

FROM : Panasonic FAX SYSTEM

PHONE NO. :

Jun. 04. 1998 10:09AM P2

INITIATOR WKM

DATE 6/4/98

LIQO-E980617-0-D

ENGINEERING CHANGE REQUEST (ECR)

NEXT ASSEMBLY NO. D972-001

CUSTOMER DRAWING NO. D972118

DRAWING TITLE LIQO BSC CROSSBEAM WELDMENT

REVISION: FROM B TO C



HYTEC
INCORPORATED

DESCRIPTION OF CHANGE (Simple Phrase, Identify Dims If Possible):

CHANGE 8 OF THE EXISTING 12 HOLES IN TOP
OF CROSSBEAM. HOLES ARE Ø.375-.380,

CHANGE TO 1/2-13UNC-2B SEE SKETCH

Add the coating call out to be applied to all unpainted

REASONS FOR CHANGE: surfaces.

MOUNTING OF RAIL SYSTEM

IDENTIFY OTHER PARTS/GROUPS THAT INTERFACE WITH THE ABOVE (Required):

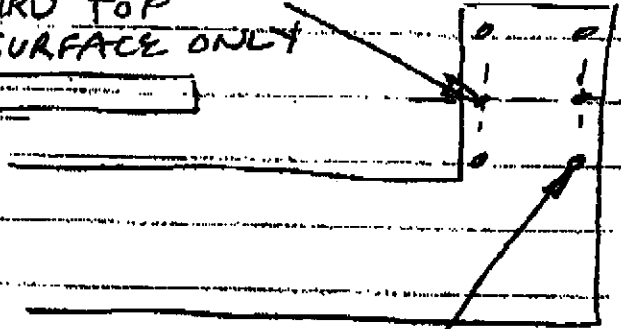
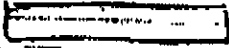
INTERFACE	RESPONSIBLE PARTY	INITIAL

NOTIFY COGNIZANT DESIGNER: William Miller / Fogel

NOTIFY COGNIZANT ENGINEER: _____

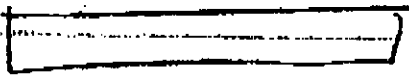
APPROVED: TW

(2X) $\phi .375-.380$
THRU TOP
SURFACE ONLY

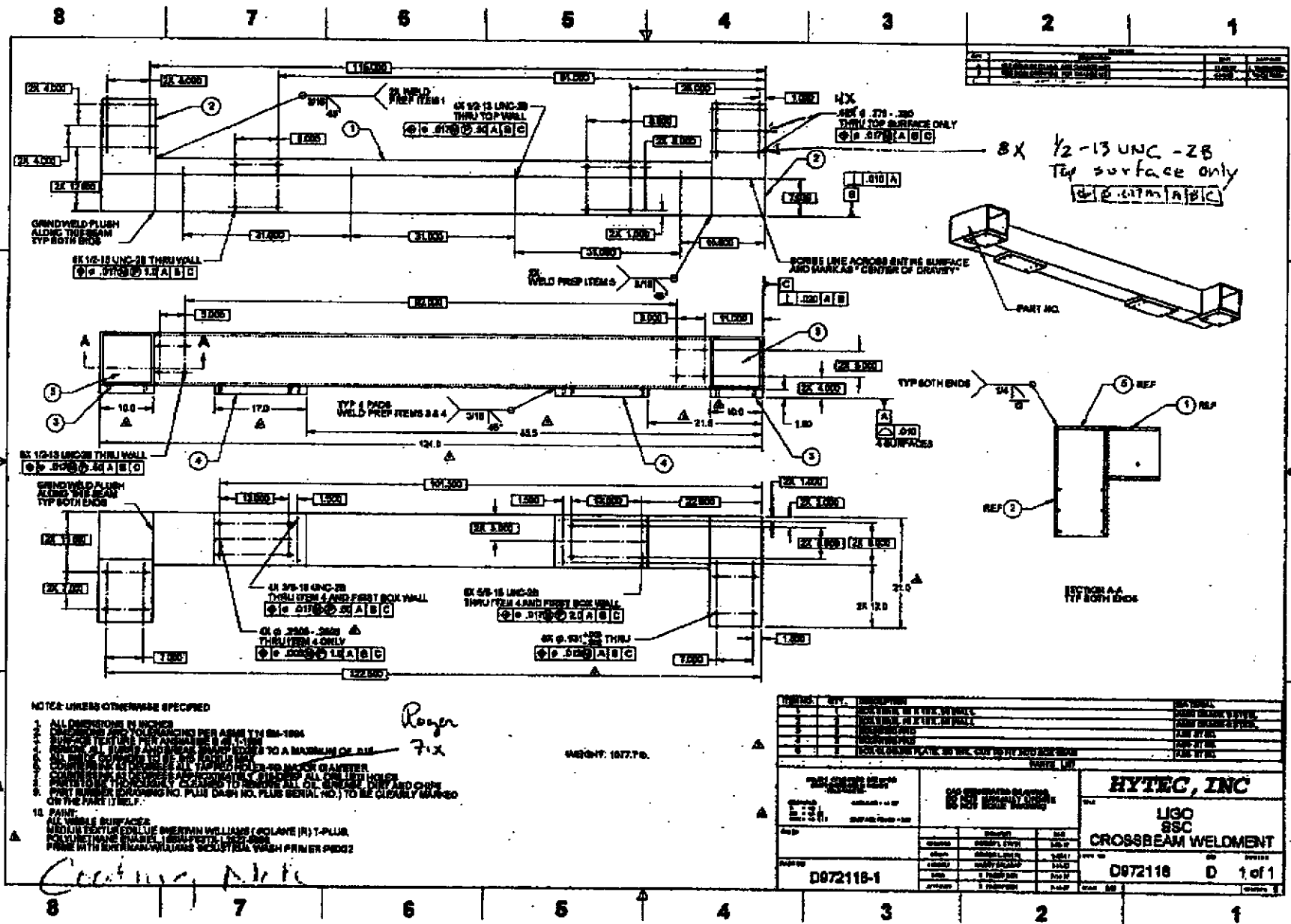


(8X)

$\frac{1}{2}$ -19UNC-2B
THRU TOP SURFACE ONLY



BOTH SIDES (ends)



NOTES: UNLESS OTHERWISE SPECIFIED

1. ALL DIMENSIONS IN INCHES
2. ALL DIMENSIONS TO CENTERLINE UNLESS OTHERWISE SPECIFIED
3. ALL DIMENSIONS TO CENTERLINE UNLESS OTHERWISE SPECIFIED
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18. ALL DIMENSIONS TO CENTERLINE UNLESS OTHERWISE SPECIFIED
19. ALL DIMENSIONS TO CENTERLINE UNLESS OTHERWISE SPECIFIED
20. ALL DIMENSIONS TO CENTERLINE UNLESS OTHERWISE SPECIFIED

*Roger
Fix*

WEIGHT: 107.7 LB.

Coating Note

ITEMS	QTY.	DESCRIPTION	REMARKS
1	1	CROSSBEAM WELDMENT	
2	1	WELD PREP	
3	1	GRIND WELD FLUSH	
4	1	WELD PREP	
5	1	GRIND WELD FLUSH	
6	1	WELD PREP	
7	1	GRIND WELD FLUSH	
8	1	WELD PREP	
9	1	GRIND WELD FLUSH	
10	1	WELD PREP	
11	1	GRIND WELD FLUSH	
12	1	WELD PREP	
13	1	GRIND WELD FLUSH	
14	1	WELD PREP	
15	1	GRIND WELD FLUSH	
16	1	WELD PREP	
17	1	GRIND WELD FLUSH	
18	1	WELD PREP	
19	1	GRIND WELD FLUSH	
20	1	WELD PREP	

HYTEC, INC.	
LIGO SSC CROSSBEAM WELDMENT	
D072118-1	D072118 0 1 of 1