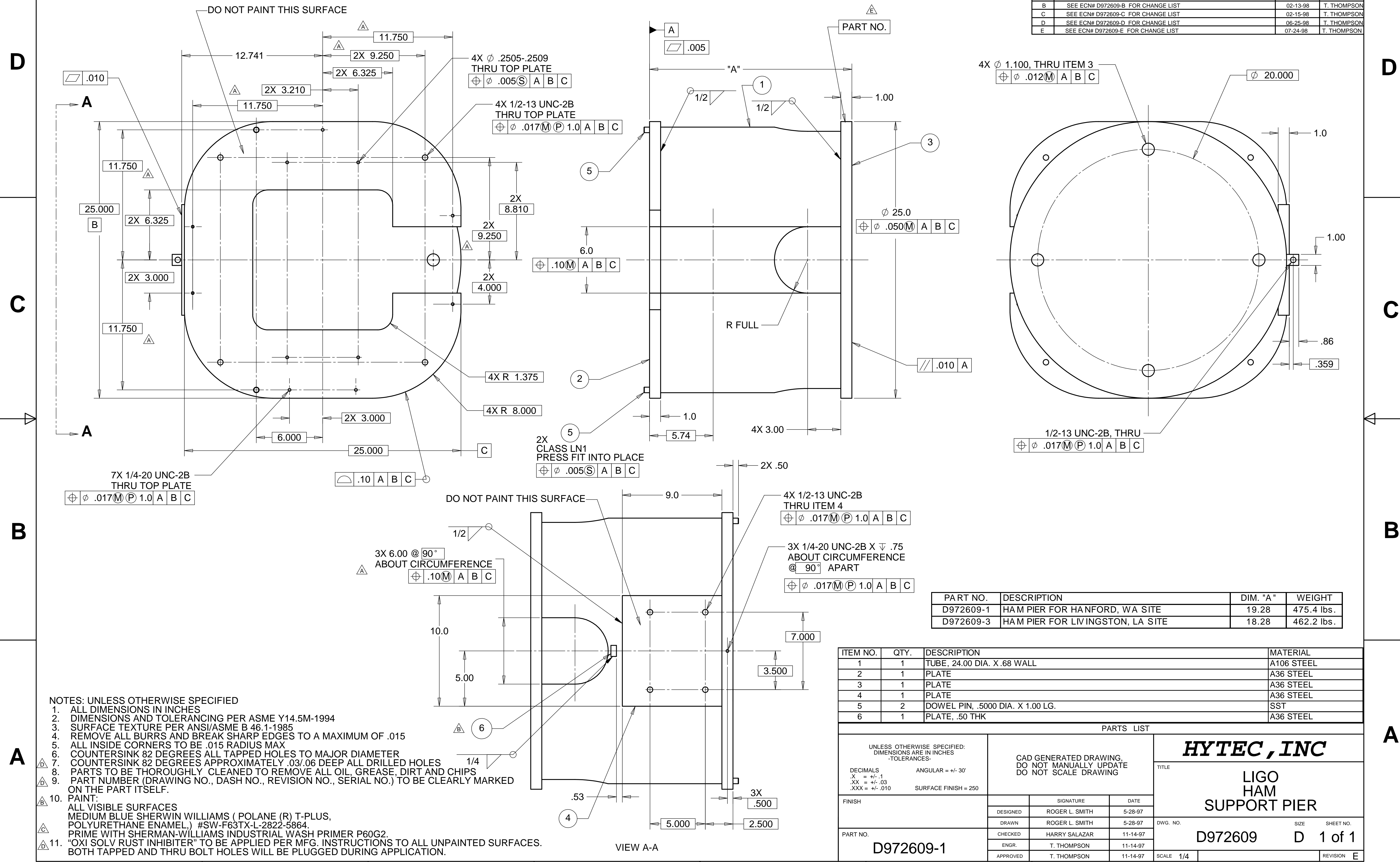


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972609-A FOR CHANGE LIST	11-03-97	T. THOMPSON
B	SEE ECN# D972609-B FOR CHANGE LIST	02-13-98	T. THOMPSON
C	SEE ECN# D972609-C FOR CHANGE LIST	02-15-98	T. THOMPSON
D	SEE ECN# D972609-D FOR CHANGE LIST	06-25-98	T. THOMPSON
E	SEE ECN# D972609-E FOR CHANGE LIST	07-24-98	T. THOMPSON



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 .03/.06 DEEP ALL DRILLED HOLES
 8. PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
 9. PART NUMBER (DRAWING NO., DASH NO., REVISION NO., SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
 10. PAINT: ALL VISIBLE SURFACES MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS, POLYURETHANE ENAMEL.) #SW-F63TX-L-2822-5864. PRIME WITH SHERMAN-WILLIAMS INDUSTRIAL WASH PRIMER P60G2.
 11. "OXI SOLV RUST INHIBITER" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU BOLT HOLES WILL BE PLUGGED DURING APPLICATION.

PART NO.	DESCRIPTION	DIM. "A"	WEIGHT
D972609-1	HAM PIER FOR HANFORD, WA SITE	19.28	475.4 lbs.
D972609-3	HAM PIER FOR LIVINGSTON, LA SITE	18.28	462.2 lbs.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
1	1	TUBE, 24.00 DIA. X .68 WALL	A106 STEEL
2	1	PLATE	A36 STEEL
3	1	PLATE	A36 STEEL
4	1	PLATE	A36 STEEL
5	2	DOWEL PIN, .5000 DIA. X 1.00 LG.	SST
6	1	PLATE, .50 THK	A36 STEEL

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-

DECIMALS: .X = +/- .1
 .XX = +/- .03
 .XXX = +/- .010

ANGULAR = +/- .30°
 SURFACE FINISH = 250

CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE, DO NOT SCALE DRAWING

HYTEC, INC

LIGO HAM SUPPORT PIER

D972609 D 1 of 1

SCALE 1/4" = 1"

REVISION E