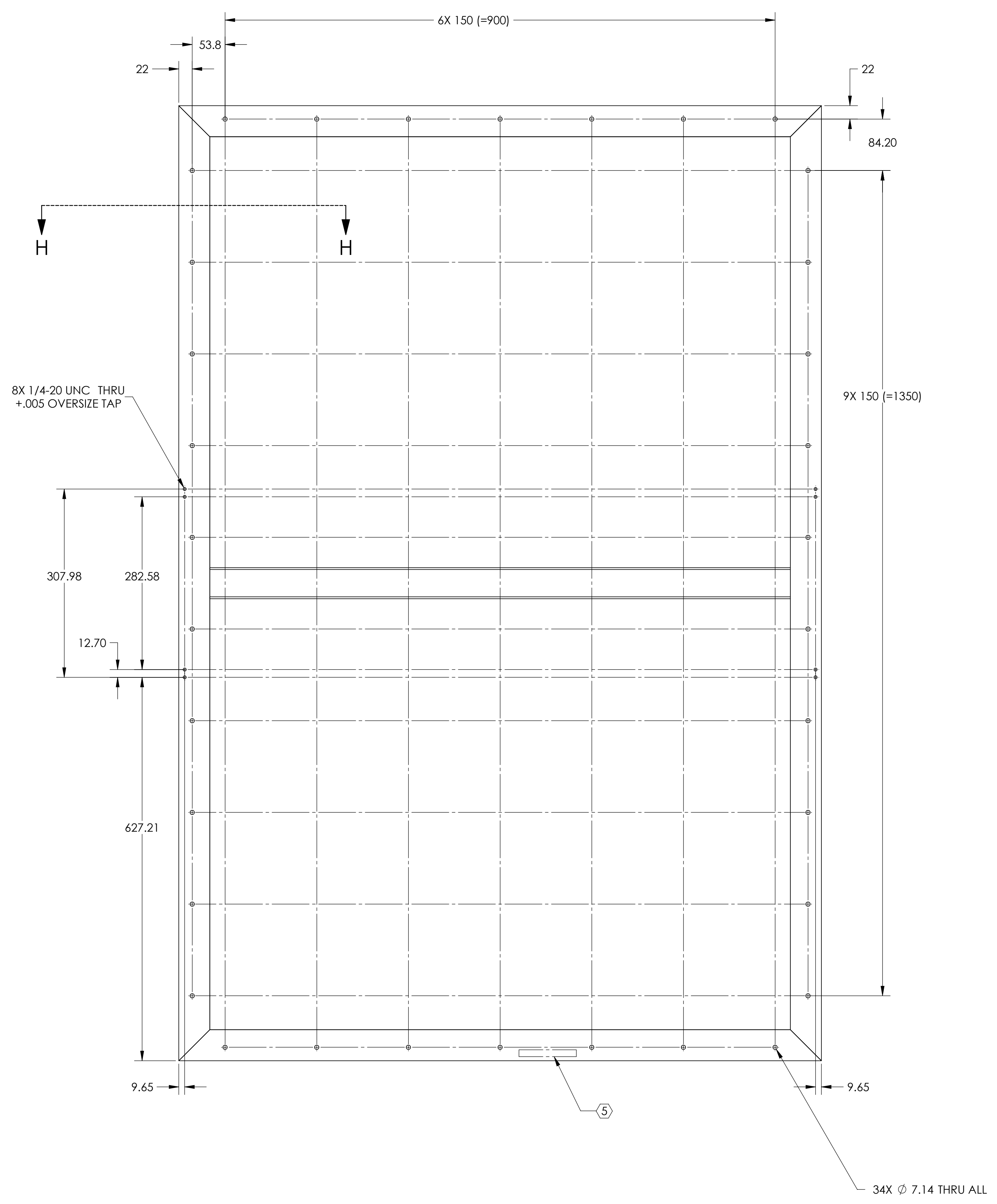
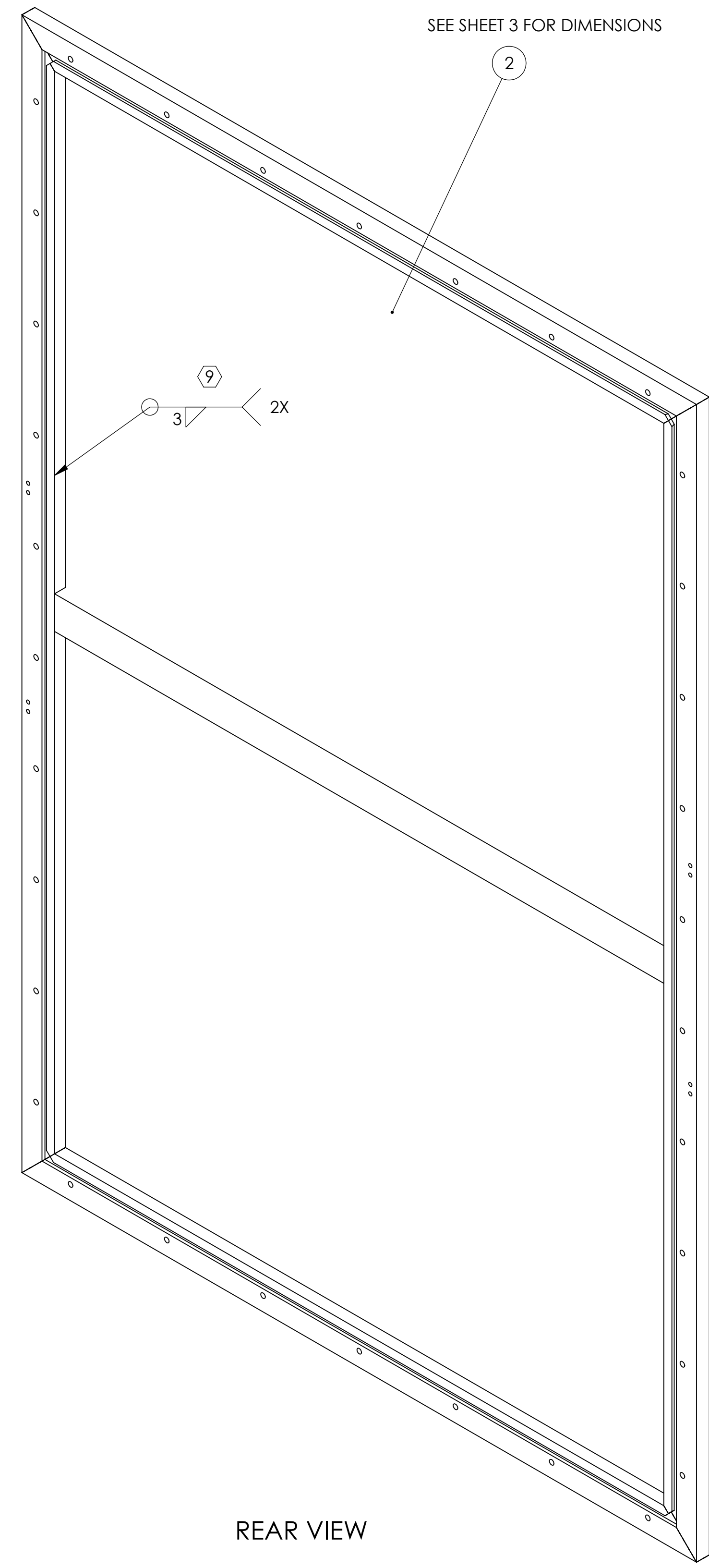
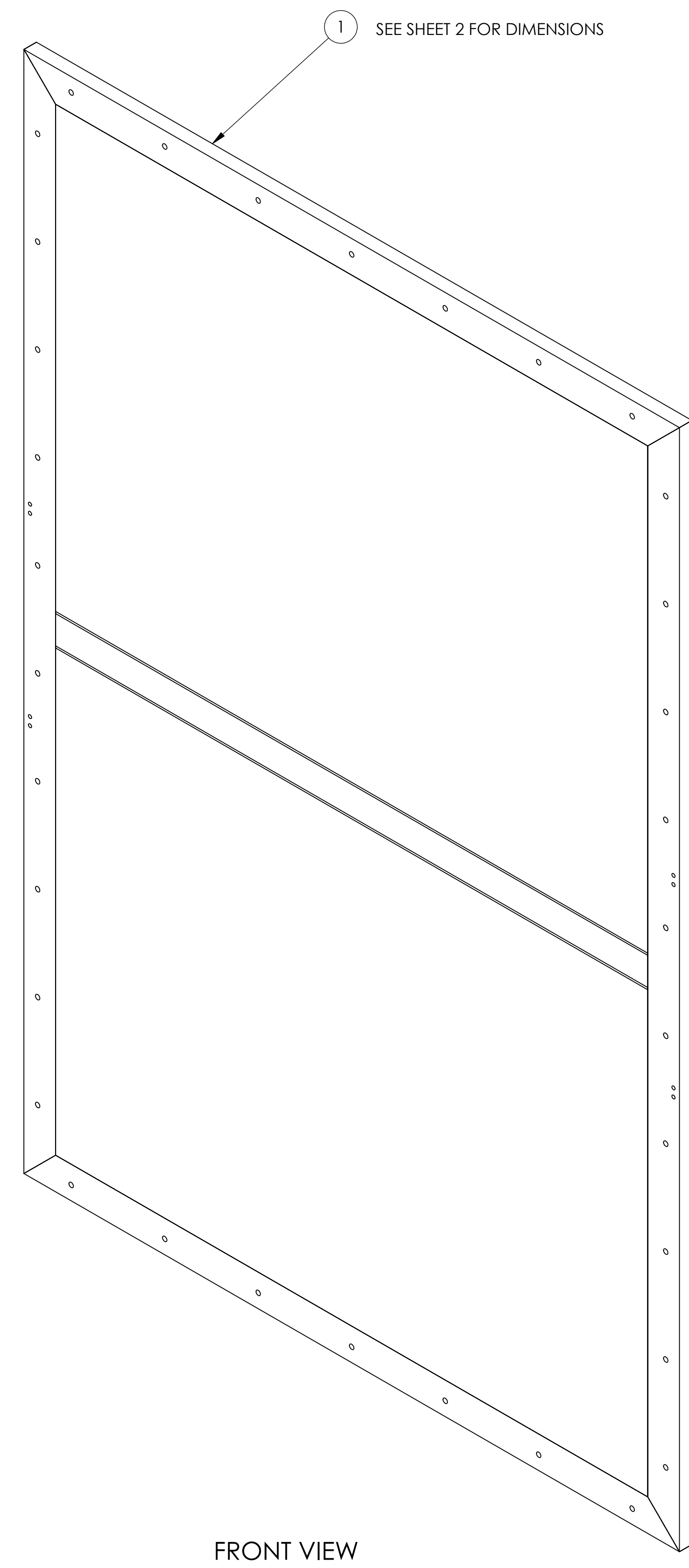
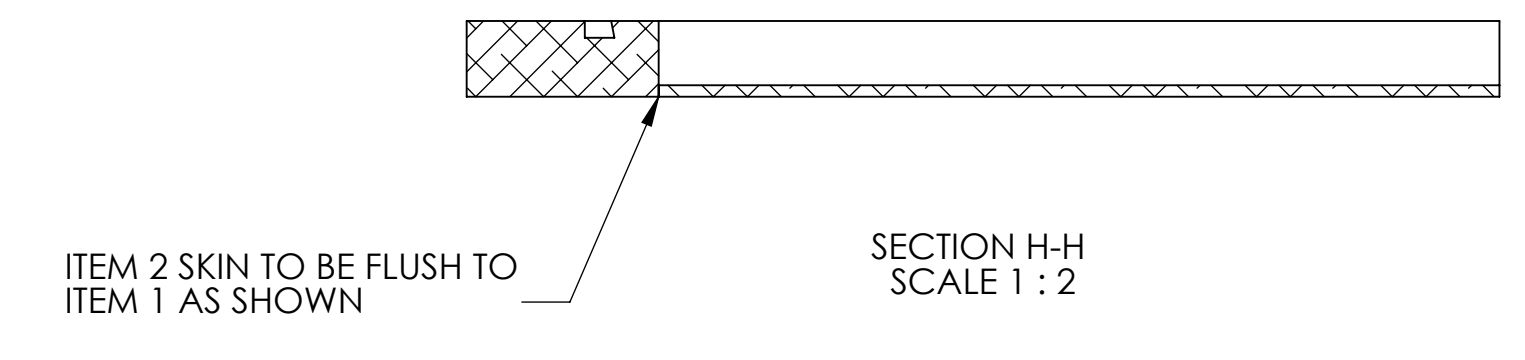


NOTES CONTINUED:

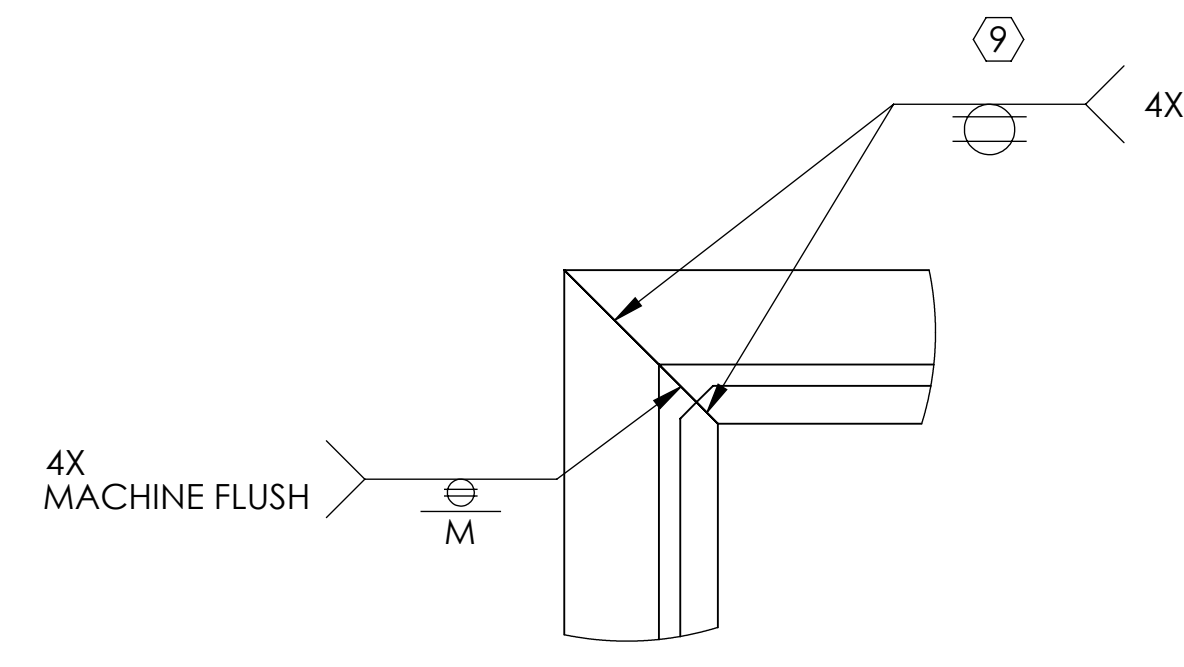
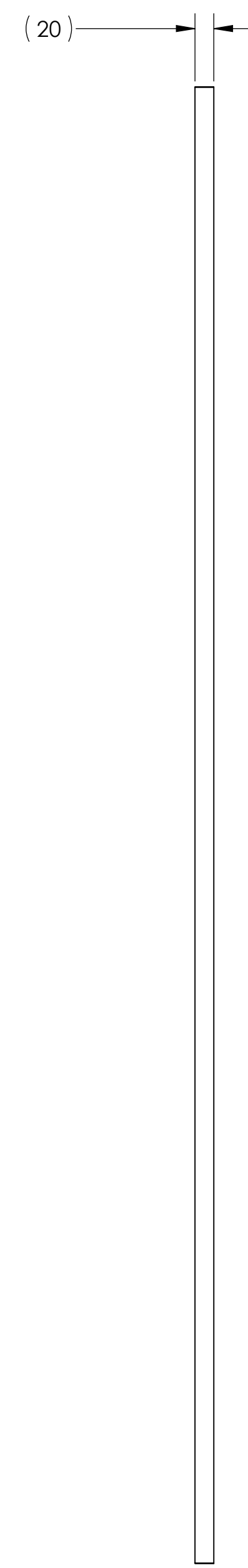
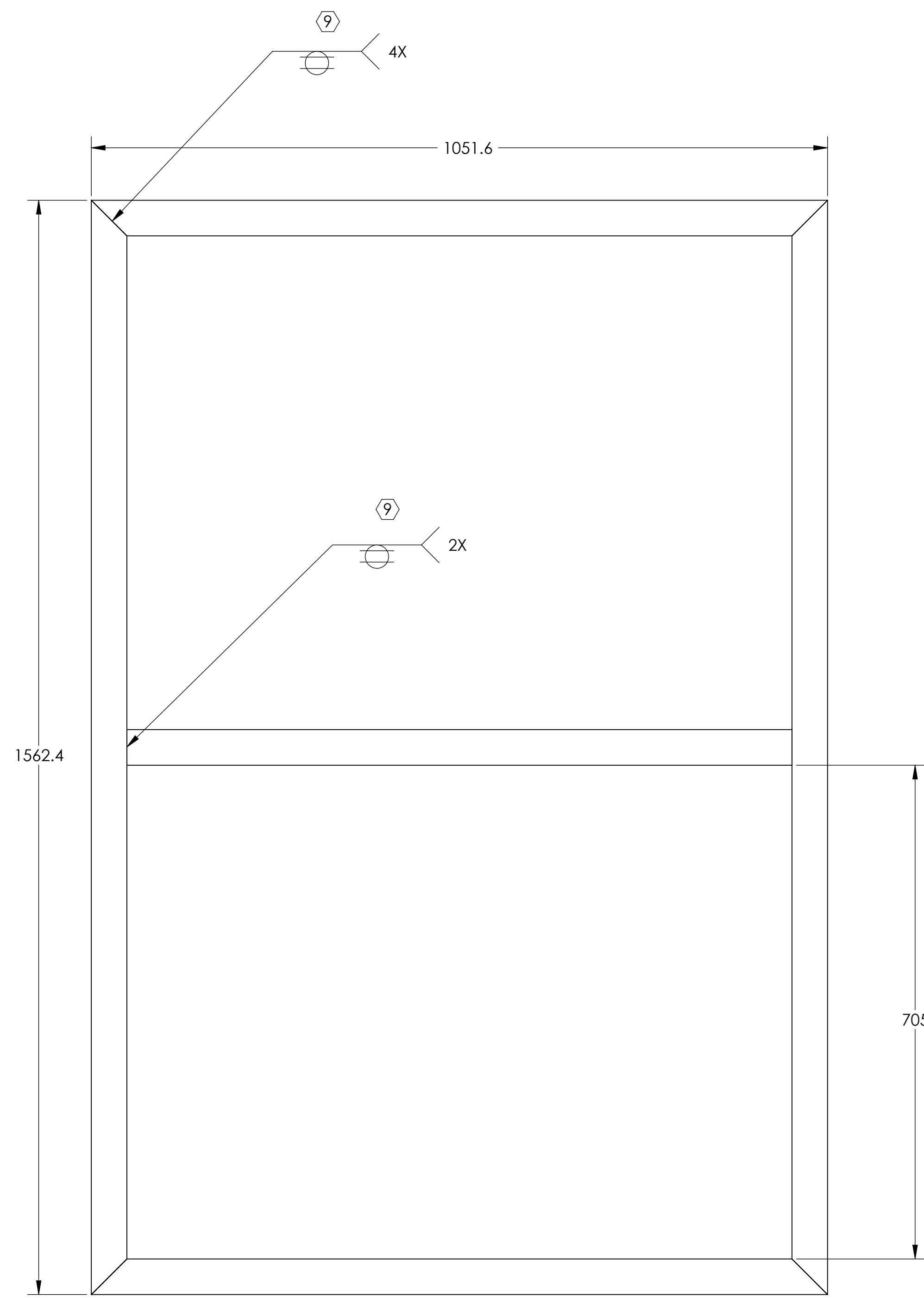
- ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWINGS PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 59 LB.
- ⑦ MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ⑨ WELDING:  
ALL DIMENSIONS APPLY AFTER WELDING.  
ALL WELDS SHALL BE DONE ON THE INTERIOR OF THE CONTAINER SUCH THAT NO SEAMS ARE EXPOSED ON THE INTERIOR OF THE BOX.  
ALL WELDS MUST BE CONTINUOUS.  
SEAMS WILL TRAP CONTAMINATION AND BE HARD TO CLEAN.  
ALL WELDS MUST BE COMPLETE JOINT PENETRATION WELDS OR PARTIAL PENETRATION WELDS. THE CONTAINER SHOULD FULLY SEAL AT THE WELDS, SUCH THAT THE CONTAINER IS AIR TIGHT.  
NO TRAPPED VOLUMES ARE PERMITTED.  
WELDMENTS WITH CREVICES ARE CONSIDERED NON-CLEANABLE SINCE THESE CREVICES ACT AS TRAPS FOR CLEANING SOLUTIONS.  
ALL WELDERS SHOULD BE CERTIFIED TO AMERICAN WELDING SOCIETY (AWS).
- 10. THE FRONT PANEL CAN BE MADE FROM ONE PIECE IF PREFERRED.

REV.	DATE	DCN #	DRAWING TREE #
V1	18 AUG 2010		
V2	20 AUG 2010		
V3	29 SEPT 2010		
V4	12 OCT 2010	E1000577	
V5	7 DEC 2010	E1000840	

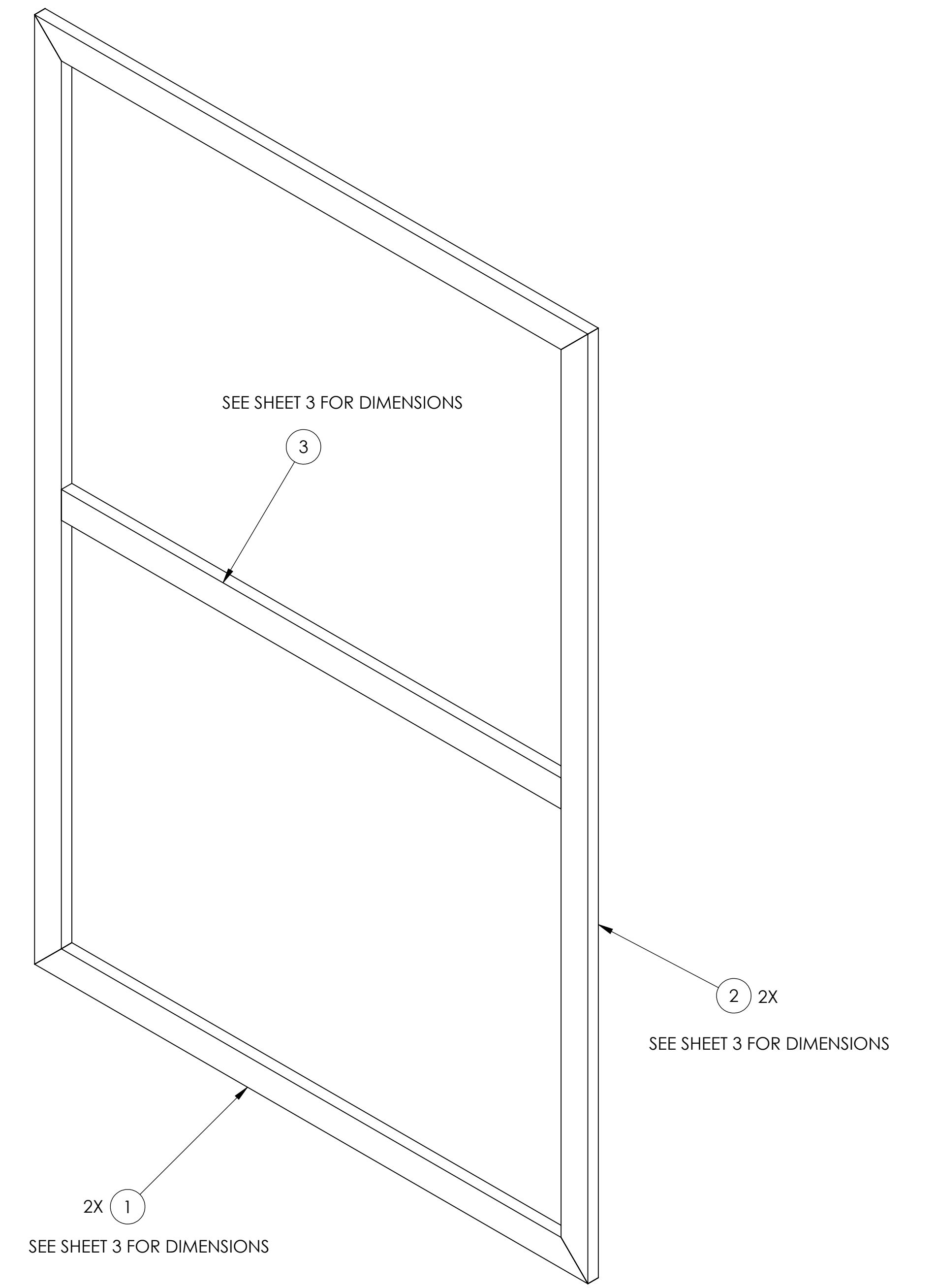
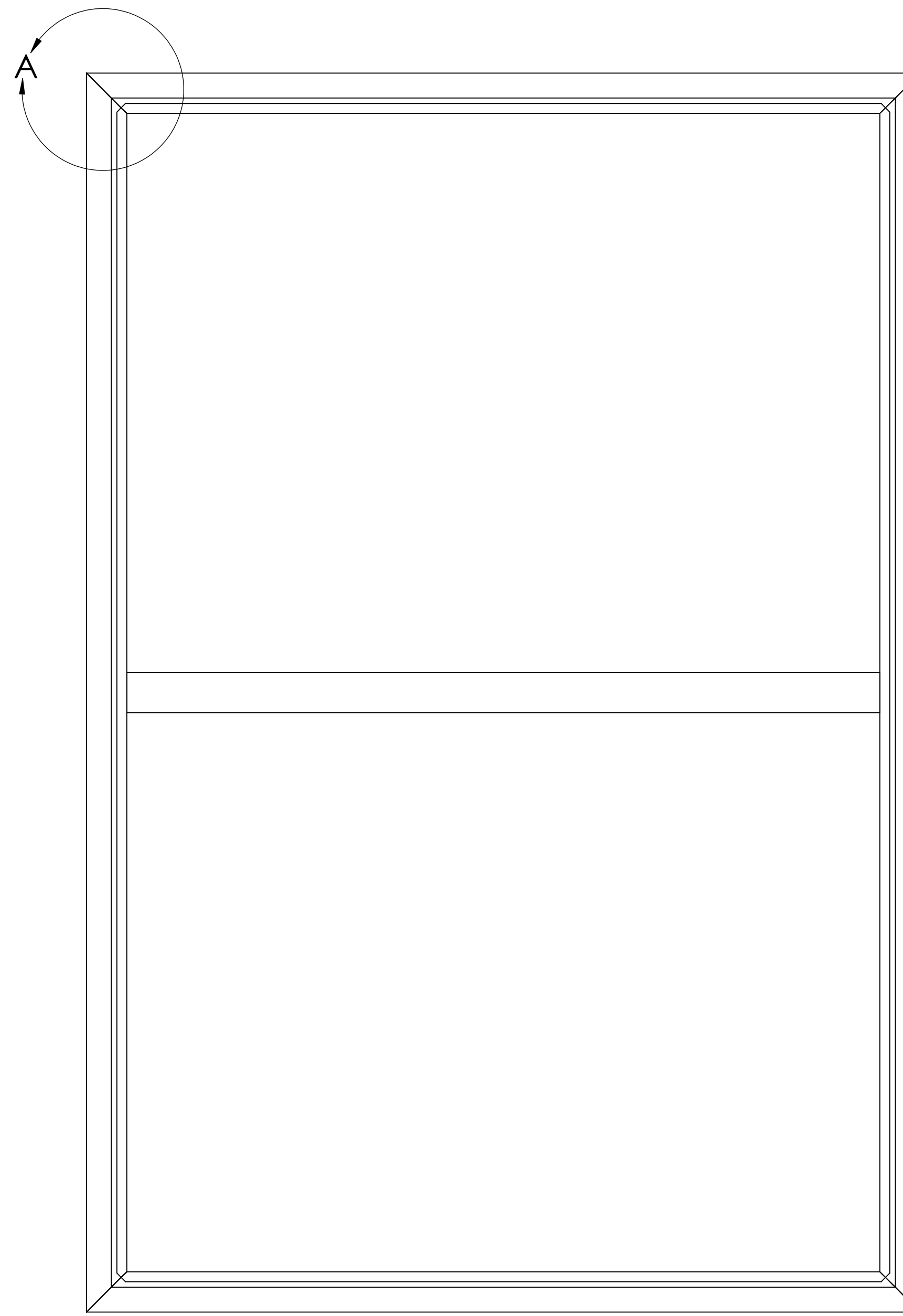


ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
2	BACK SKIN	LOWER QUAD STORAGE CONTAINER BACK SKIN	6061-T6 Al	2		2
1	FRONT PANEL	LOWER QUAD STORAGE CONTAINER FRONT PANEL	6061-T6 Al	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .25 .XXX ± .13 ANGULAR ± .5°		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY SYSTEM <b>ADVANCED LIGO</b> SUB-SYSTEM SUS NEXT ASSY D1002118		PART NAME <b>LOWER STRUCTURE STORAGE CONTAINER FRONT PANEL</b> DESIGNER: K. BUCKLAND 6 AUG 2010 DRAFTER: K. BUCKLAND 18 AUG 2010 CHECKER: APPROVAL:		SIZE DWG. NO. <b>E D1002120</b> SCALE: 1:4 PROJECTION:		REV. <b>v5</b> SHEET 1 OF 3	
--	--	--	--	--	--	--	--	--	--	-----------------------------------	--

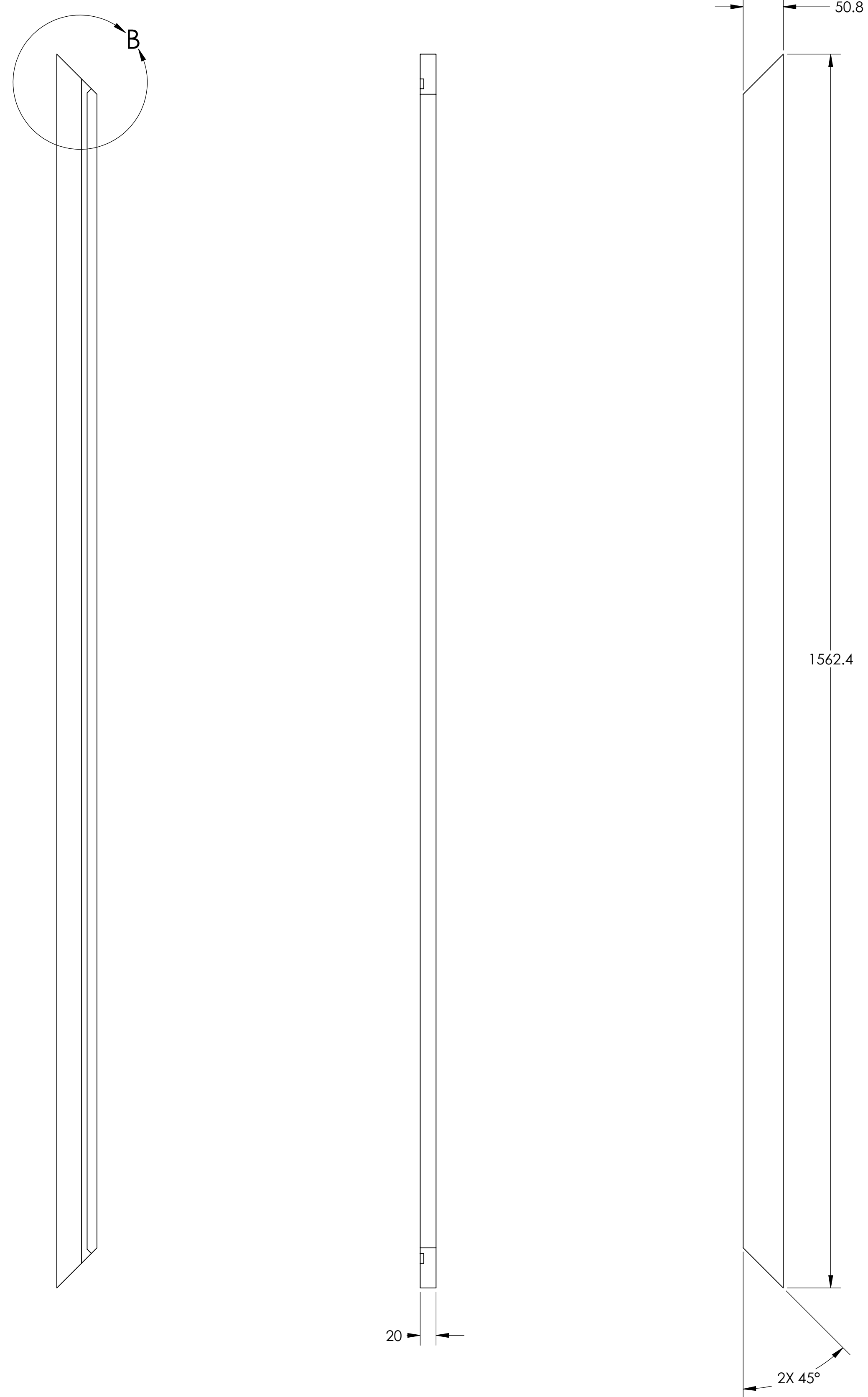
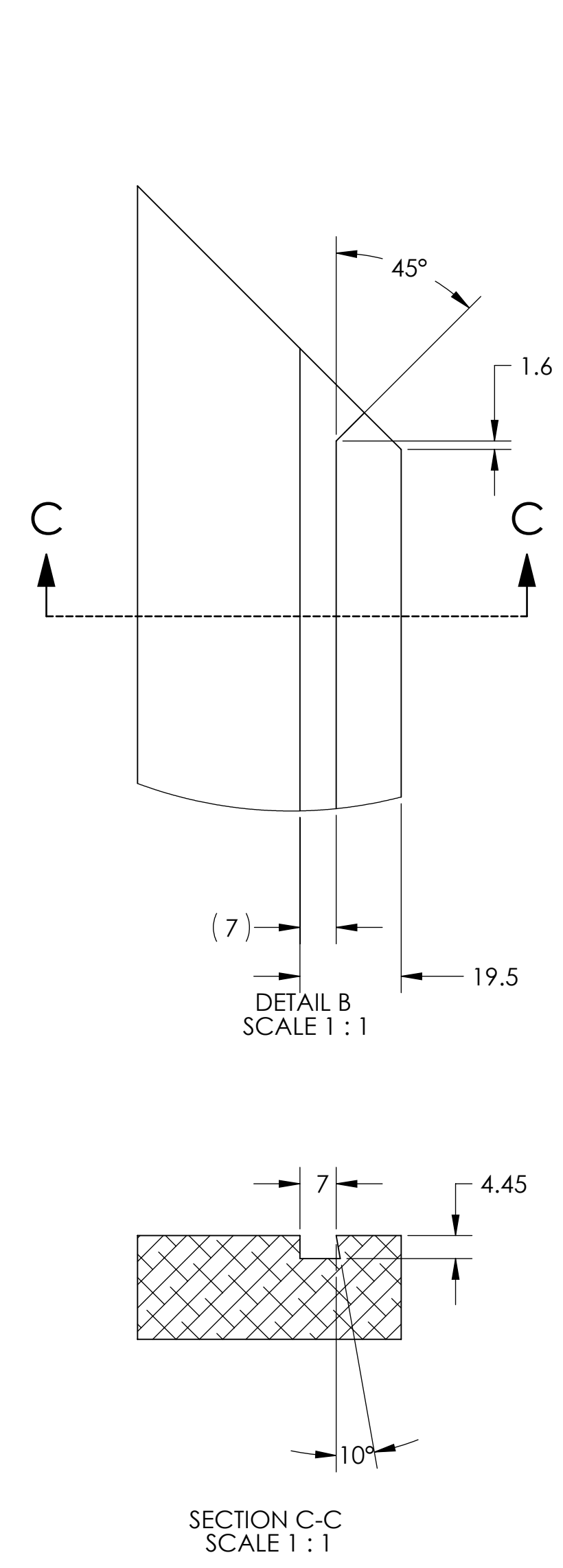


DETAIL A  
SCALE 2 : 5

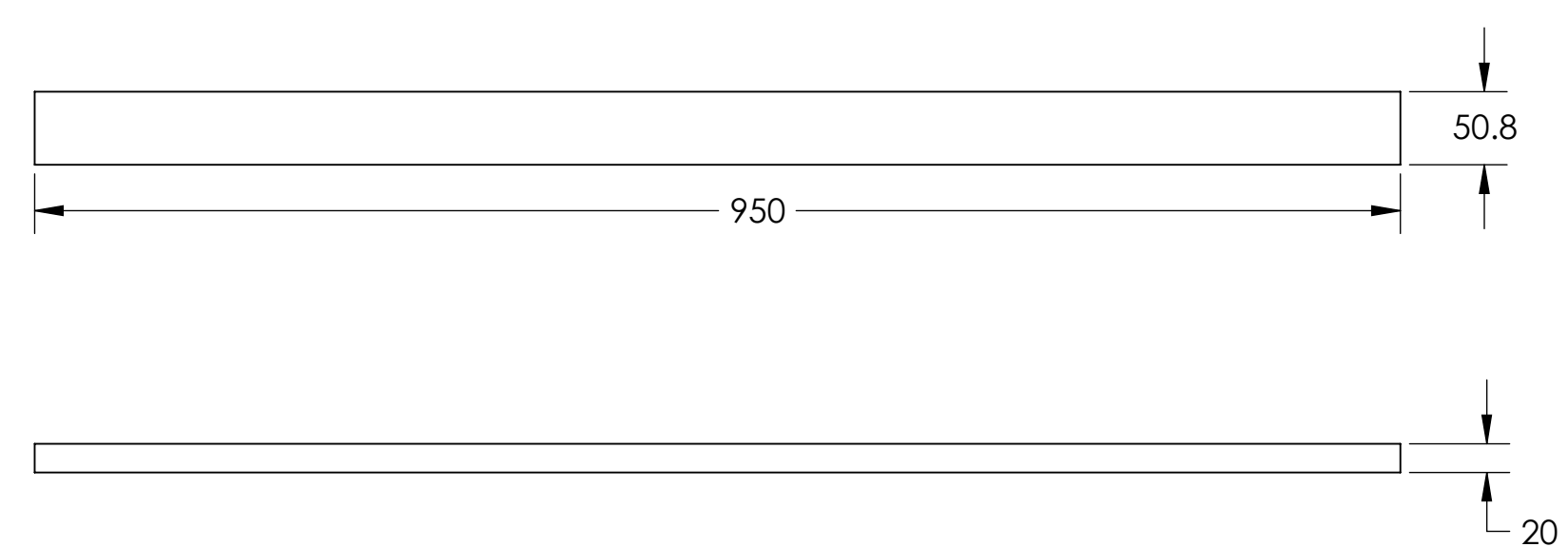


ITEM NO.	QTY.	DESCRIPTION	LENGTH
1	2	C CHANNEL, 50.80 X 5	1051.6
2	2	C CHANNEL, 50.80 X 5	1562.4
3	1	C CHANNEL, 50.80 X 5	950

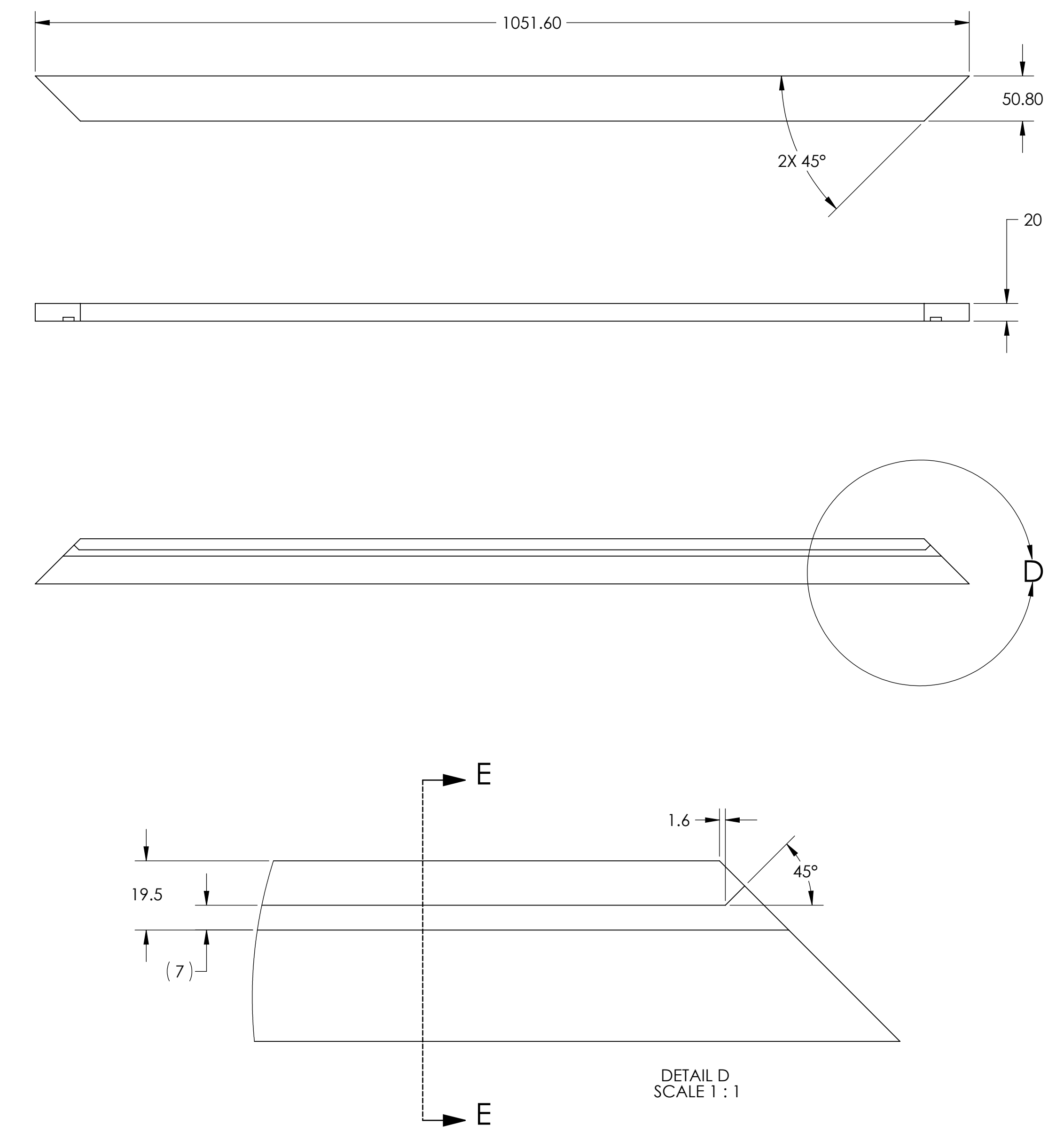
D:\000201-0400-USE-LOWER STRUCTURE FRAME\CONFRAME FRONT PANEL.dwg, PLOT FILE REV. 2004, DRAWING FILE REV. X.008



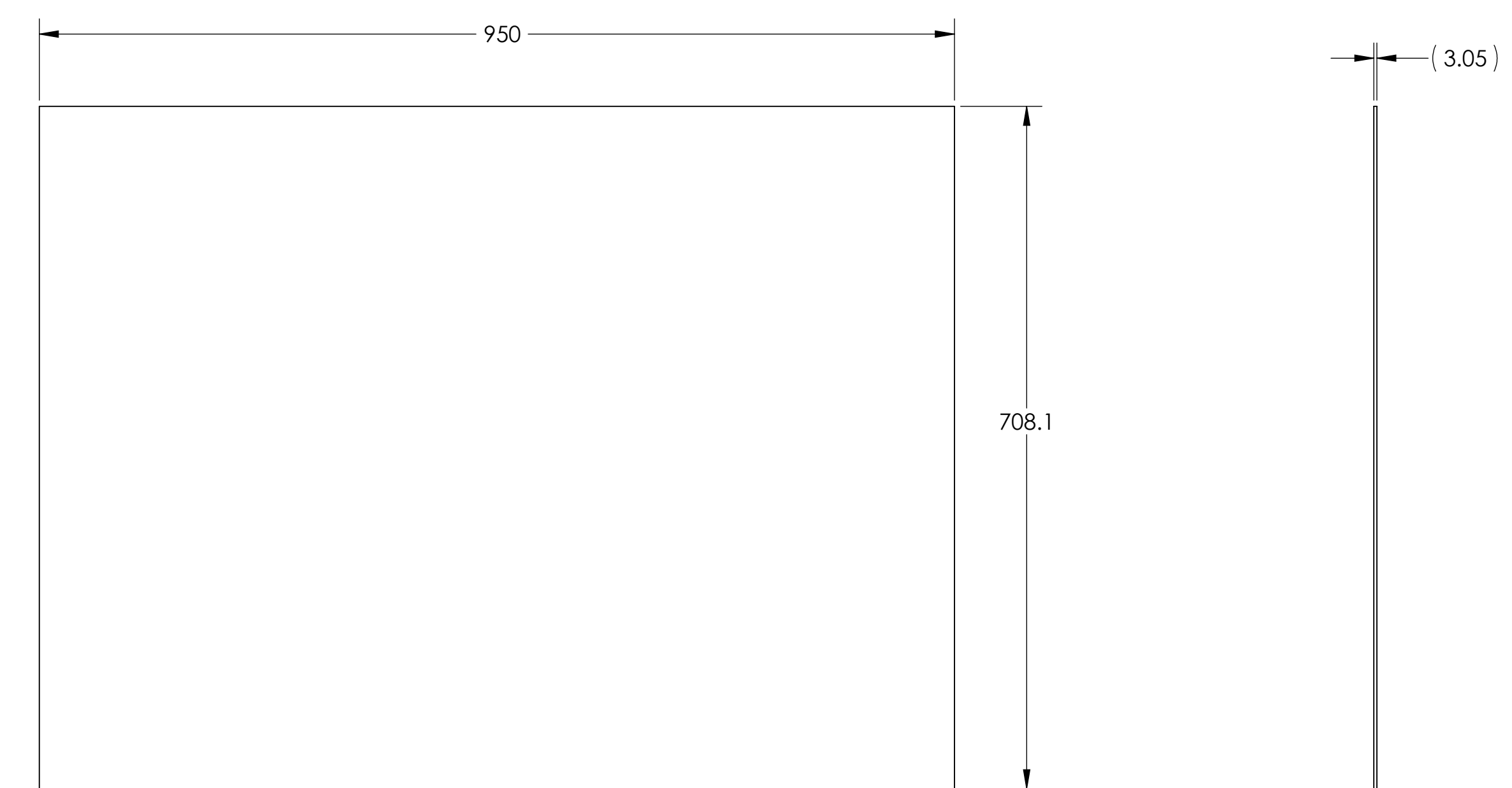
SIDE  
MATERIAL: 6061-T6 ALUM ALLOY  
SURFACE FINISH: 63 μINCH ⑦  
2 REQ'D



MIDDLE  
MATERIAL: 6061-T6 ALUM ALLOY  
SURFACE FINISH: 63 μINCH ⑦  
1 REQ'D



TOP AND BOTTOM  
MATERIAL: 6061-T6 ALUM ALLOY  
SURFACE FINISH: 63 μINCH ⑦  
2 REQ'D



FRONT PANEL SKIN  
MATERIAL: .12 THICK  
6061 OR 5052 ALUM ALLOY  
SURFACE FINISH: 32 μinch  
2 REQ'D