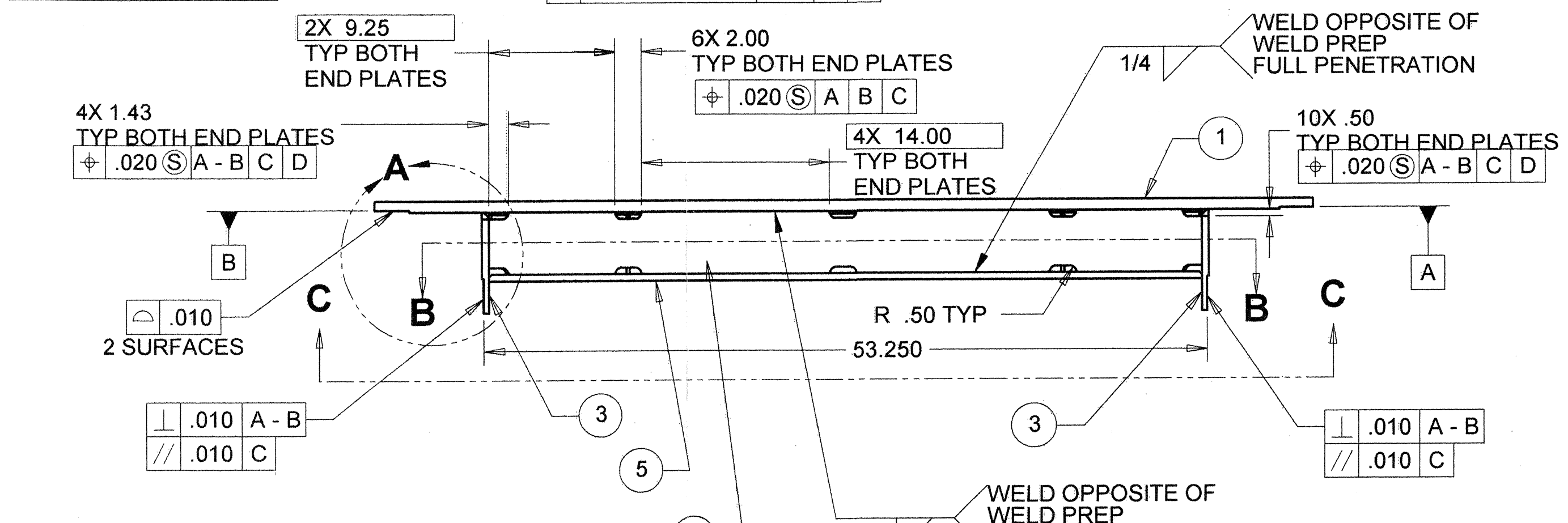
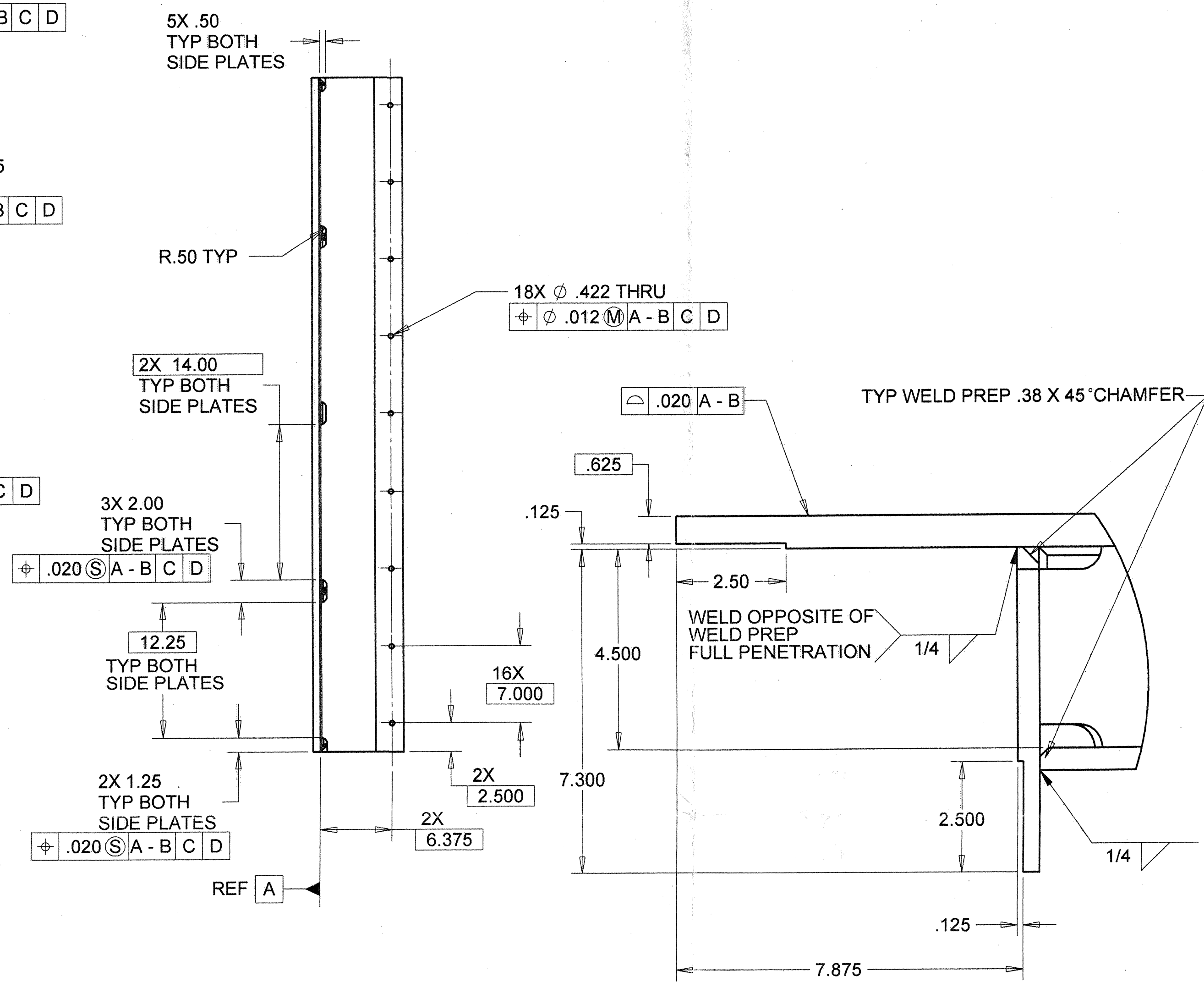
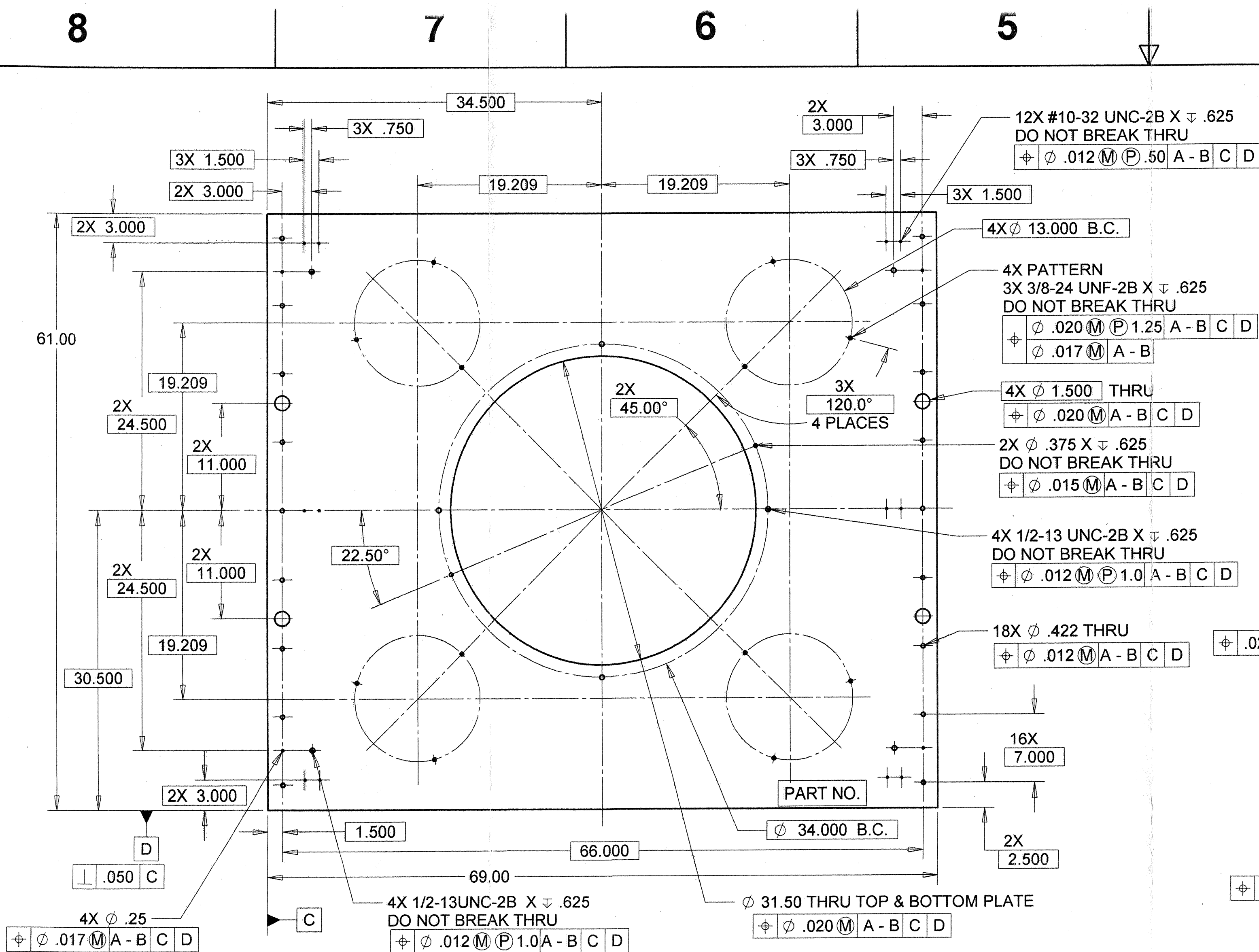


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



NOTES: UNLESS OTHERWISE SPECIFIED

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

SEE SHEET D2 FOR SECTIONS B & C

PRELIMINARY

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	TOP PLATE	ALUM. 6061-T651
2	2	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651
3	2	SIDE PLATE, .50 THK	ALUM. 6061-T651
4	2	END PLATE, .50 THK	ALUM. 6061-T651
5	1	BOTTOM PLATE, .50 THK	ALUM. 6061-T651
6	2	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651
7	4	INTERNAL GUSSET, .25 THK	ALUM. 6061-T651

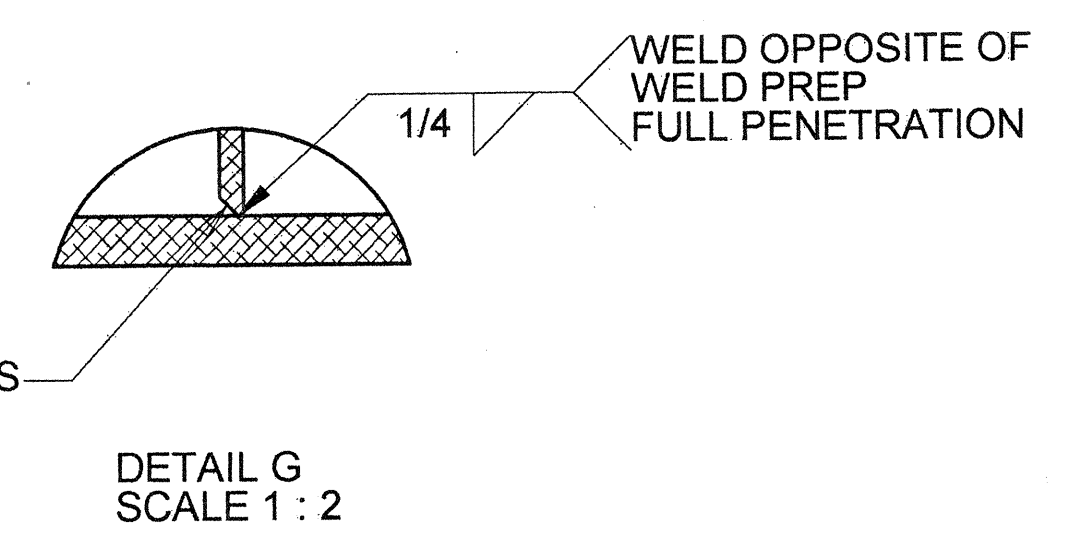
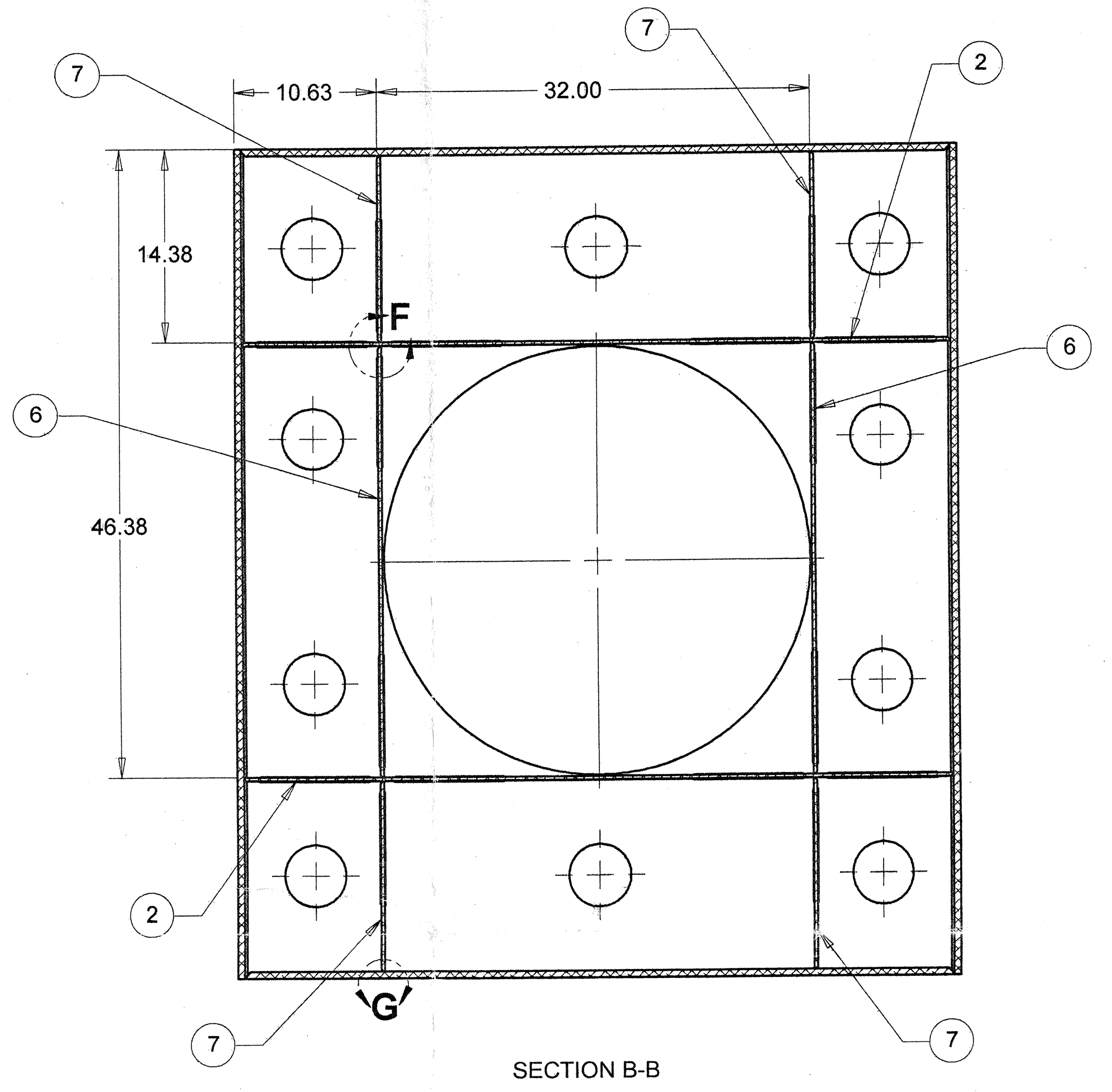
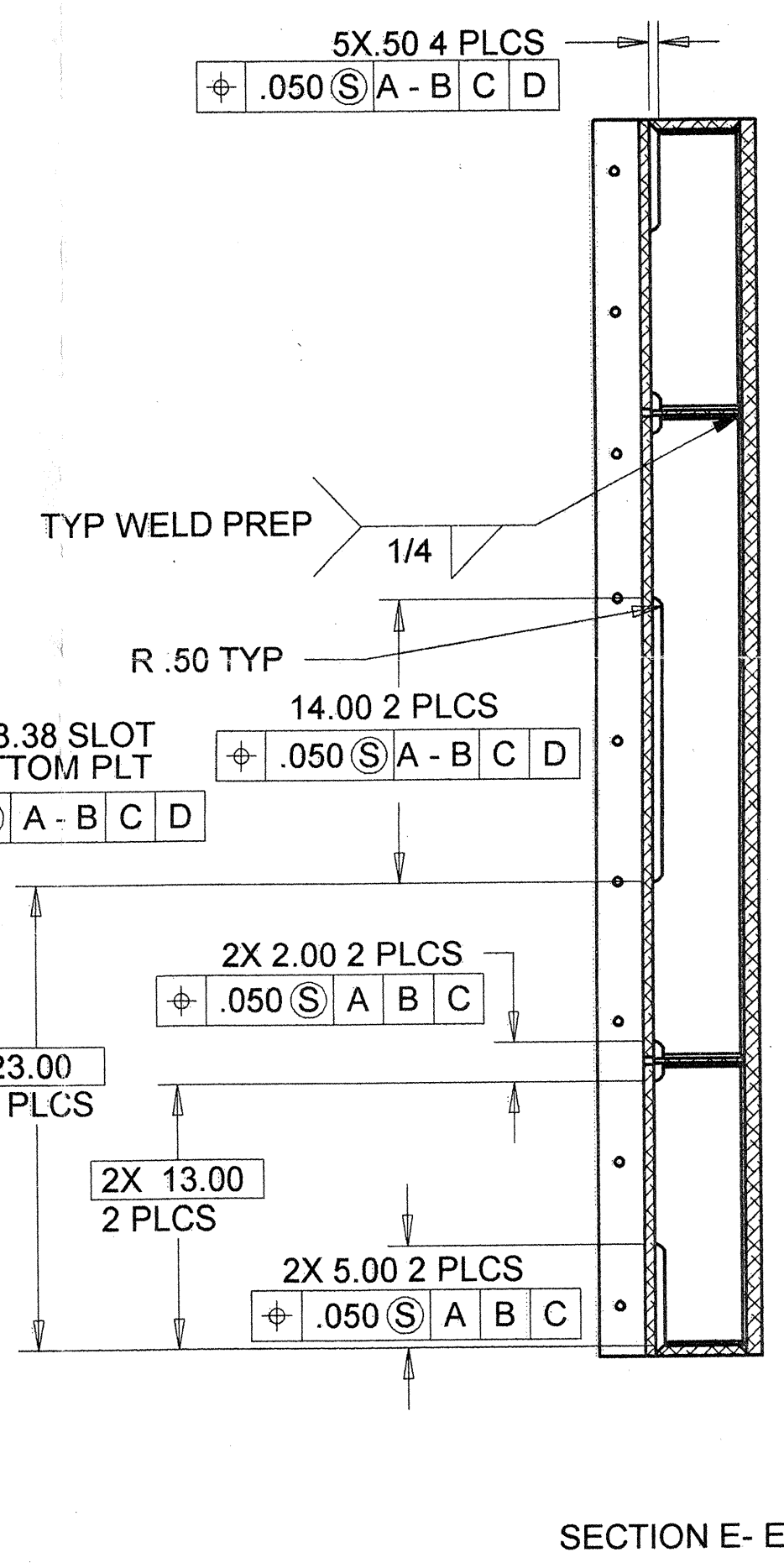
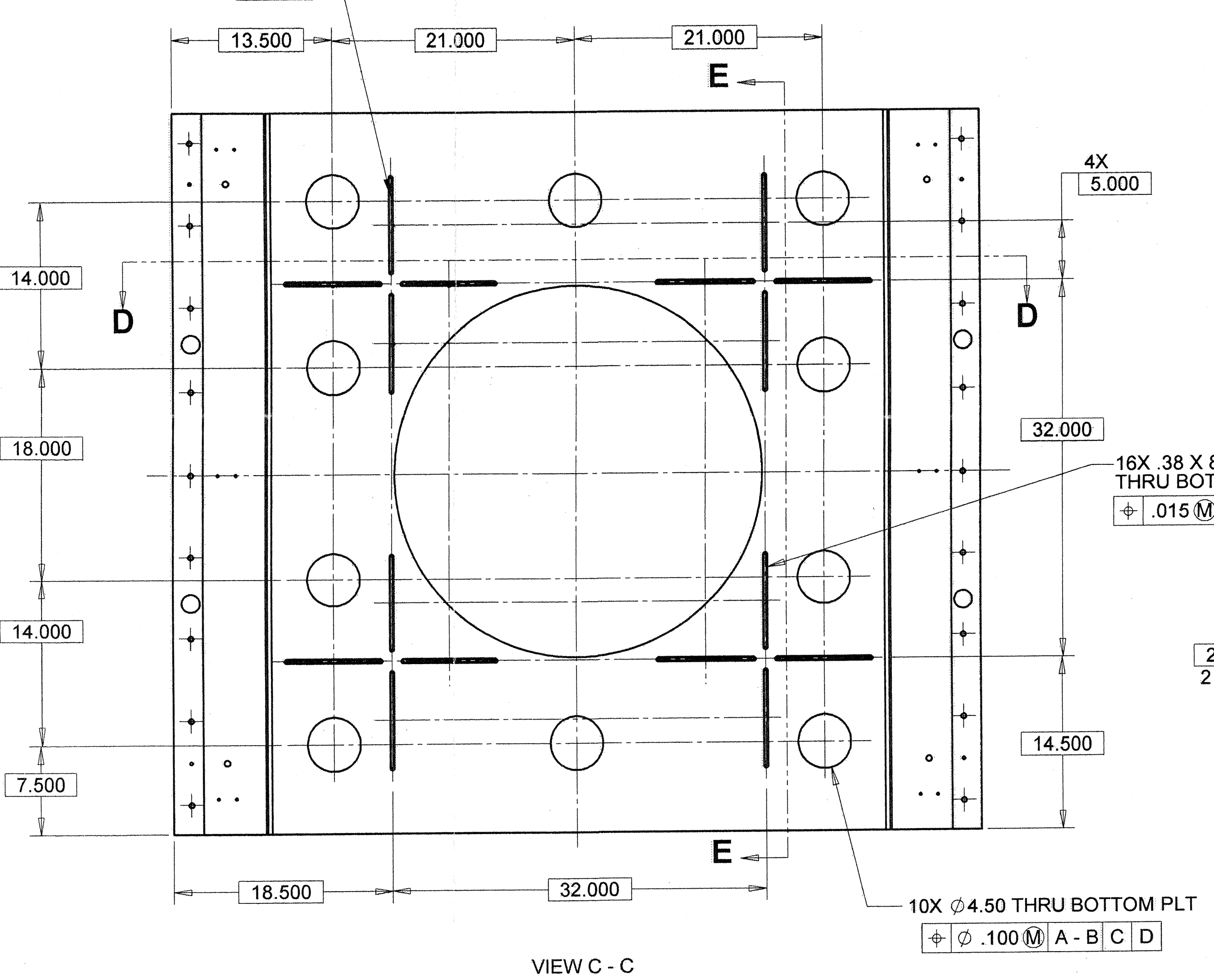
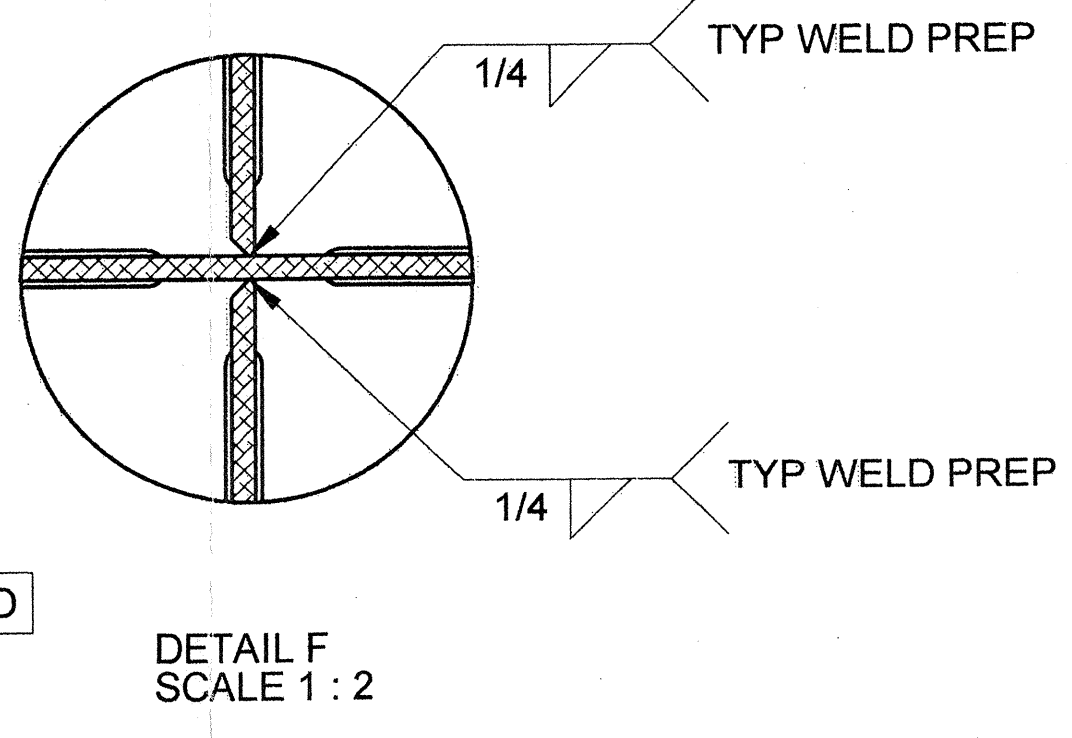
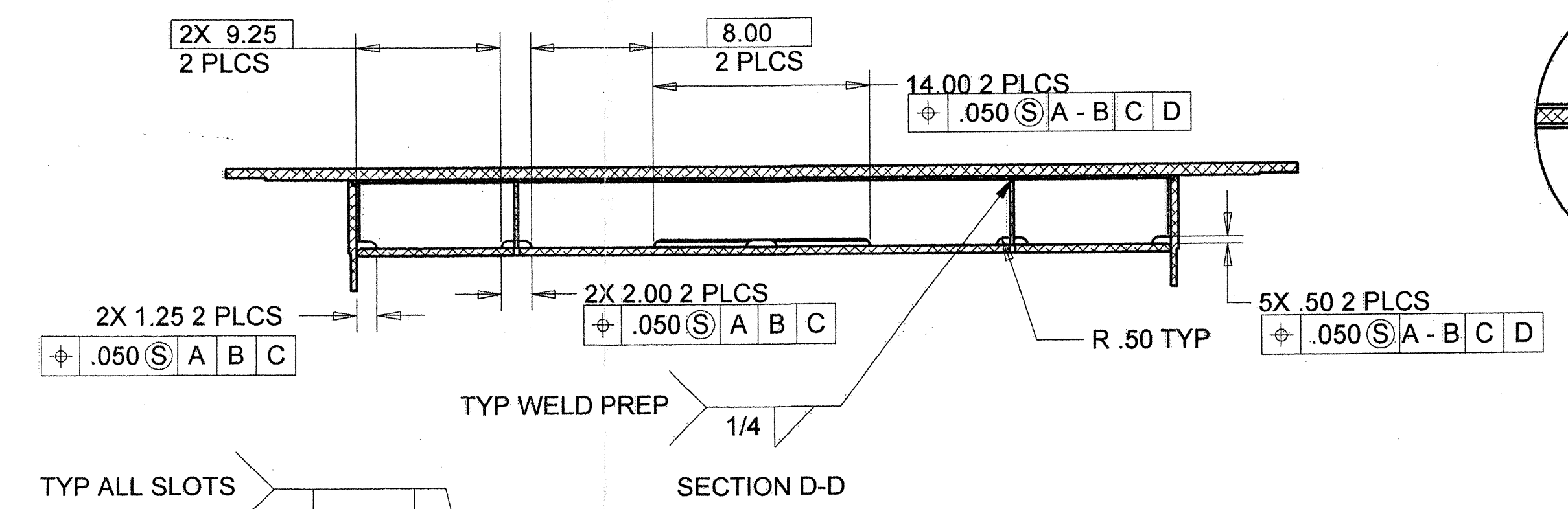
PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING. DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	<p><b>HYTEC, INC</b></p> <p>TITLE: LIGO BSC SUPPORT TABLE WELDMENT</p>	
FINISH ALL MACHINED SURFACES 32 RMS	DESIGNED ROGER L. SMITH 5-28-97	SIGNATURE ROGER L. SMITH	DATE 5-28-97
PART NO. D9722212-1	CHECKED HARRY SALAZAR 6-6-97	DWG. NO. D972212	
	ENGR. T. THOMPSON 7-10-97	SIZE D	SHEET NO. 1 of 2
	APPROVED T. THOMPSON 7-10-97	SCALE 1/8	REVISION

REVISIONS		
REV.	DESCRIPTION	DATE

8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



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	TITLE <b>HYTEC, INC</b> LIGO BSC SUPPORT TABLE WELDMENT	
FINISH ALL MACHINED SURFACES 32 RMS	SIGNATURE DESIGNED: ROGER L. SMITH DRAWN: ROGER L. SMITH CHECKED: HARRY SALAZAR ENGR: T. THOMPSON APPROVED: T. THOMPSON	DATE 5-28-97 5-28-97 6-6-97 7-10-97 7-10-97	DWG. NO. D972212 SCALE 1/8
PART NO. D9722212-1	SIZE D	SHEET NO. 2 of 2	REVISION

8 7 6 5 4 3 2 1