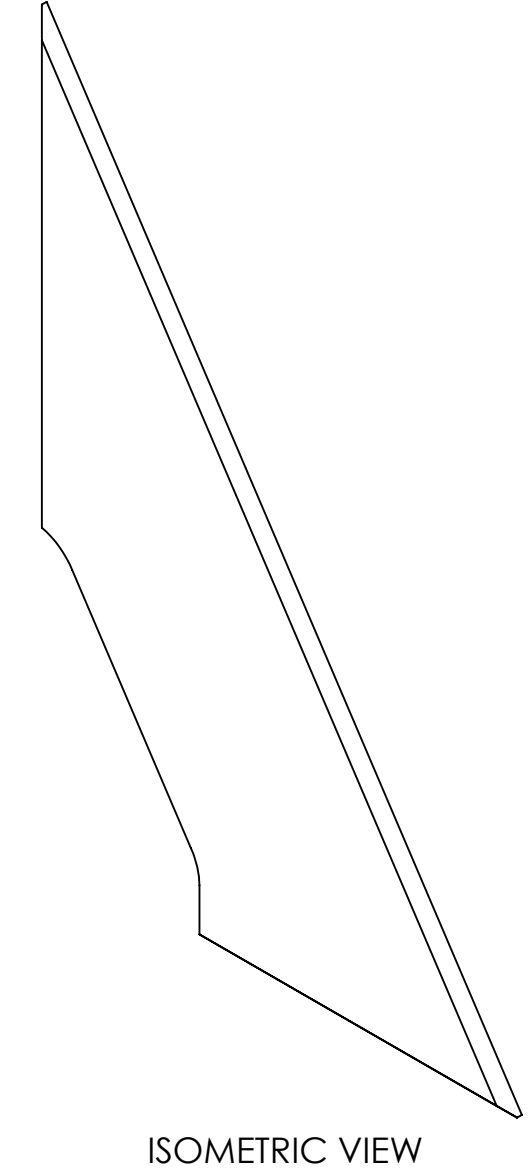
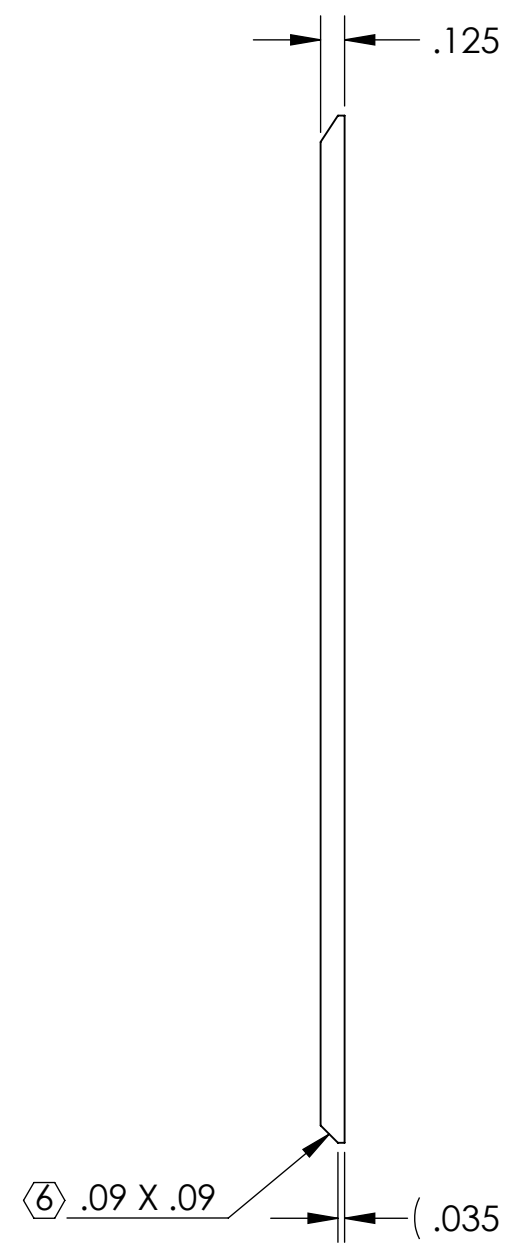
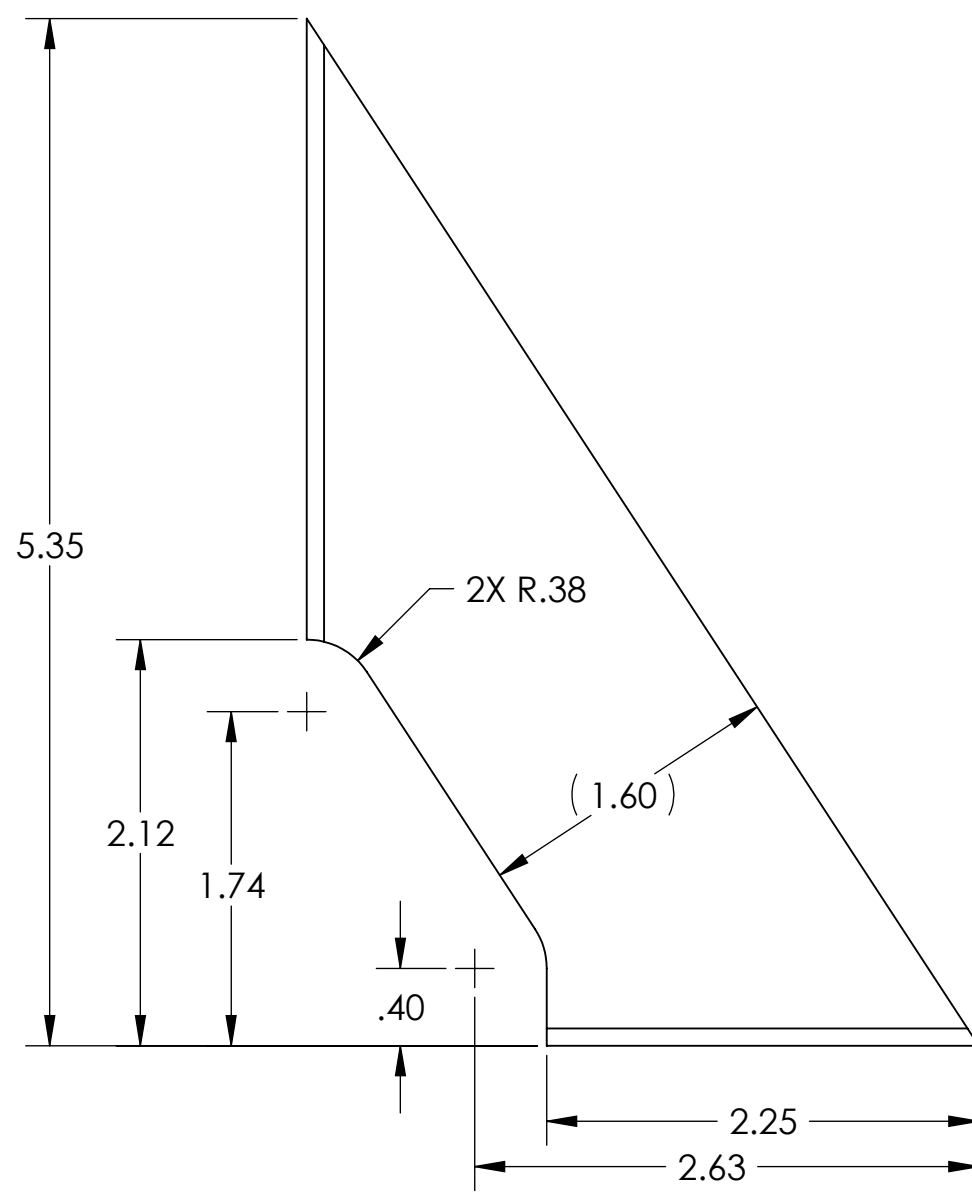
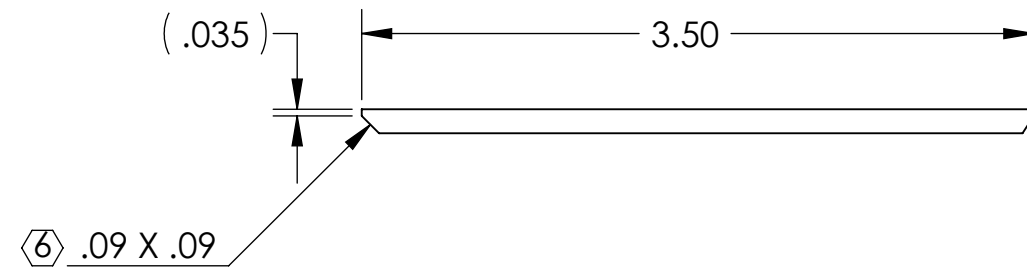


NOTES CONTINUED:

- 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
-	-	-	-



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