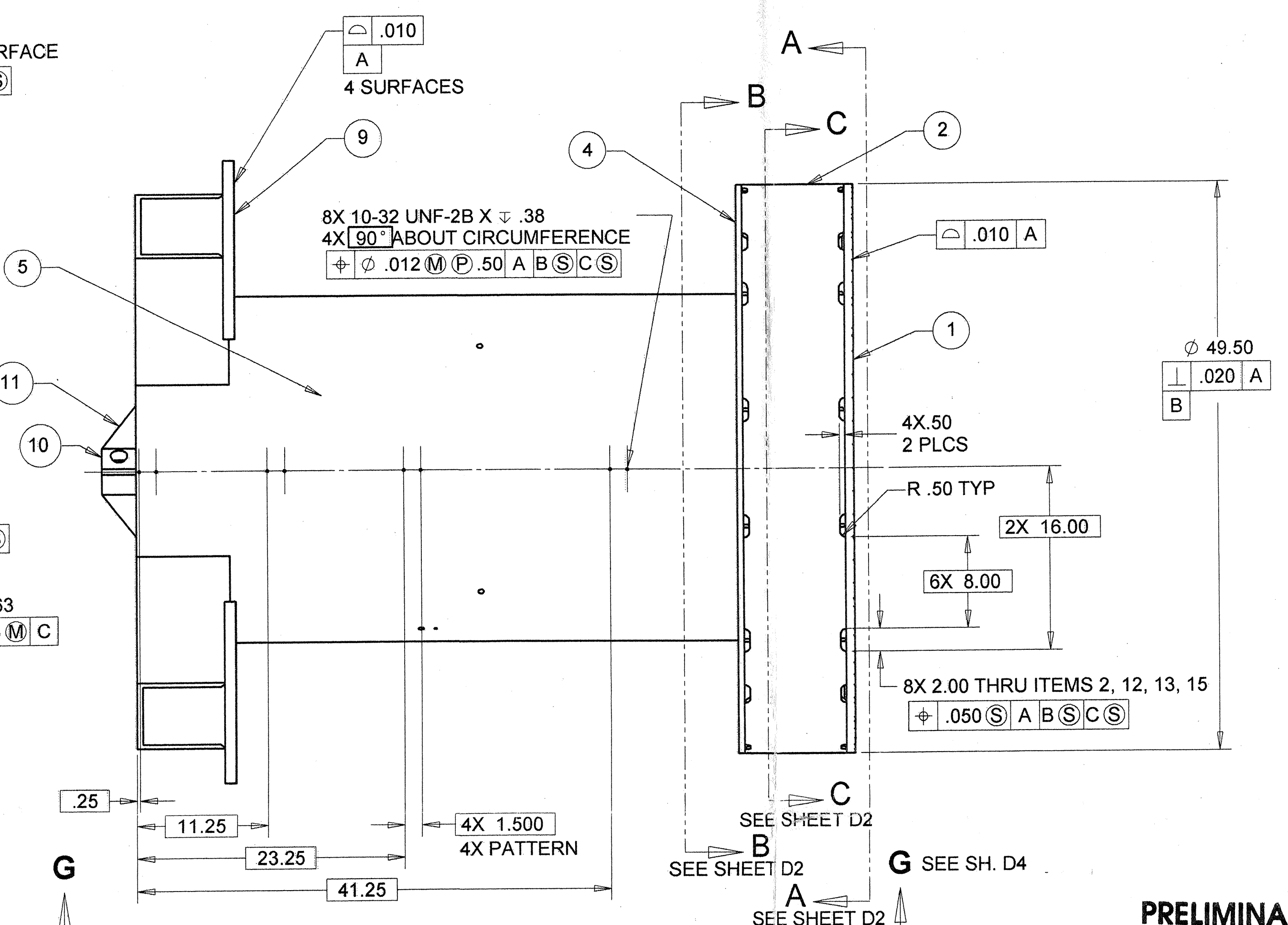
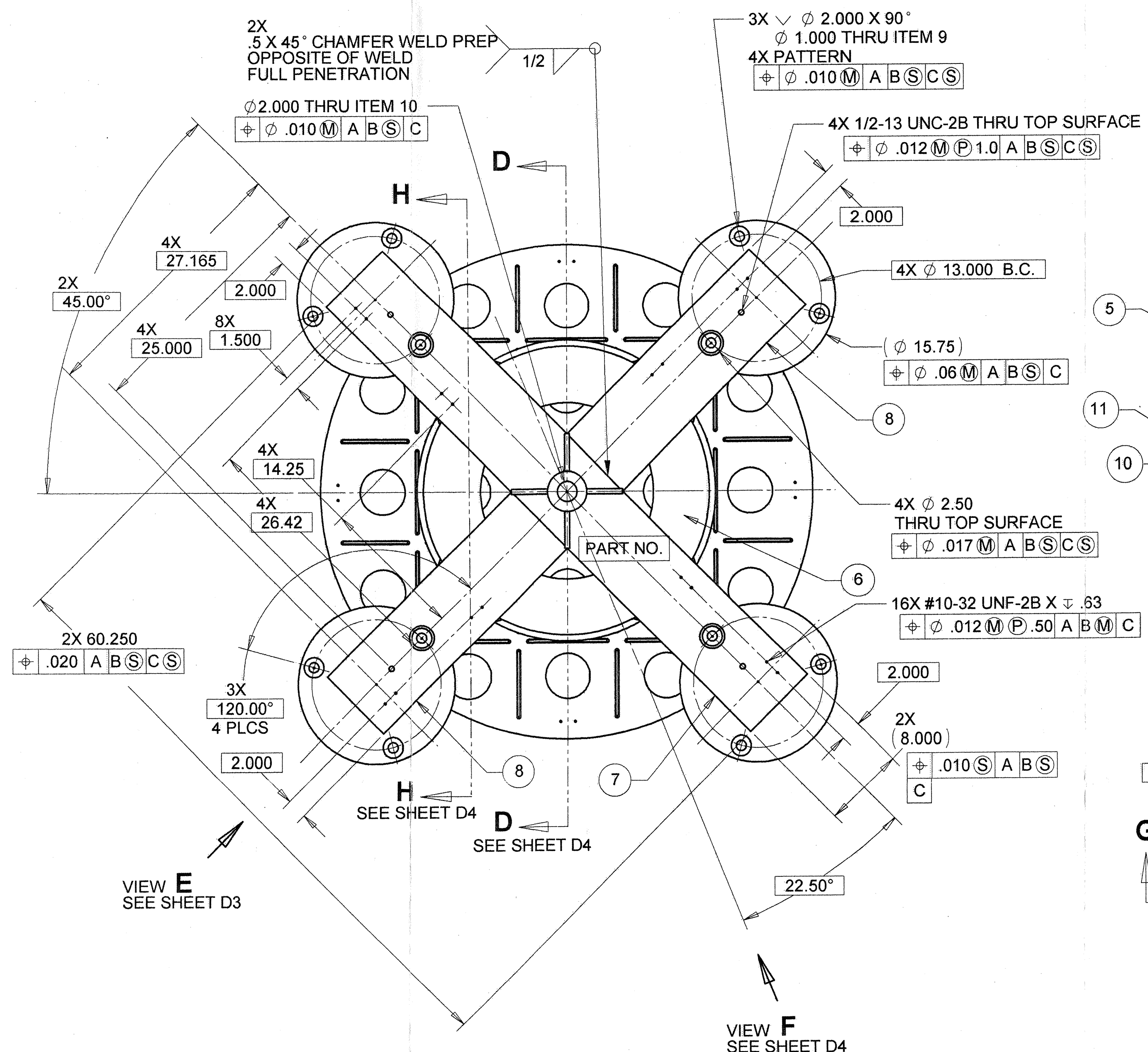


8 7 6 5 4 3 2 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION: LIGO-TS-03 CATEGORY 1.
- ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN WELDING ELECTRODES AND ER4043 WELDING ROD (SPEC. PER AWS A5.10-80).
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: ALUMICUT, MISTIC METAL MOVER, PRINCETON, IL.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	LOWER PLATE	ALUM. 6061-T651
2	1	OUTER RING, 49.50 OD X .25 WALL X 9.25 WIDE	ALUM. 6061-T651
3	2	INTERNAL GUSSET, 1/4 THK X (48.00 LG.) X 9.25 WIDE	ALUM. 6061-T651
4	1	UPPER PLATE, .50 THK	ALUM. 6061-T651
5	1	DOWNTUBE, 30.00 OD X .625 WALL X (51.628 LG.)	ALUM. 6061-T651
6	2	DOWNTUBE STIFFENER, .75 THK PLT	ALUM. 6061-T651
7	1	LONG BOXBEAM, 8.00 X 8.00 X .50 WALL	ALUM. 6061-T651
8	2	SHORT BOXBEAM, 8.00 X 8.00 X .50 WALL	ALUM. 6061-T651
9	4	LEG PADS, (1.00 THK) X 15.75 DIAM. PLT	ALUM. 6061-T651
10	1	LIFTING CENTER, 4.00 DIAM. X 11.25 LG	ALUM. 6061-T651
11	4	LIFTING CENTER GUSSET, .50 THK PLT	ALUM. 6061-T651
12	12	INTERNAL GUSSET, 1/4 THK X (9.75 LG.) X 9.25 WIDE	ALUM. 6061-T651
13	4	INTERNAL GUSSET, 1/4 THK X (4.30 LG.) X 9.25 WIDE	ALUM. 6061-T651
14	2	INTERNAL GUSSET, 1/4 THK X (38.84 LG.) X 9.25 WIDE	ALUM. 6061-T651
15	4	INTERNAL GUSSET, 1/4 THK X (8.87 LG.) X 9.25 WIDE	ALUM. 6061-T651

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES:		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC TITLE LIGO BSC DOWNTUBE WELDMENT	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	SIGNATURE			
FINISH ALL MACHINED SURFACES 32 RMS	DESIGNED ROGER L. SMITH	DATE 5-28-97	DWG. NO. D972211 SIZE SHEET NO. D 1 of 4 SCALE 1/8 REVISION		
PART NO. D9722211-1	CHECKED HARRY SALAZAR	DATE 6-6-97			
	ENGR. T. THOMPSON	DATE 7-10-97			
	APPROVED T. THOMPSON	DATE 7-10-97			

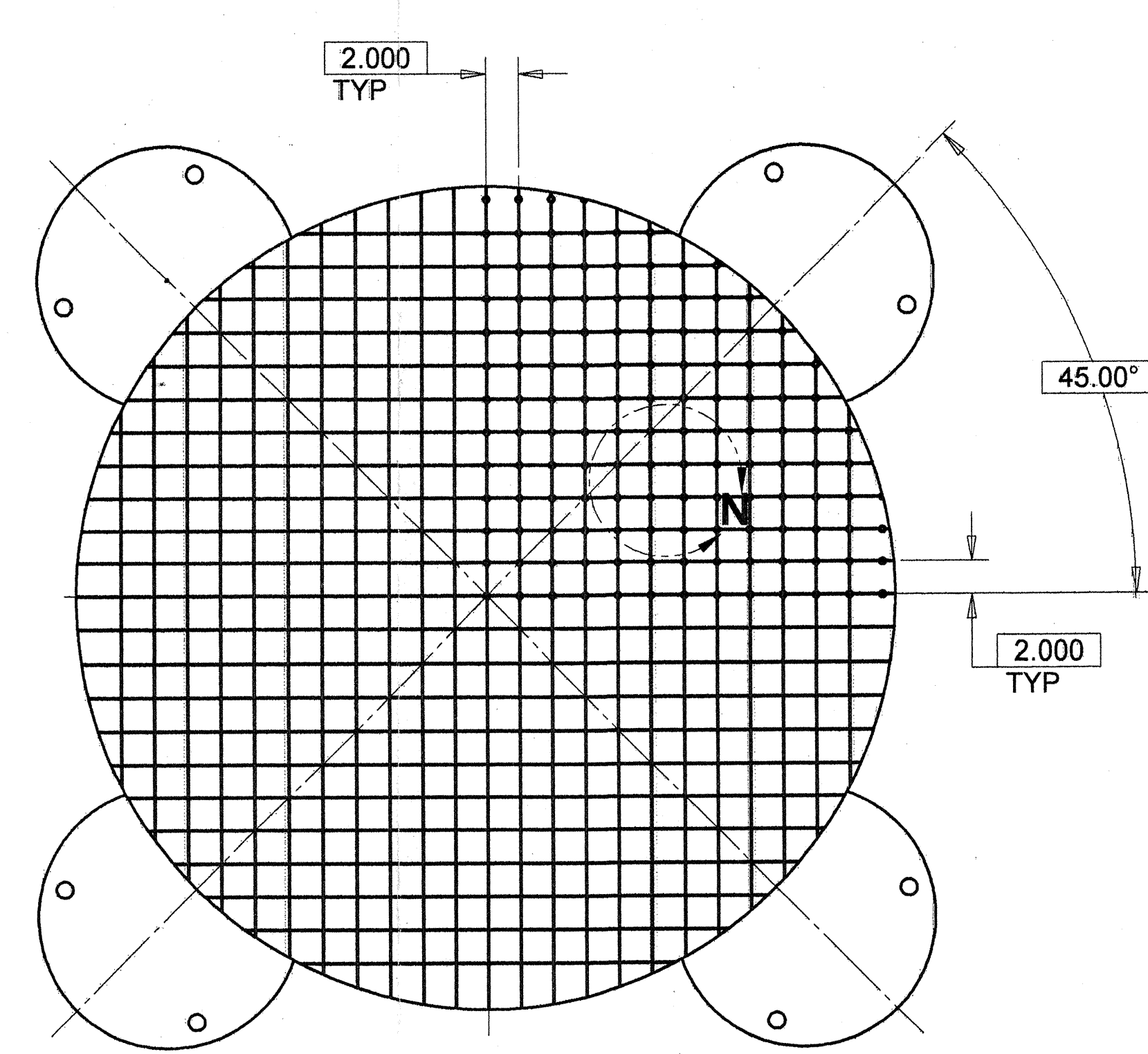
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8 7 6 5 4 3 2 1

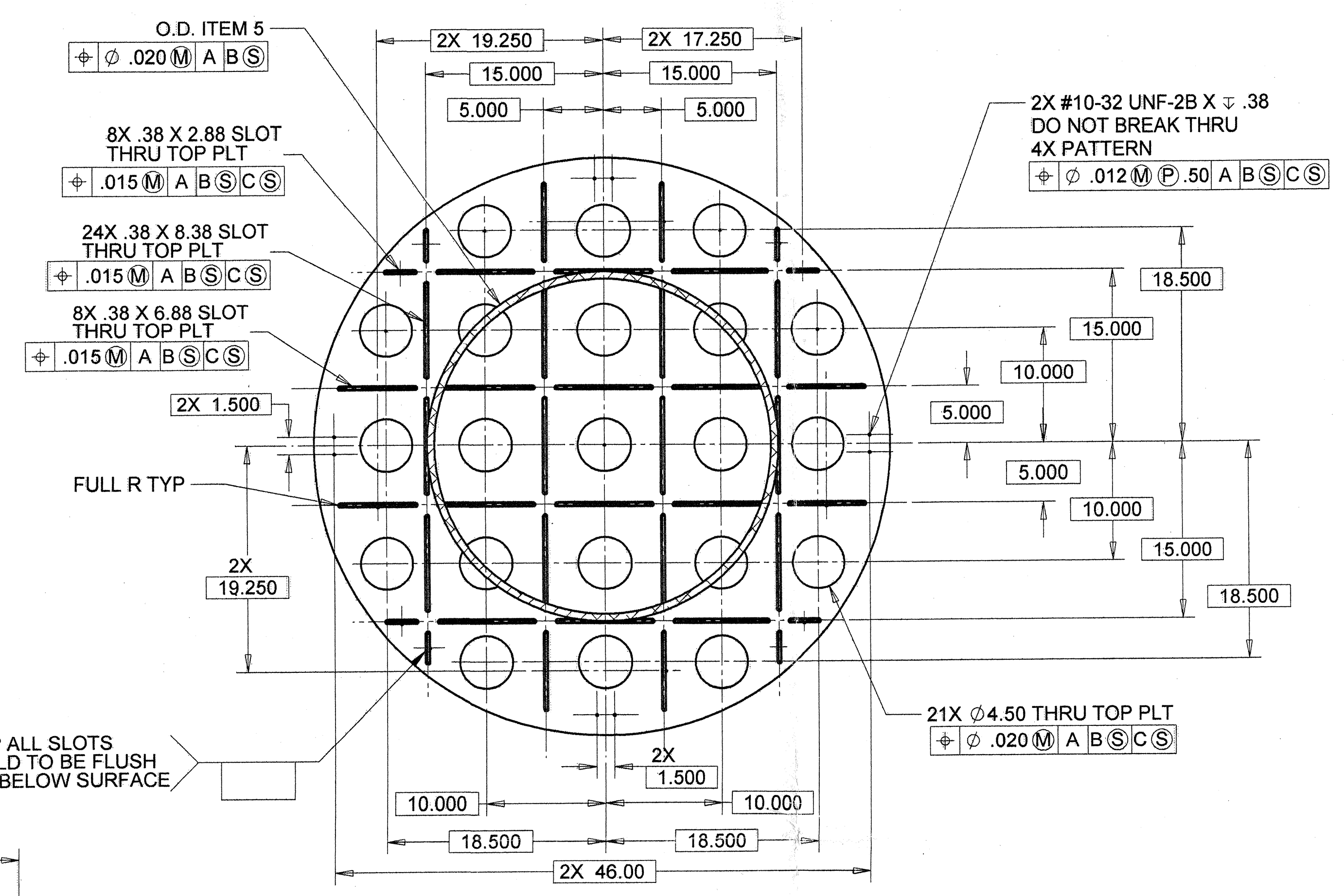
REV.	DESCRIPTION	DATE	APPROVED

D
C
B
A

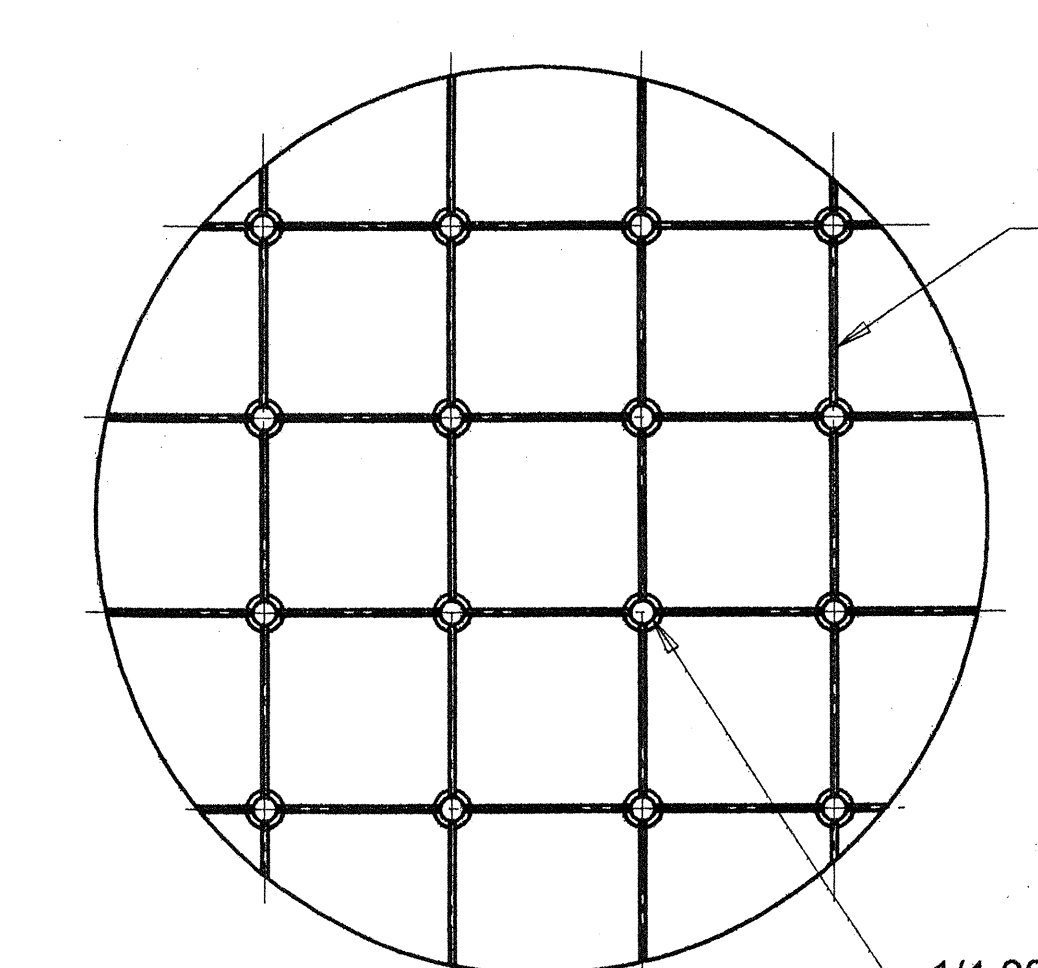
D
C
B
A



VIEW A-A FROM SHEET D1

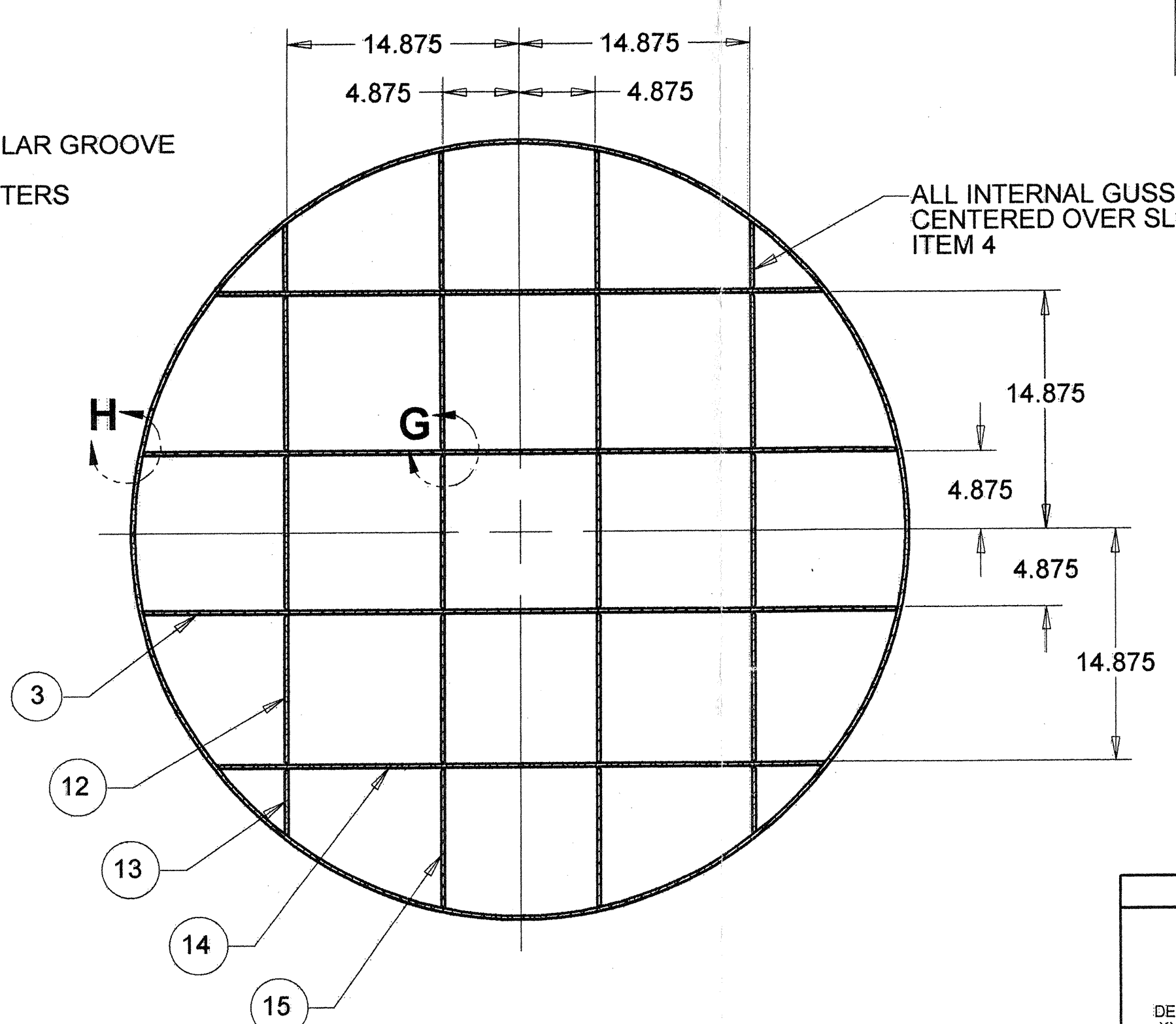


SECTION B-B FROM SHEET D1

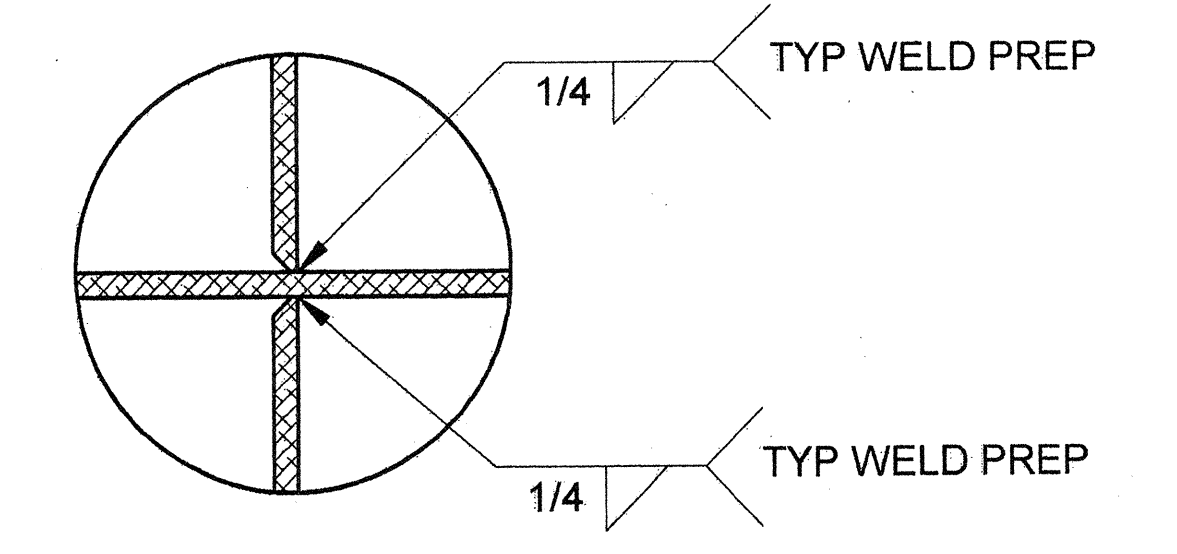


DETAIL N SCALE 1:2

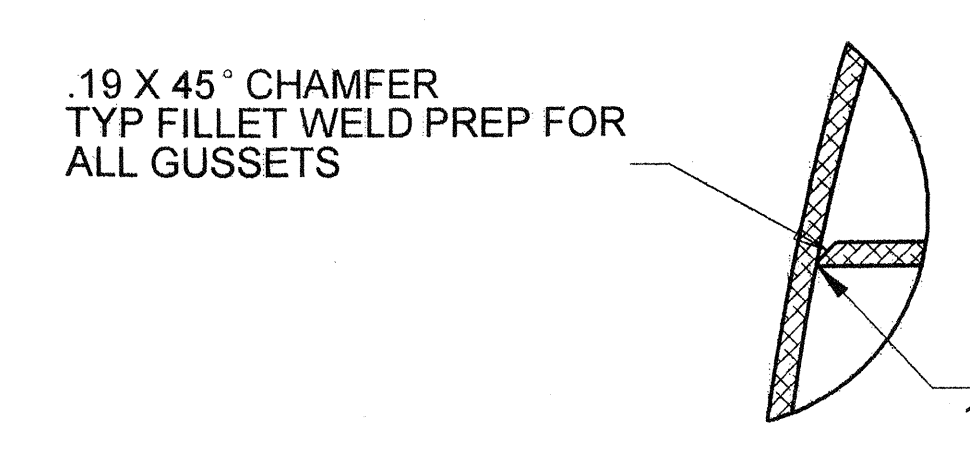
1/4-20 UNC-2B X .50 DO NOT BREAK THRU
 √ Ø .390 X 82°
 2.000 X 2.000 HOLE PATTERN FILLS THE ENTIRE SURFACE
 HOLES TO BE NO CLOSER THAN .50 TO OUTER SURFACE
 Ø .012 M P .50 A B S C S



SECTION C-C FROM SHEET D1



DETAIL G SCALE 1:2
 TYP FOR ALL GUSSET INTERSECTIONS



DETAIL H SCALE 1:2

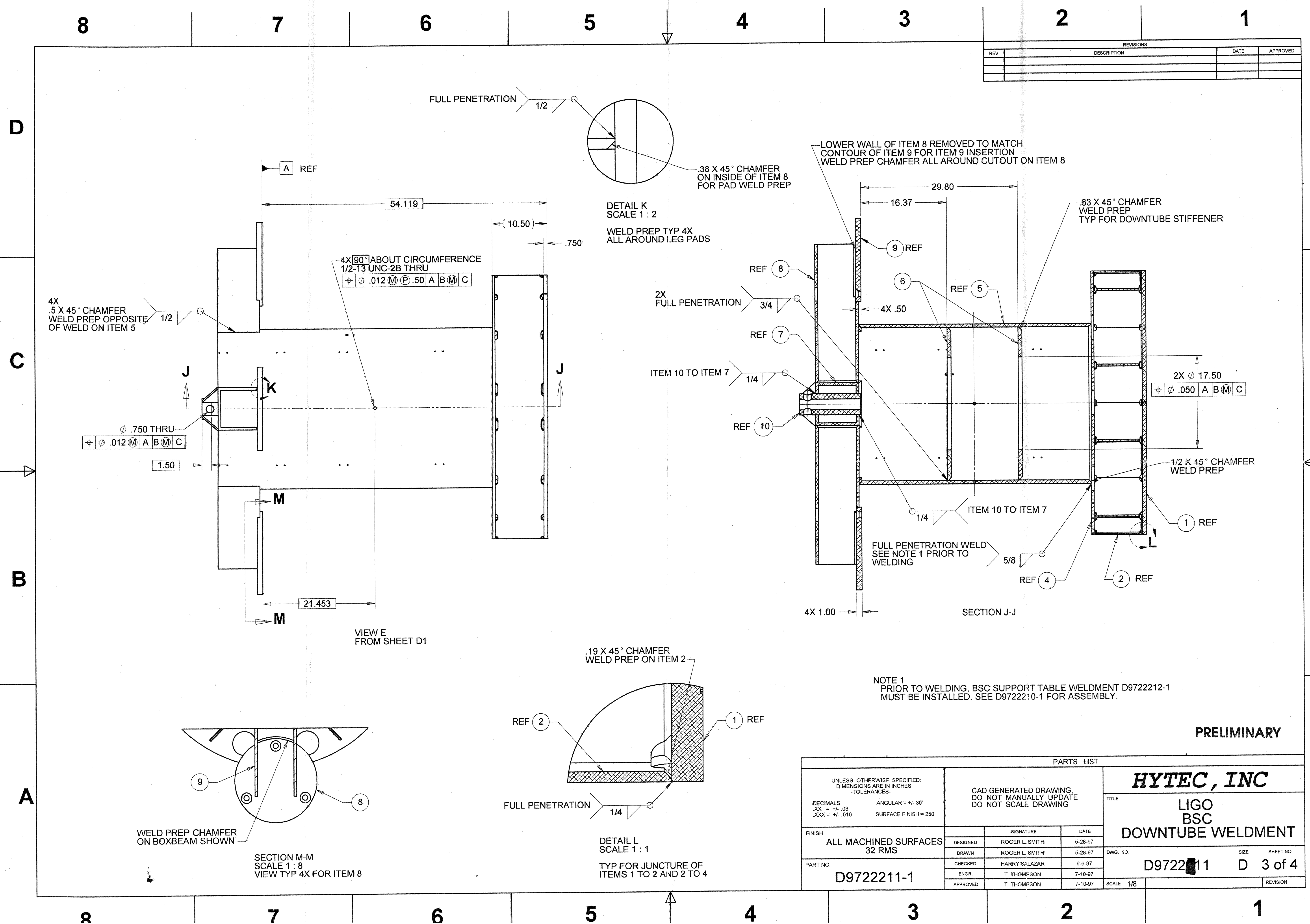
TYP FILLET WELD OPPOSITE OF WELD PREP FULL PENETRATION

PRELIMINARY

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		SIGNATURE		DATE	HYTEC, INC	
DECIMALS	ANGULAR = +/- .30°	DESIGNED	ROGER L. SMITH	5-28-97	TITLE	
XX = +/- .03	SURFACE FINISH = 250	DRAWN	ROGER L. SMITH	5-28-97	LIGO BSC DOWNTUBE WELDMENT	
XXX = +/- .010		CHECKED	HARRY SALAZAR	6-6-97	DWG. NO.	D972211-1
		ENGR.	T. THOMPSON	7-10-97	SIZE	D 2 of 4
		APPROVED	T. THOMPSON	7-10-97	SCALE	1/8
FINISH	ALL MACHINED SURFACES 32 RMS	PARTS LIST				
PART NO.	D9722211-1	CAD GENERATED DRAWING. DO NOT MANUALLY UPDATE. DO NOT SCALE DRAWING.				

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REVISIONS		
REV.	DESCRIPTION	DATE

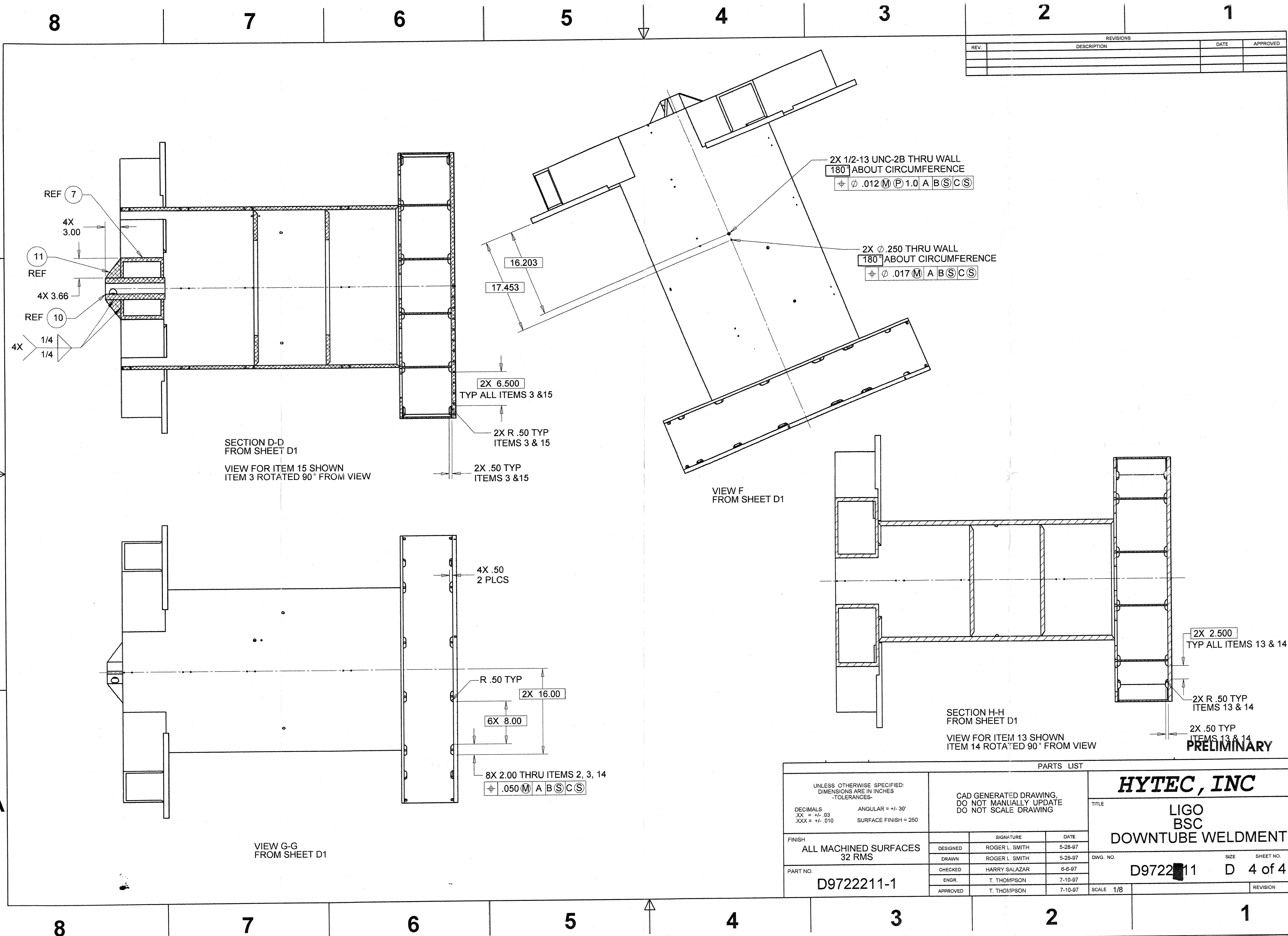


NOTE 1
 PRIOR TO WELDING, BSC SUPPORT TABLE WELDMENT D972212-1
 MUST BE INSTALLED. SEE D972210-1 FOR ASSEMBLY.

PRELIMINARY

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING. DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	SIGNATURE	DATE
FINISH ALL MACHINED SURFACES 32 RMS	DESIGNED ROGER L. SMITH	ROGER L. SMITH	5-28-97
PART NO. D9722211-1	DRAWN ROGER L. SMITH	HARRY SALAZAR	5-28-97
	CHECKED HARRY SALAZAR	T. THOMPSON	8-6-97
	ENGR. T. THOMPSON	T. THOMPSON	7-10-97
APPROVED T. THOMPSON	T. THOMPSON	7-10-97	SCALE 1/8
TITLE HYTEC, INC LIGO BSC DOWNTUBE WELDMENT		DWG. NO. D972211	SIZE SHEET NO. D 3 of 4

REV.	DESCRIPTION	DATE	APPROVED



PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	SIGNATURE	DATE
FINISH ALL MACHINED SURFACES 32 RMS	DESIGNED ROGER L. SMITH	ROGER L. SMITH	5-28-97
PART NO. D9722211-1	DRAWN HARRY SALAZAR	HARRY SALAZAR	6-6-97
	CHECKED T. THOMPSON	T. THOMPSON	7-10-97
	APPROVED T. THOMPSON	T. THOMPSON	7-10-97
TITLE HYTEC, INC LIGO BSC DOWNTUBE WELDMENT		DWG. NO. D9722211	SIZE SHEET NO. D 4 of 4
SCALE 1/8		REVISION	