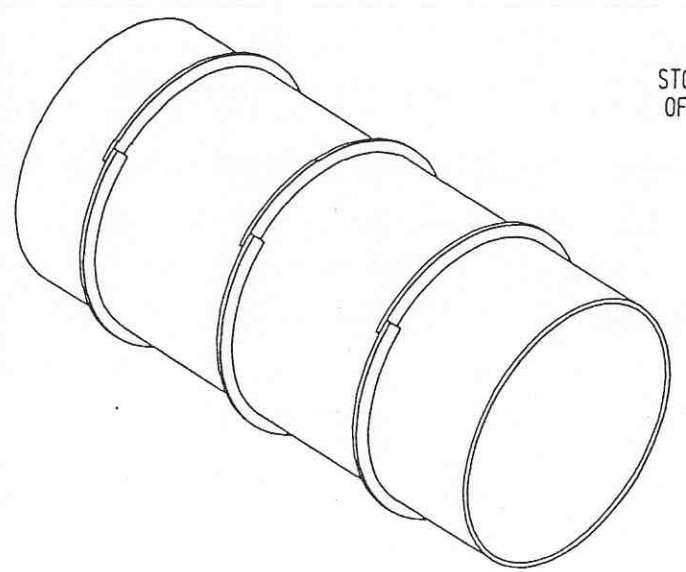
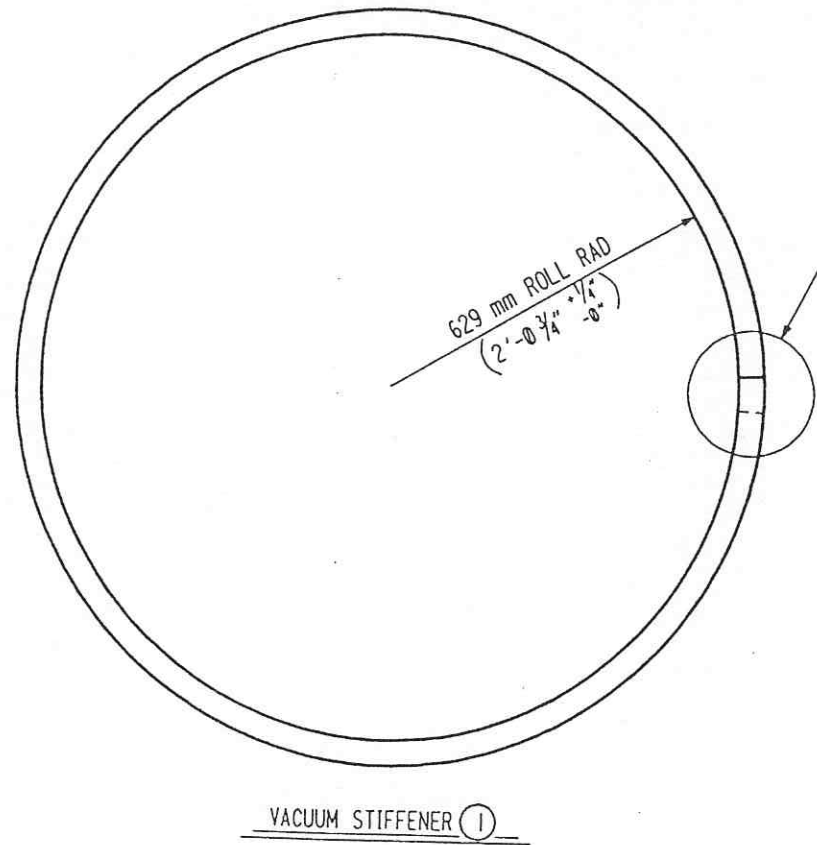
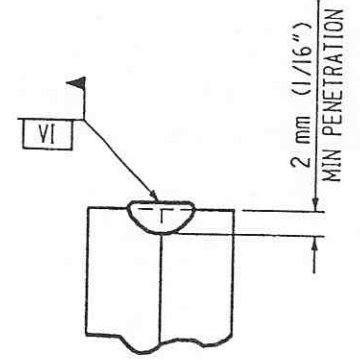
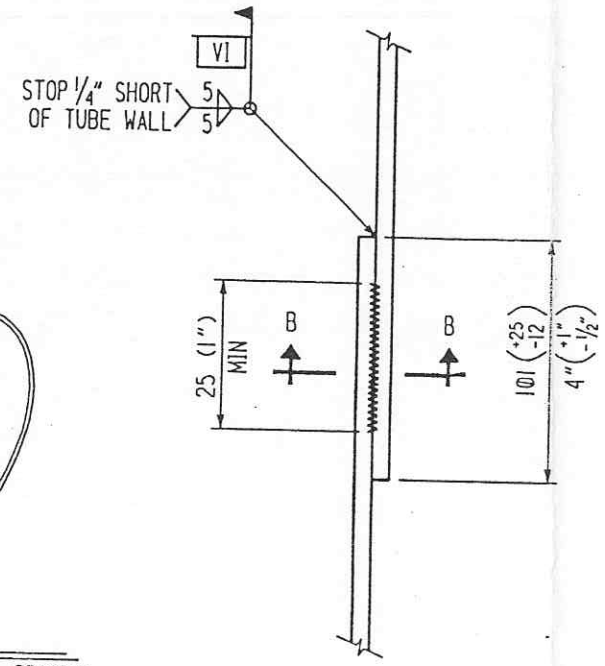


3212A015.DGN

Date Rec'd: 11/10/95	LIGO- D950040-02-B	Contractor: CBI	Approved: [Signature]
TIM#: 25	LIGO- C960675-00-V	Approved: [Signature]	
Date: 3/29/96	TDM: [Signature]	Approved: [Signature]	
Gen'l Transmittal	LIGO-	Approved:	
Date: / /			



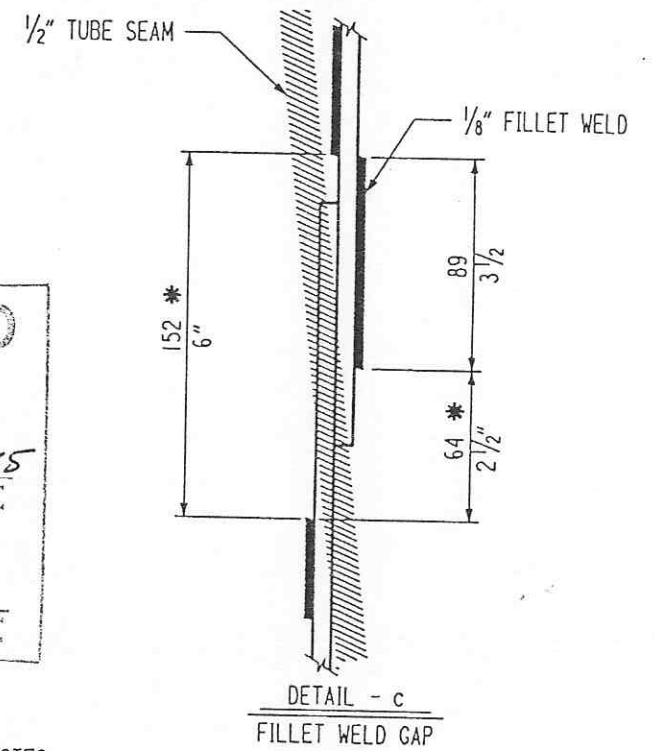
SEE SUB-MODULE DRAWINGS (# 2 & 3) FOR EXACT SPACING



**APPROVED**

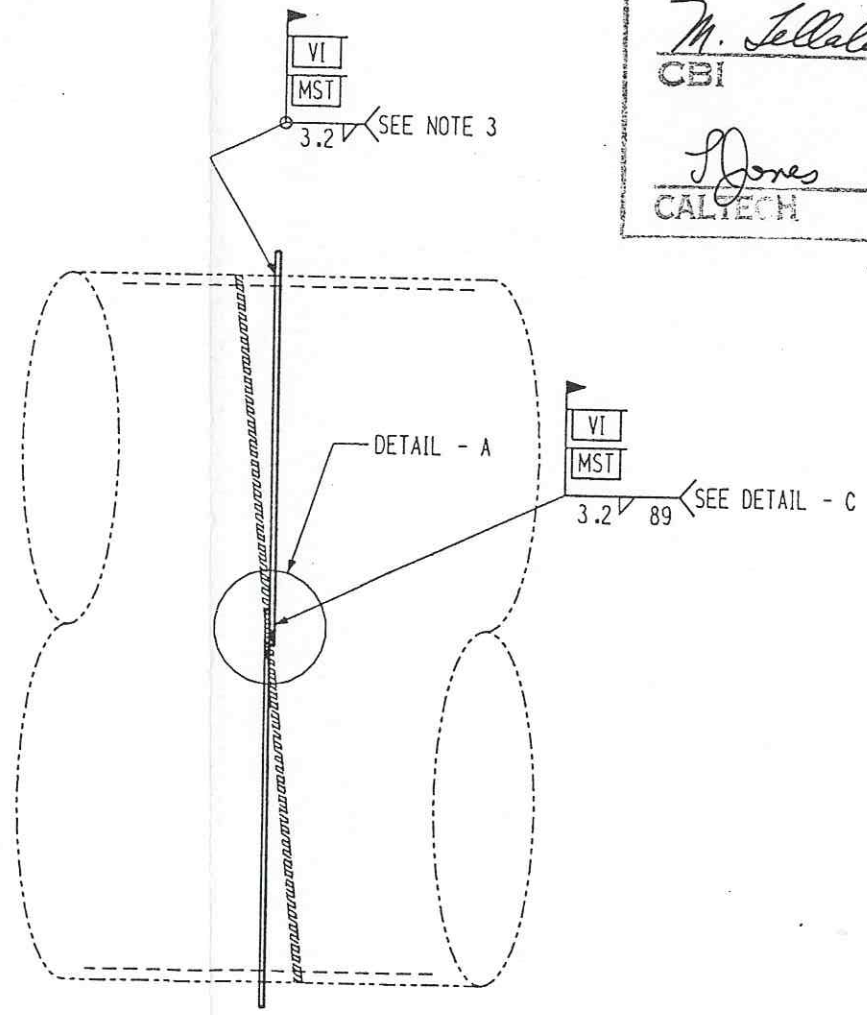
M. Jellalian 11/10/95  
CBI DATE

J. Jones 11/10/95  
CALTECH DATE



- NOTES:
1. STIFFENERS TO BE A SINGLE CONTINUOUS PIECE FORMED BY ROLLING 3/16" X 1 3/4" FLATS; ONLY THE ENDS OF THE STIFFENER TO BE CUT EDGES.
  2. STIFFENERS ARE TO BE INSTALLED BY EXPANDING OVER THE TUBE AND RELEASING INTO PLACE WITH A TIGHT FIT AROUND THE TUBE.
  3. DISCONTINUE FILLET WELD WHERE STIFFENER CROSSES TUBE SPIRAL WELD. SEE DETAIL - C.
  4. ALLOW EXTRA LENGTH FOR FORMING SO THAT THE ENDS OF THE STIFFENERS ARE ROLLED TO 622 (2'-0 1/2" +/- 1/4") RADIUS. STIFFENERS NOT FORMED AT ENDS MAY BE REJECTED.

\* UNWELDED AREA MAY BE DECREASE BY LOCATING SPLICE CAREFULLY WITH LAP ON RIGHT SIDE.



INDICATES CHANGE FROM PREVIOUS ISSUE

SHP PC	MARK	ASSM PC	DESCRIPTION	LENGTH MM	SPEC
			VACUUM STIFFENERS		
1974	15-1		BAR 44 x 5 ROLL	4172	M3
			(1 3/4 x 3/16 x 13'-8 1/4)		
			M3 = MAT'L SPEC C-VAC-1		
			(SA240 TP 304L)		

CBI		SUPPLIER'S / PURCHASER'S NO	
VACUUM STIFFENER			
LIGO BEAM TUBE HANFORD, WA & LIVINGSTON, LA			
CUSTOMER'S NO		CONTRACT NO	
BY KJR CHKD DATE		930212	
D.E. Thom		DWC IS	
ENGINEERING ASSIGNED		SHT	
LIGO-D950040-02-B		REV 2	