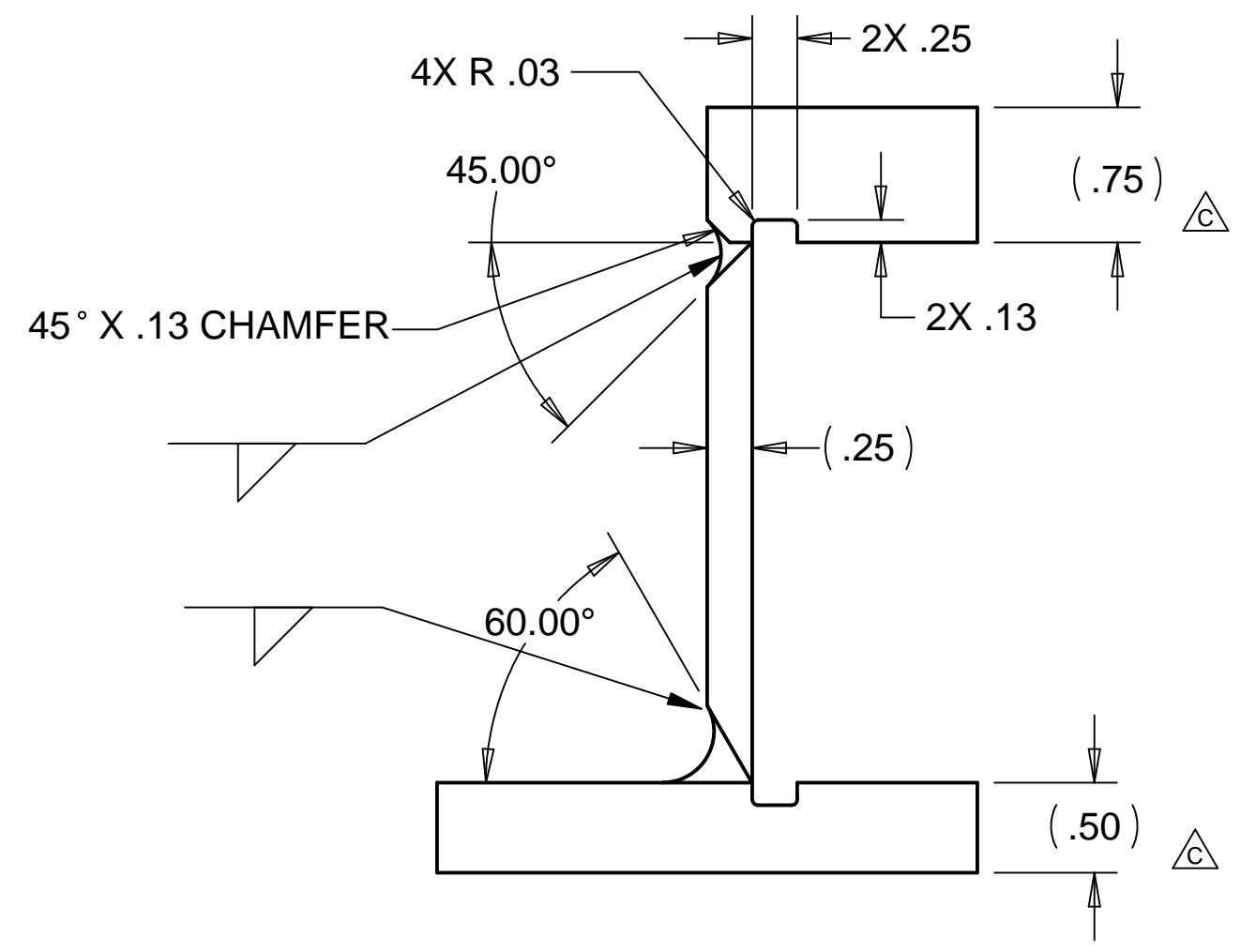


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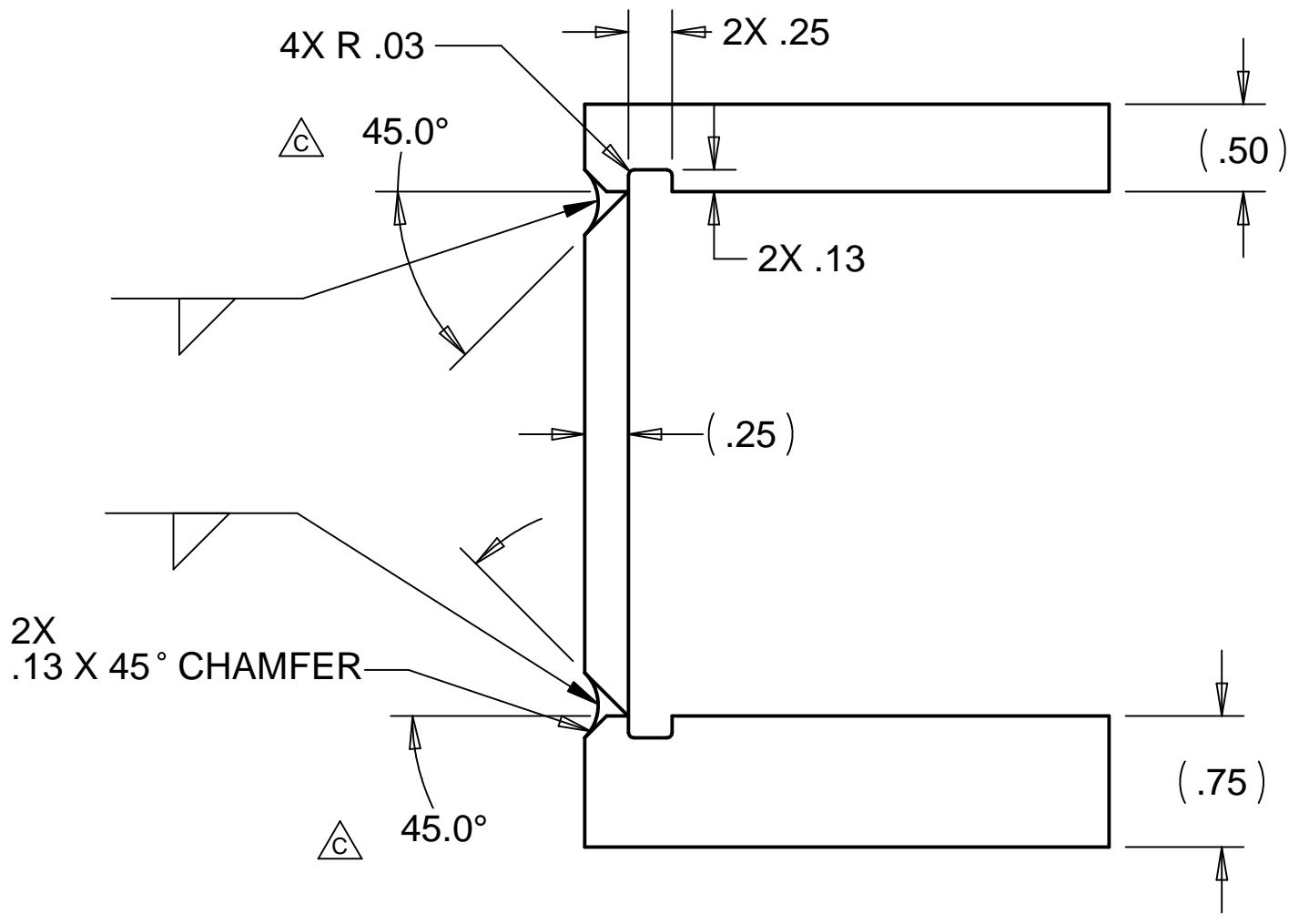
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
B	SEE ECN# D972202-B FOR CHANGE LIST	03-11-98	T. THOMPSON
C	SEE ECN# D972202-C FOR CHANGE LIST	03-20-98	T. THOMPSON

D

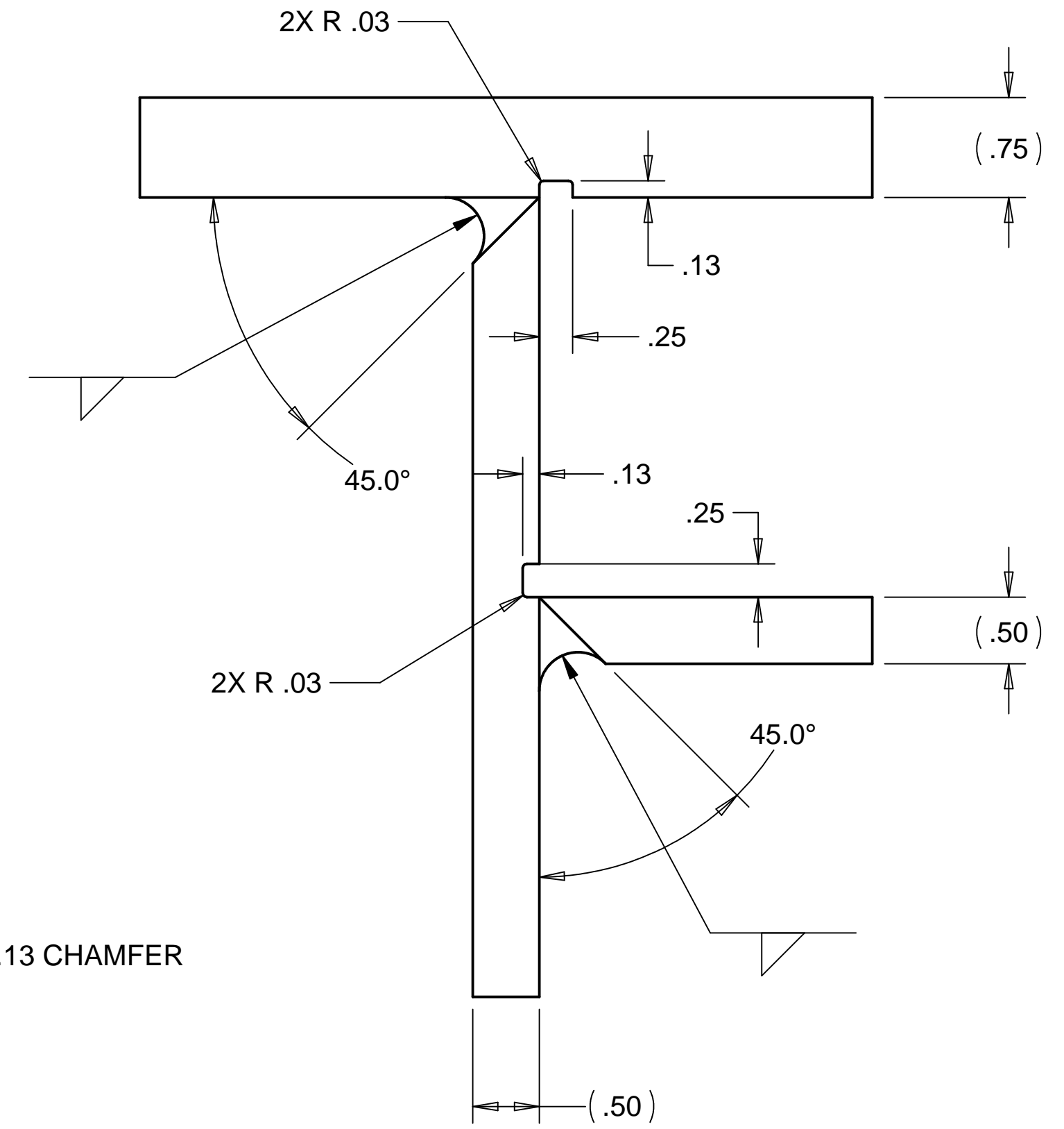
D



△ CONFIGURATION #1
USED ON: D972711



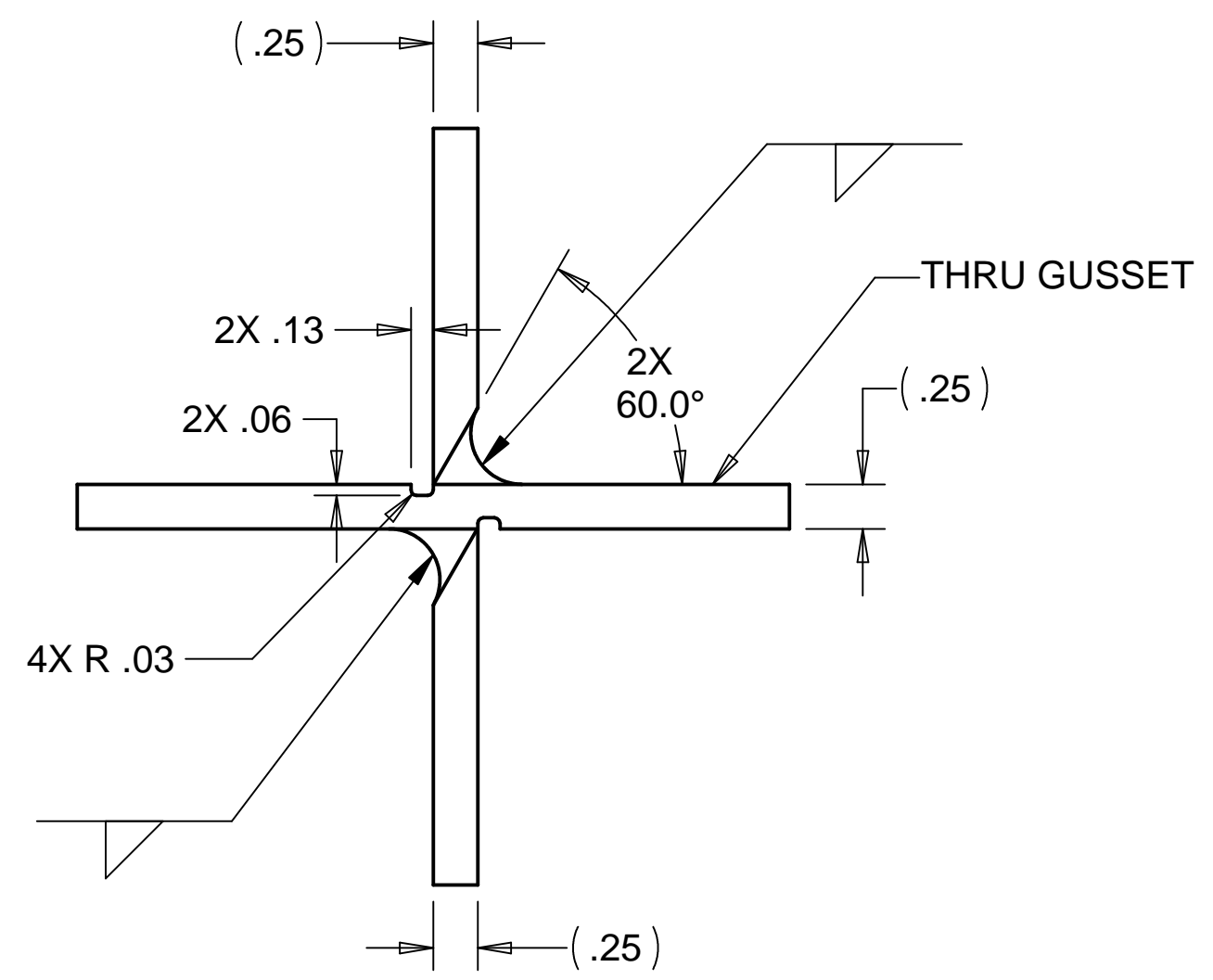
△ CONFIGURATION #2
USED ON: D972211
D972212
D972710
D972711



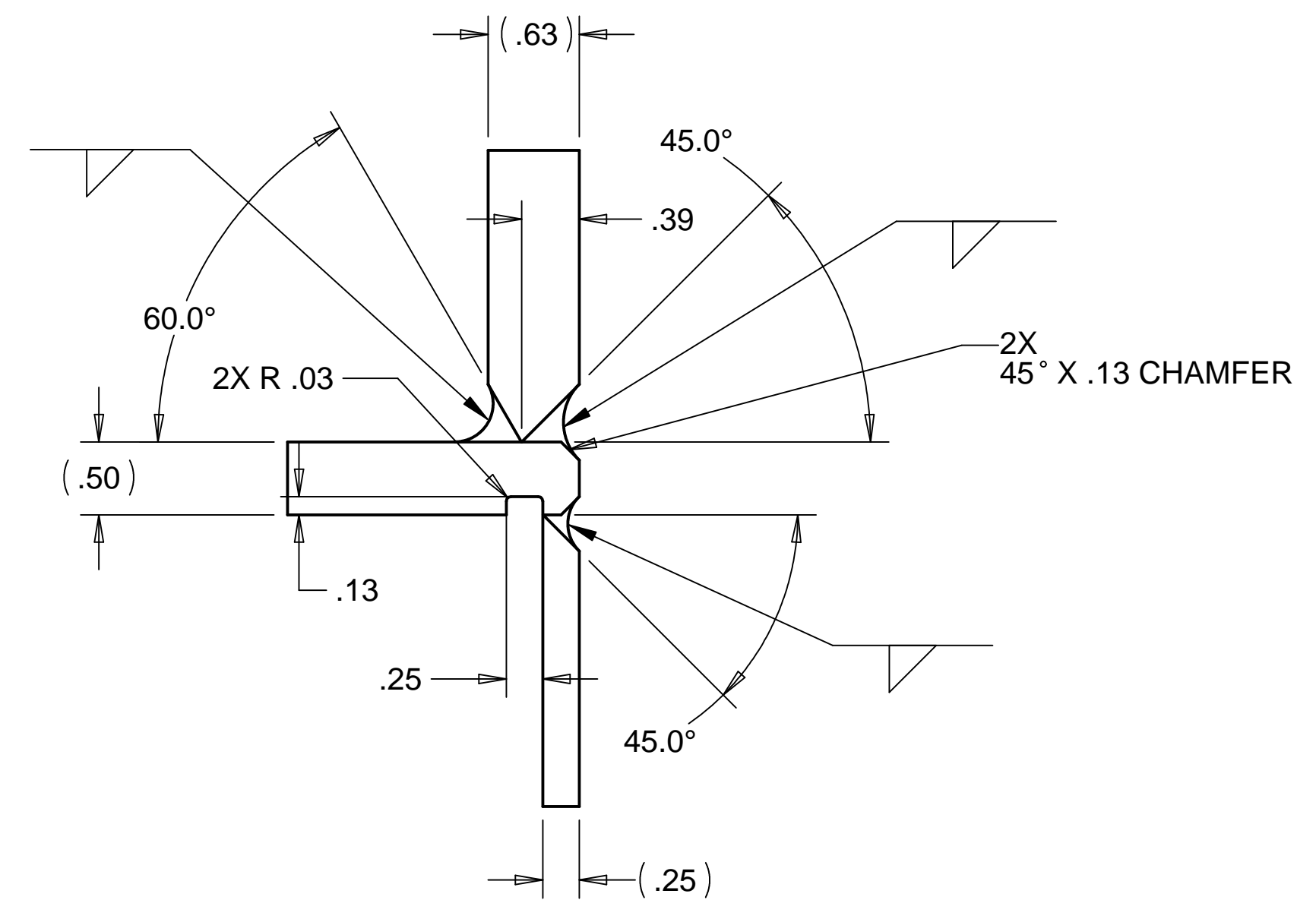
△ CONFIGURATION #3
USED ON: D972212

C

C



△ CONFIGURATION #4
USED ON: D972211
D972212
D972710



△ CONFIGURATION #5
USED ON: D972211

B

B

A

A

NOTES:

1. WELD RELIEF GROOVES TO BE INTERMITANT, CENTERED ON WELD TABS. GROOVES TO BE 1/4" - 1/2" LONGER THAN LENGTH, EACH SIDE.
2. ALL ALUM. WELDING DONE BY A GTAW PROCESS USING 2% THORIATED TUNGSTEN WELDING ELECTRODES AND ER4043 WELDING ROD (SPEC. PER AWS A5.10-80).
3. NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED MACHINE LUBRICANT: HANSTERFER S-500CF.
4. WRAP WELD START/STOP CORNERS ON DOUBLE BEVEL WELDS (5,6,7,10,12,17) FOR VIRTUAL LEAK FREE WELD.
5. WELDS SHOULD BE CONTINUOUS OVER THE FULL LENGTH OF THE WELD PREPARATION.
6. WELDS SHOULD BE STRUCTURALLY SOUND. MULTIPLE PASSES MAY BE REQUIRED. OK TO NOT FILL COMPLETE.

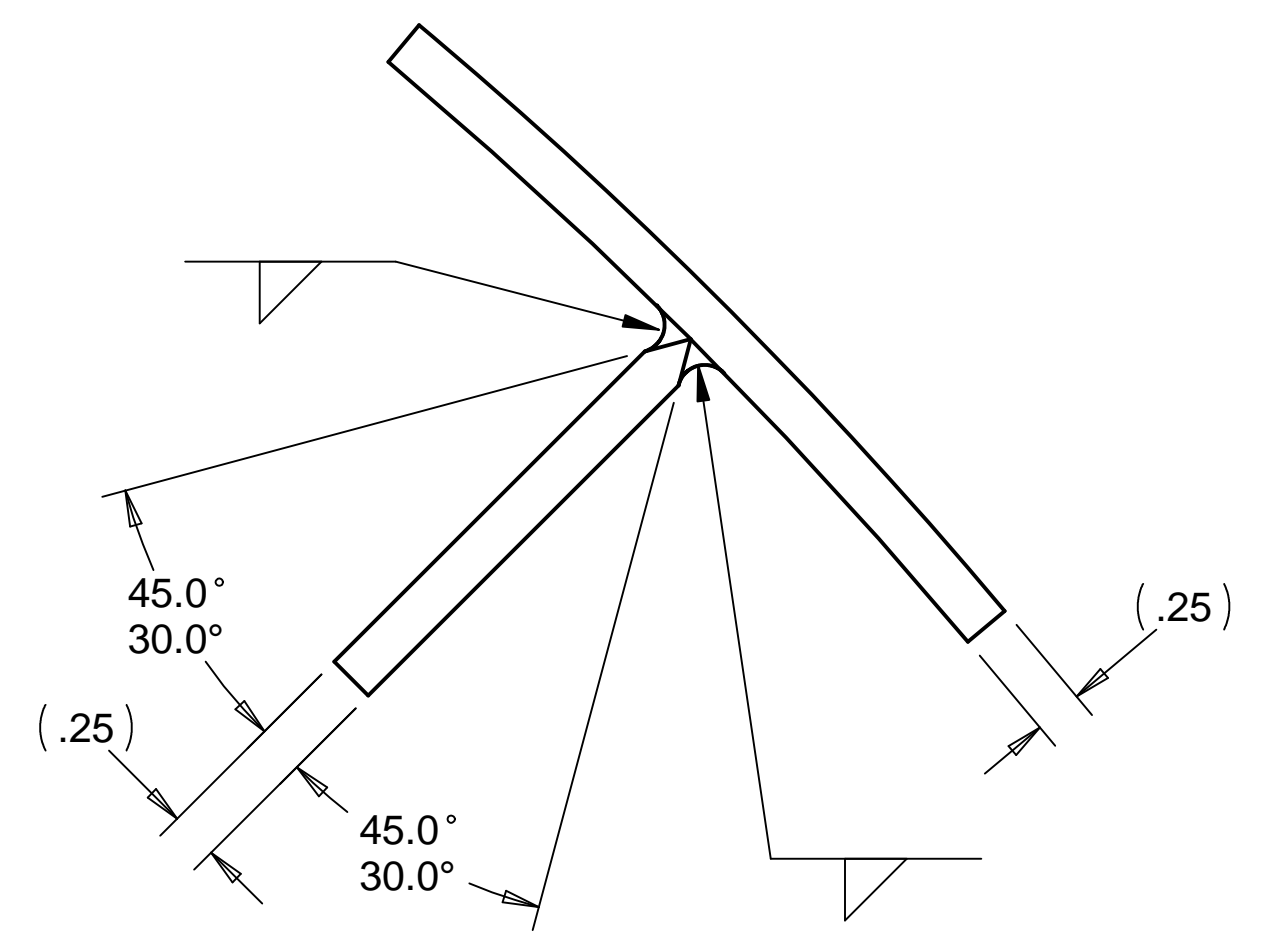
PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		HYTEC, INC TITLE LIGO WELD CONFIGURATION & WELD PROCEDURE
	DECIMALS .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30' SURFACE FINISH = 250	
FINISH	SIGNATURE	DATE	SIZE SHEET NO.
	DESIGNED ROGER L. SMITH	5-28-97	D 1 of 3
	DRAWN ROGER L. SMITH	5-28-97	
	CHECKED HARRY SALAZAR	6-6-97	
	ENGR. T. THOMPSON	7-10-97	
PART NO. D972202-1	APPROVED T. THOMPSON	7-10-97	SCALE 1/1 REVISION C

8 7 6 5 4 3 2 1

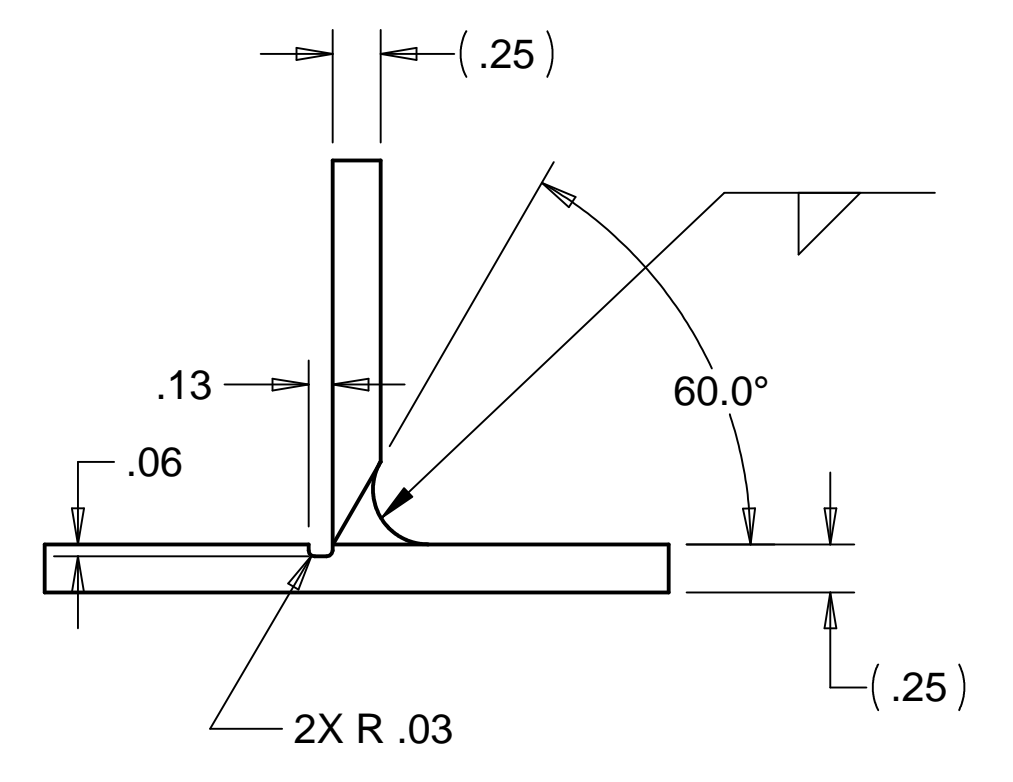
8 7 6 5 4 3 2 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
B	SEE ECN# D972202-B FOR CHANGE LIST	03-11-98	T. THOMPSON
C	SEE ECN# D972202-C FOR CHANGE LIST	03-20-98	T. THOMPSON

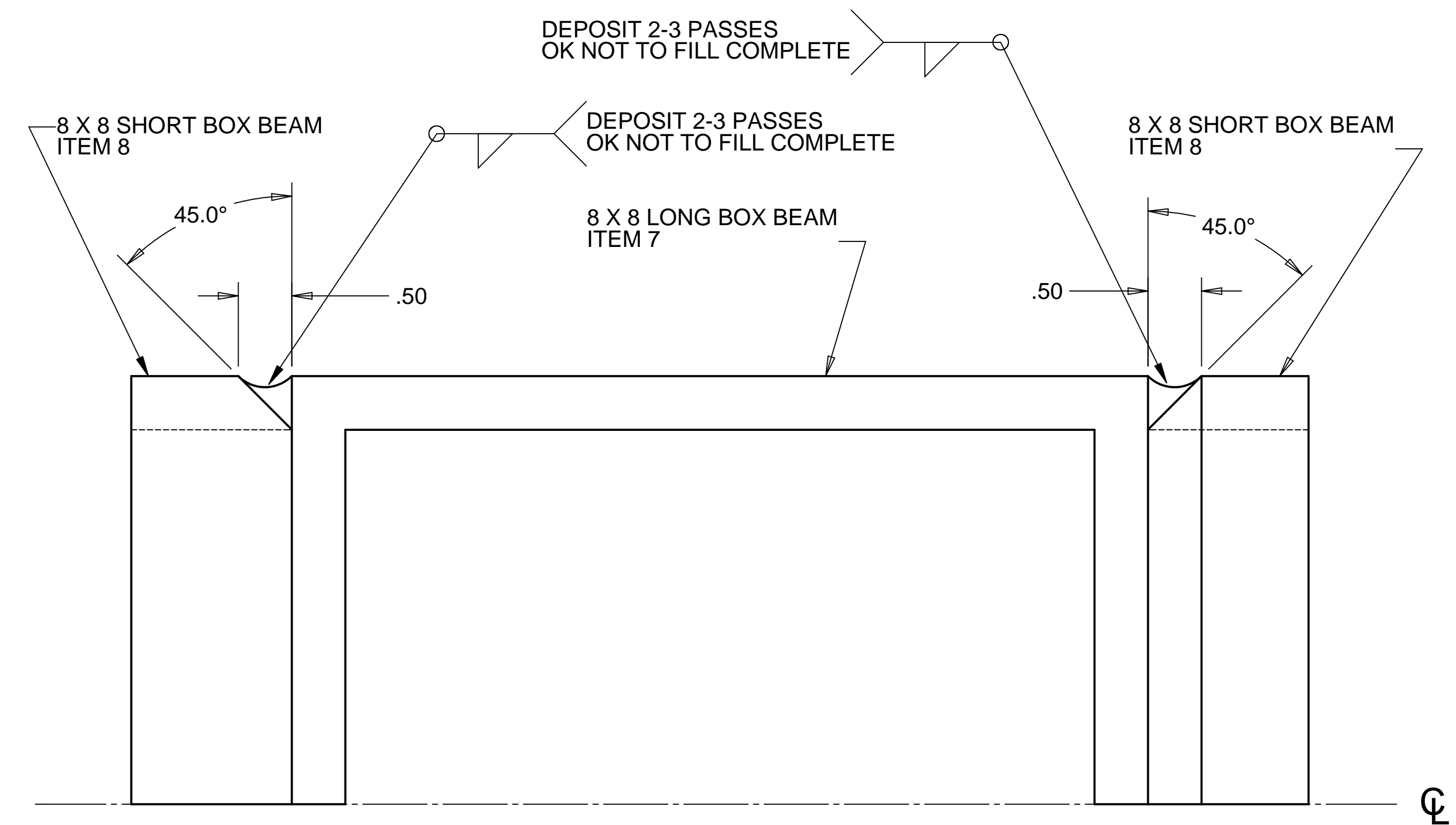
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CONFIGURATION #7
USED ON: D972211

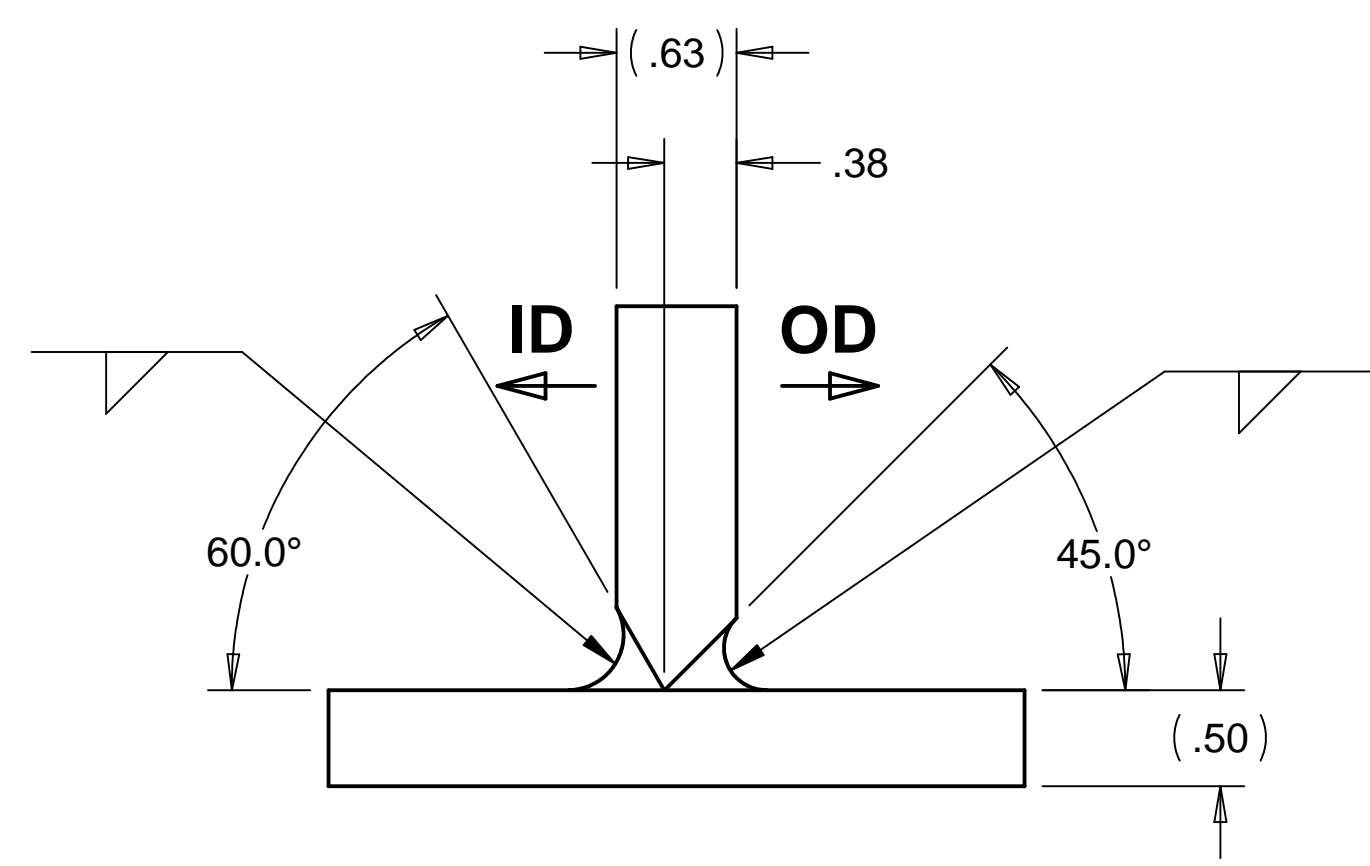


CONFIGURATION #8
USED ON: D972710

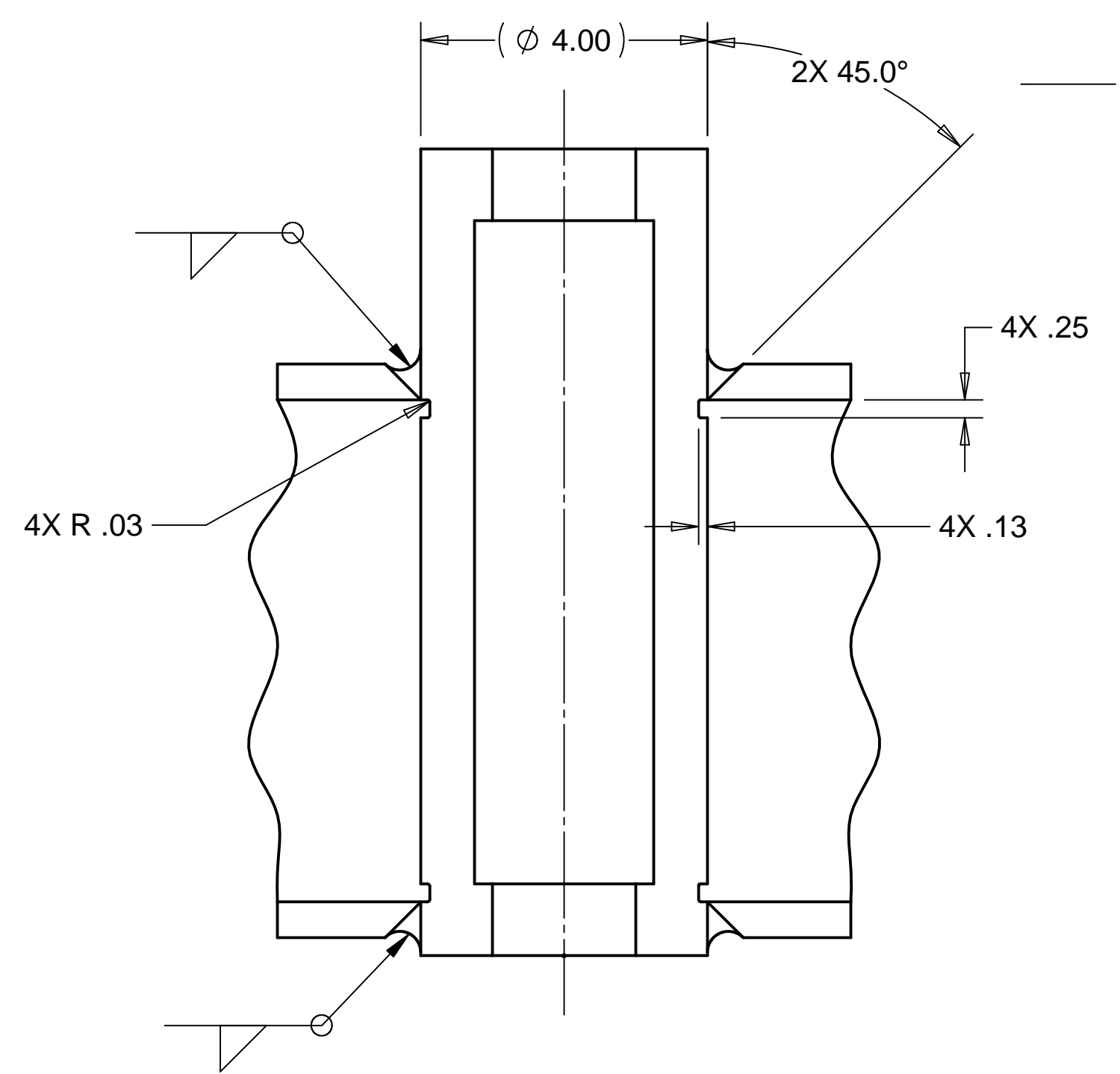


CONFIGURATION #9
USED ON: D972211

C

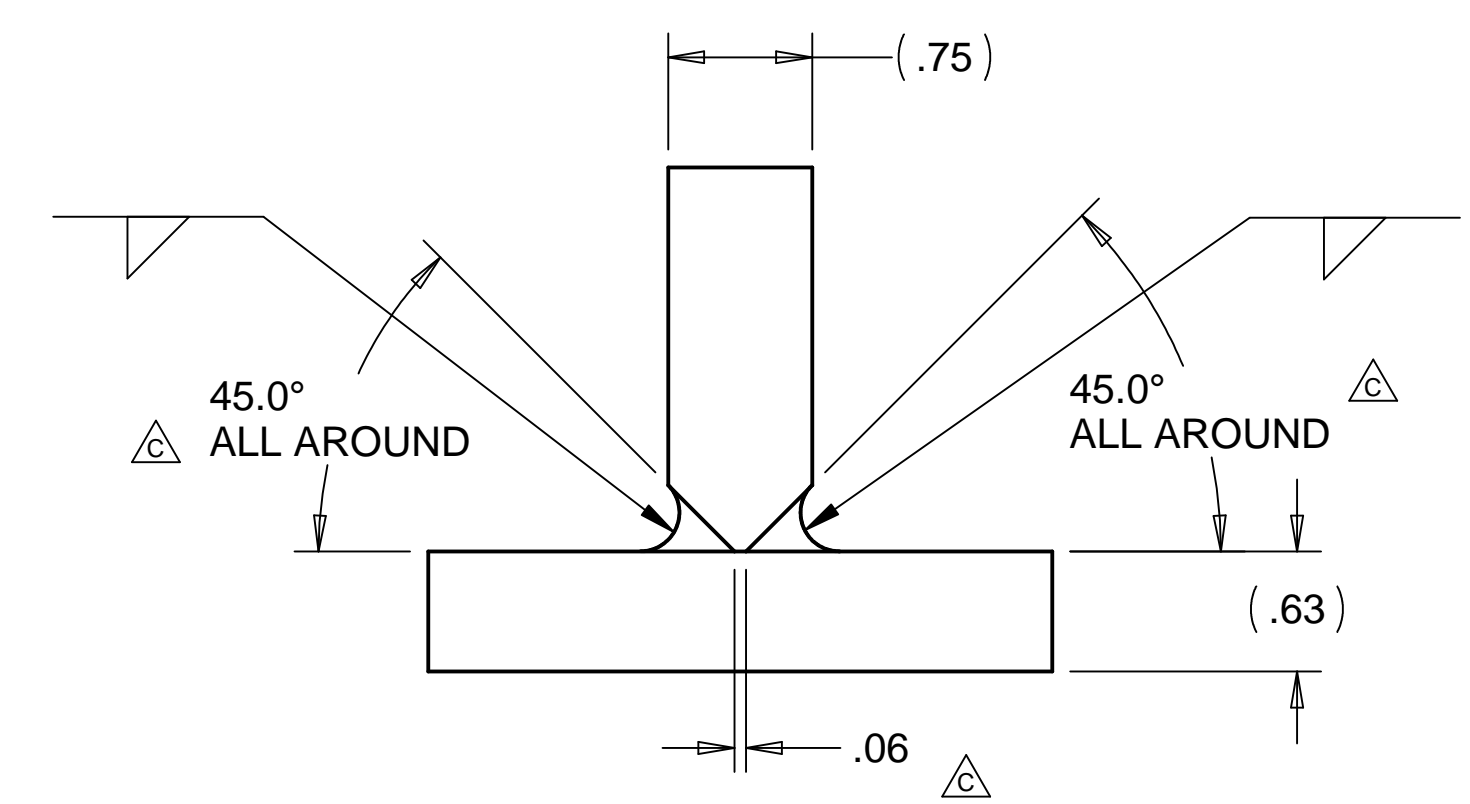


CONFIGURATION #10
USED ON: D972211



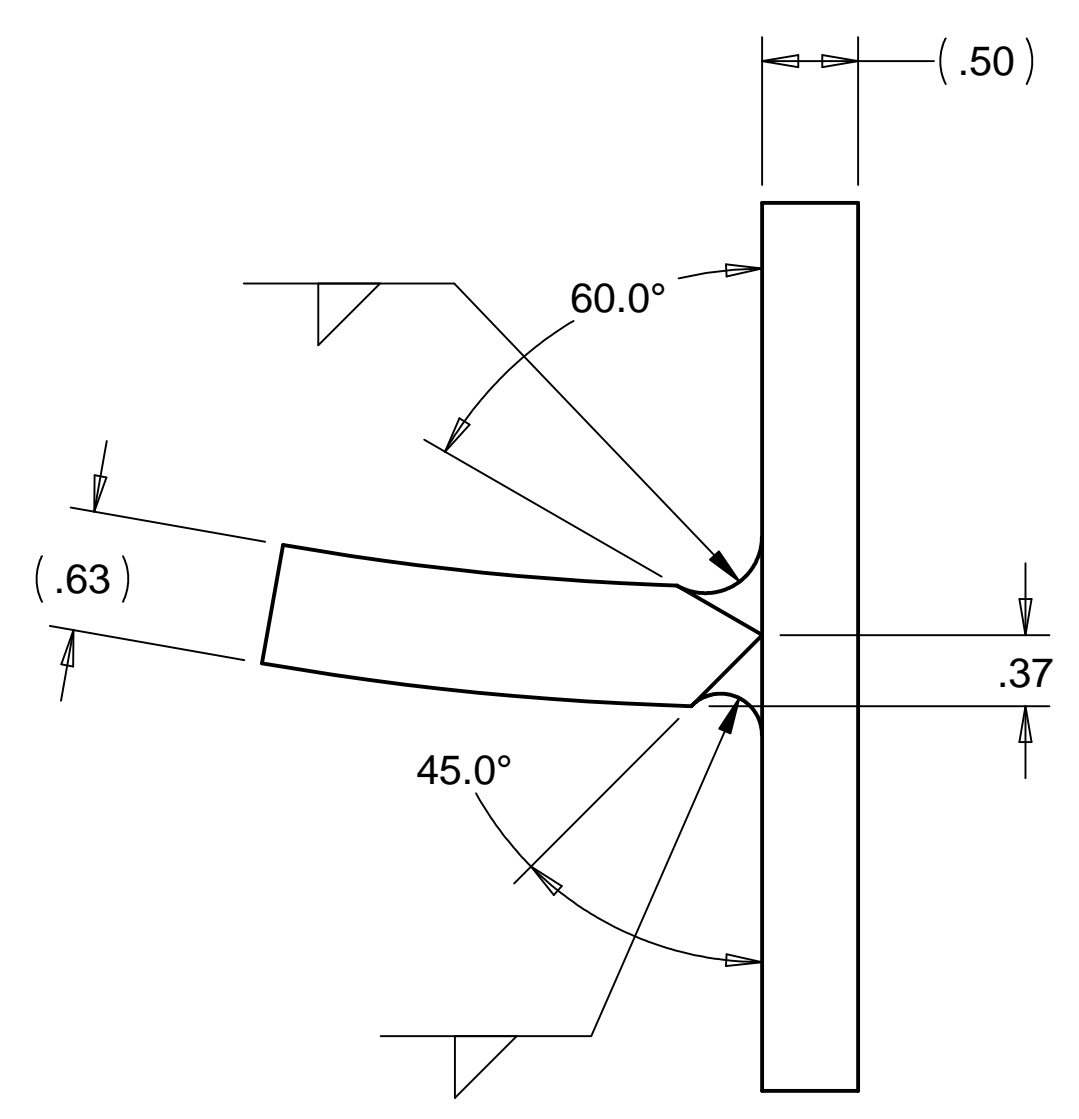
CONFIGURATION #11
USED ON: D972211
SCALE 1/2

B



CONFIGURATION #12
USED ON: D972211

A



CONFIGURATION #6
USED ON: D972211

PARTS LIST				
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 TITLE LIGO WELD CONFIGURATION & WELD PROCEDURE DWG. NO. D972202 SIZE D SHEET NO. 2 of 3 SCALE 1/1 REVISION C	
	FINISH	SIGNATURE		DATE
		ROGER L. SMITH		03-09-98
	DRAWN	ROGER L. SMITH		03-09-98
	CHECKED	T. THOMPSON		03-11-98
PART NO. D972202-1	ENGR.	T. THOMPSON	03-11-98	
	APPROVED	T. THOMPSON	03-11-98	

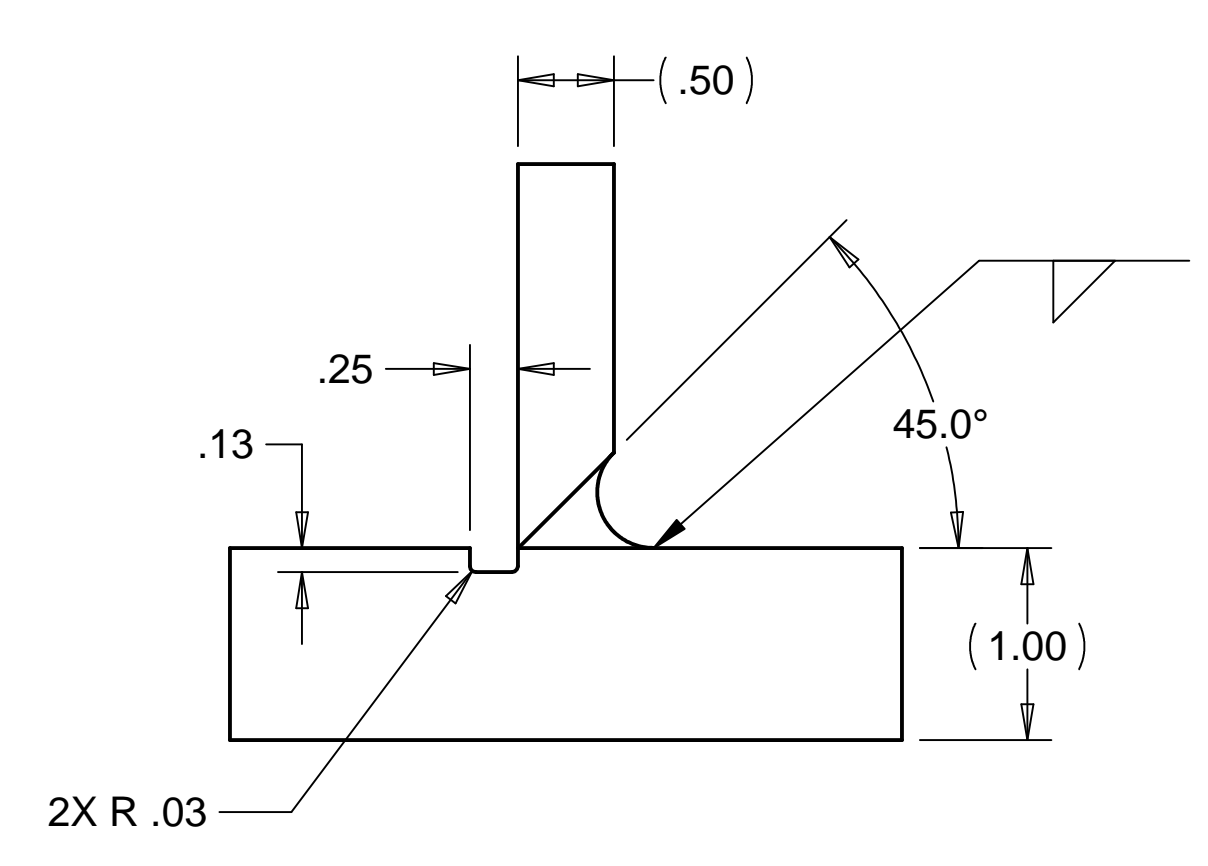
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

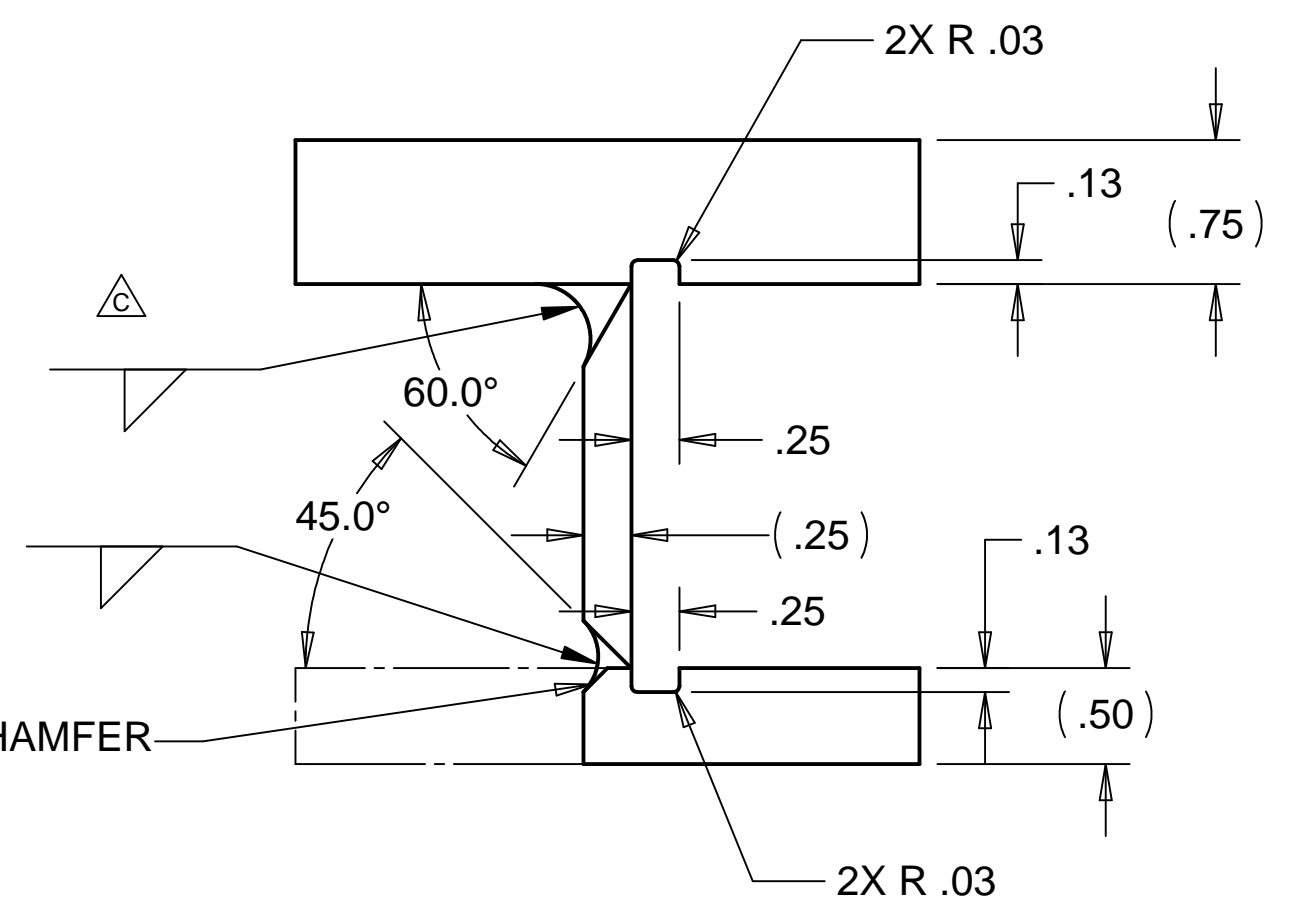
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
B	SEE ECN# D972202-B FOR CHANGE LIST	03-11-98	T. THOMPSON
C	SEE ECN# D972202-C FOR CHANGE LIST	03-20-98	T. THOMPSON

D

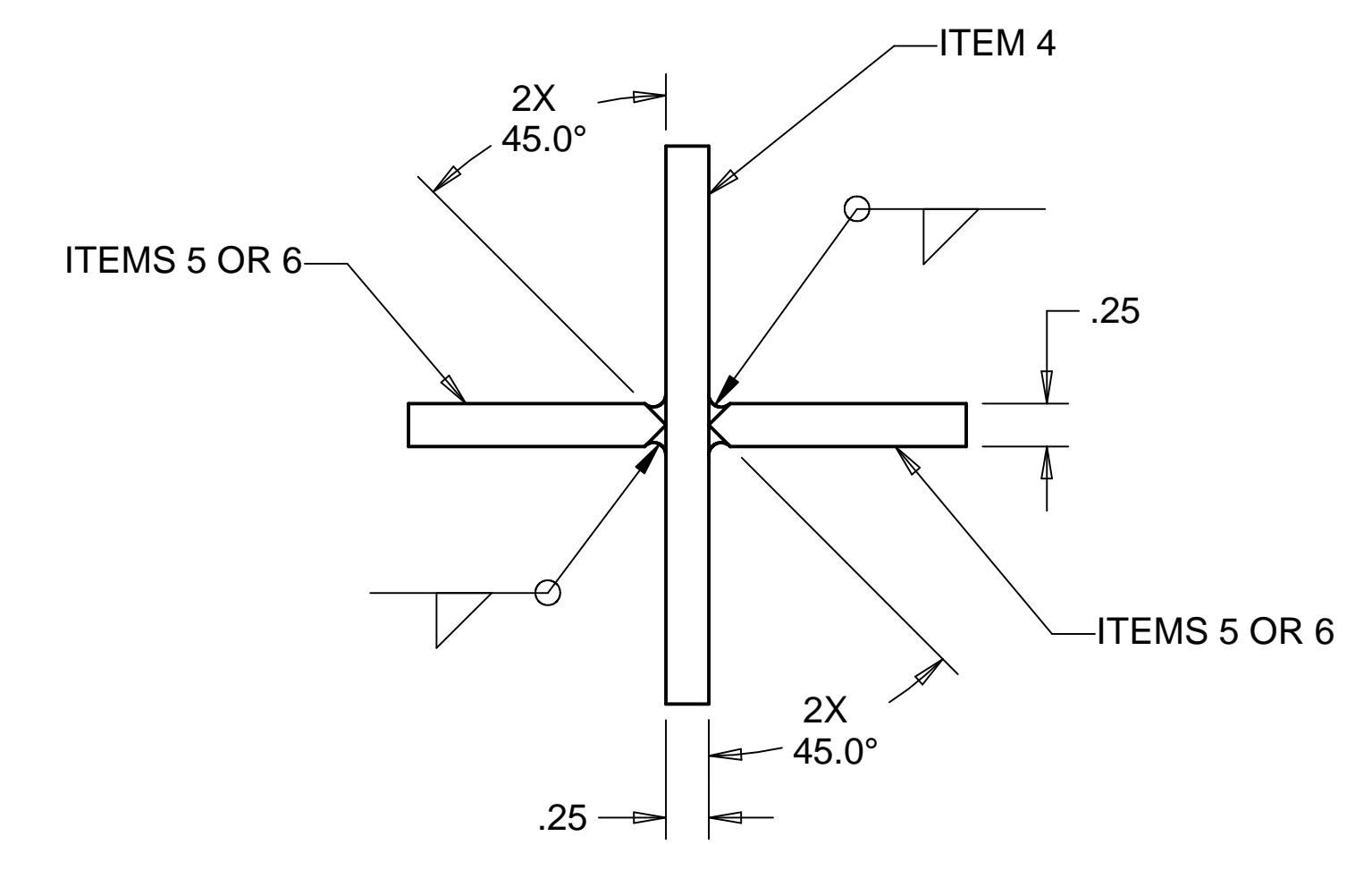
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CONFIGURATION #13
USED ON: D972211



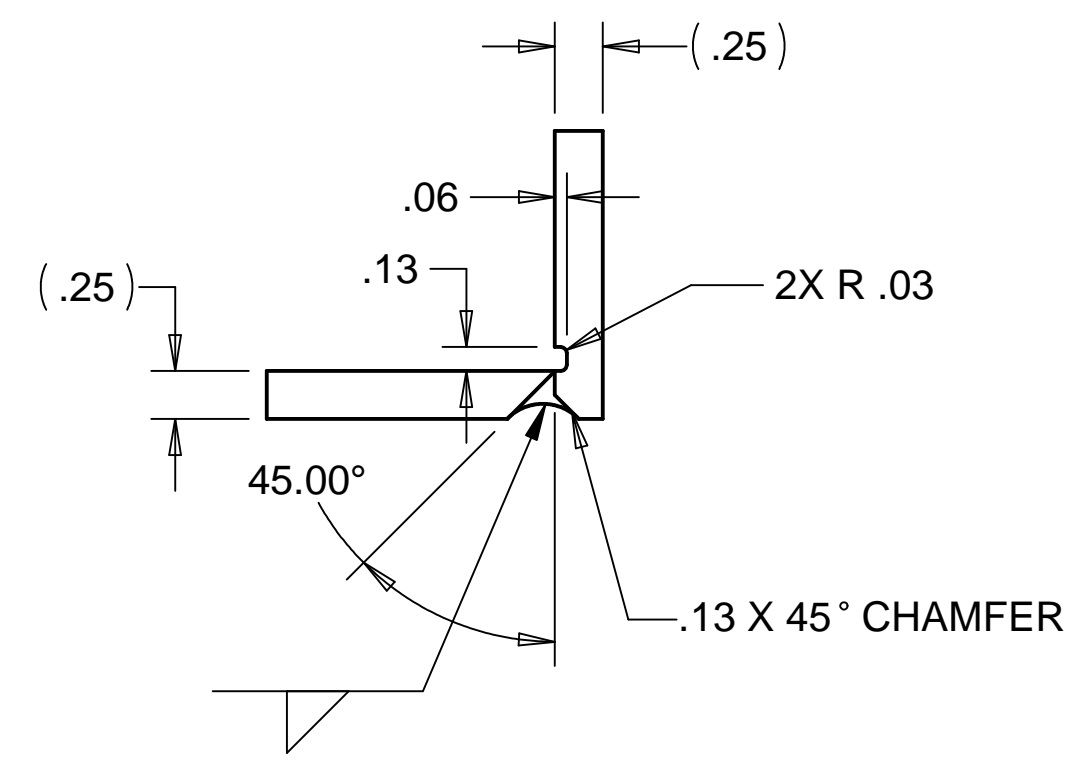
CONFIGURATION #14
USED ON: D972211
D972212
D972710
D972711



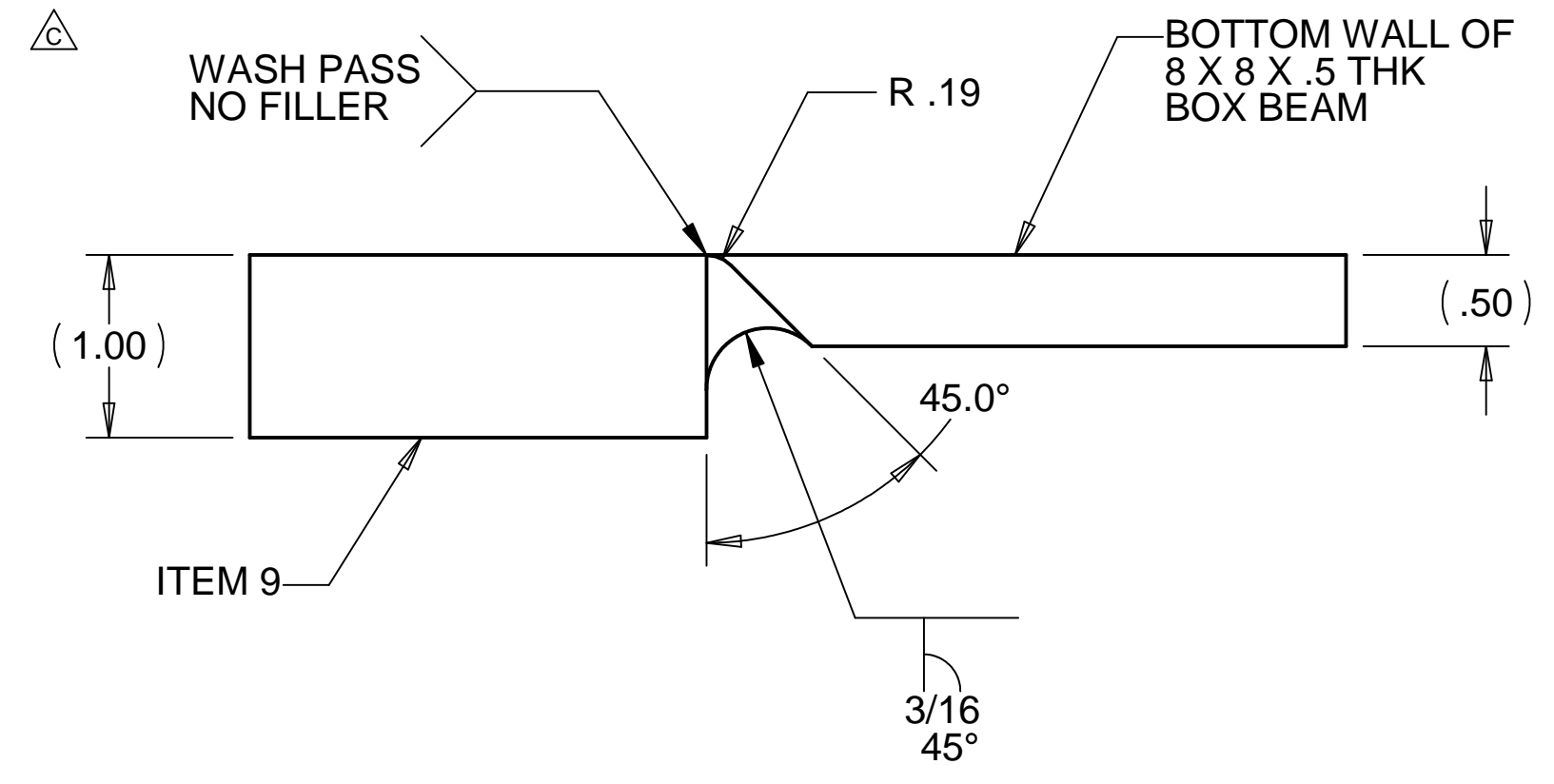
CONFIGURATION #19
USED ON: D972711

C

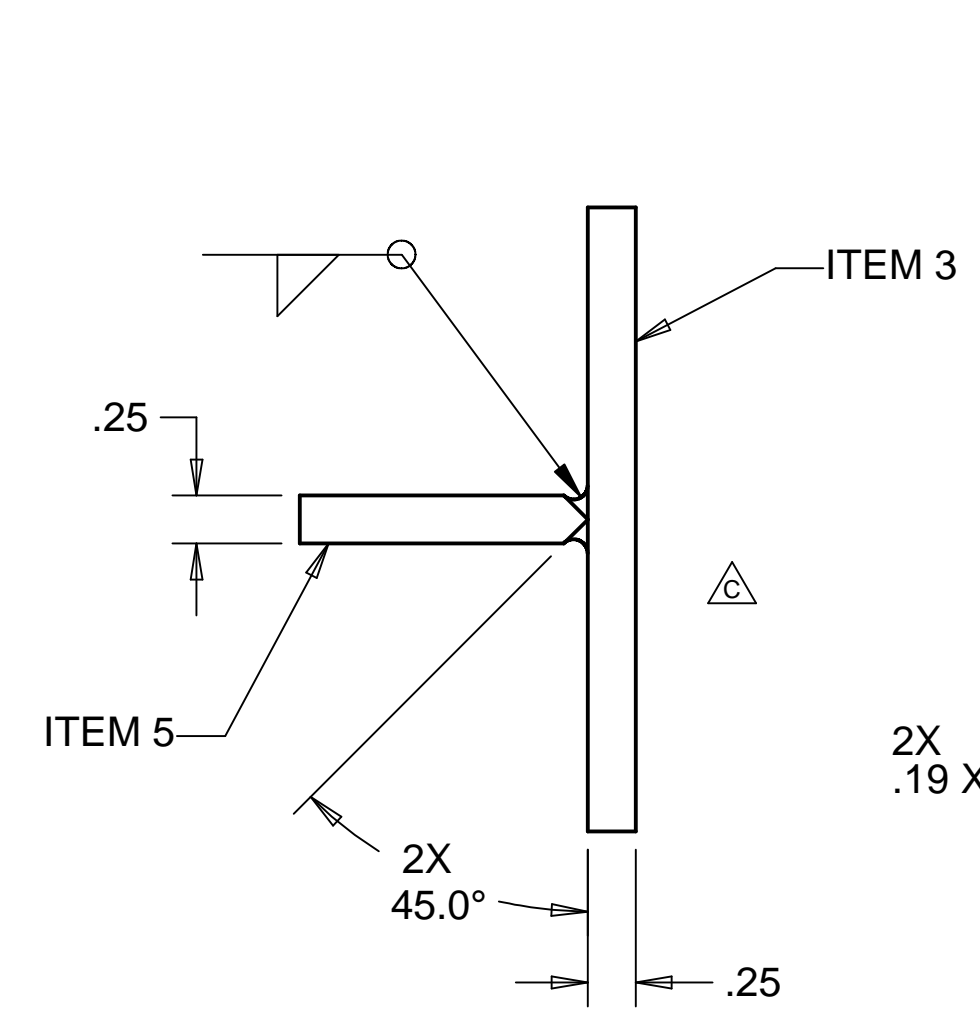
C



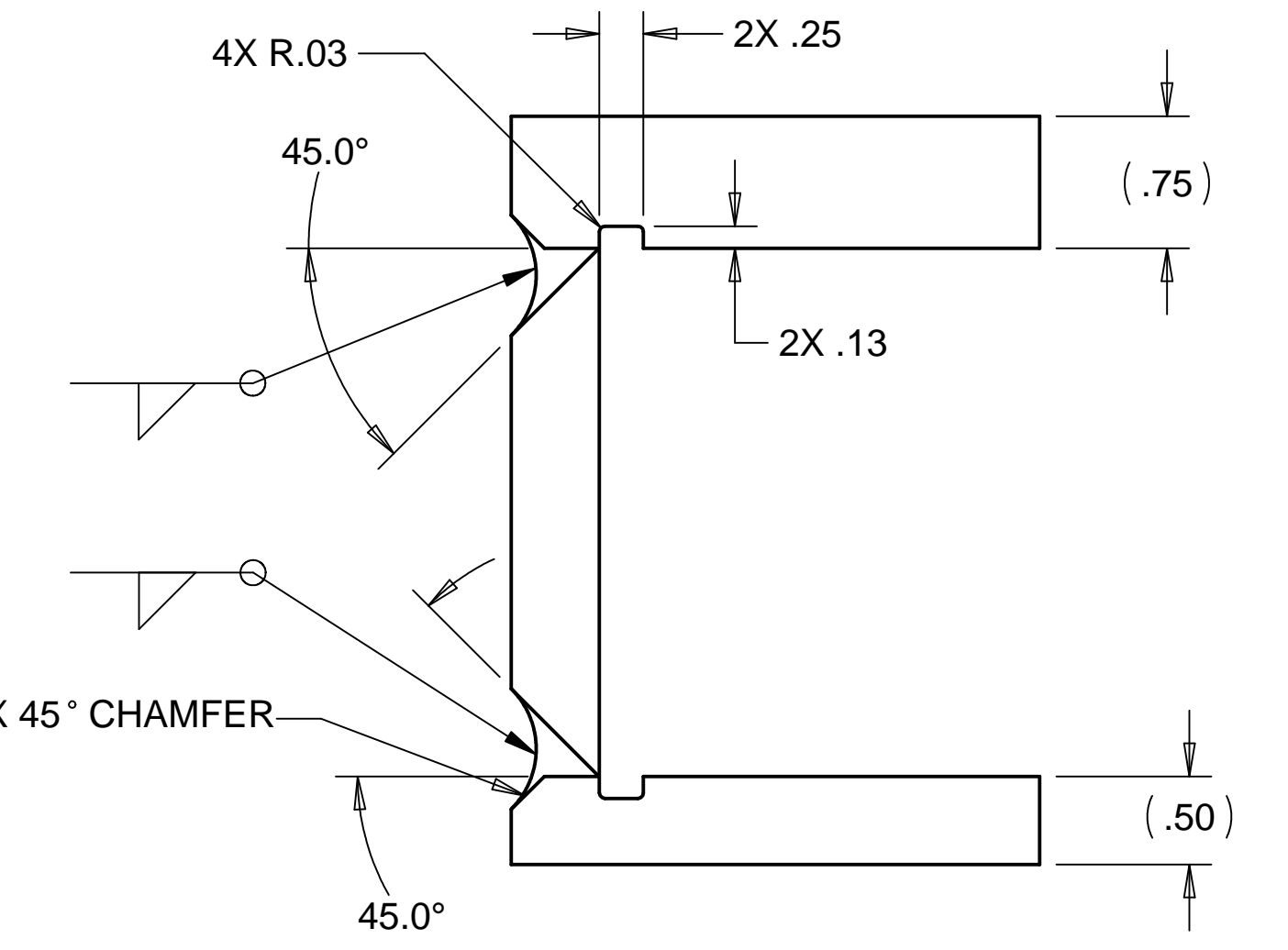
CONFIGURATION #15
USED ON: D972710



CONFIGURATION #16
USED ON: D972211



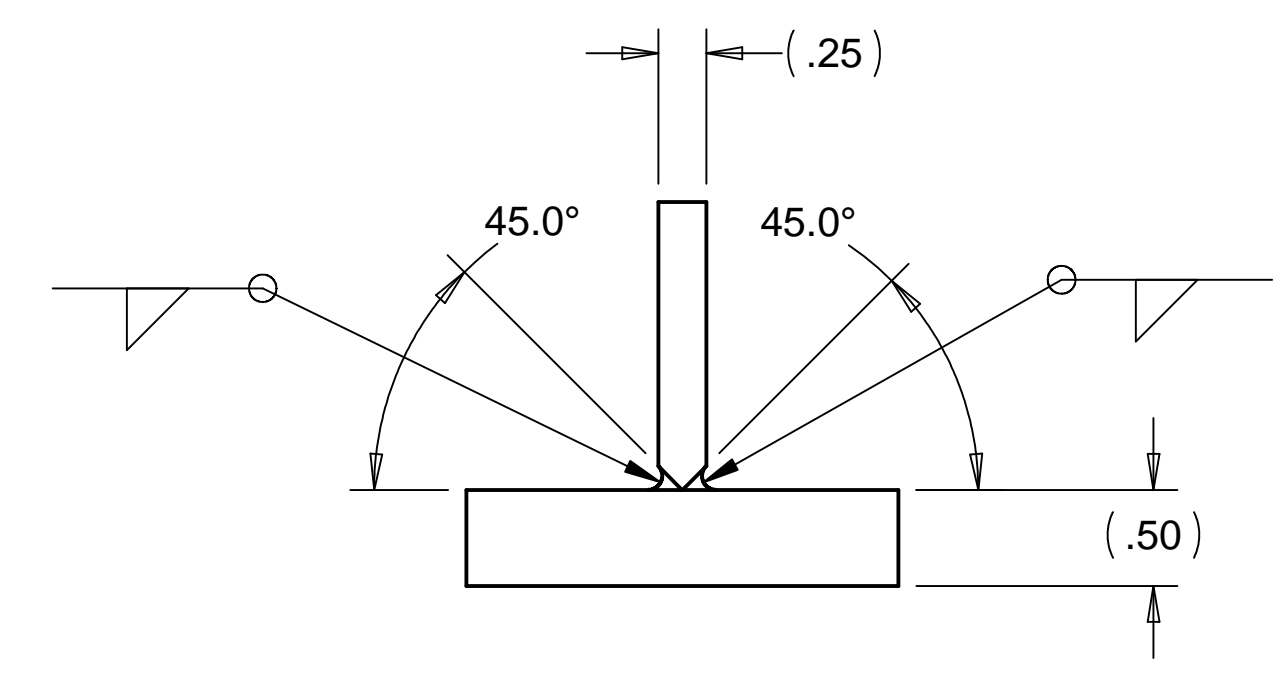
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USED ON: D972711



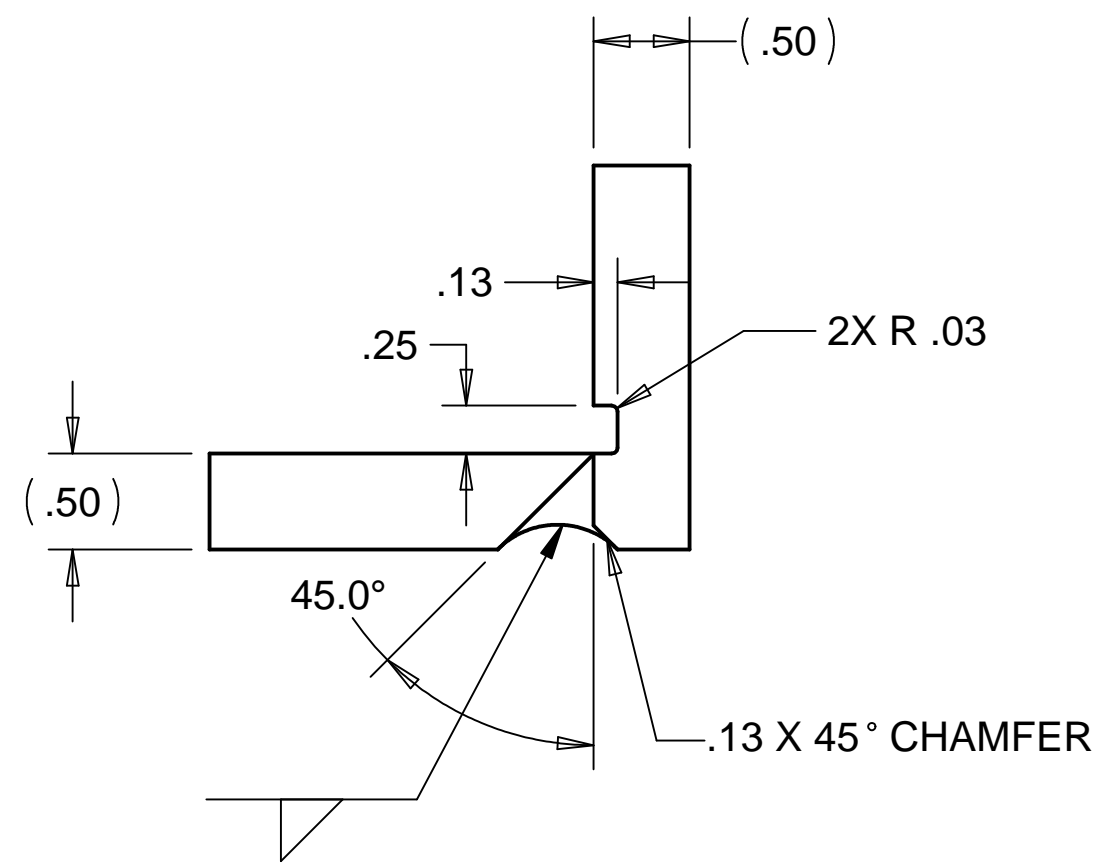
CONFIGURATION #21
USED ON: D972212

B

B



CONFIGURATION #17
USED ON: D972211



CONFIGURATION #18
USED ON: D972212

A

A

PARTS LIST							
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		HYTEC, INC TITLE LIGO WELD CONFIGURATION & WELD PROCEDURE					
DECIMALS	ANGULAR = +/- .30°						
.X = +/- .1		SIGNATURE	DATE				
.XX = +/- .03		DESIGNED	ROGER L. SMITH	03-09-98			
.XXX = +/- .010	SURFACE FINISH = 250	DRAWN	ROGER L. SMITH	03-09-98			
PART NO. D972202-1		CHECKED	T. THOMPSON	03-11-98			
		ENGR.	T. THOMPSON	03-11-98			
		APPROVED	T. THOMPSON	03-11-98			
SCALE 1/1		DWG. NO.	D972202	SIZE	D	SHEET NO.	3 of 3
		REVISION		C			

8 7 6 5 4 3 2 1