

WELDMENT ISOMETRIC VIEWS

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
12	D070577	SIDE GUSSET	304 SSSL	8	0	8
11	D070578	SIDE STRUT	304 SSSL	2	0	2
10	D070582	TOP GUSSET, SHORT	304 SSSL	4	0	4
9	D070584	SIDE CROSS BEAM, THIN	304 SSSL	4	0	4
8	D080282	SIDE CROSS BEAM, THICK	304 SSSL	2	0	2
7	D070576	LOWER FRONT GUSSET	304 SSSL	8	0	8
6	D070579	UPPER FRONT GUSSET	304 SSSL	8	0	8
5	D070580	TOP GUSSET	304 SSSL	28	0	28
4	D070583	FRONT CROSS BEAM, THIN	304 SSSL	4	0	4
3	D080283	FRONT CROSS BEAM, THICK	304 SSSL	2	0	2
2	D070581	LEG	304 SSSL	4	0	4
1	D070575	BASE PLATE	304 SSSL	1	0	1

**ADDITIONAL NOTES:**  
 1. FINISH TO BE CLEANED, VACUUM BAKED AND SEALED IN ACCORDANCE WITH LIGO REQUIREMENTS.  
 2. HOLE THROUGH OTHER WALL OF TUBE ONLY.  
 3. HOLE THROUGH INNER WALL OF TUBE ONLY.  
 4. HOLE THROUGH BOTH WALLS OF TUBE.  
 5. DO NOT DEBUR OR PERFORM OTHER SECONDARY OPERATIONS.

**NOTES (UNLESS OTHERWISE SPECIFIED):**  
 1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.  
 2. DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.  
 3. DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.  
 4. DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.  
 5. DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.

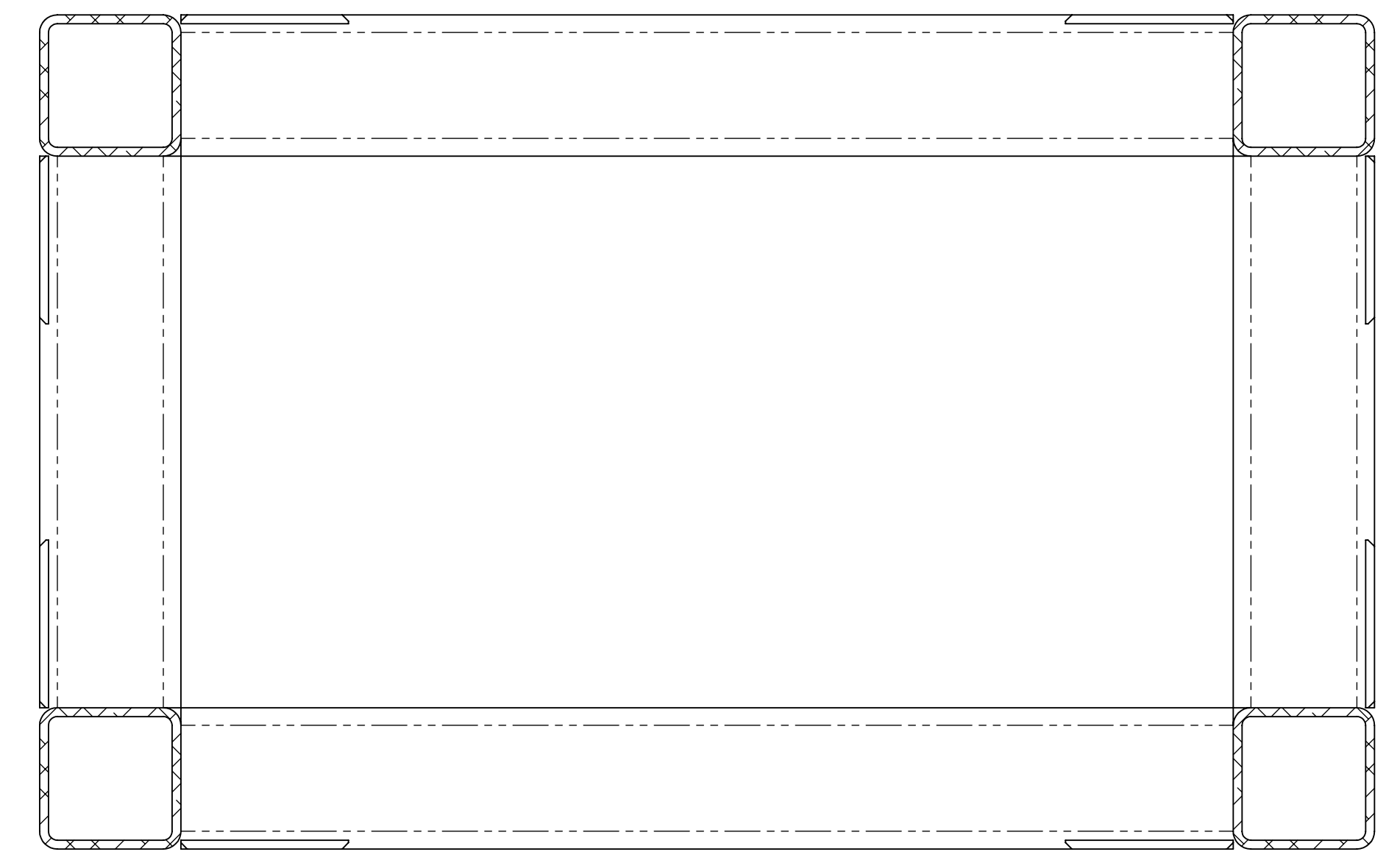
**CAUTION: HAZARDOUS MATERIALS**  
 LIGO  
 SYSTEM  
 SUB-SYSTEM  
 HLTS STRUCTURE

**FINISH:** N/A  
**SCALE:** 1:1  
**DATE:** 12/02/09  
**DESIGNED BY:** E  
**CHECKED BY:** E

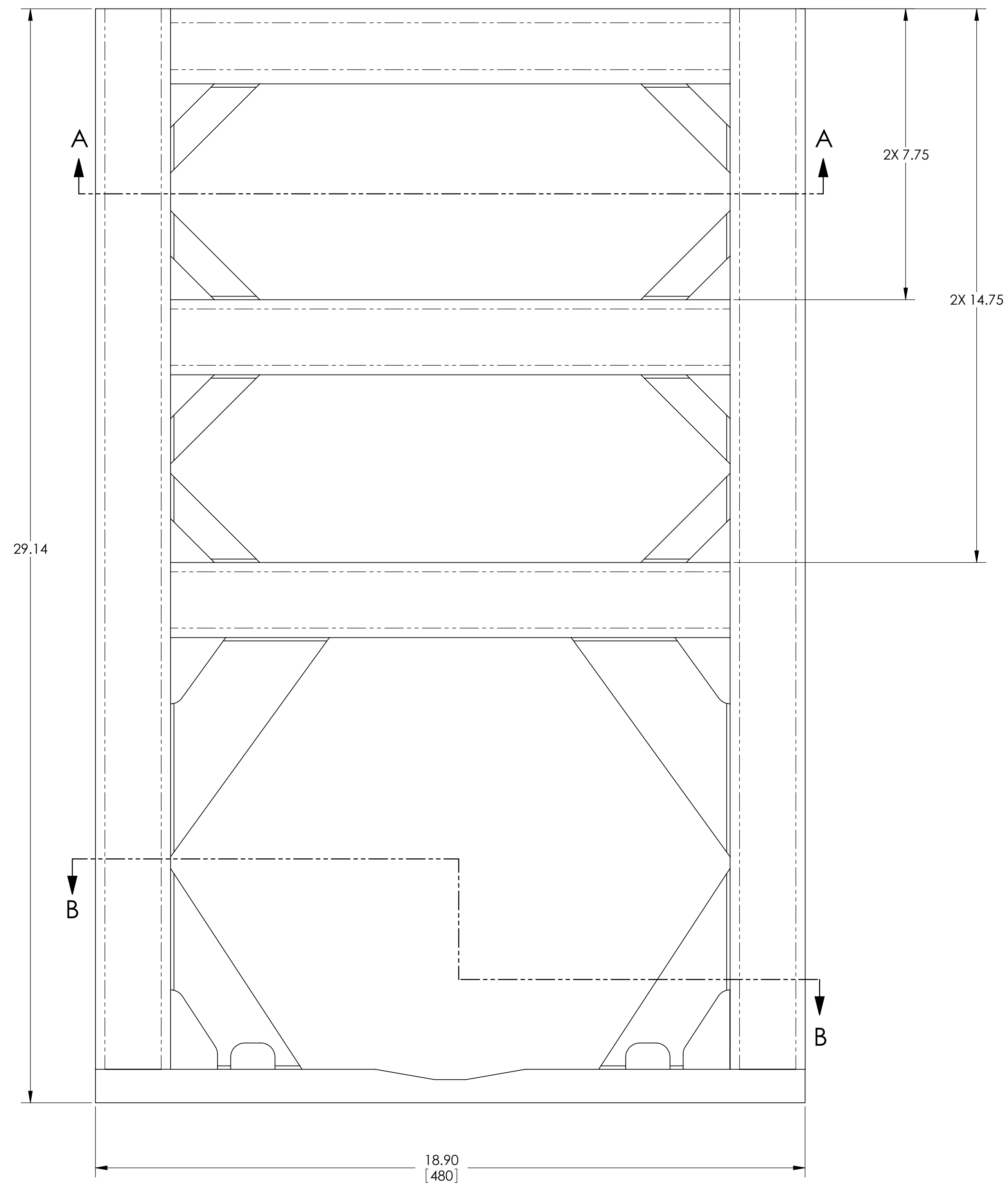
**PART NAME:** HLTS STRUCTURAL WELDMENT  
**REV:** V2  
**DWG NO:** D070442  
**SHEET OF 8**



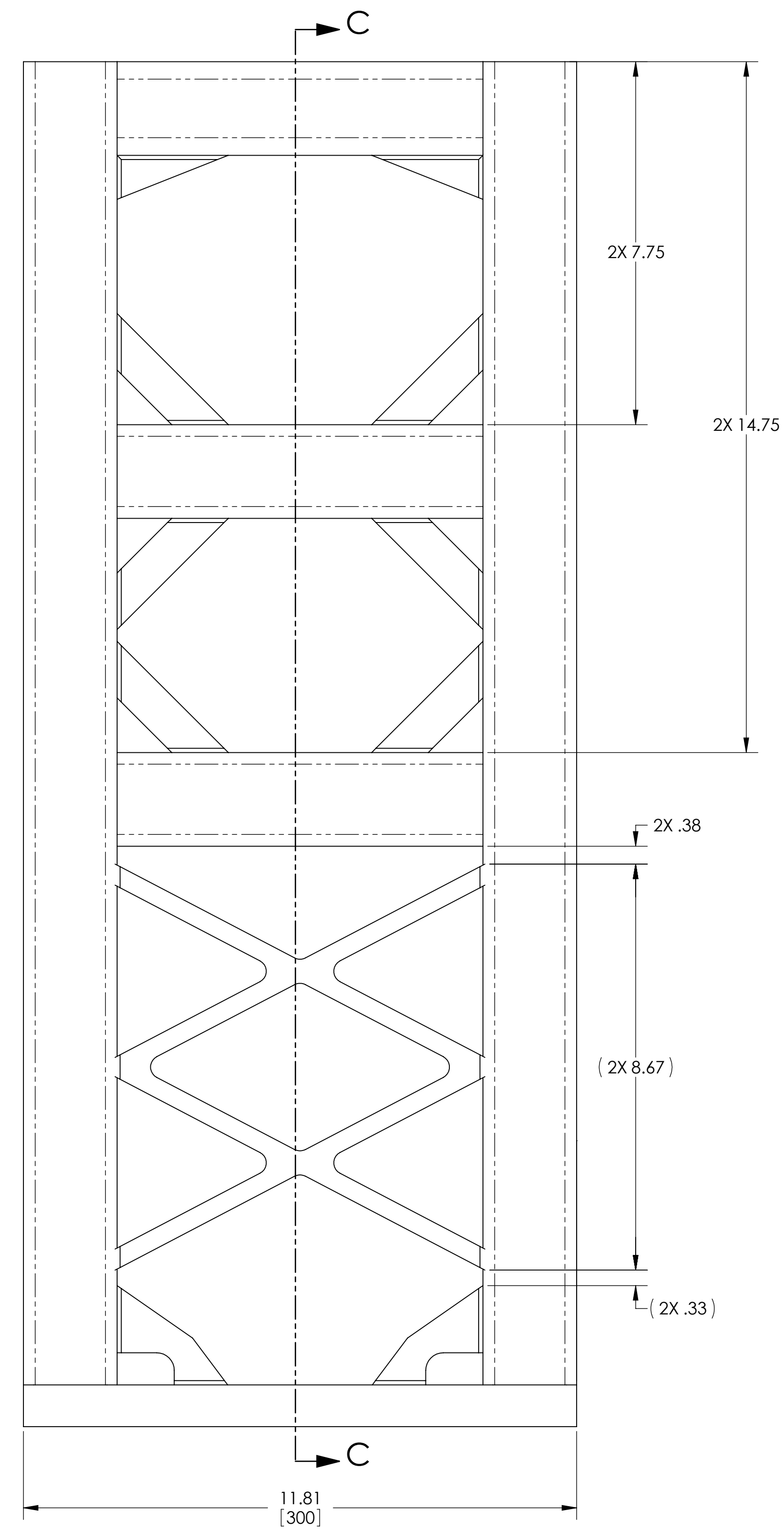
SECTION A-A



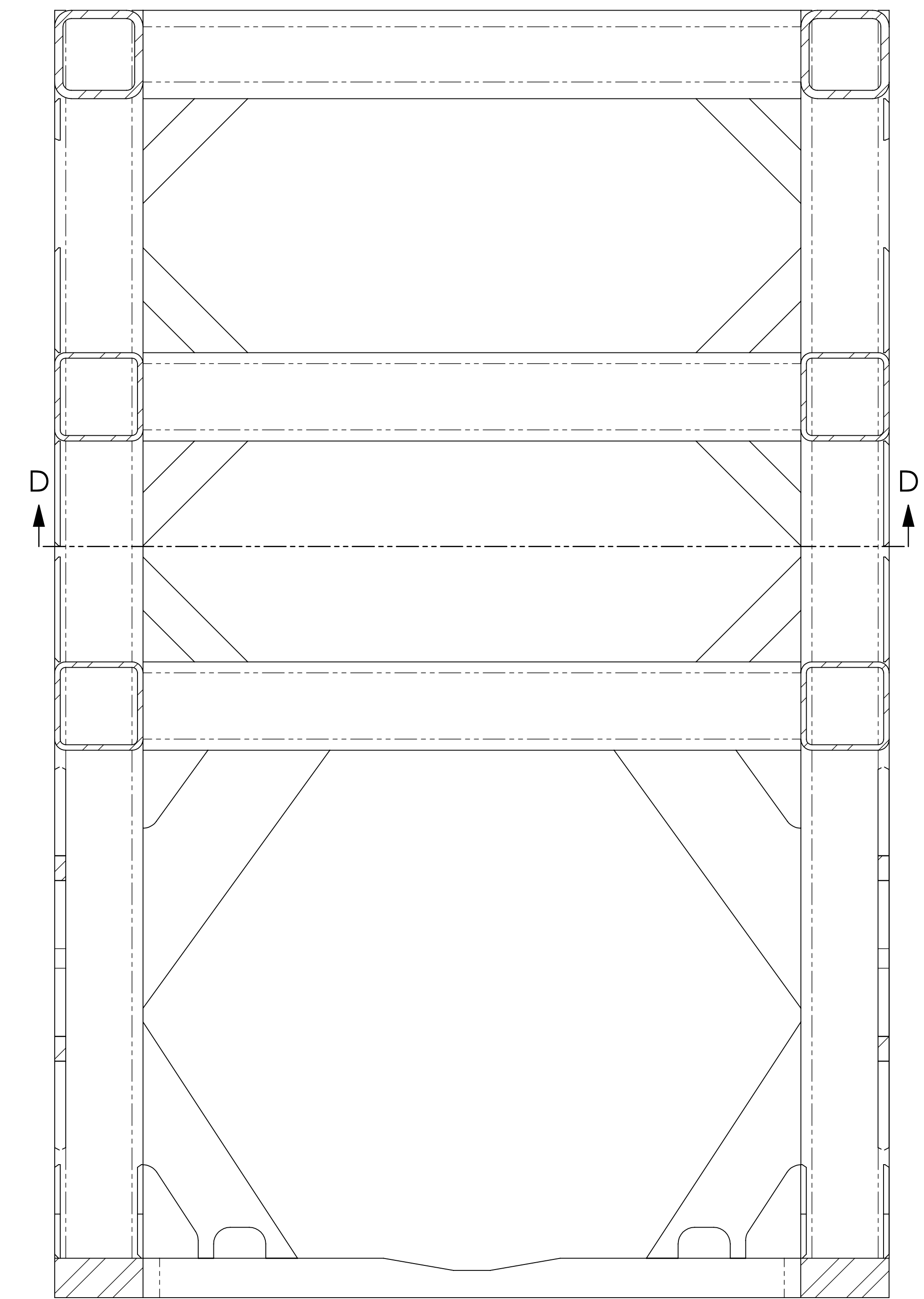
SECTION D-D



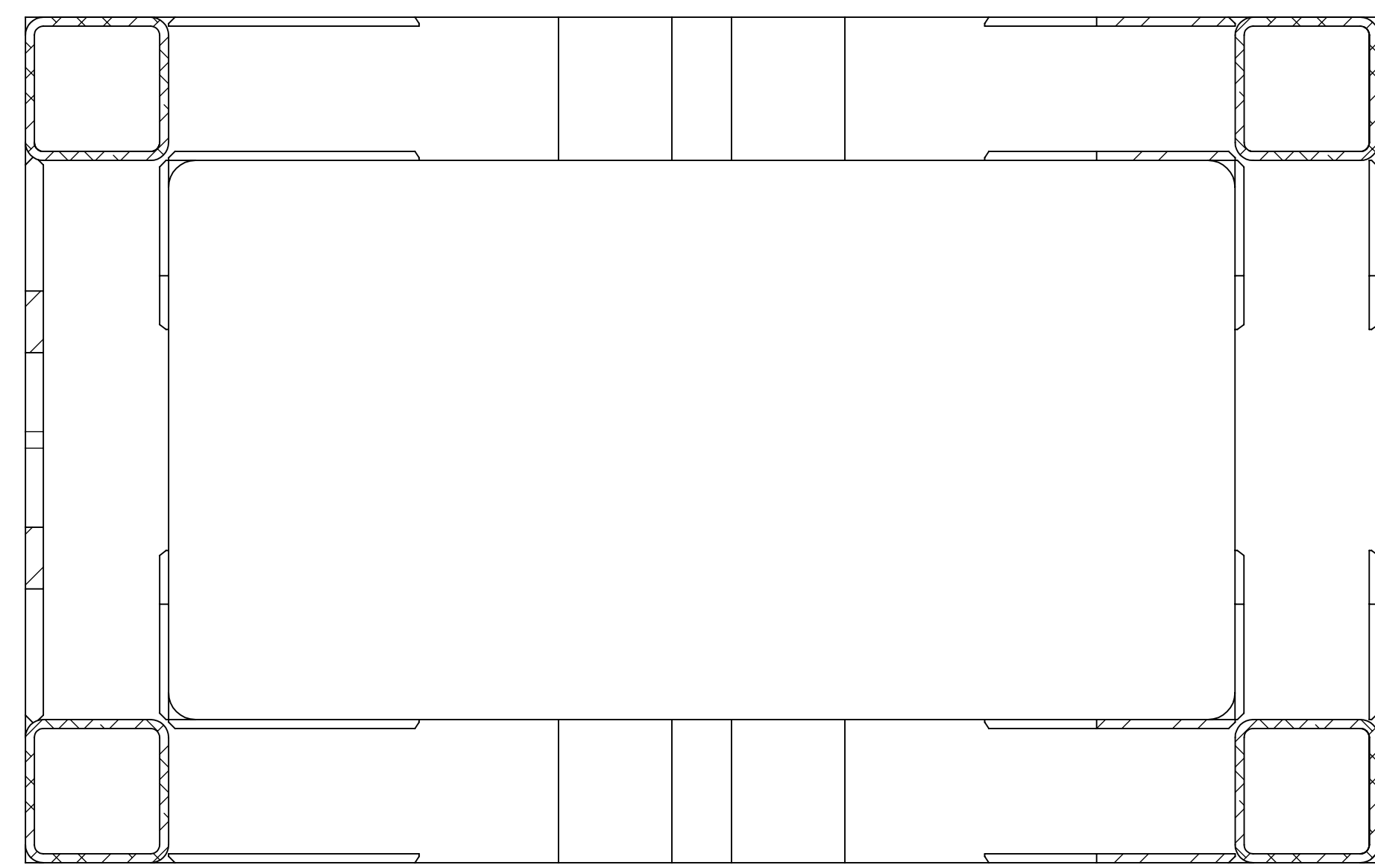
SECTION B-B

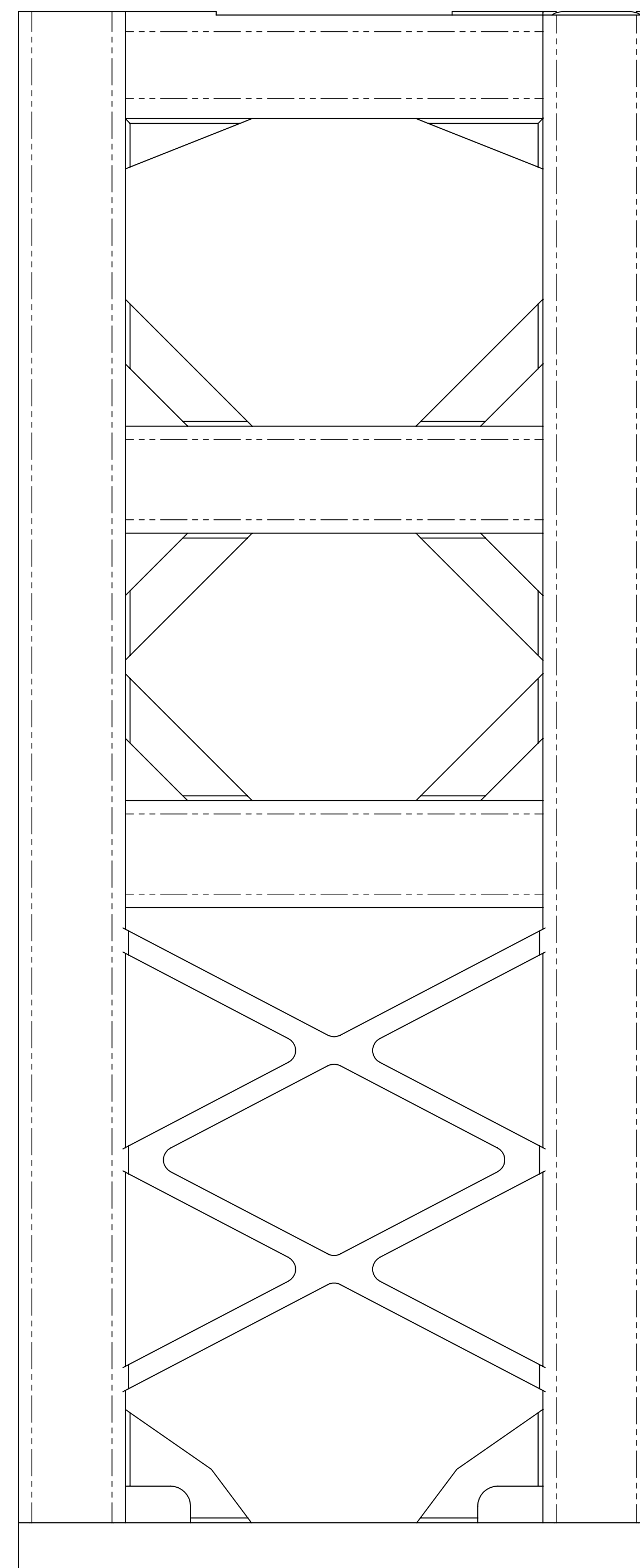
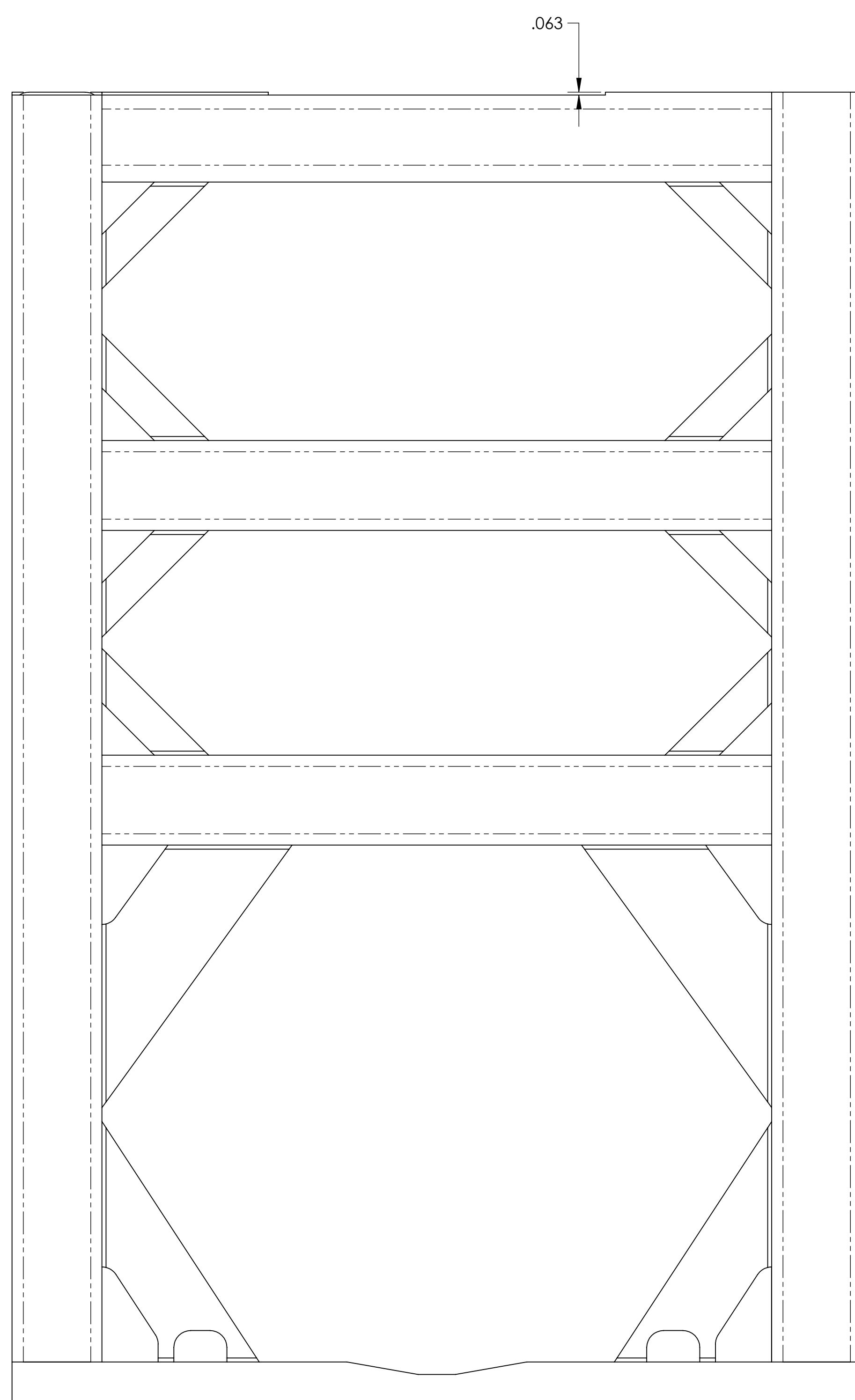
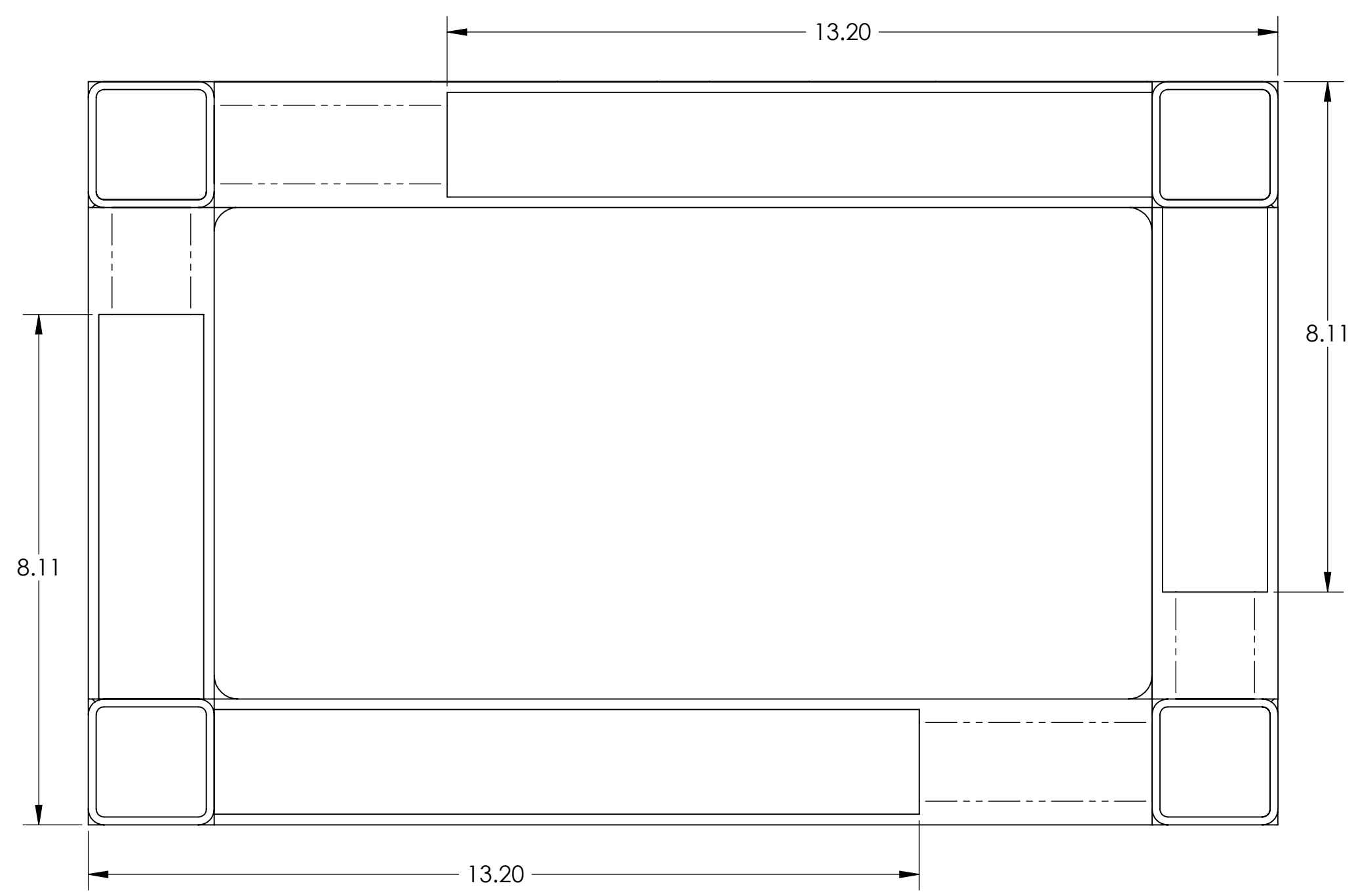


WELDMENT LAYOUT

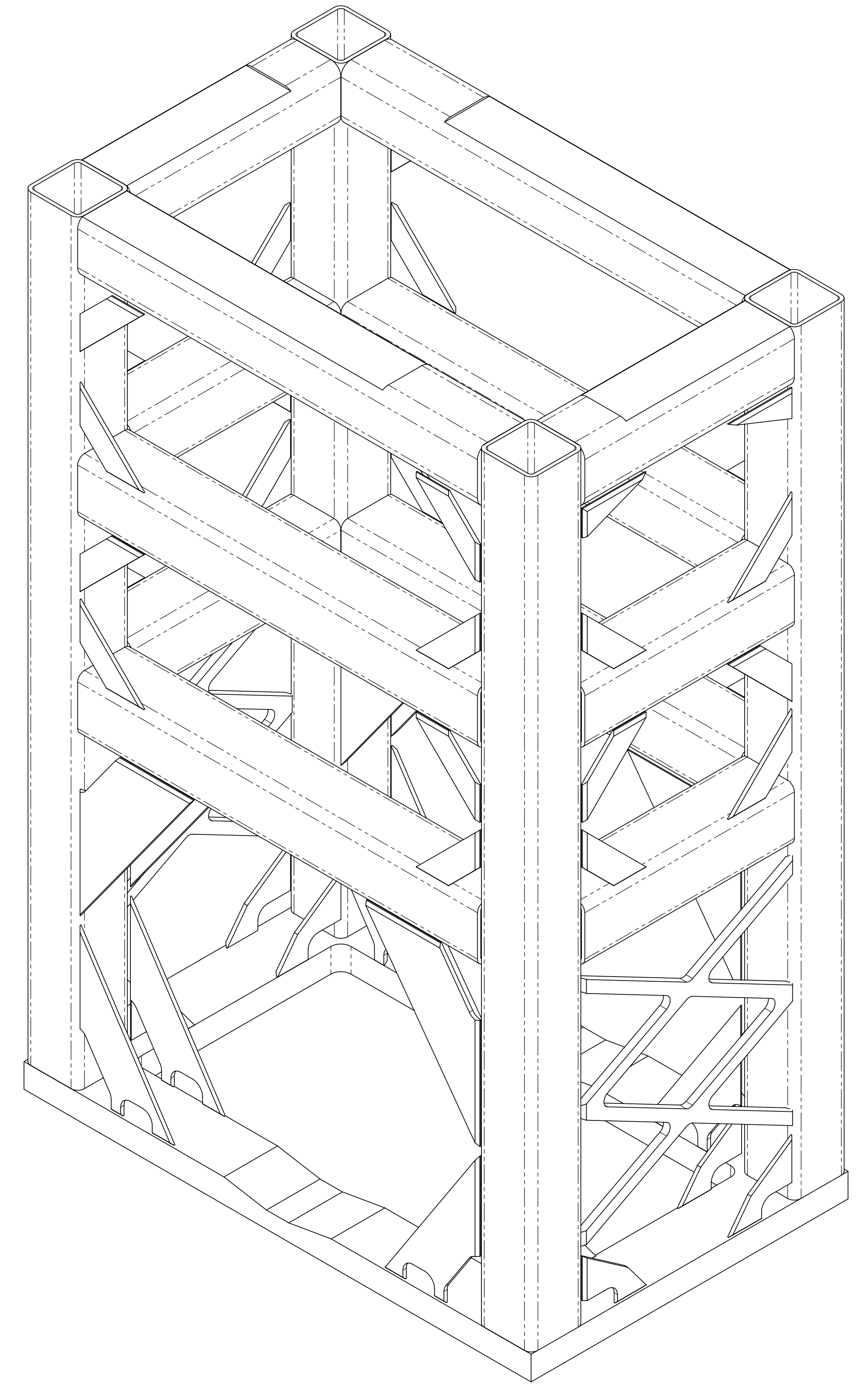


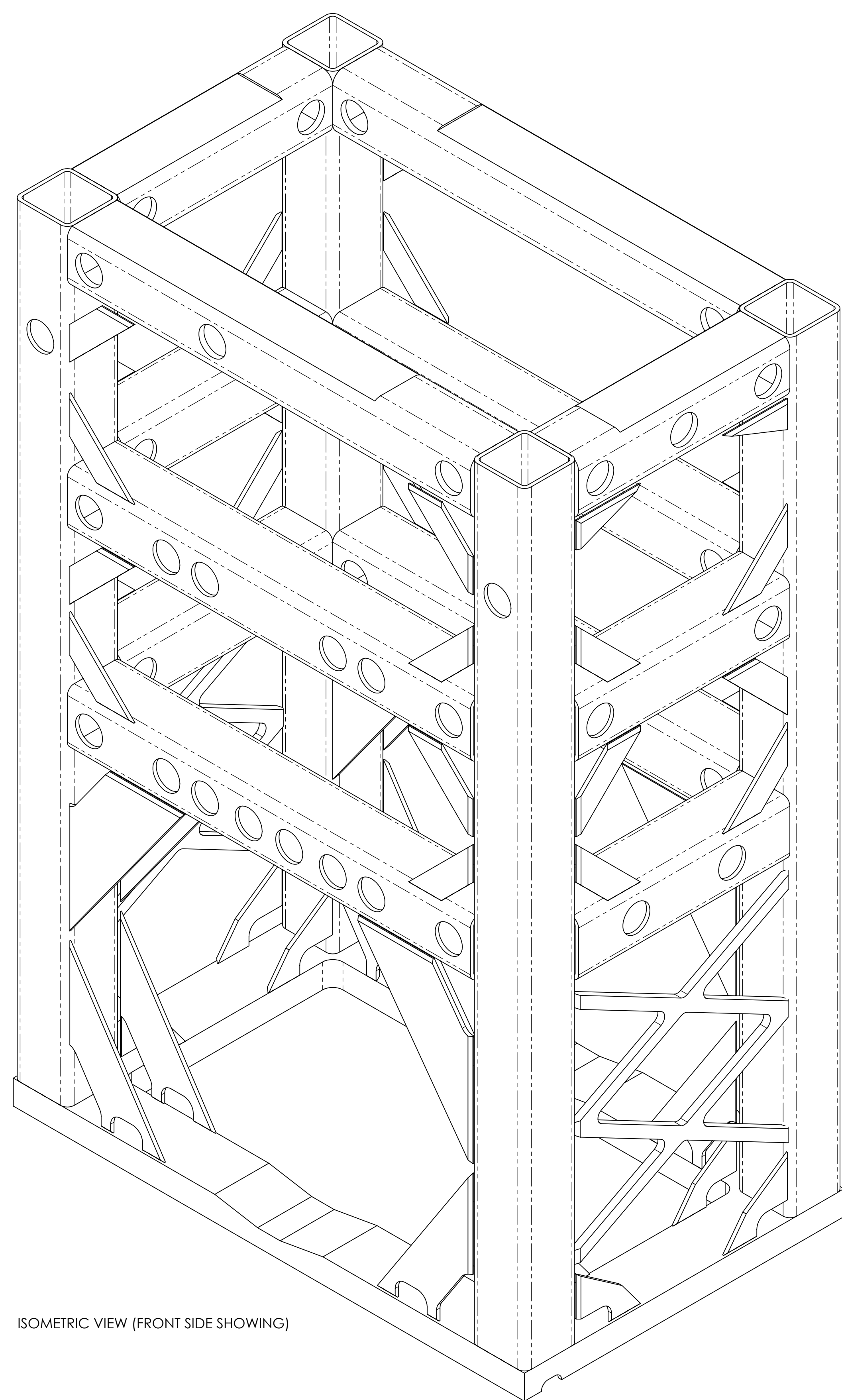
SECTION C-C



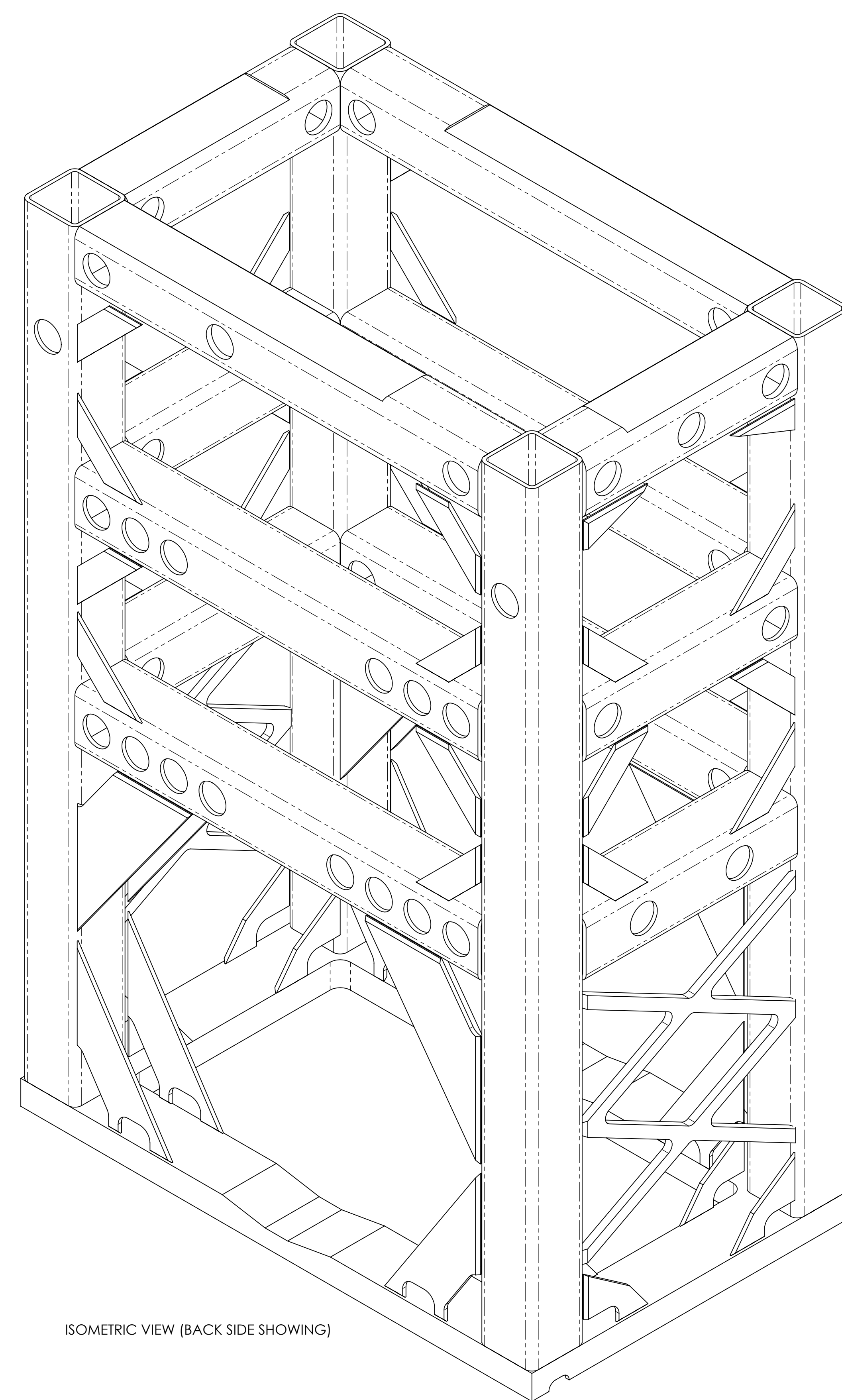


MACHINING LAYOUT



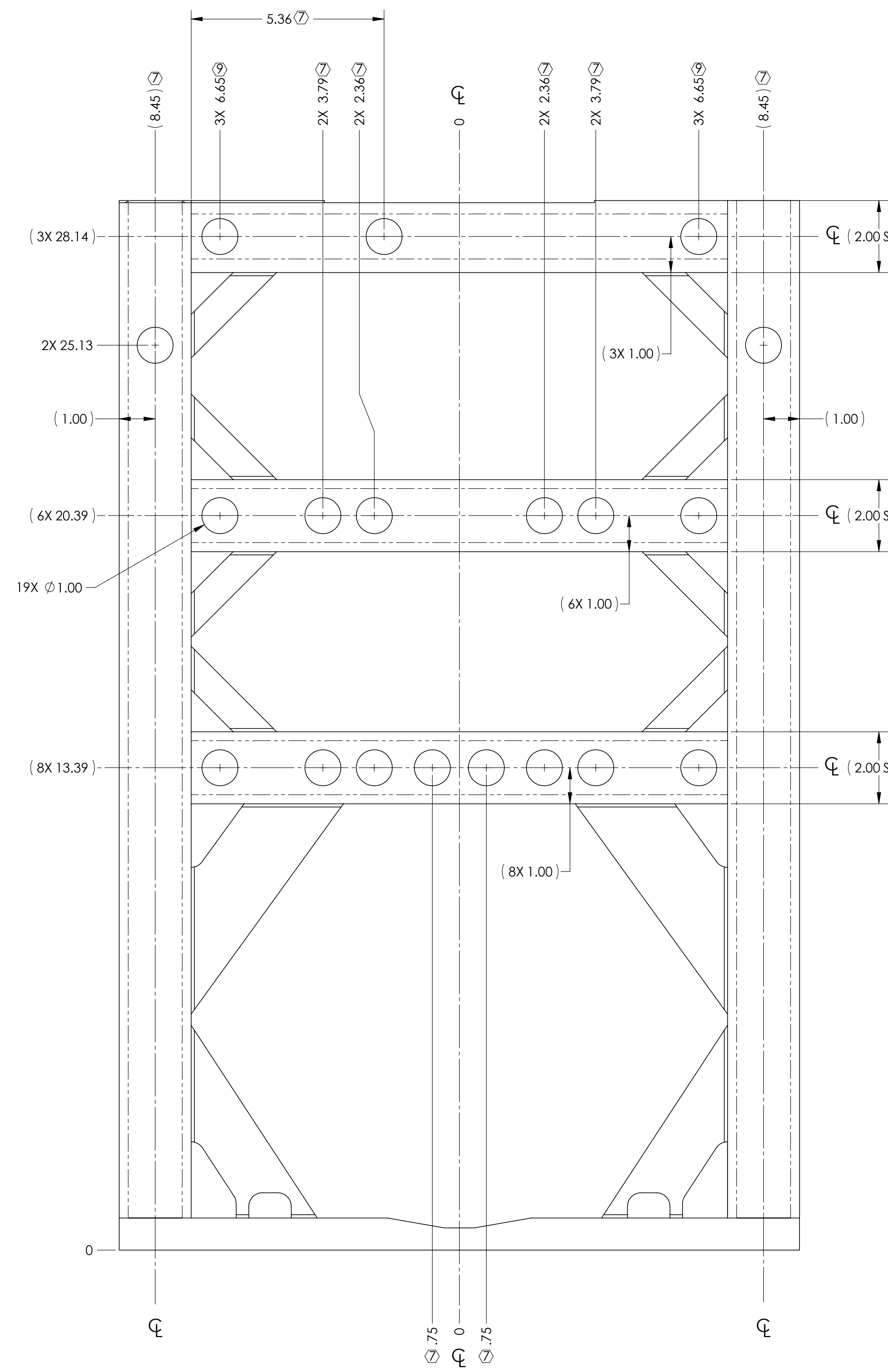


ISOMETRIC VIEW (FRONT SIDE SHOWING)

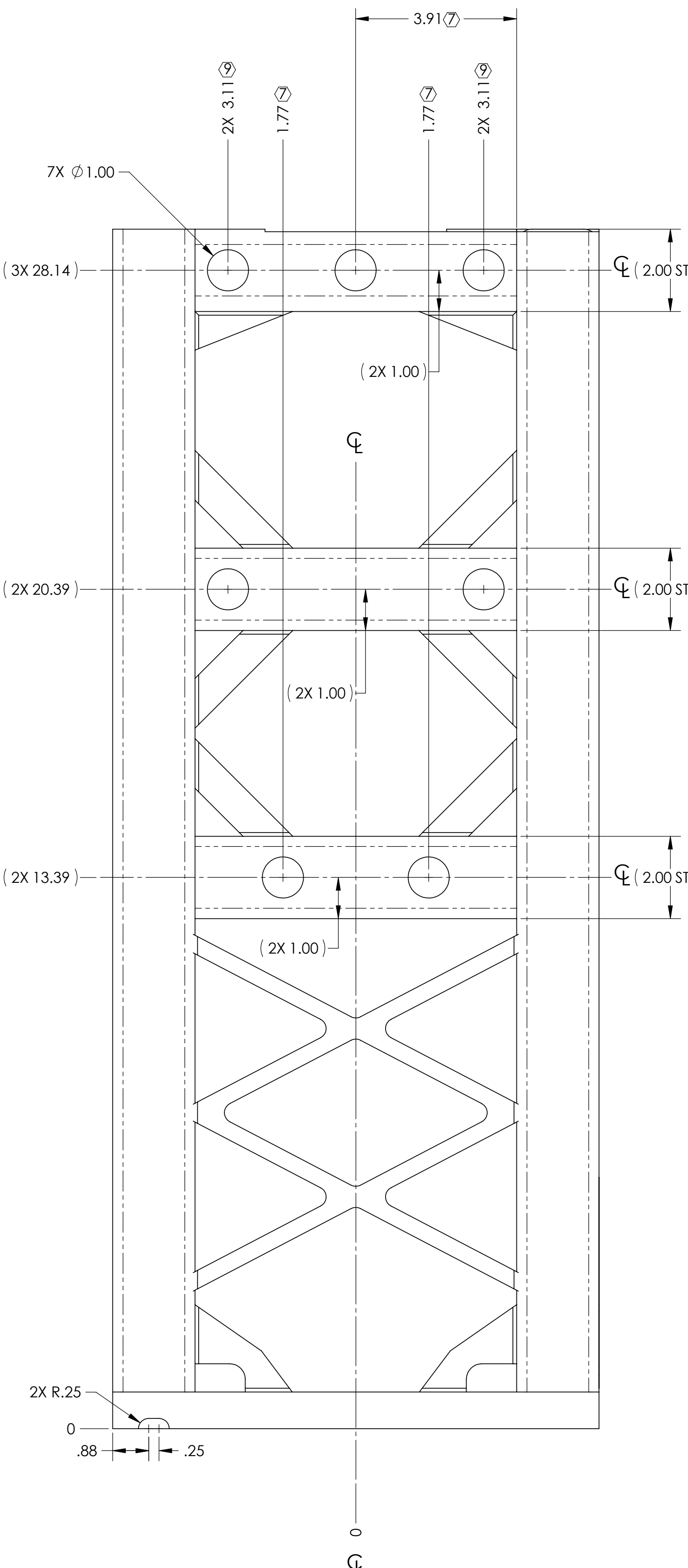


ISOMETRIC VIEW (BACK SIDE SHOWING)

ISOMETRIC VIEWS FOR LARGE HOLE PLACEMENT

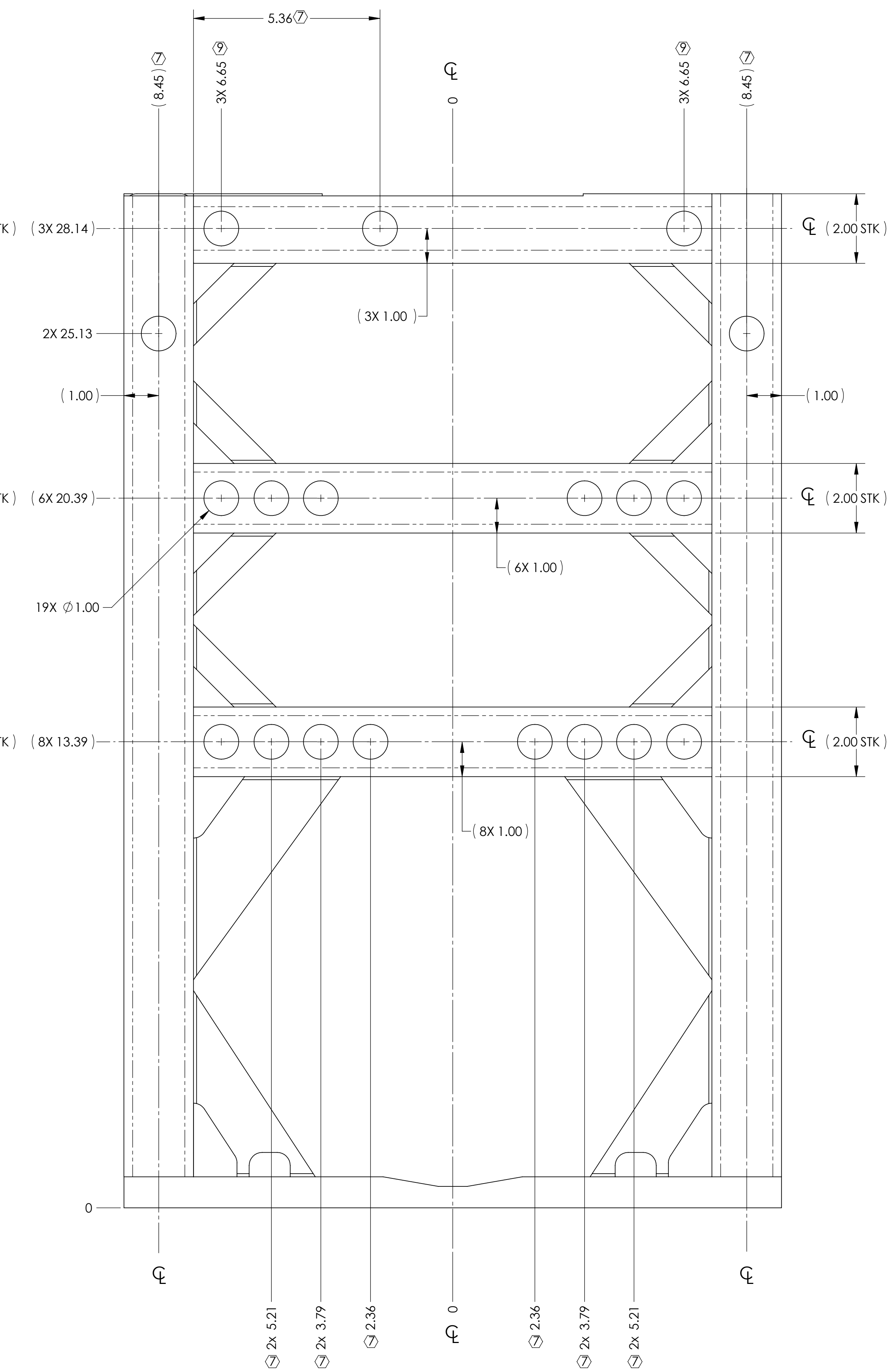


FRONT VIEW

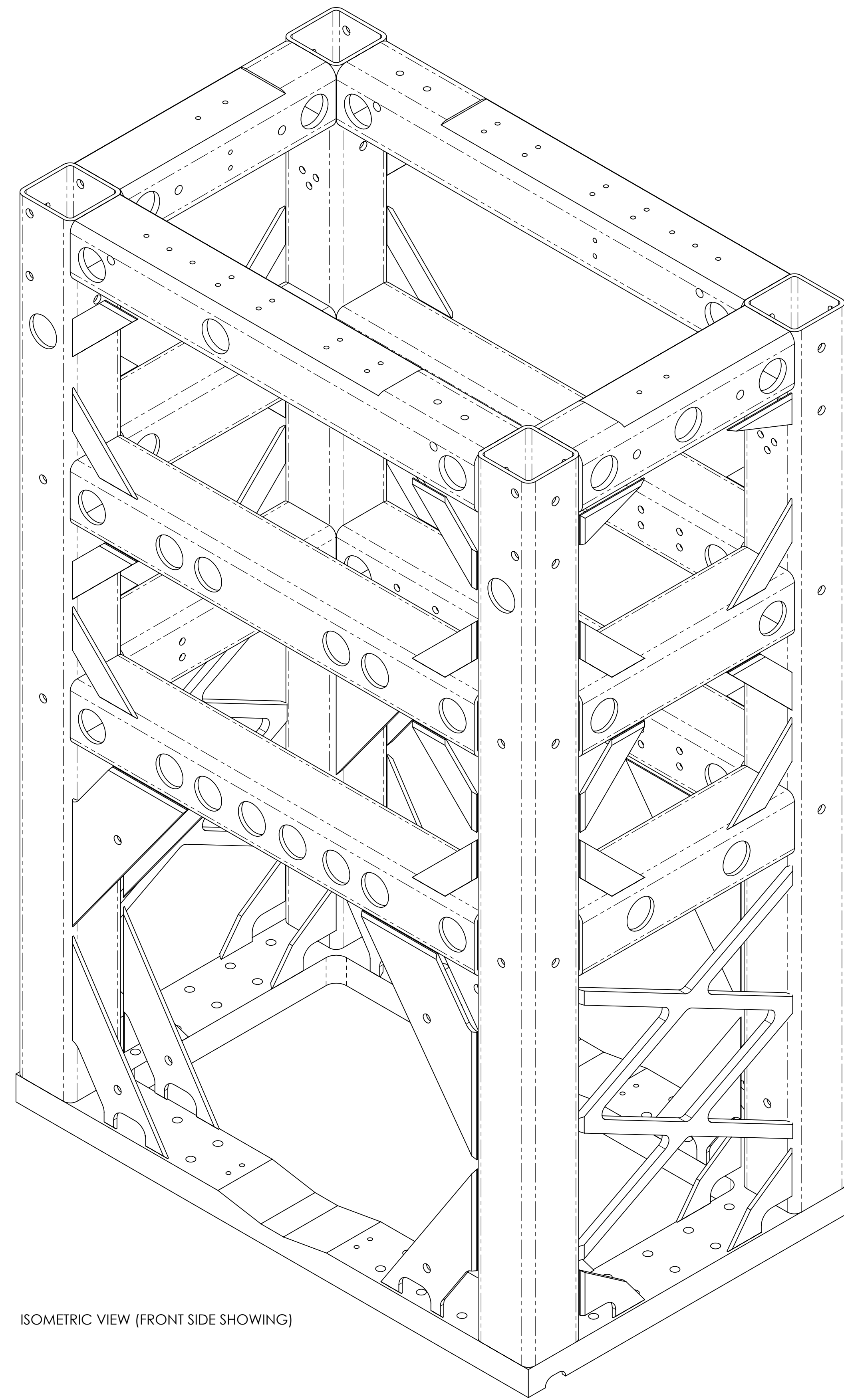


LEFT AND RIGHT VIEW

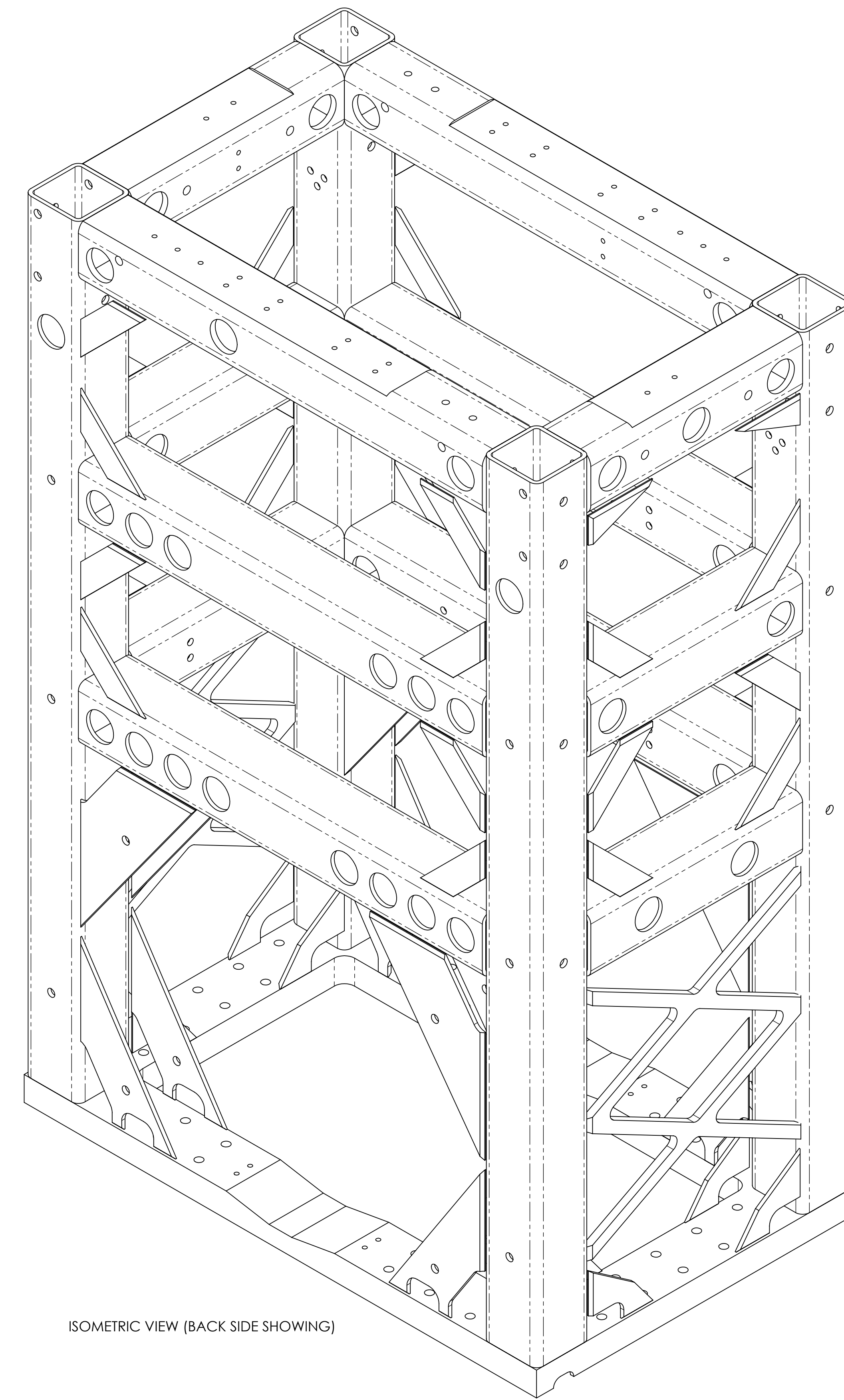
LARGE HOLE LAYOUT



BACK VIEW

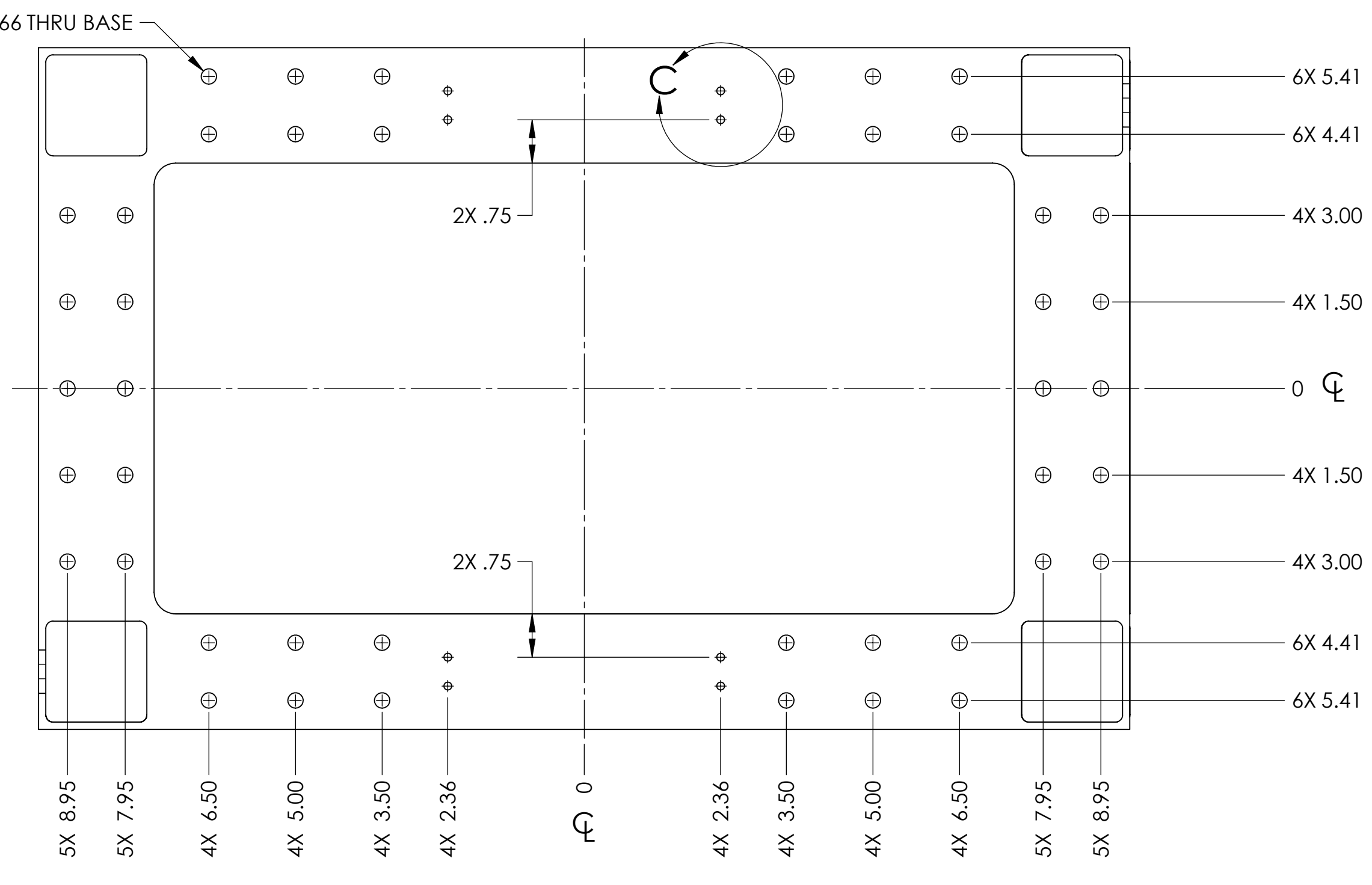
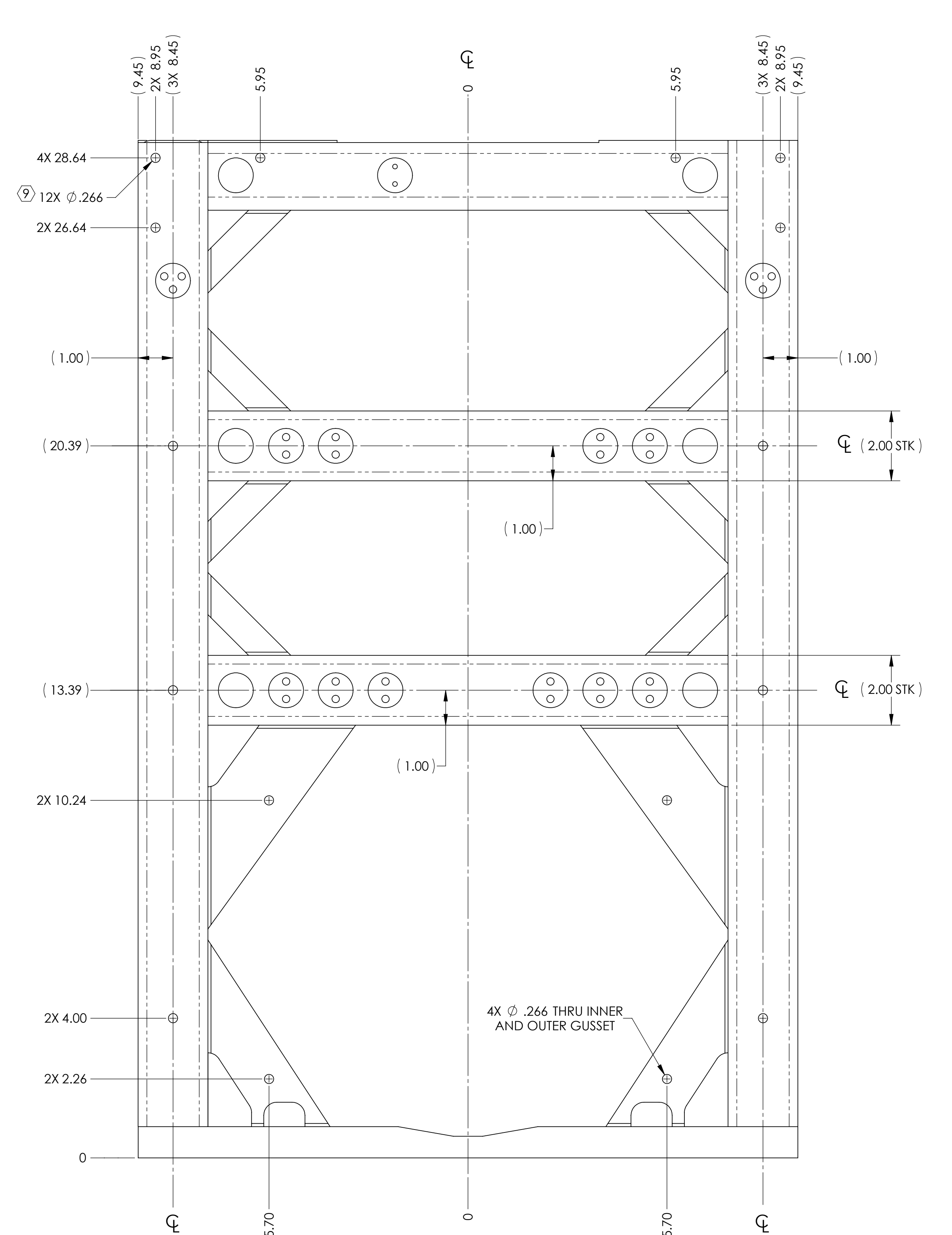
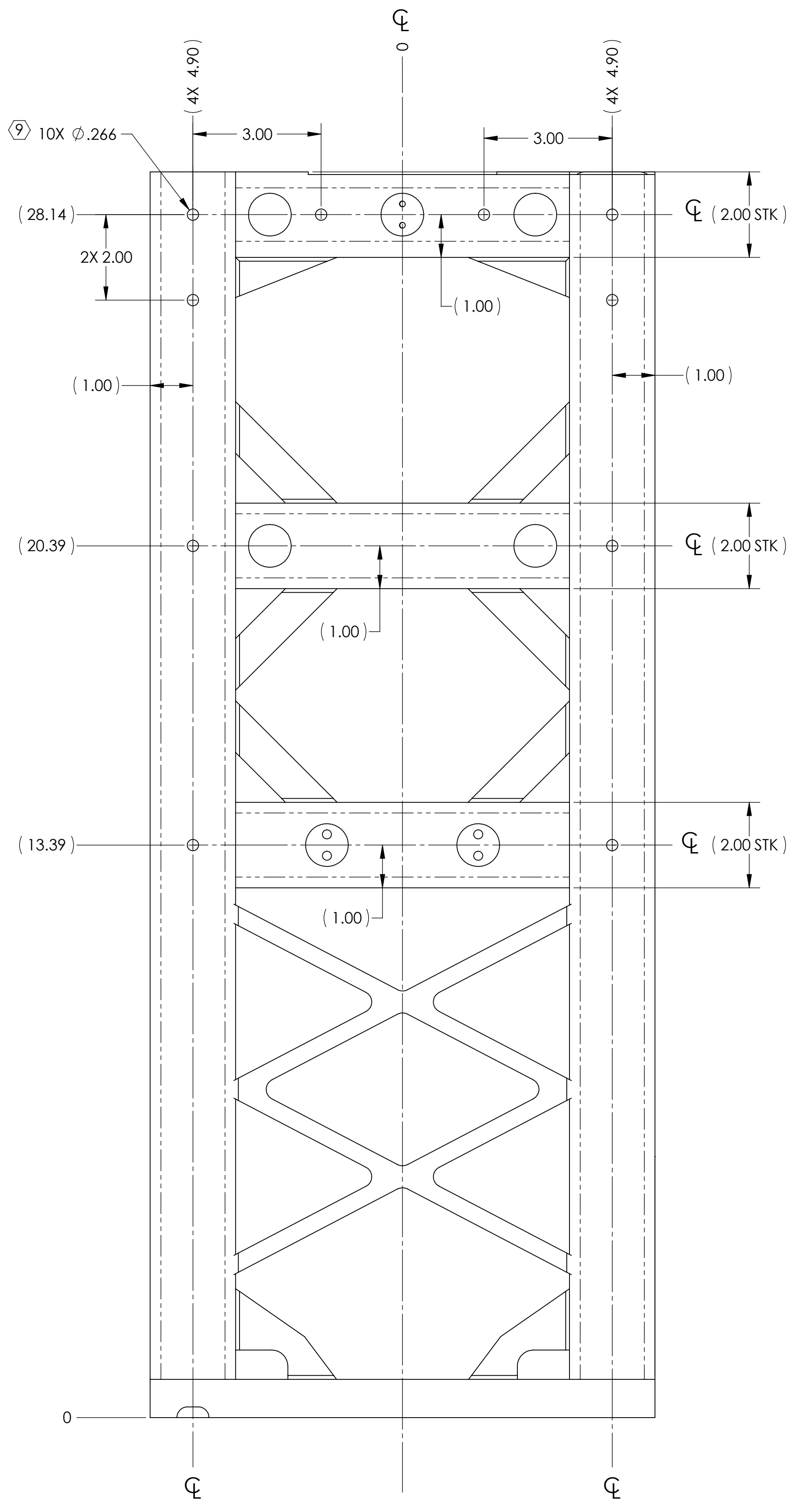
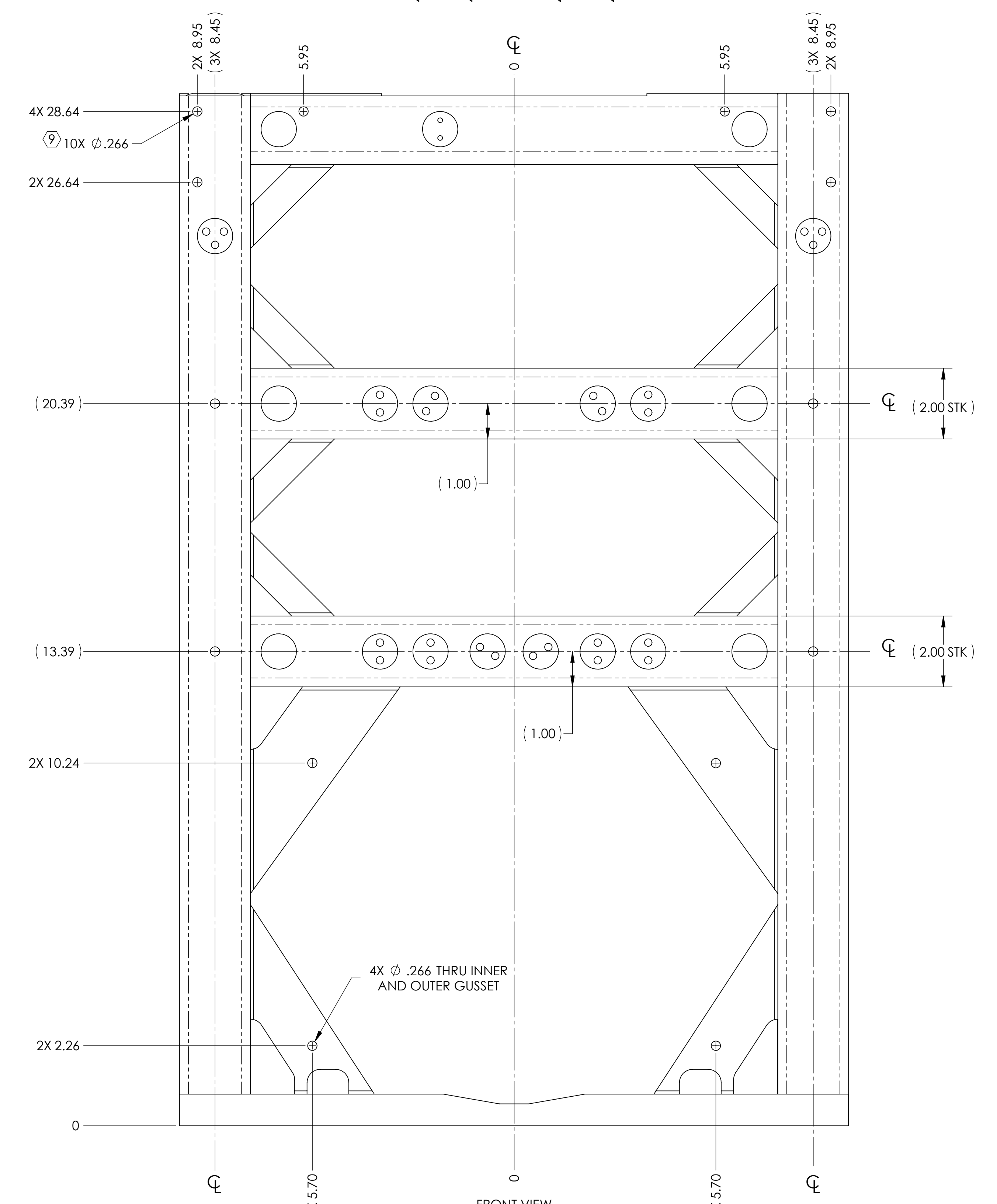
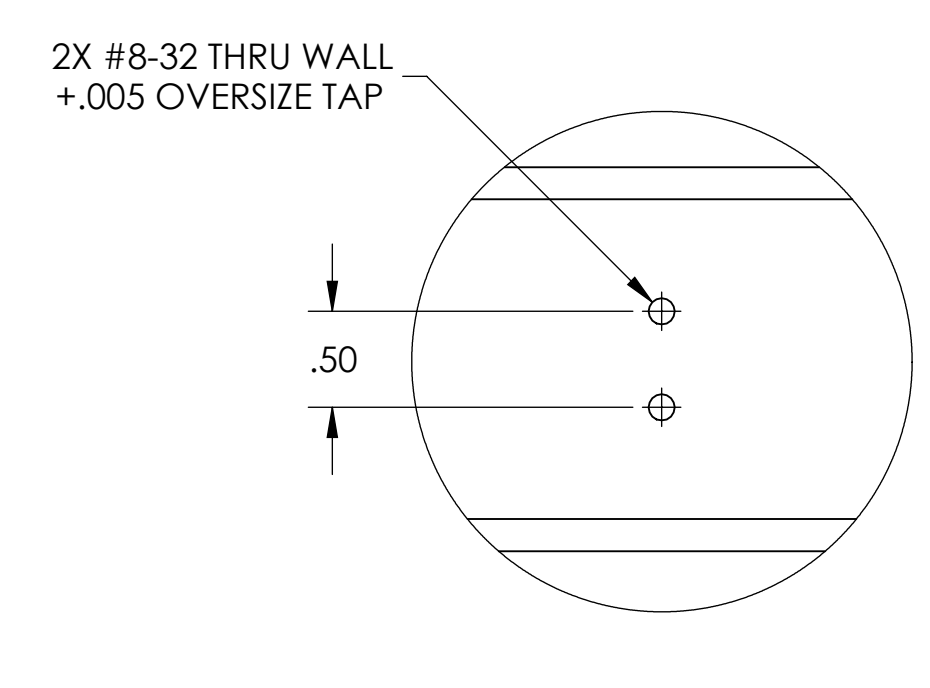
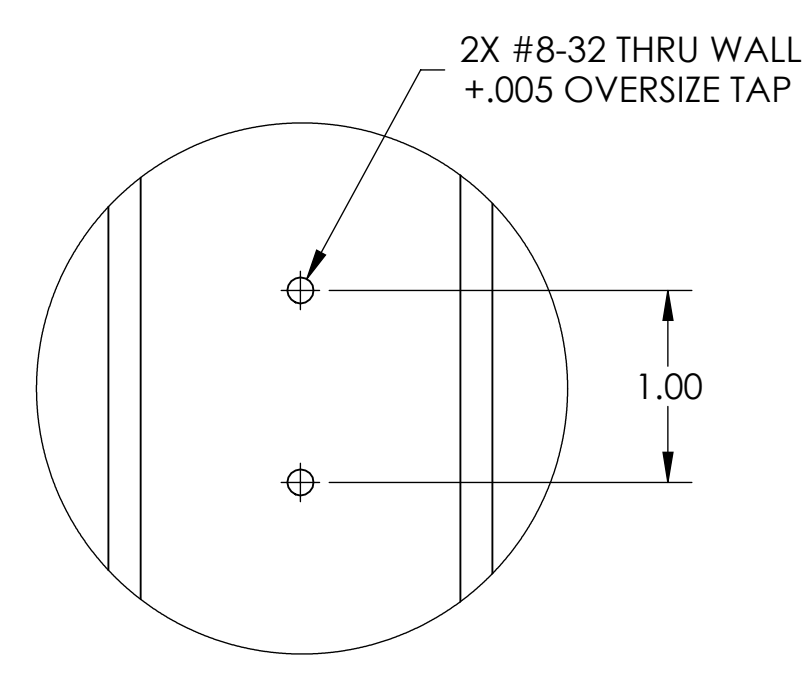
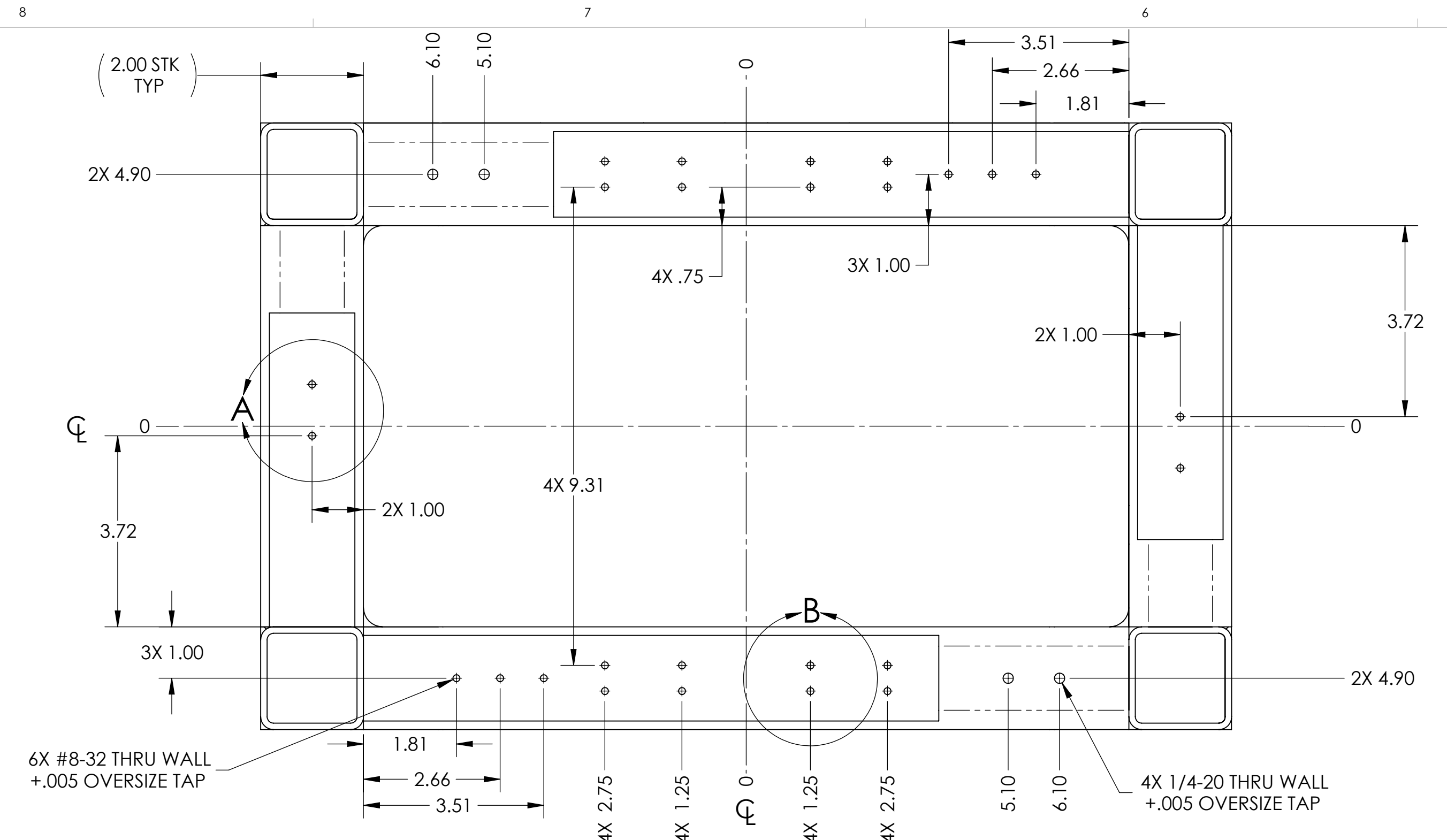


ISOMETRIC VIEW (FRONT SIDE SHOWING)

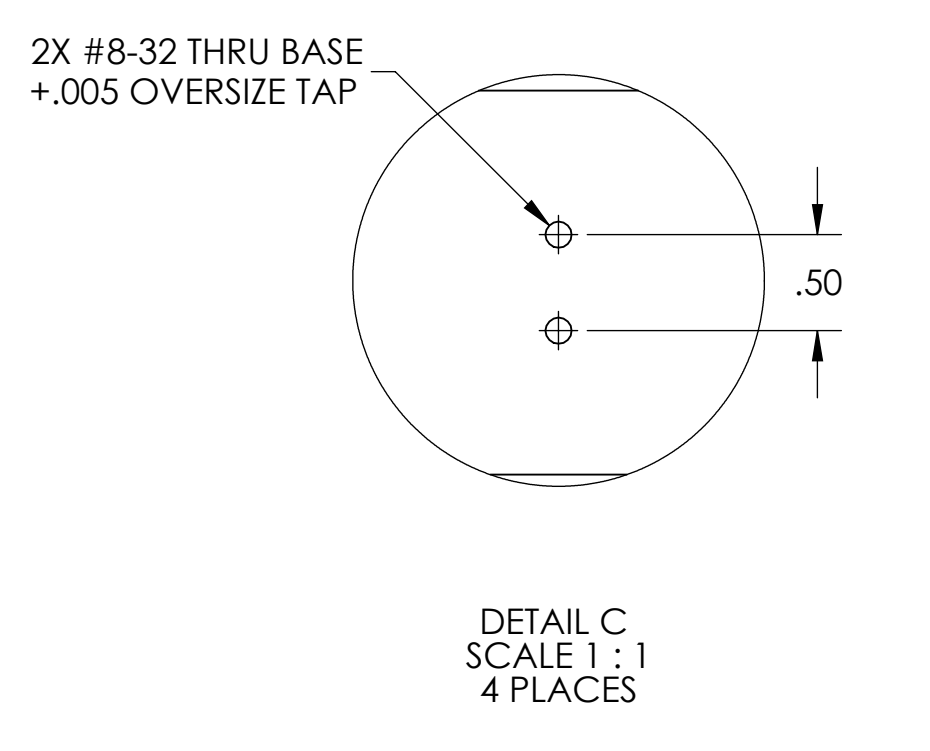


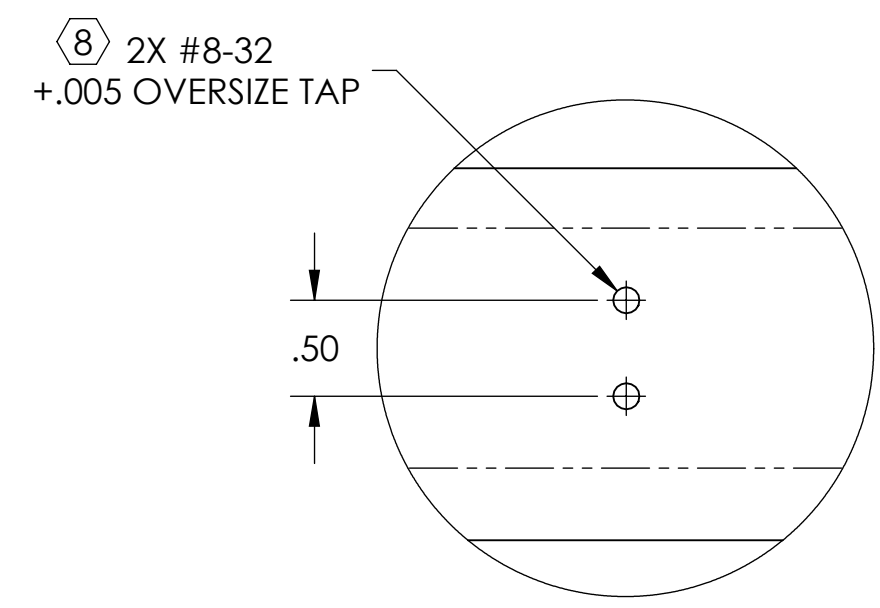
ISOMETRIC VIEW (BACK SIDE SHOWING)

ISOMETRIC VIEWS FOR SMALL HOLE PLACEMENT

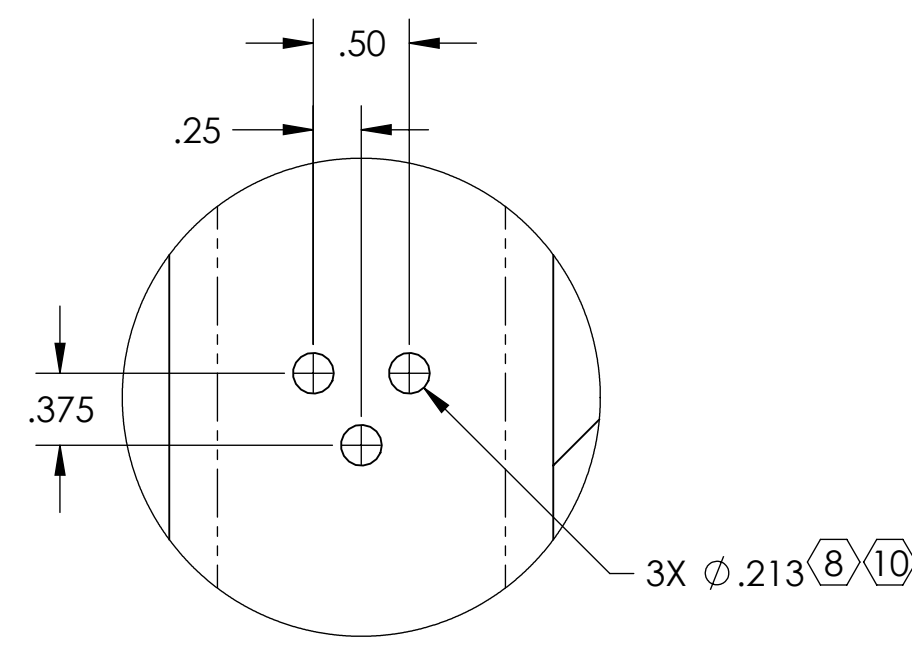


SMALL HOLE LAYOUT

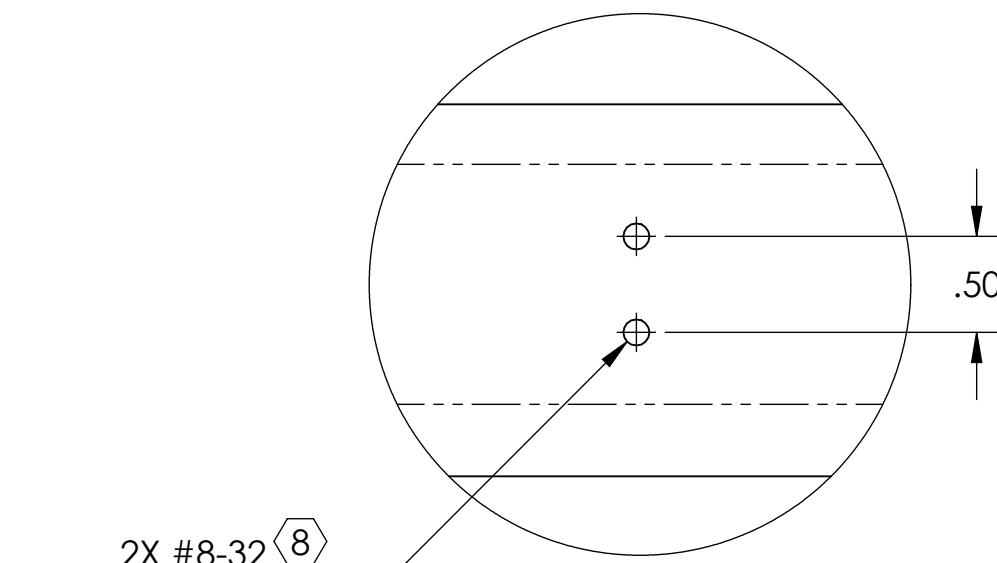




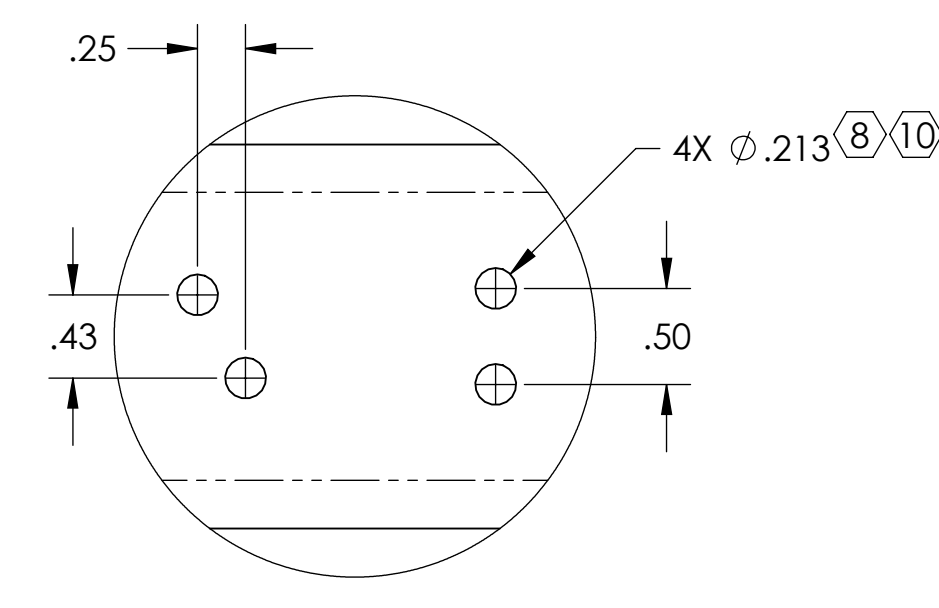
DETAIL D  
SCALE 1 : 1



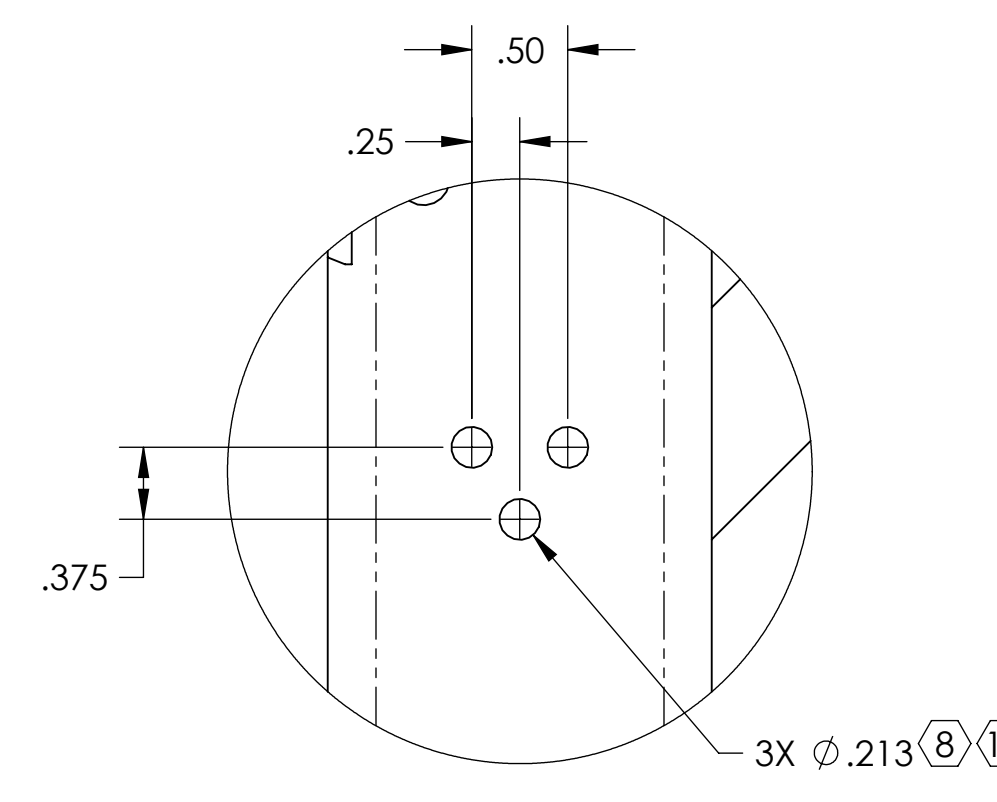
DETAIL F  
SCALE 1 : 1  
2 PLACES



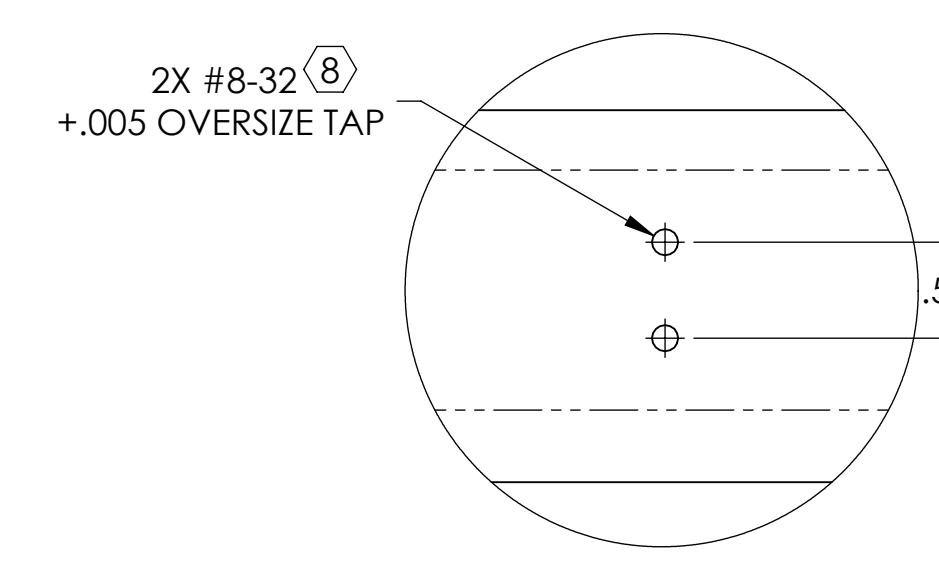
DETAIL G  
SCALE 1 : 1



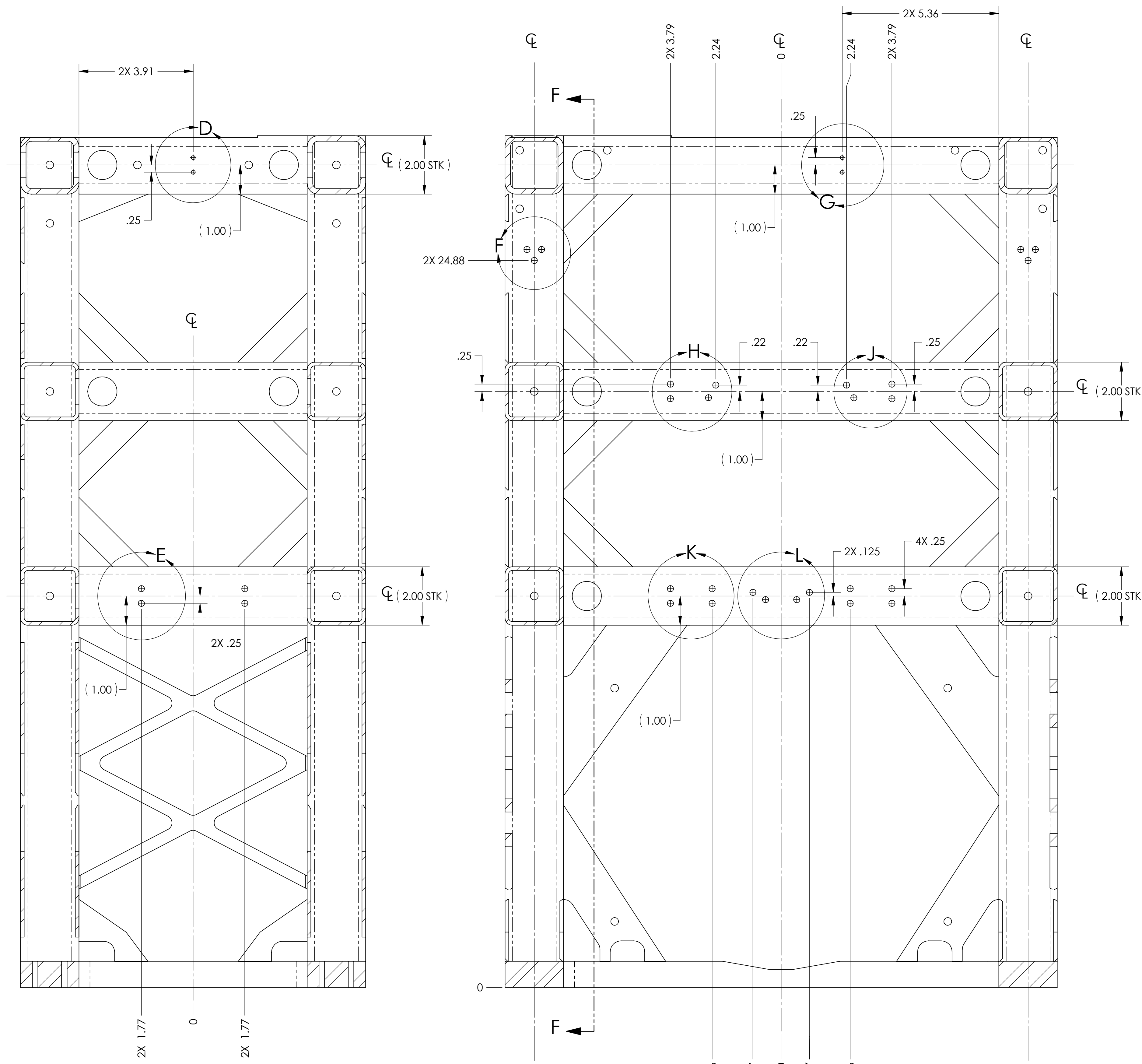
DETAIL J  
SCALE 1 : 1



DETAIL M  
SCALE 1 : 1  
2 PLACES

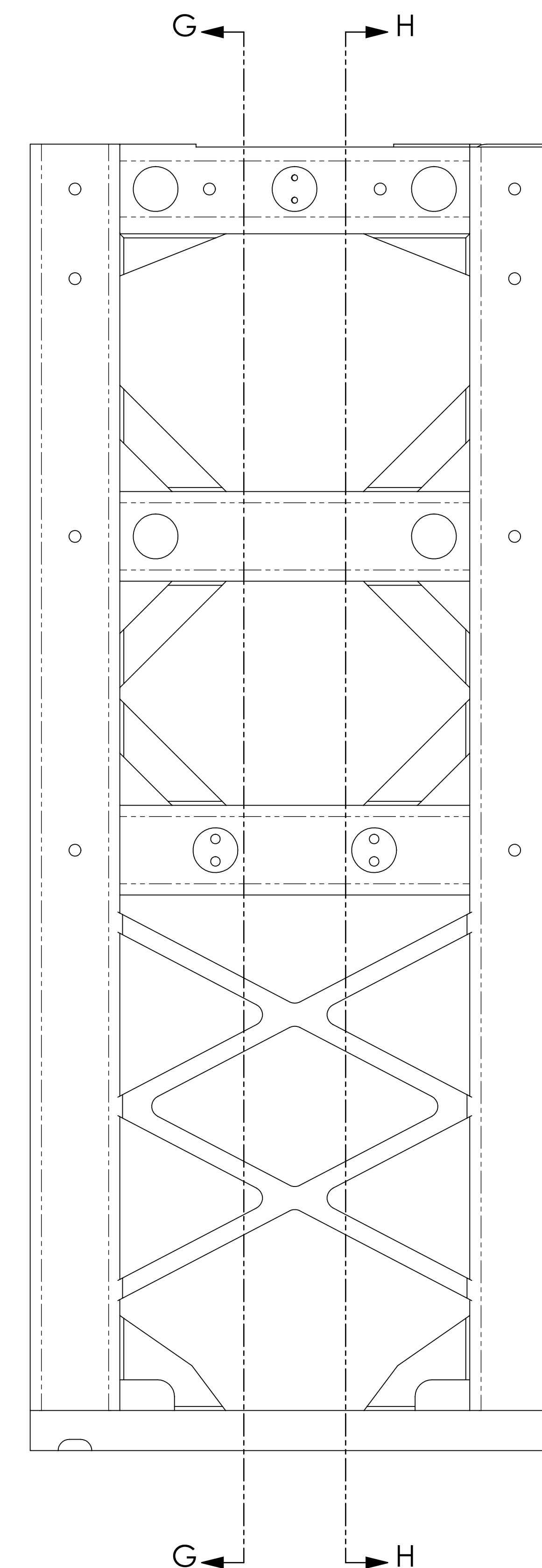


DETAIL N  
SCALE 1 : 1

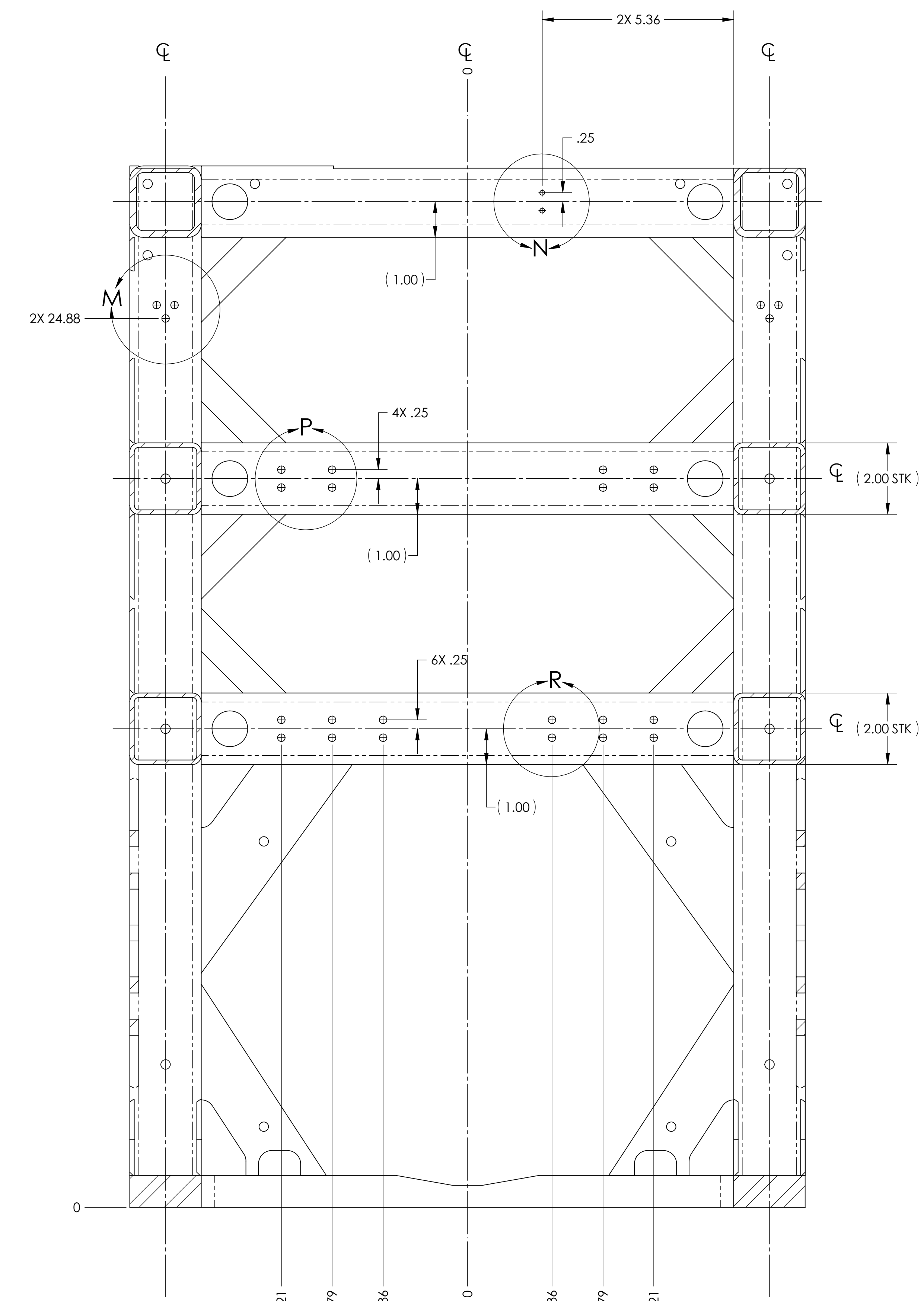


SECTION F-F  
LEFT AND RIGHT INSIDE VIEW

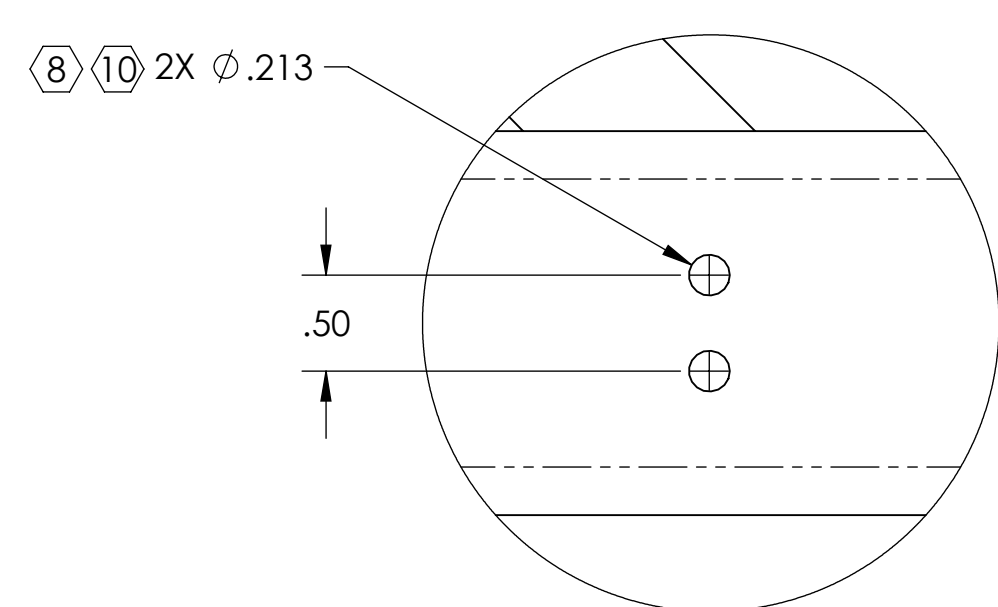
SECTION G-G  
FRONT INSIDE VIEW



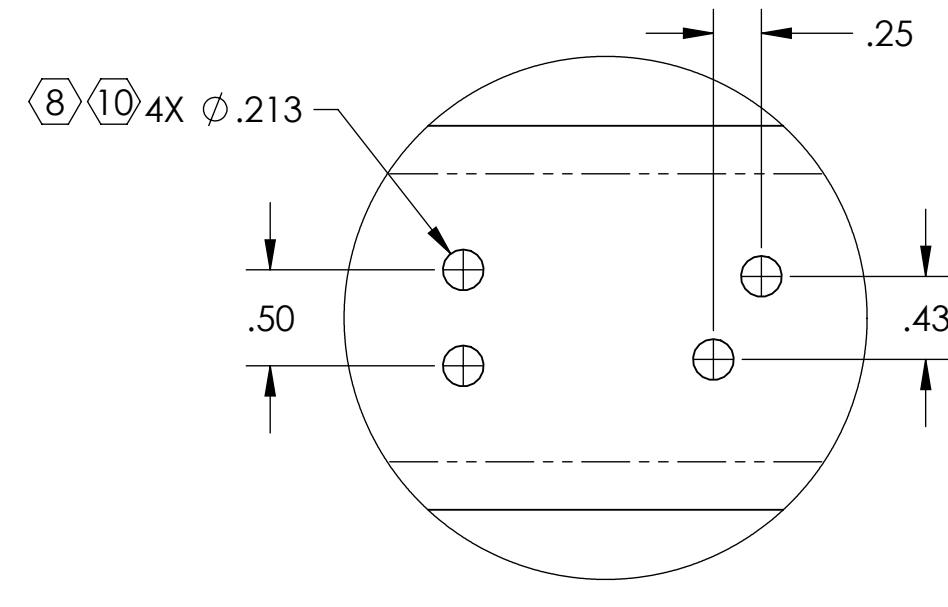
SECTION H-H  
BACK INSIDE VIEW



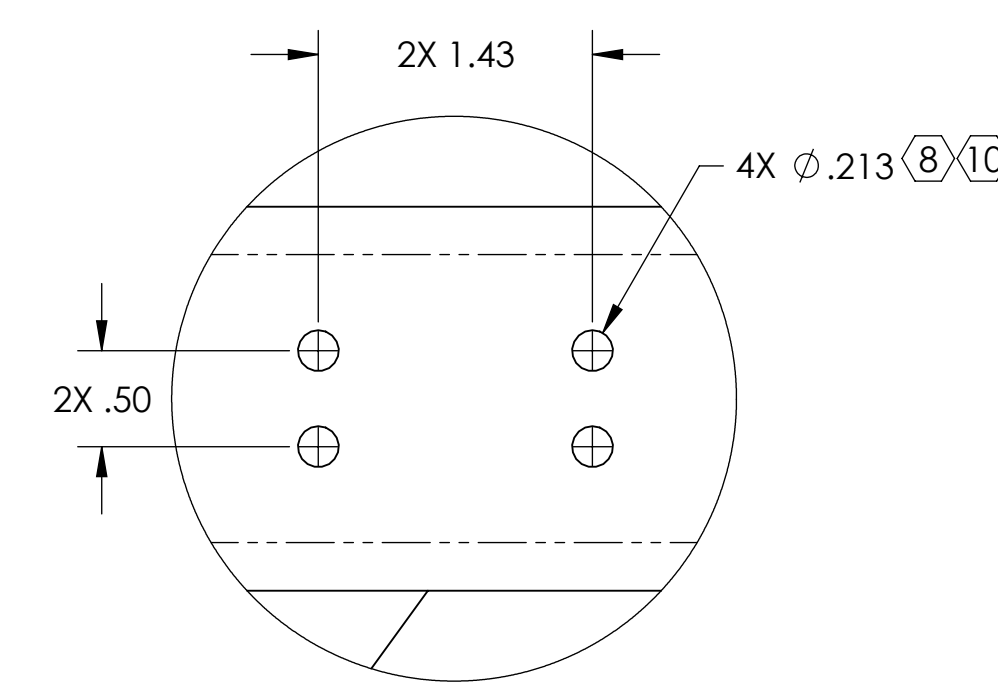
SECTION I-I  
BACK INSIDE VIEW



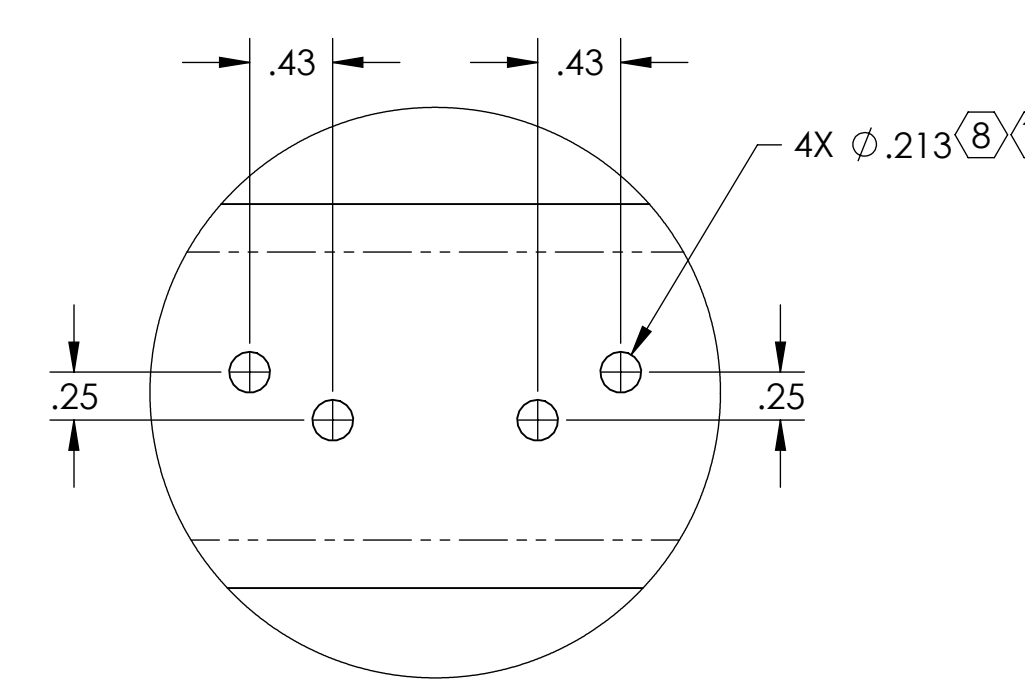
DETAIL E  
SCALE 1 : 1  
2 PLACES



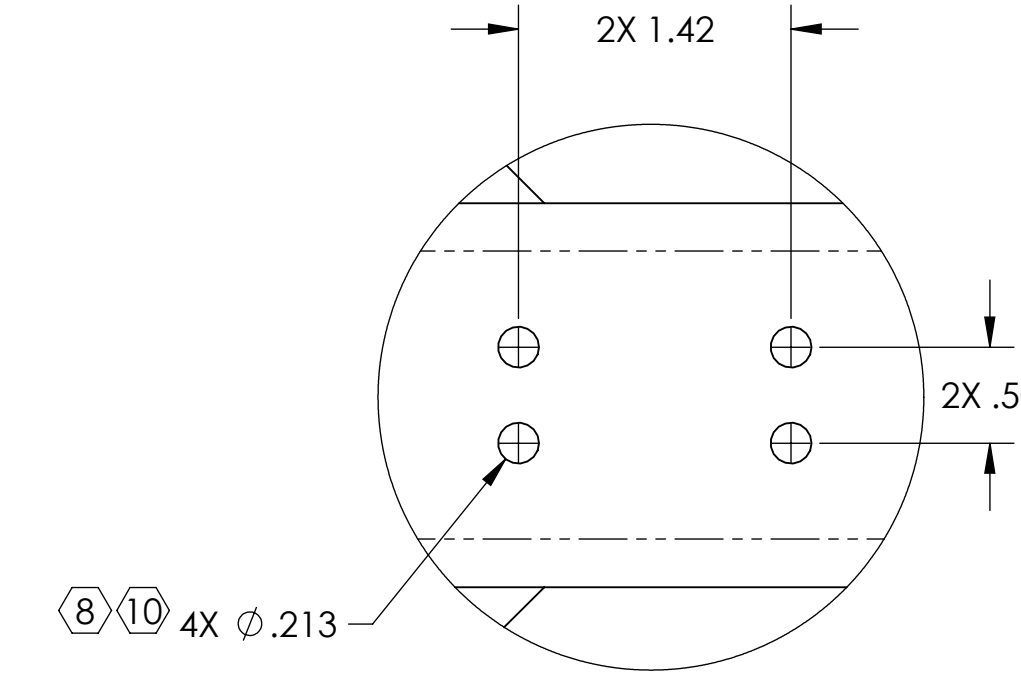
DETAIL H  
SCALE 1 : 1



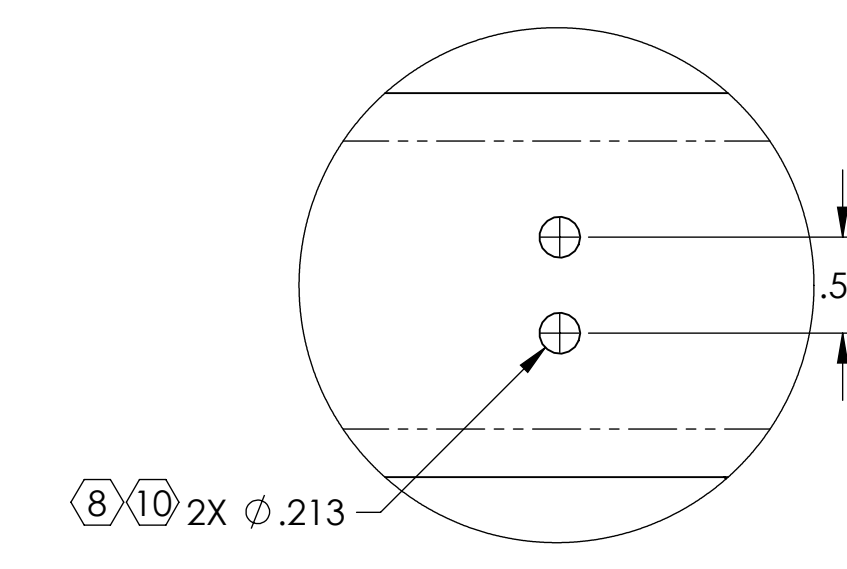
DETAIL K  
SCALE 1 : 1  
2 PLACES



DETAIL L  
SCALE 1 : 1



DETAIL P  
SCALE 1 : 1  
2 PLACES



DETAIL R  
SCALE 1 : 1  
6 PLACES