



TITLE PLATE CLEAN-UP PROCEDURE		IDENTIFICATION CUP-8X LIGO-E950047-02-B			
		REFERENCE NO. 930212		SHT 1 OF 1	
PRODUCT LIGO BEAM TUBE MODULES CALIFORNIA INSTITUTE OF TECHNOLOGY		OFFICE COH		REVISION 2	
		MADE BY RWP	CHKD BY BGG	MADE BY RWP	CHKD BY BGG
		DATE 2/18/94	DATE 3/1/94	DATE 4/18/94	DATE 4/18/94

1.0 SCOPE:

This procedure describes the methods of plate (forgings, pipe, etc.) clean-up. This includes removal of such things as:

- 1.1 Temporary attachments.
- 1.2 Usual handling marks such as clamp marks, fit-up marks, etc.
- 1.3 Arc strikes.

2.0 TEMPORARY ATTACHMENTS:

- 2.1 Remove temporary attachments.
- 2.2 Grind remaining weld smooth.
- 2.3 Small surface imperfections shall be welded per WPS-ER308L/REPAIR.
- 2.4 Visually inspect all areas.

3.0 HANDLING AND FIT-UP MARKS:

- 3.1 Weld per WPS-ER308L/REPAIR.
- 3.2 Visually inspect all areas.


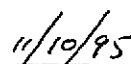

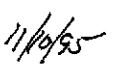
4.0 ARC STRIKES:

- 4.1 Grind smooth.
- 4.2 Small surface imperfections shall be welded per WPS-ER308L/REPAIR.
- 4.3 Visually inspect all areas.

5.0 DOCUMENTATION:

None required.

APPROVED

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