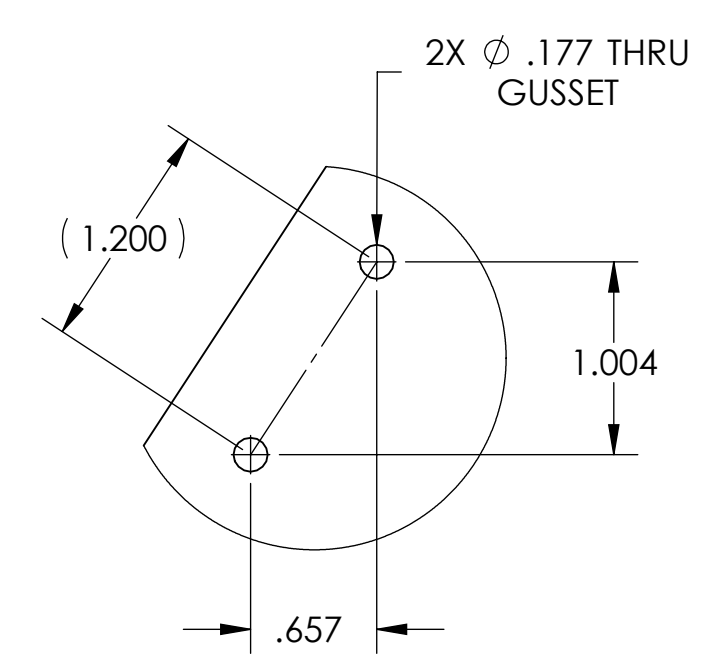
DETAIL N
SCALE 1 : 1
2 PLACES



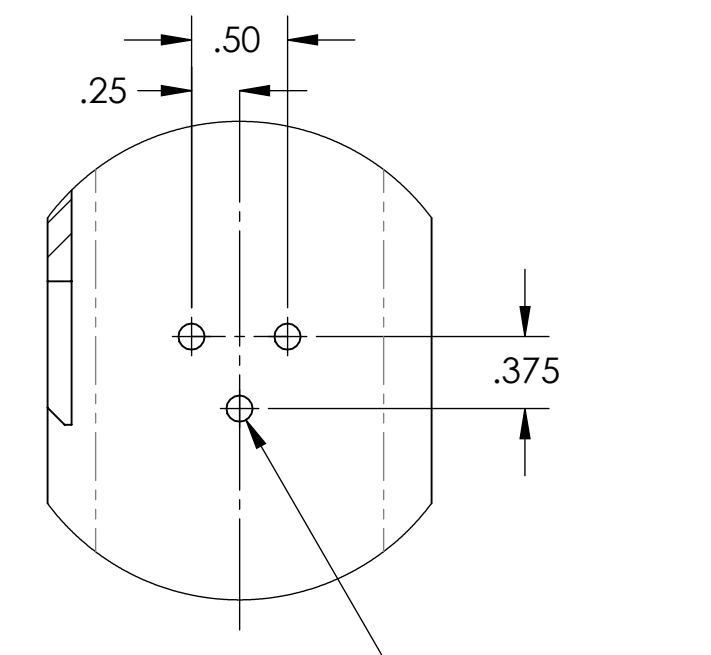
DETAIL P
SCALE 1 : 1
2 PLACES



DETAIL Q
SCALE 1 : 1
2 PLACES



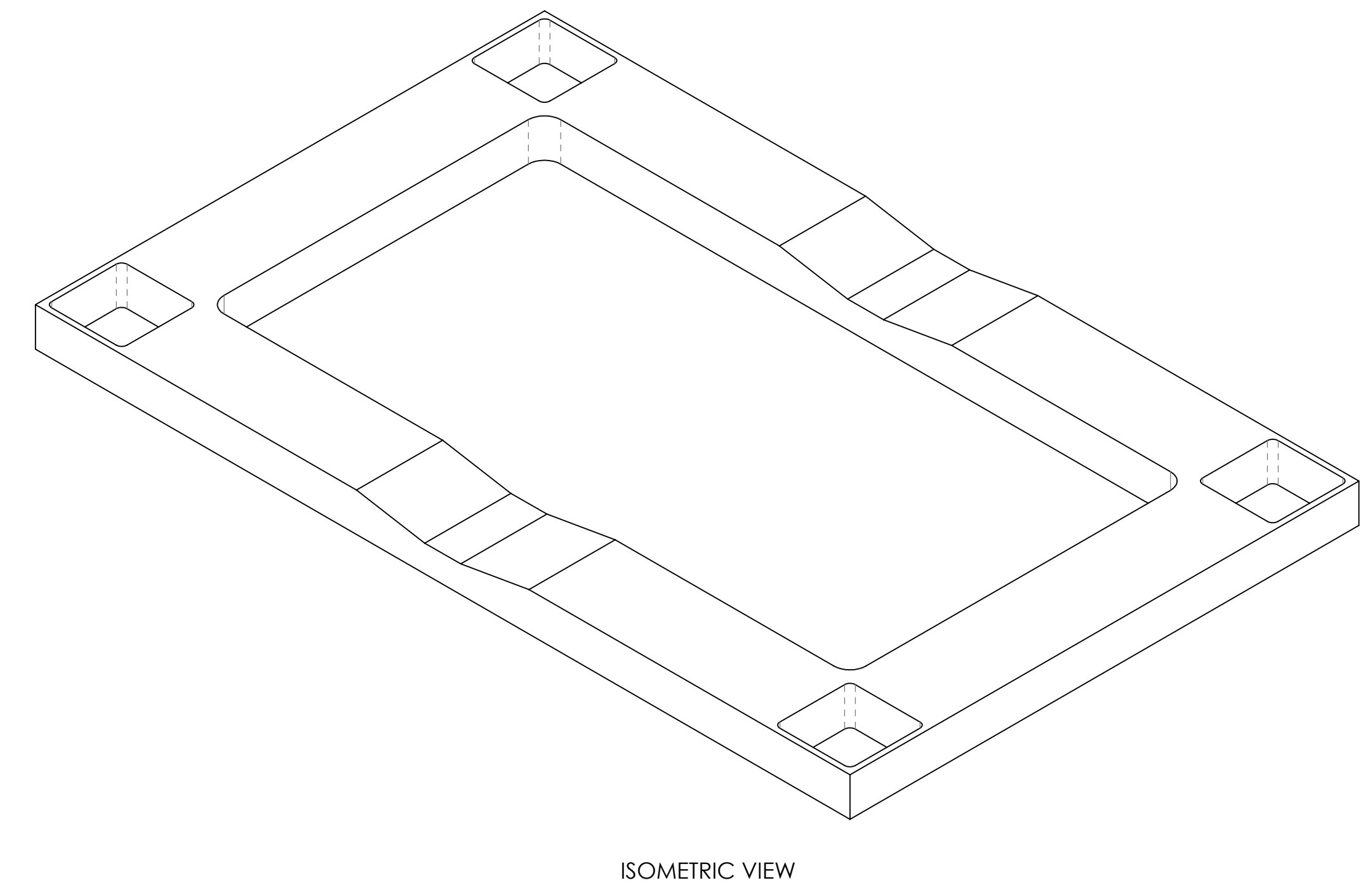
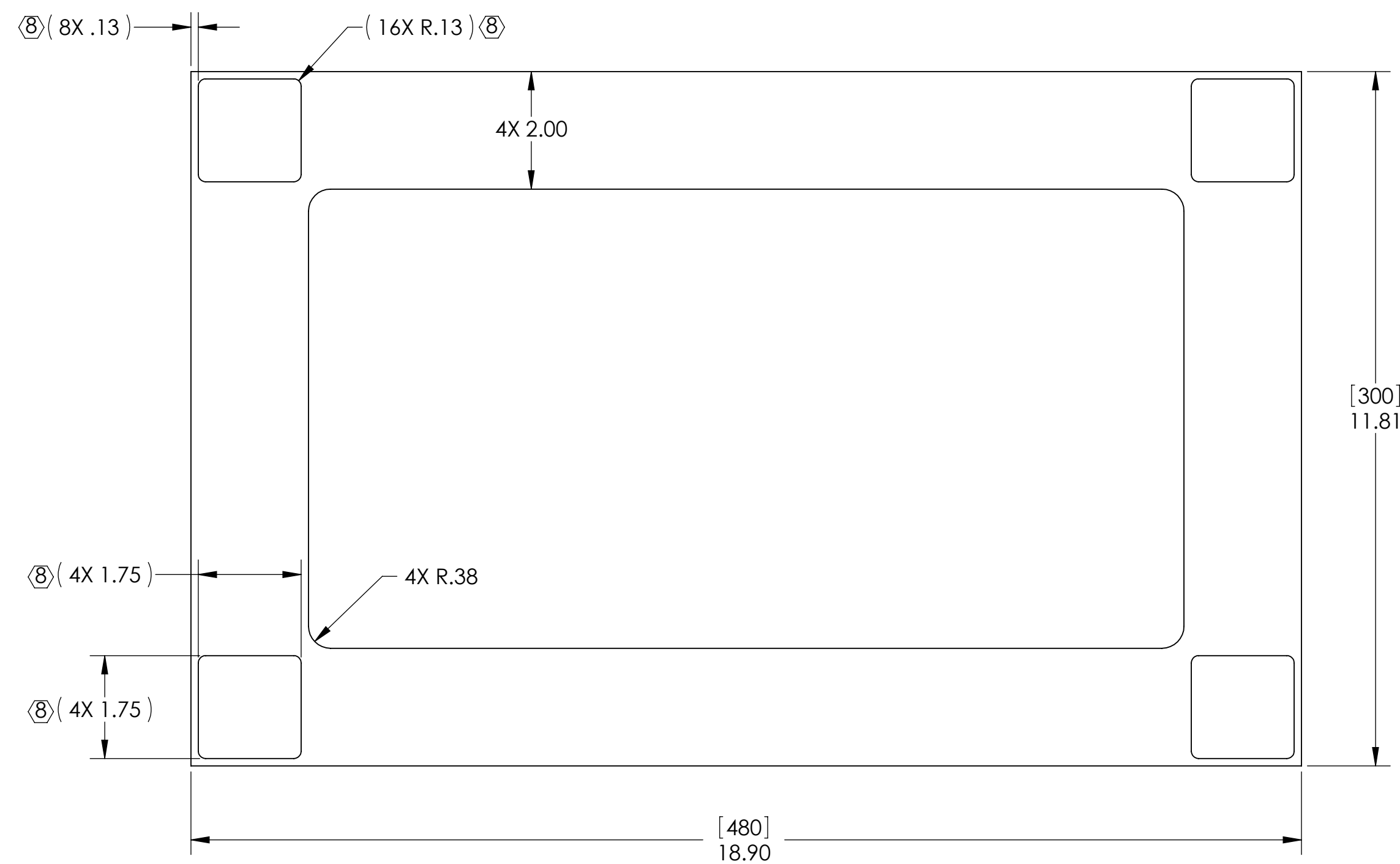
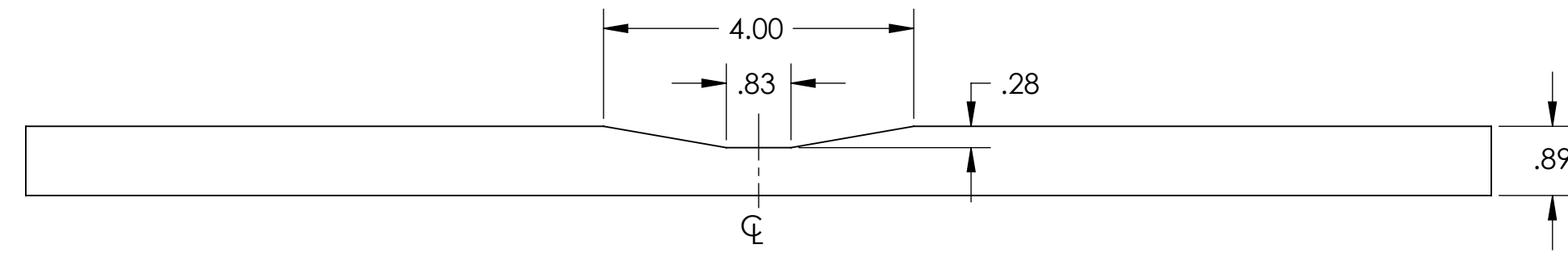
DETAIL R
SCALE 1 : 1
2 PLACES



DETAIL S
SCALE 1 : 1

NOTES CONTINUED:
 5. THIS PRICE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE E070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ISO SPECIFICATION ISO9004.
 8. MACHINE CUTOFF TO MATCH INNER PROFILE OF LEG TUBE. DIMENSIONS PROVIDED ARE FOR REFERENCE ONLY.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES [MM]	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
304 OR 304L SSSL	63 μinch

LIQO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIQO SUB-SYSTEM: SUS

NEXT ASSY: STRUCTURAL WELDMENT, HLTS

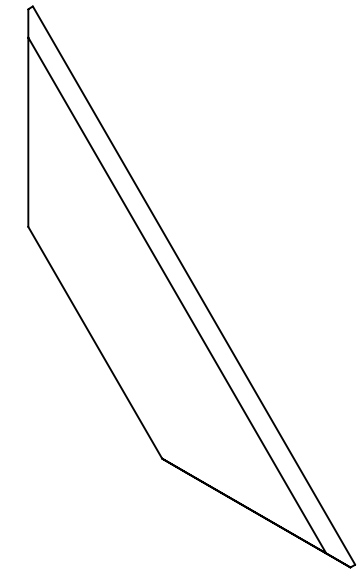
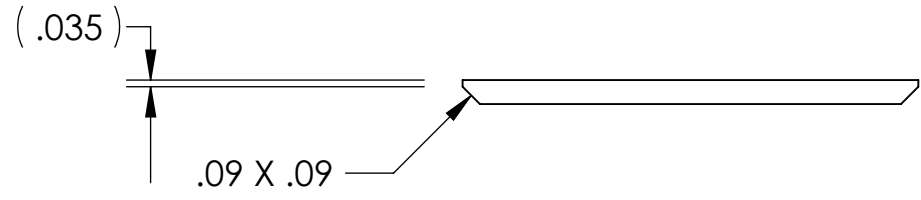
PART NAME				BASE PLATE	
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	D	D070575	v2
CHECKER	M. MEYER	30 AUG 2010	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
APPROVAL					

DD070575-Advanced LIQO_SUS_HLTS_Structure_Base_Plate_PART PDM REV: V1-002, DRAWING PDM REV: V1-002

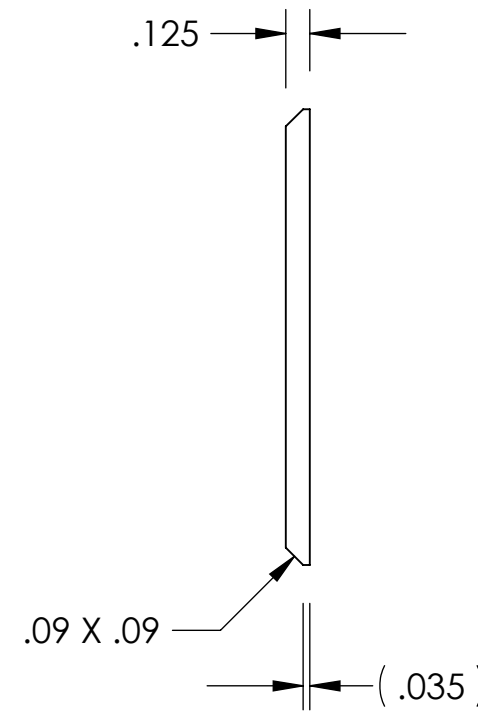
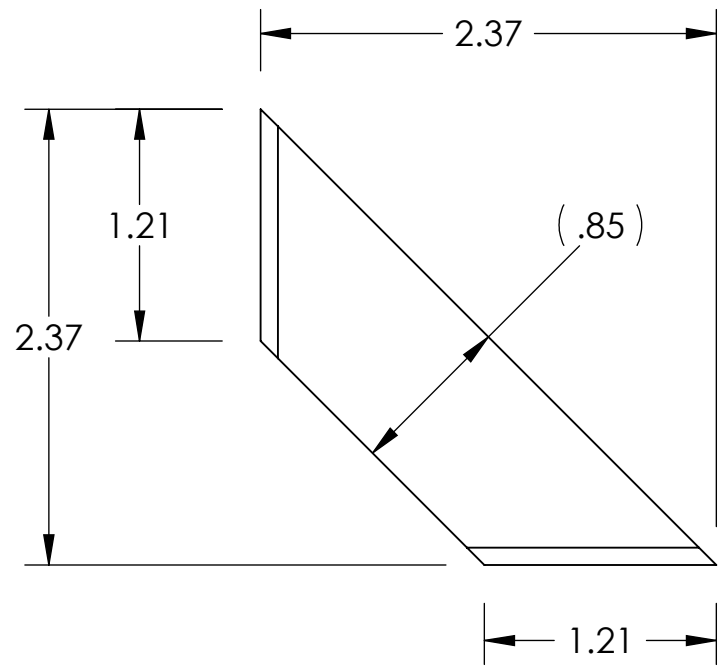
D070580_Advanced_LIGO_SUS_HLTS_Structure_Top_Gusset, PART PDM REV: V1-003, DRAWING PDM REV: V1-001

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



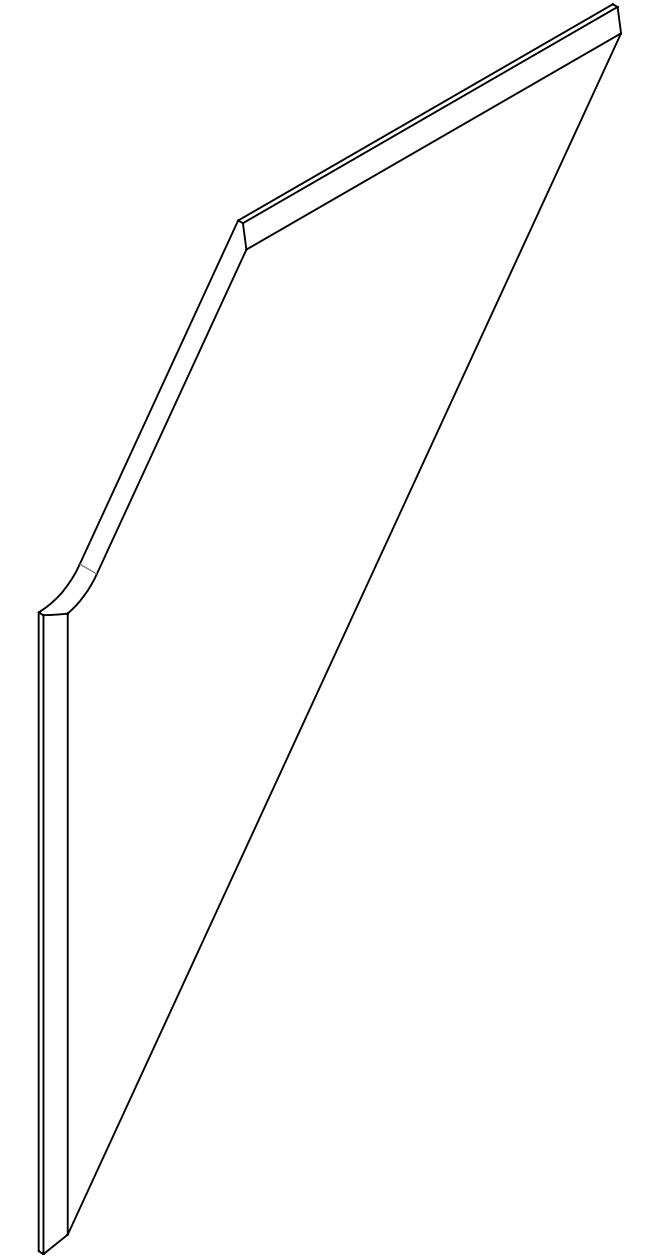
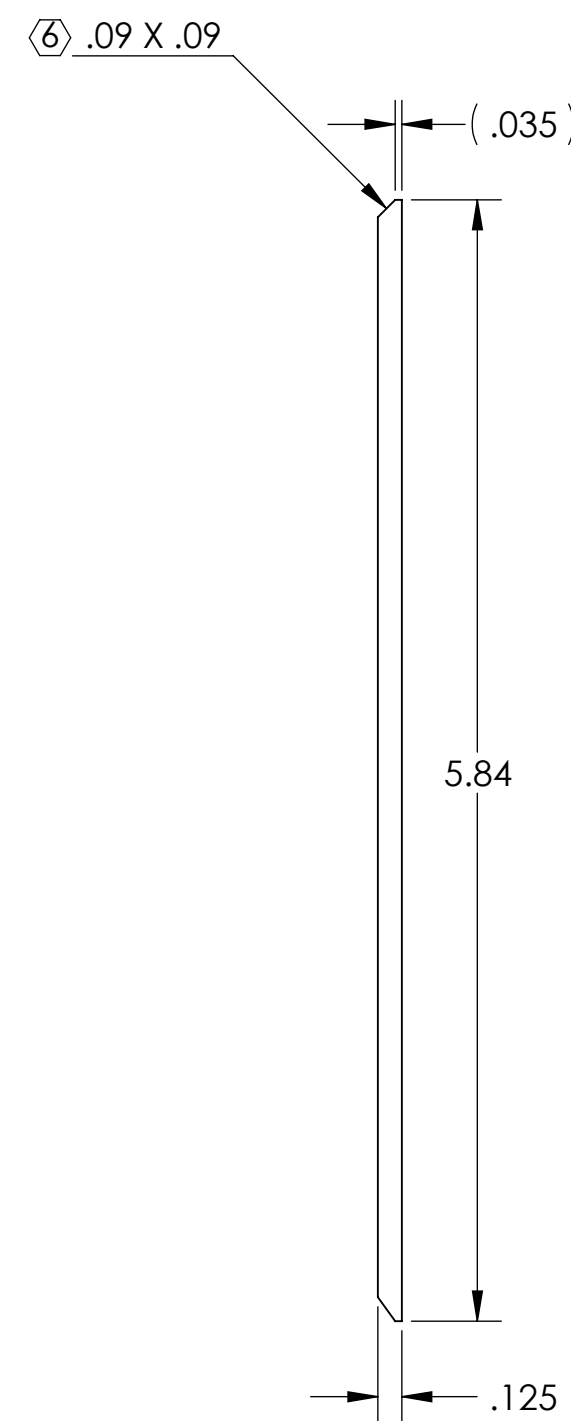
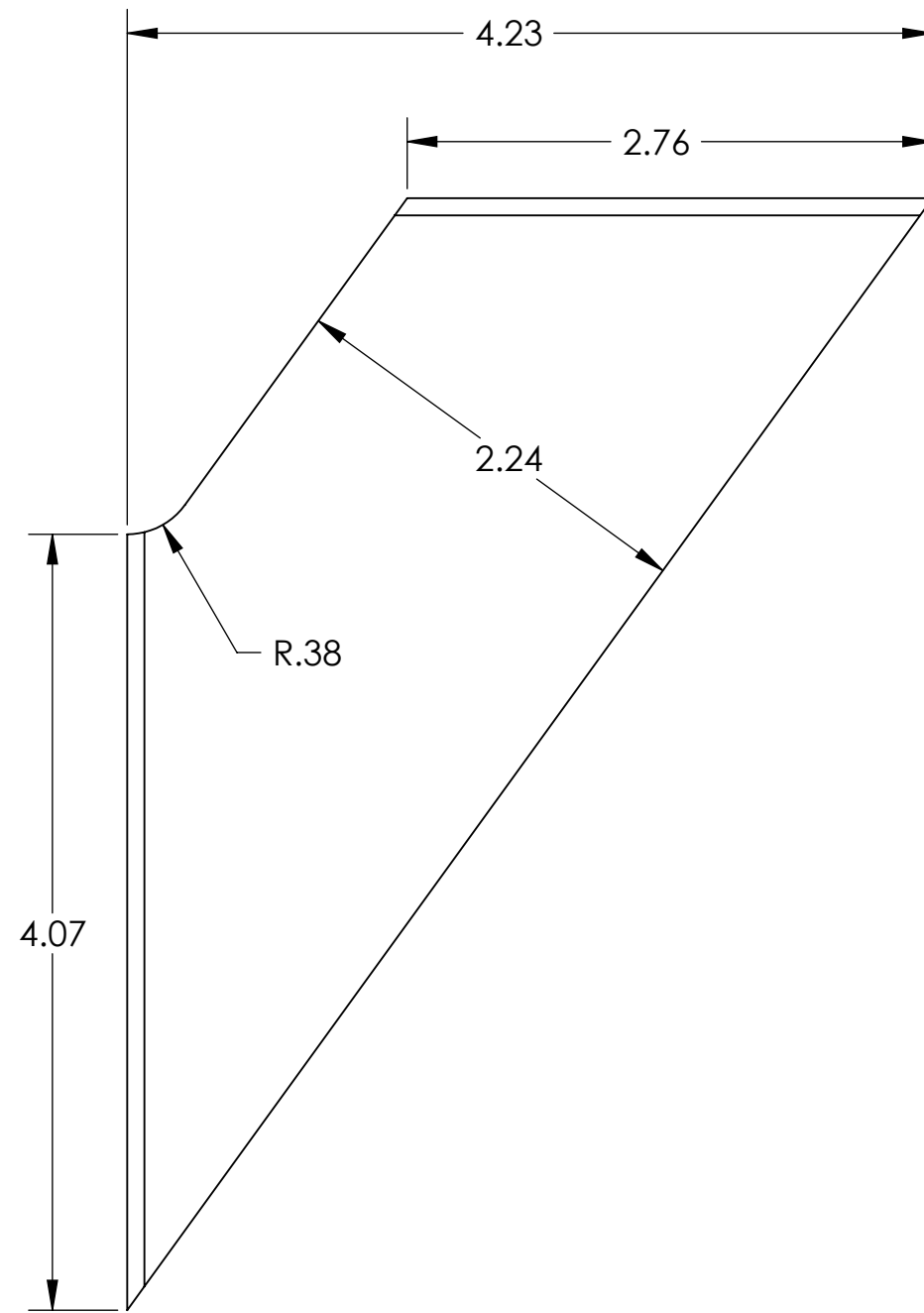
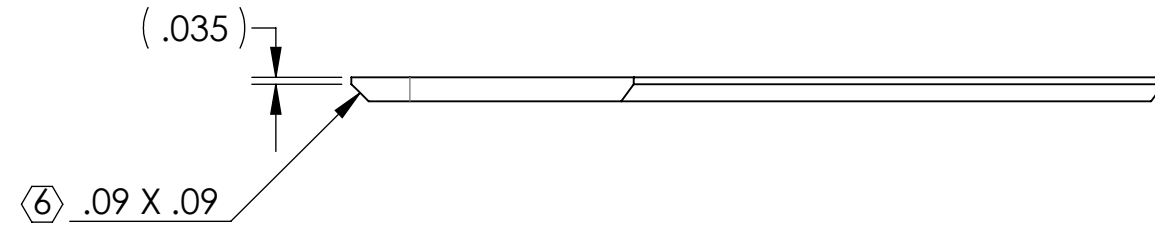
ISOMETRIC VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		TOP GUSSET	
						MATERIAL 304 OR 304L SSSL FINISH 63 μinch	
				SYSTEM ADVANCED LIGO SUB-SYSTEM SUS		DESIGNER D. BRIDGES 29 AUG 2010 SIZE DWG. NO. B D070580	
				NEXT ASSY STRUCTURAL WELDMENT, HLTS		DRAFTER D. BRIDGES 29 AUG 2010 REV. v2	
						CHECKER M. MEYER 30 AUG 2010	
						APPROVAL	
						SCALE: 1:1 PROJECTION: SHEET 1 OF 1	

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. HALF OF ALL UPPER FRONT GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E090364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 304 OR 304L SSSL
FINISH 63 μinch



SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS

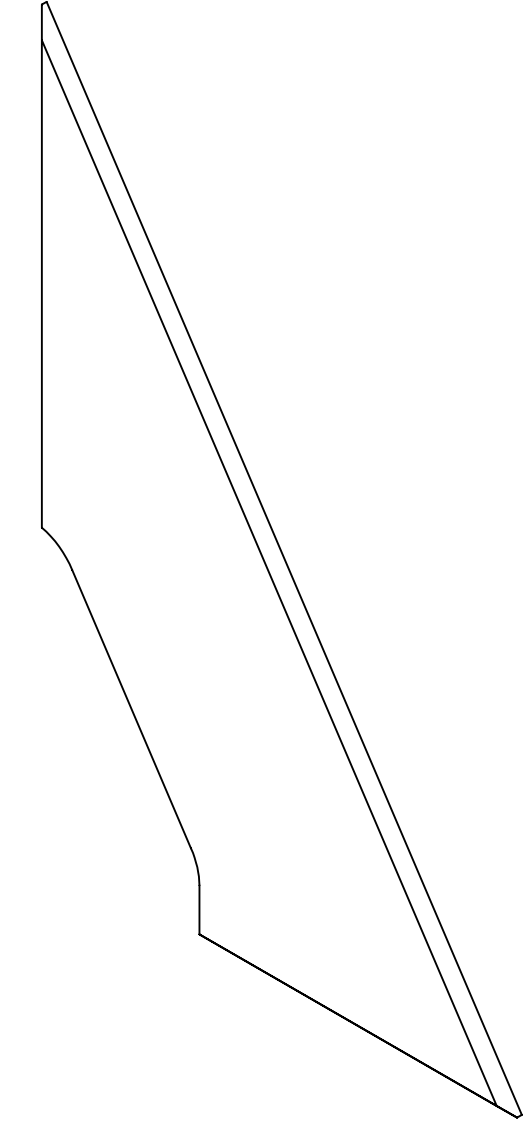
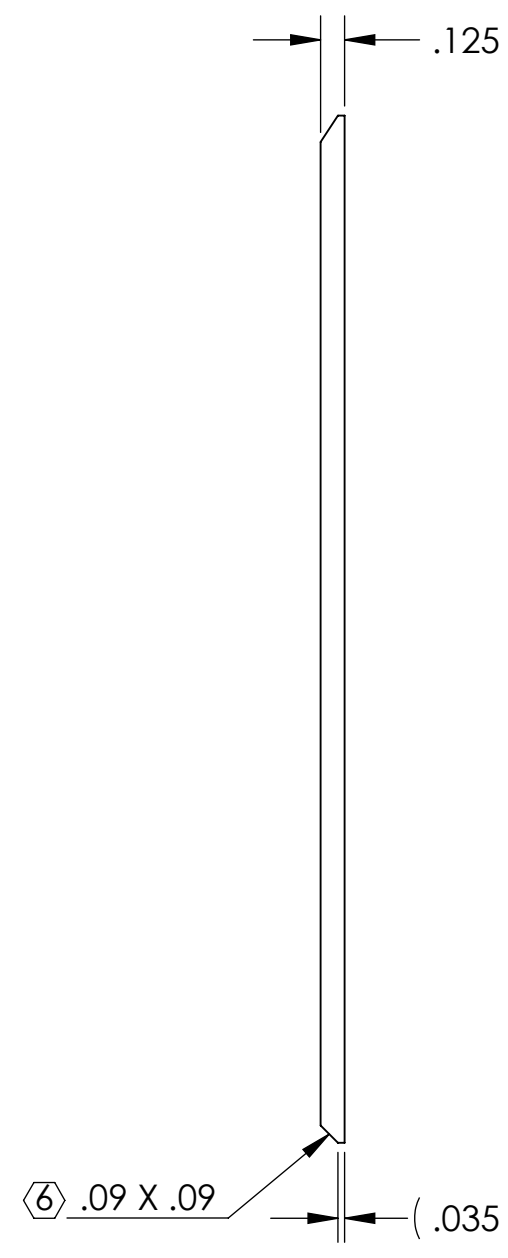
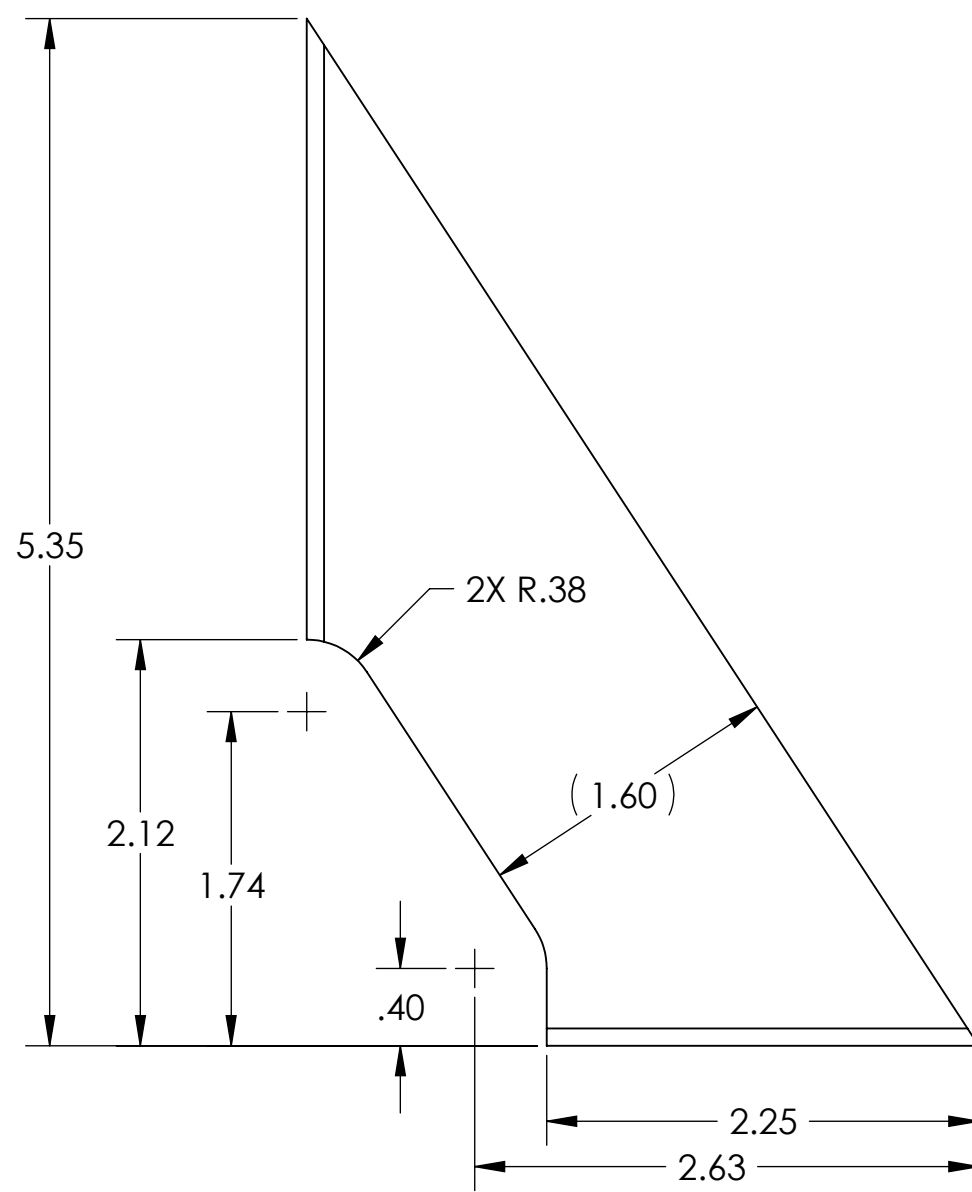
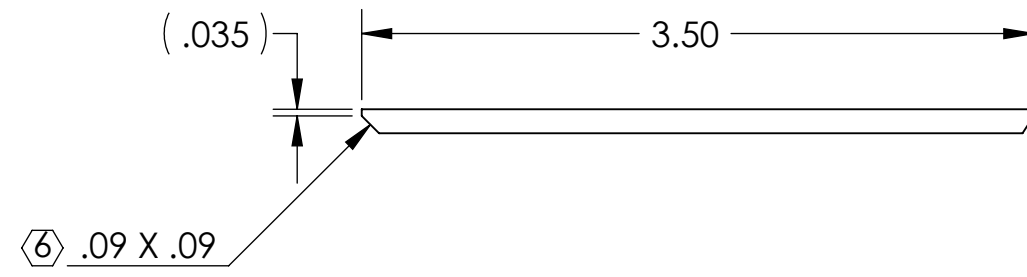
NEXT ASSY STRUCTURAL WELDMENT, HLTS

PART NAME			UPPER FRONT GUSSET		
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	c	D070579	v2
CHECKER	M. MEYER	30 AUG 2010			
APPROVAL			SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

NOTES CONTINUED:

- 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
- 6. HALF OF ALL LOWER FRONT GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

- 1. INTERPRET DRAWING PER ASME Y14.5-1994.
- 2. REMOVE ALL SHARP EDGES, R.02 MIN.
- 3. DO NOT SCALE FROM DRAWING.
- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 304 OR 304L SSSL **FINISH** 63 μinch



SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS
NEXT ASSY STRUCTURAL WELDMENT, HLTS

PART NAME

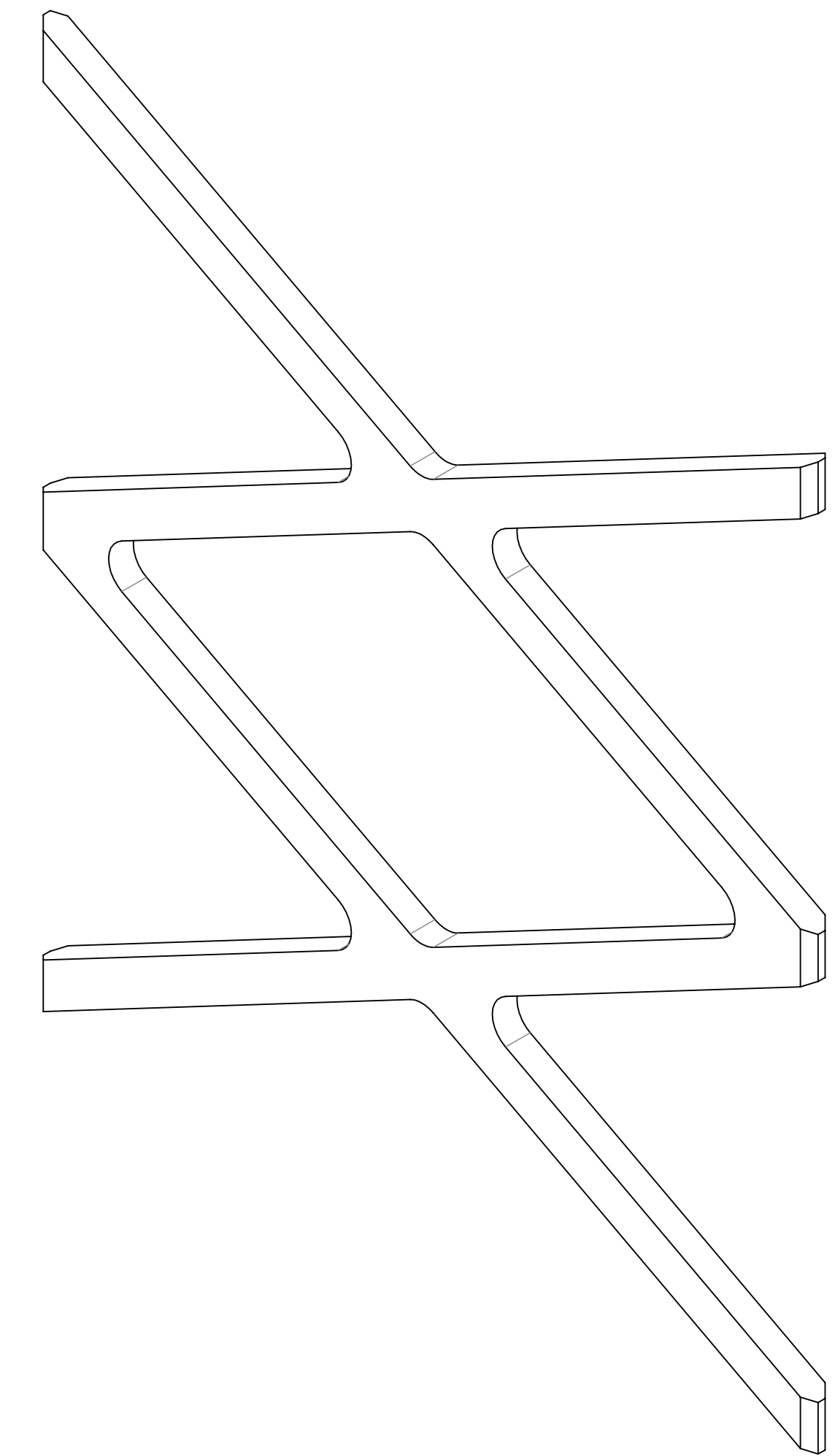
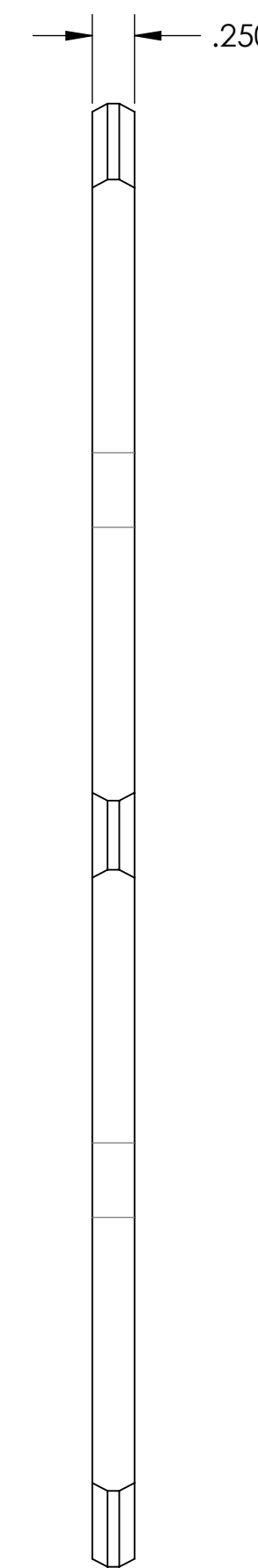
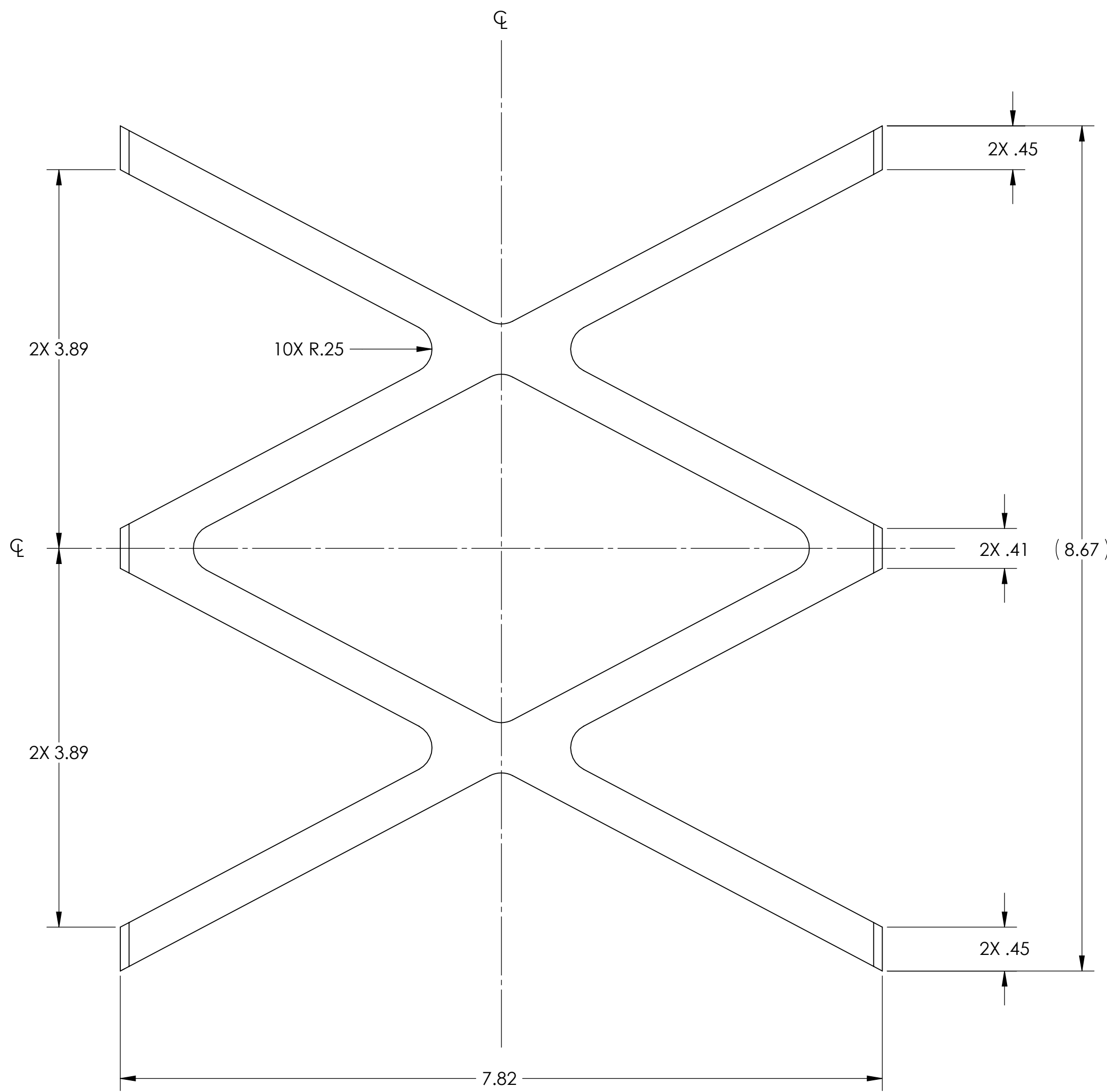
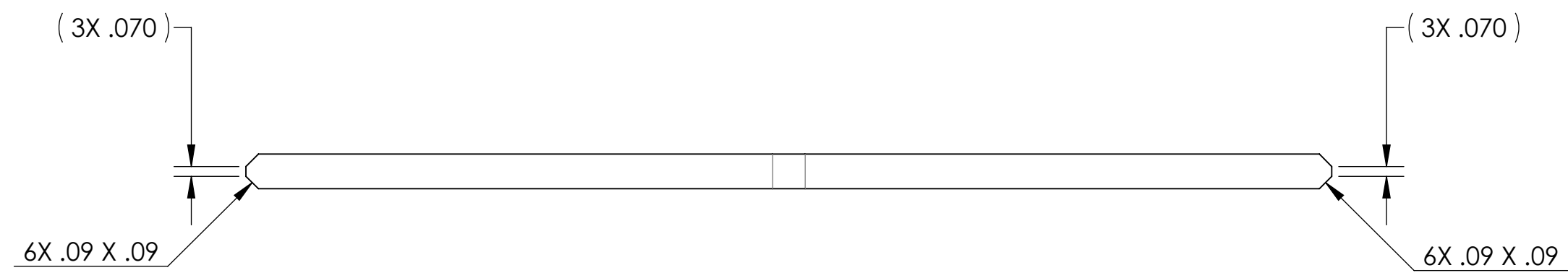
LOWER FRONT GUSSET

DESIGNER D. BRIDGES 29 AUG 2010
DRAFTER D. BRIDGES 29 AUG 2010
CHECKER M. MEYER 30 AUG 2010
APPROVAL

SIZE c **DWG. NO.** D070576 **REV.** v2
SCALE: 1:1 **PROJECTION:** SHEET 1 OF 1

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
304 OR 304L SSSL	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SUS
NEXT ASSY	
STRUCTURAL WELDMENT, HLTS	

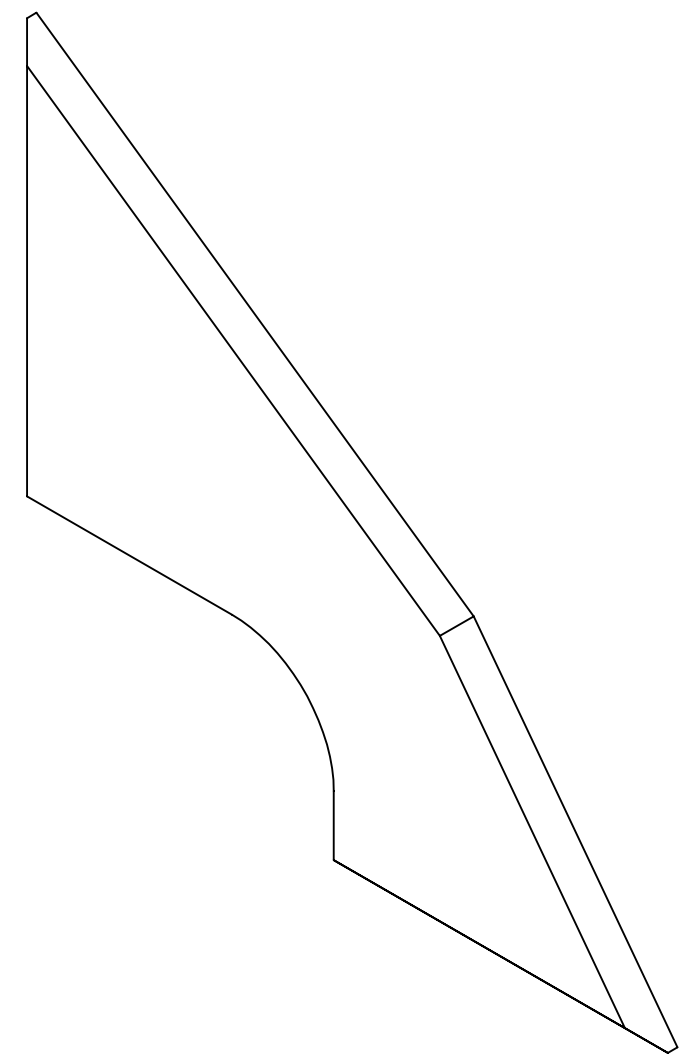
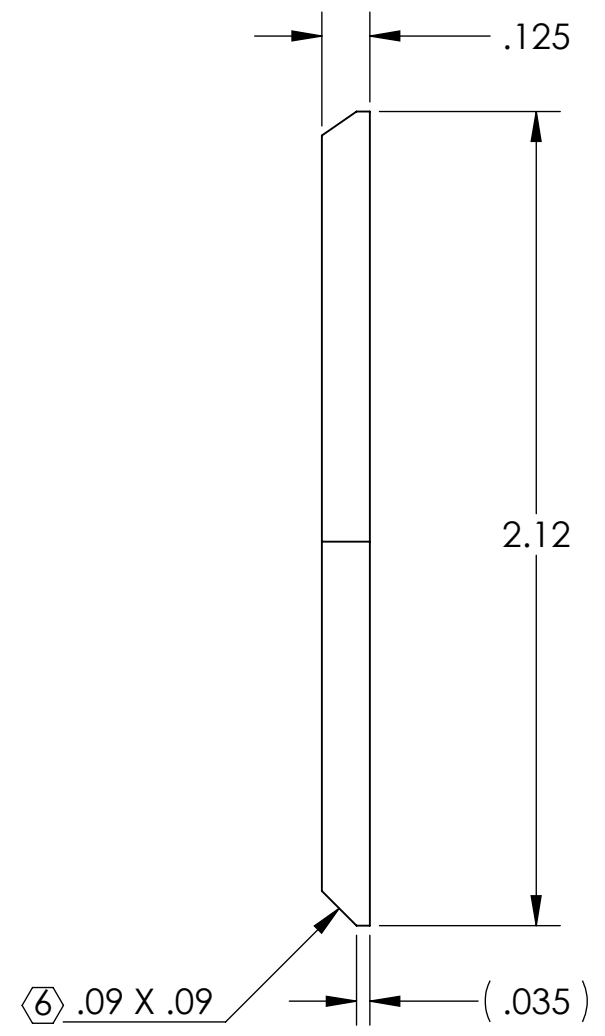
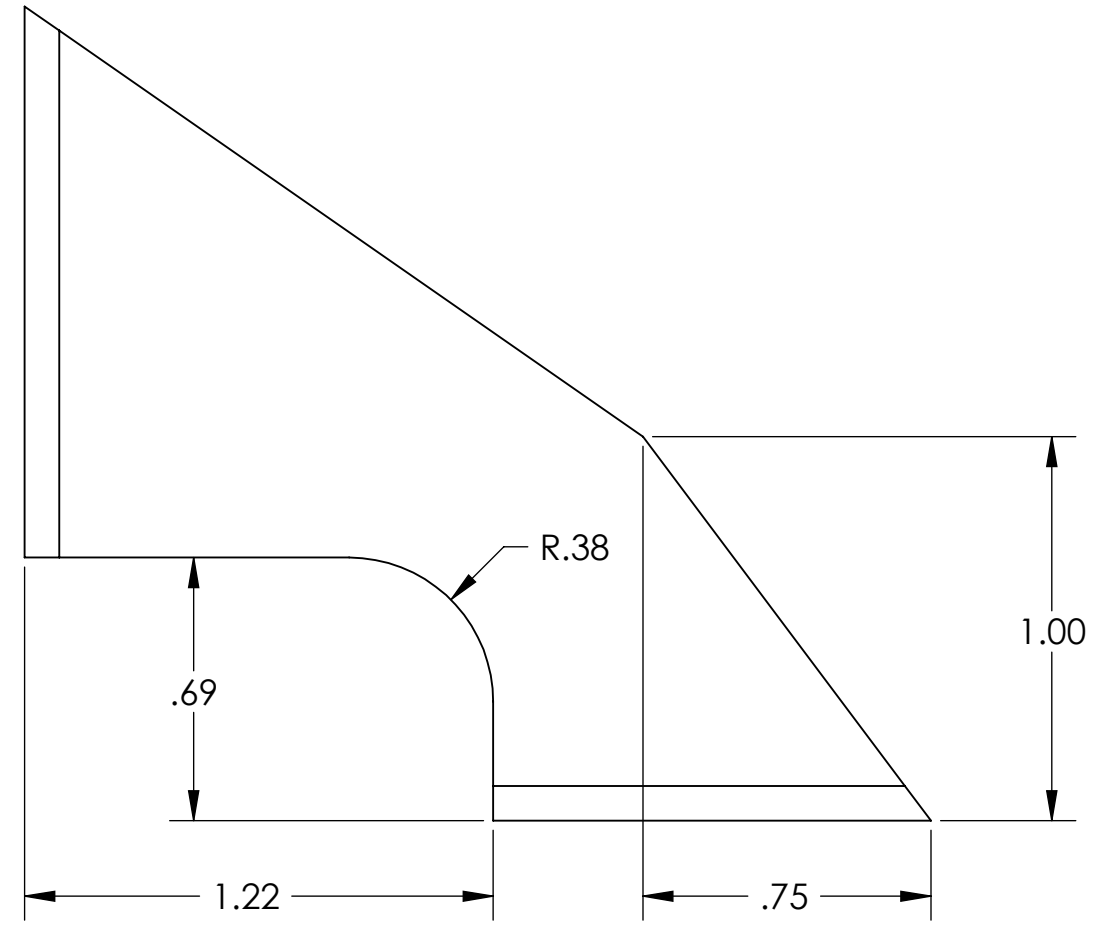
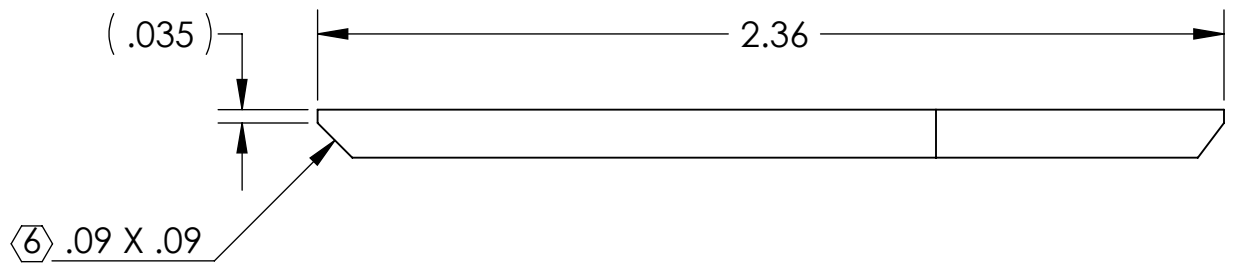
PART NAME				SIDE STRUT	
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	D	D070578	v2
CHECKER	M. MEYER	30 AUG 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

D070578-AdvancedLIGO_SUS_HLTS_Structure_Side_Std1_PART PDM REV: V1-003; DRAWING PDM REV: V1-000

D070577_Advanced_LIGO_SUS_HLTS_Structure_Side_Gusset, PART PDM REV: V1-004, DRAWING PDM REV: V1-000

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. HALF OF ALL SIDE GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



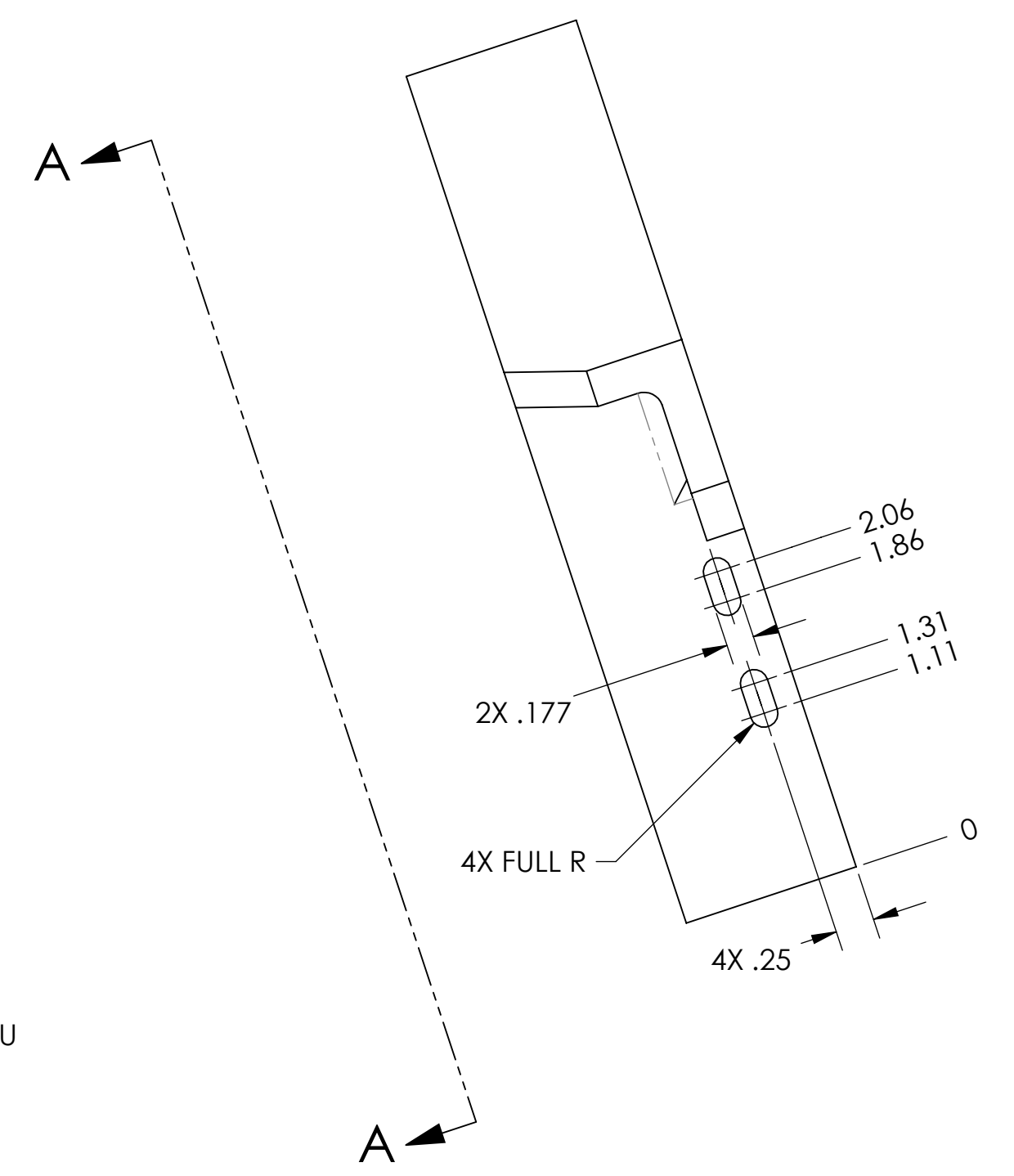
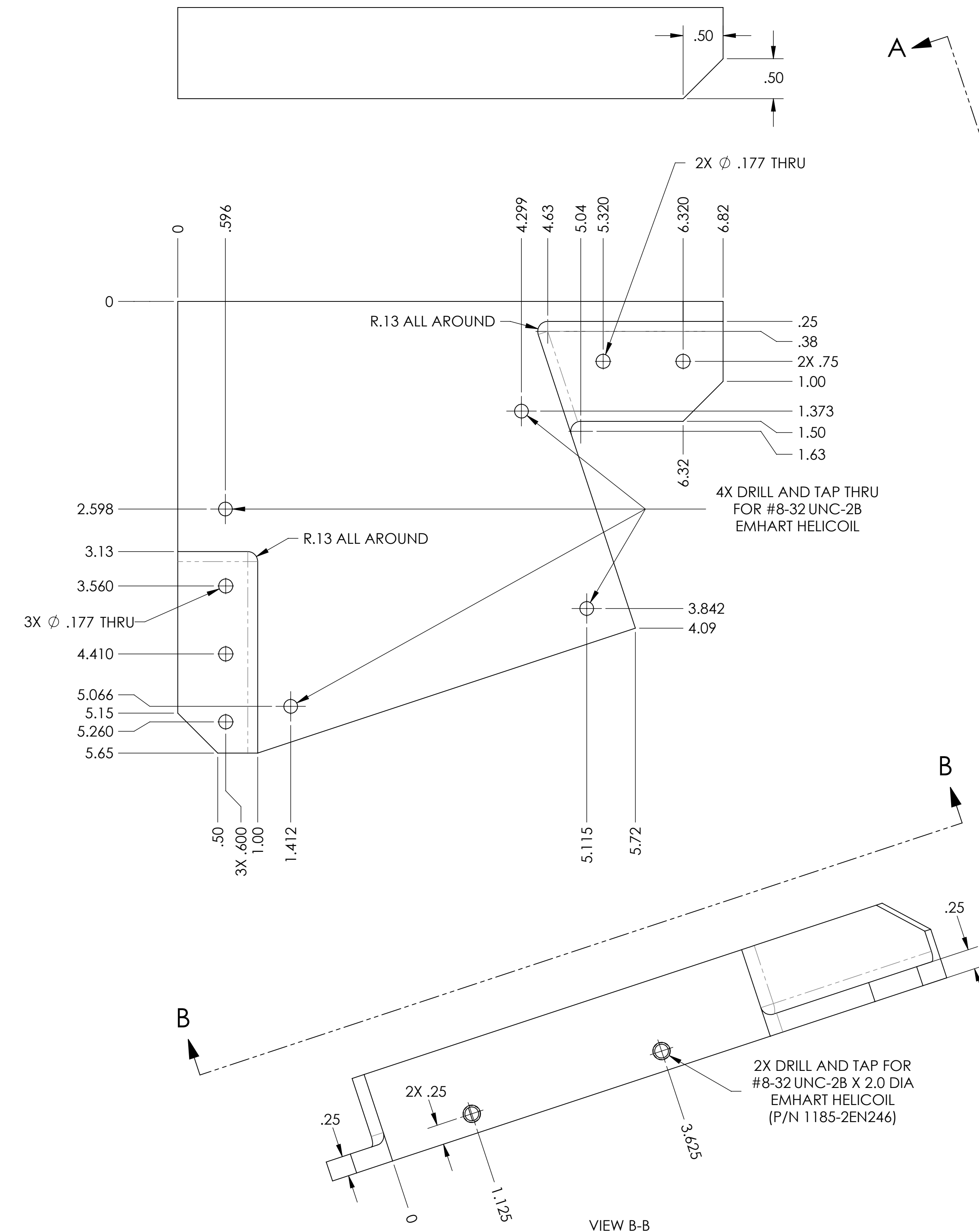
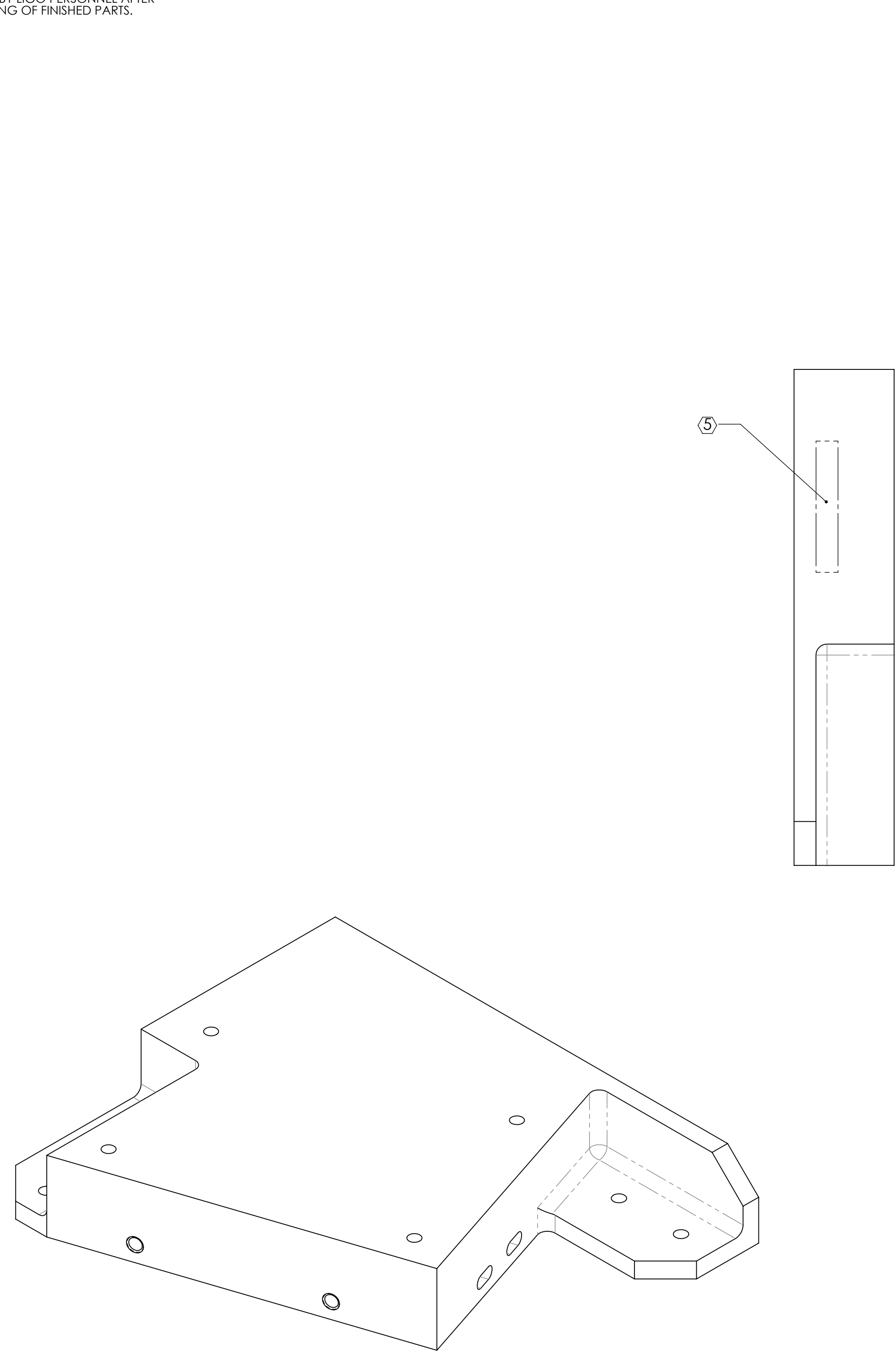
ISOMETRIC VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH
304 OR 304L SSSL	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		SIDE GUSSET	
SYSTEM	SUB-SYSTEM	DESIGNER	DATE	SIZE	DWG. NO.
ADVANCED LIGO	SUS	D. BRIDGES	29 AUG 2010	B	D070577
NEXT ASSY		DRAFTER	DATE	SCALE	PROJECTION
STRUCTURAL WELDMENT, HLTS		M. MEYER	30 AUG 2010	2:1	ASME
		CHECKER		SHEET 1 OF 1	
		APPROVAL			

- NOTES CONTINUED:**
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: DXXXXXX-VY, TYPE-XX, S/N XXX
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E0900066	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-

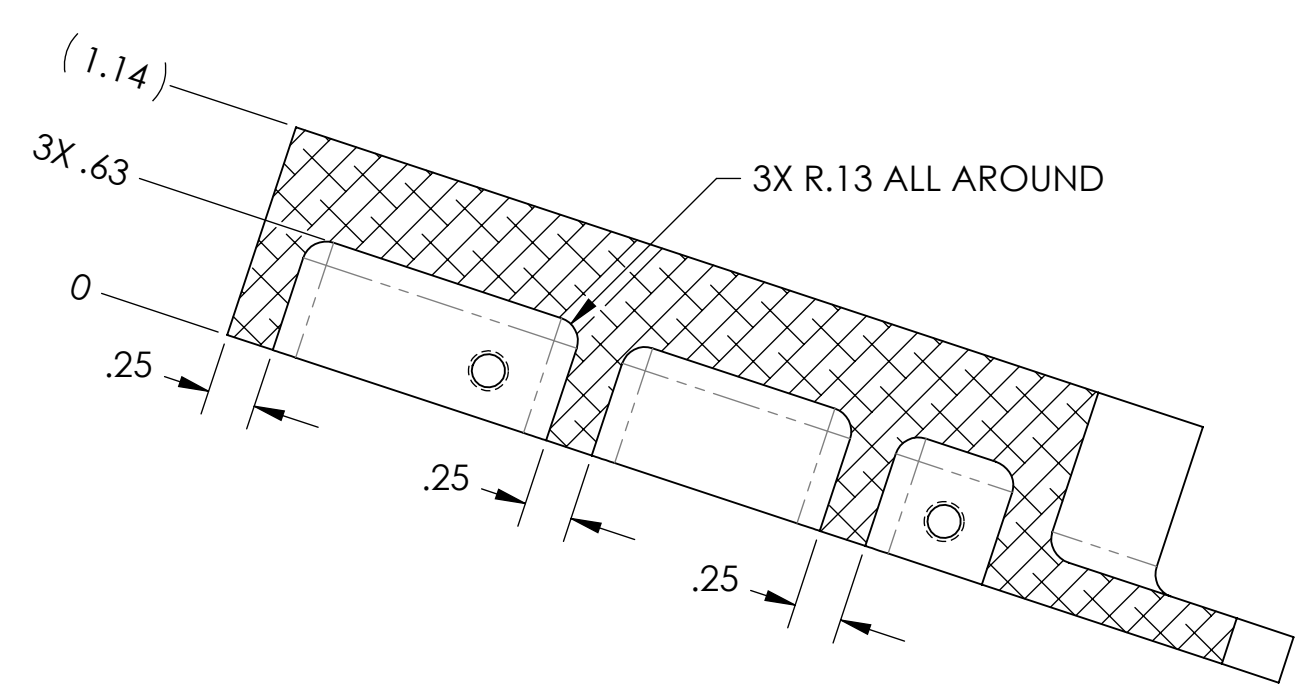
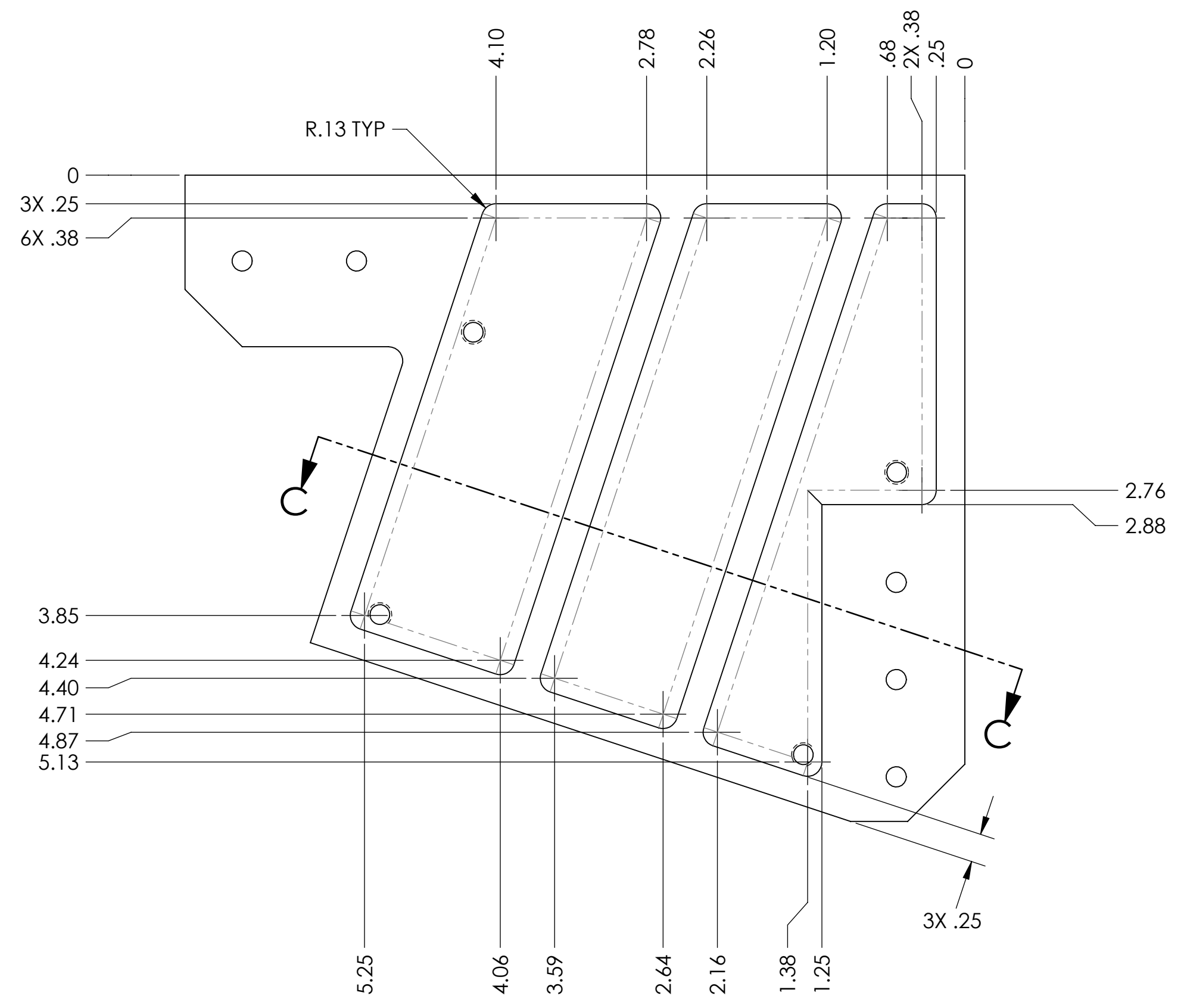


DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO SUB-SYSTEM SUS		MOUNTING PAD BODY	
ANGULAR ± 0.5°		MATERIAL 6061-T6 Al	FINISH 32 μinch	NEXT ASSY MOUNTING PAD ASSY		DESIGNER D. BRIDGES 27 AUG 2010	SIZE DWG. NO. D D070374
						DRAFTER D. BRIDGES 27 AUG 2010	REV. v2
						CHECKER M. MEYER 30 AUG 2010	
						APPROVAL	SCALE: 1:1 PROJECTION: SHEET 1 OF 2

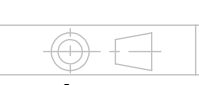
D070374-Advanced_LIGO_SUS_HITS_Mounting_Pad_Body_PART_PDM_REV-V1-001_DRAWING_PDM_REV-V1-003

8 7 6 5 4 3 2 1

H G F E D C B A



SECTION C-C

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D070374	v2
SCALE: 1:1	PROJECTION:  SHEET 2 OF 2

8 7 6 5 4 3 2 1

D070374_Advanced_LIGO_SUS_HIT3_Mounting_Pod_Body_PART_PDM_REV-V1-001_DRAWING_PDM_REV-V1-003