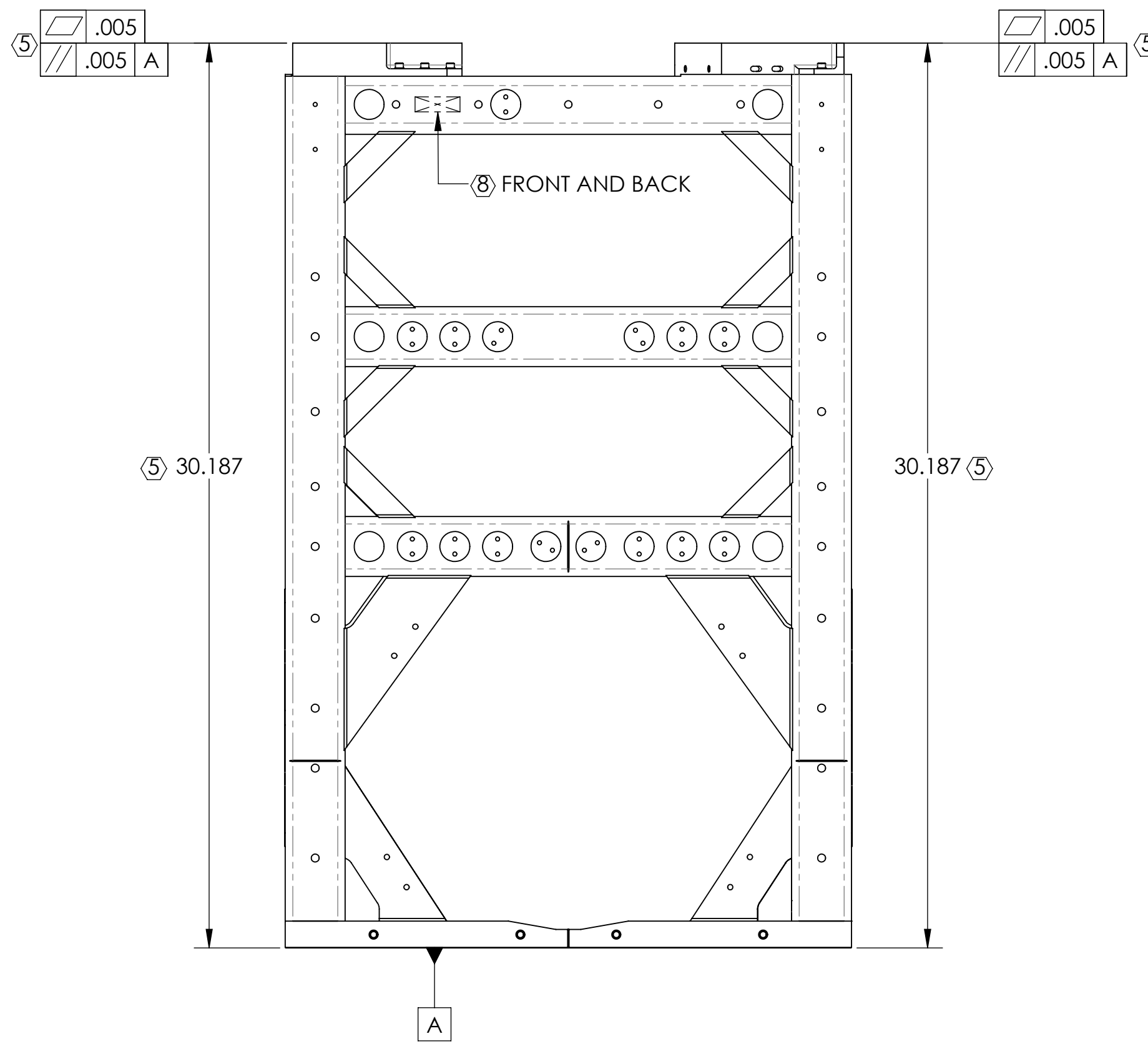
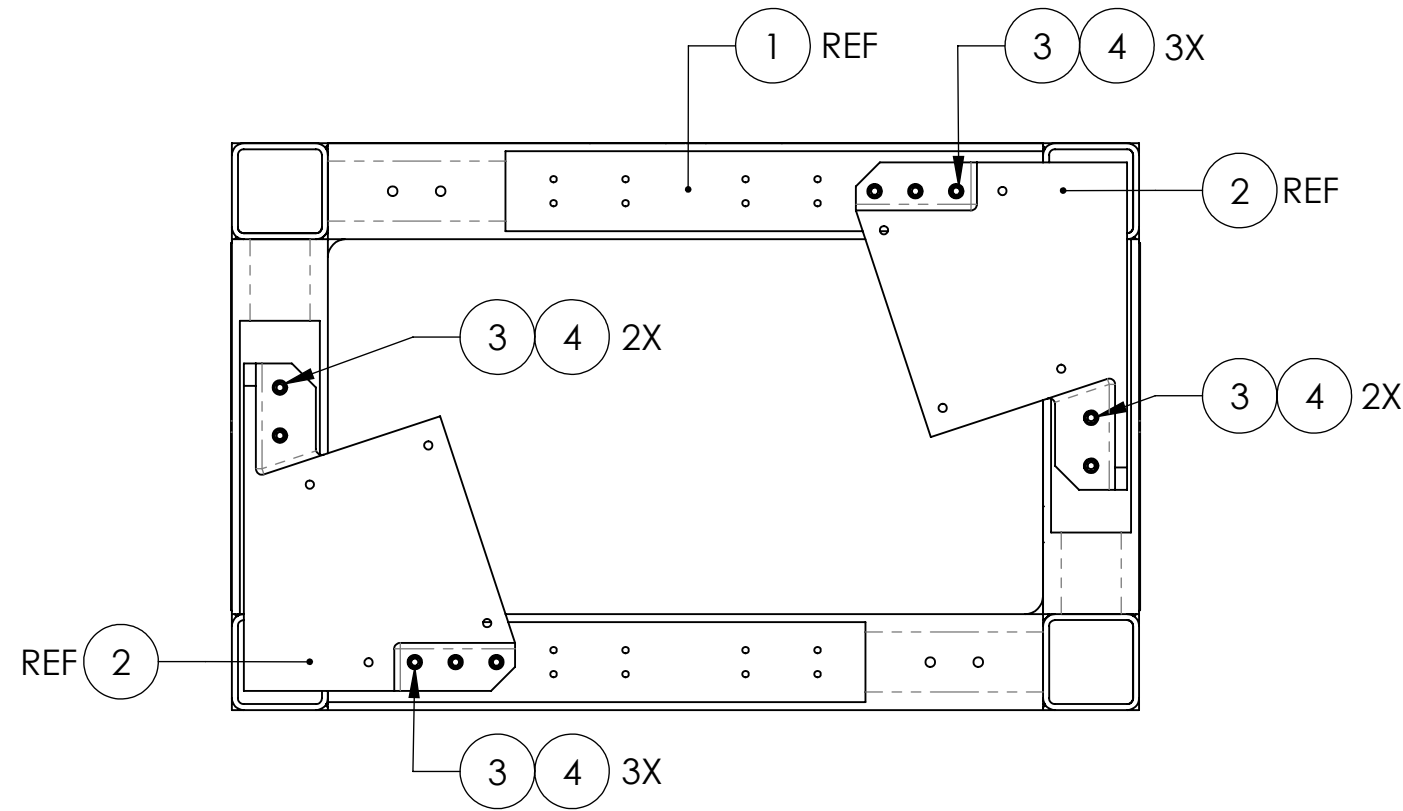
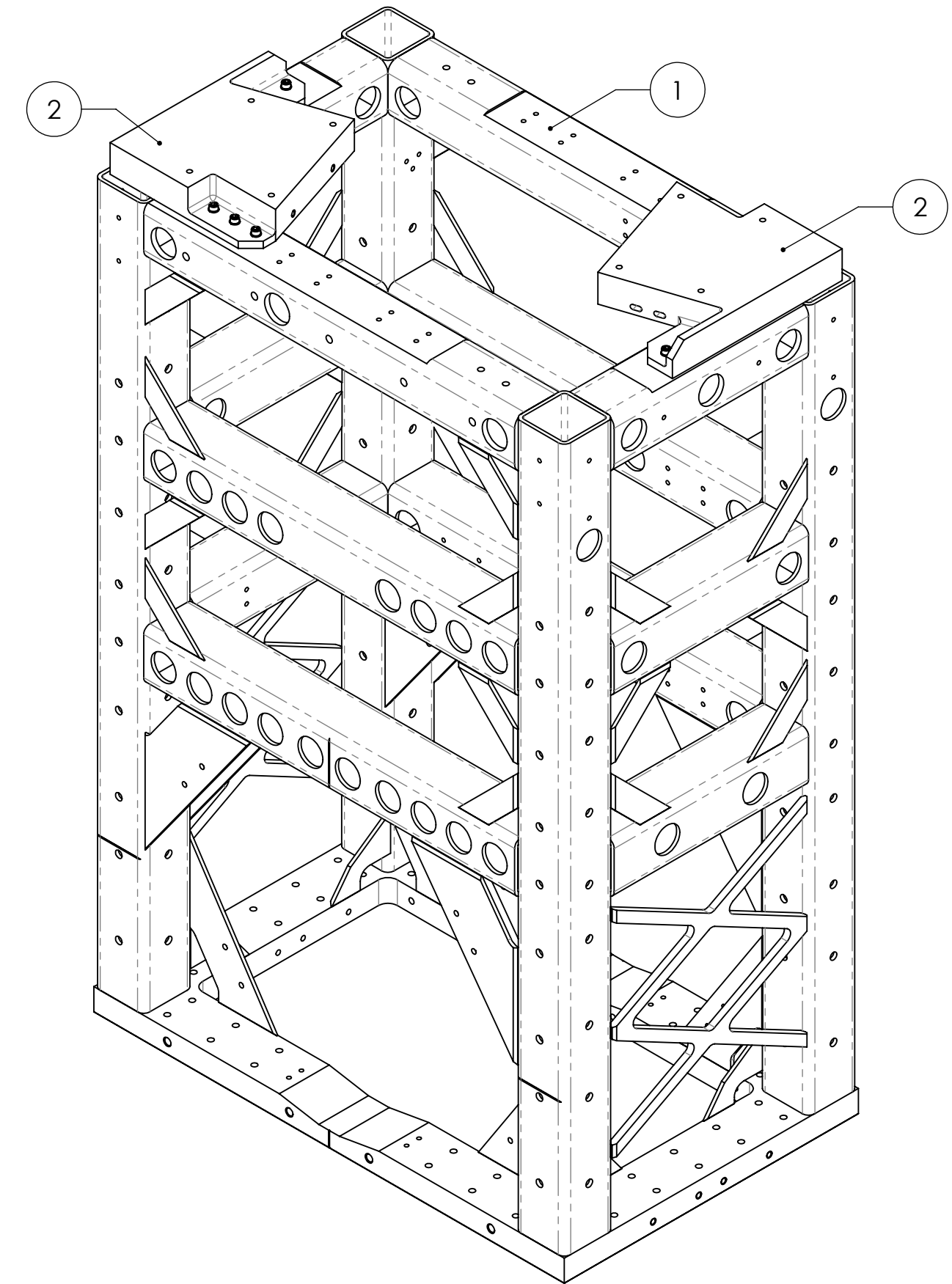


- NOTES CONTINUED:**
- ⑤ FLY CUT INDICATED SURFACES TO ACHIEVE DESIRED DIMENSIONS, PARALLELISM AND FLATNESS.
 - 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ⑧ SCRIBE OR ENGRAVE (NO INKS OR DYES) SERIAL NUMBER OF CORRESPONDING MOUNTING PAD BODY (D070374) ON STRUCTURAL WELDMENT (D070442) AFTER MACHINING.



FLY CUTTING LAYOUT

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E0900066	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	-	WASHER, FLAT, VENTED, #8 (U-C COMPONENTS P/N WFV-08 OR EQUIVALENT)	300 SSTL	10	2	12
3	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	Ag-PLATED 300 SSTL	10	2	12
2	D070374	MOUNTING PAD BODY	6061-T6 Al	2	0	0
1	D070442	STRUCTURAL WELDMENT, HLTS	-	1	0	0

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

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.

MATERIAL	N/A	FINISH	63 μinch
-----------------	-----	---------------	----------

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

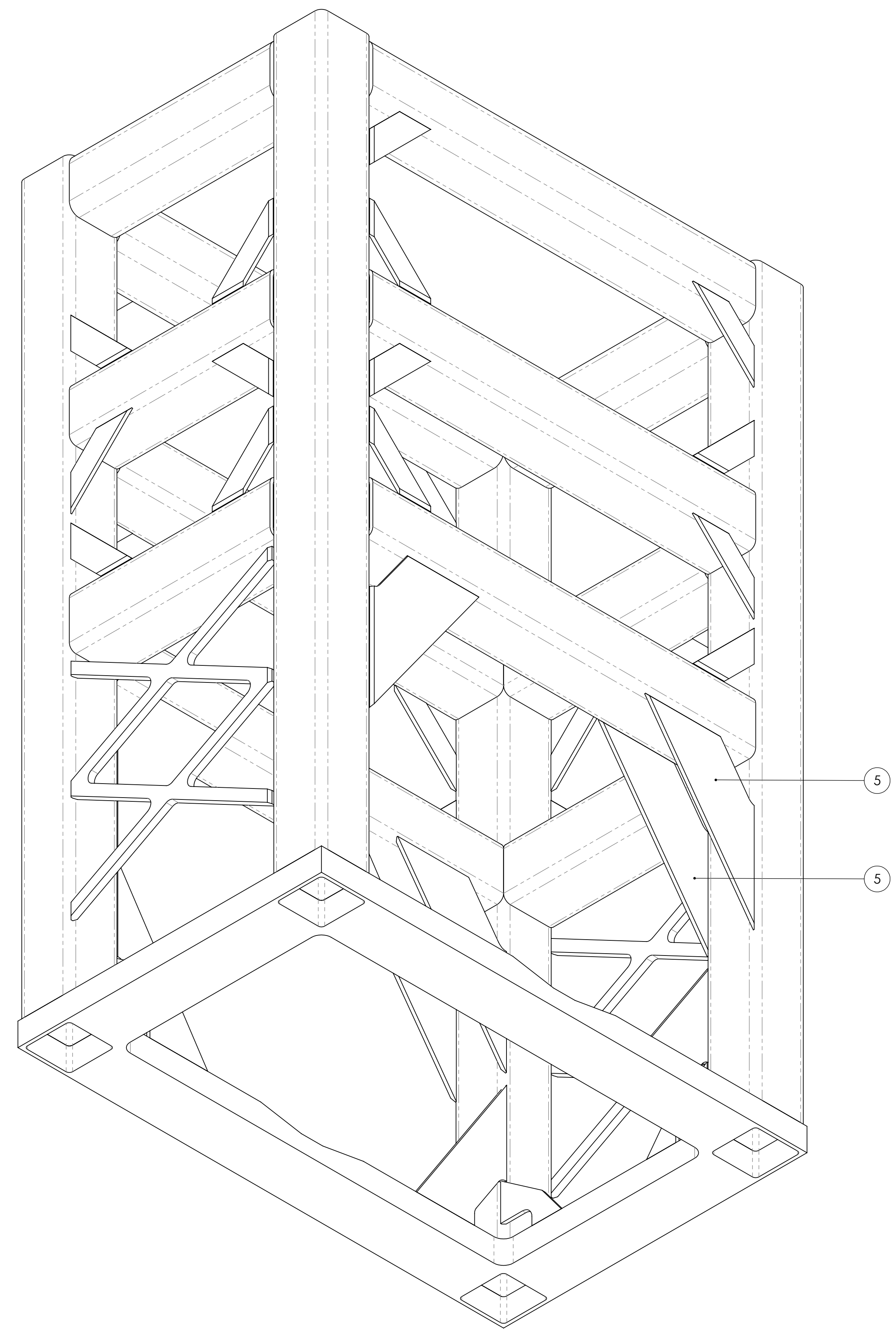
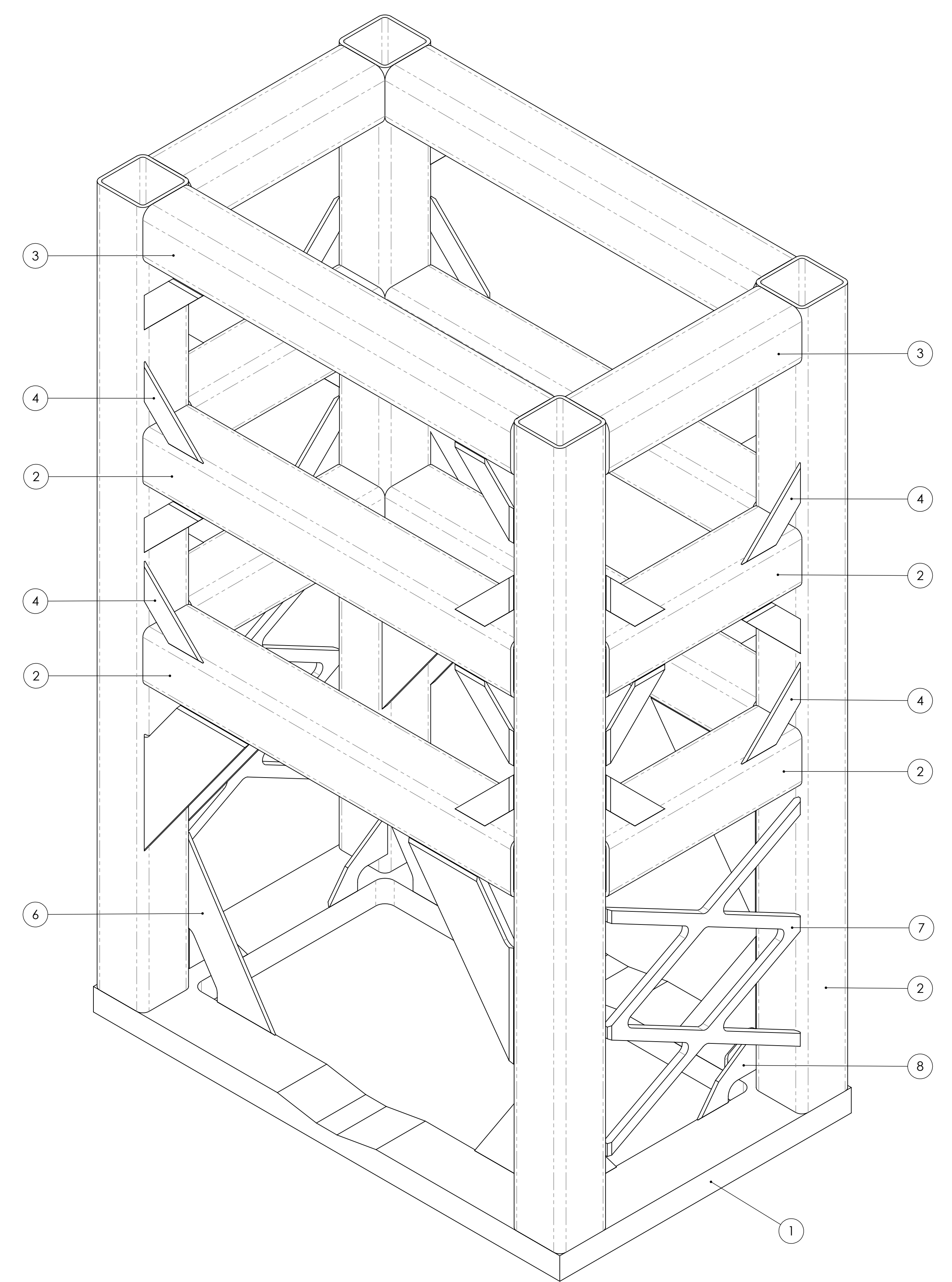
NEXT ASSY: HLTS OVERALL ASSY

PART NAME

STRUCTURE, HLTS

DESIGNER	D. BRIDGES	27 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	c	D070537	v2
CHECKER	M. MEYER	31 AUG 2010			
APPROVAL			SCALE: 1:4	PROJECTION:	SHEET 1 OF 1

- NOTES CONTINUED:
- 5) SCRIBE, ENGRAVE OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING 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 0.17" 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. ALL SURFACES OF ALL PARTS ARE TO BE MACHINED (NO AS RECEIVED, AS ROLLED, AS WELDED SURFACES WILL BE ACCEPTED), EXCEPT INNER SURFACES AND OUTER RADII OF TUBING. NO GRINDING OR LAPING WITH ABRASIVE WHEELS, CLOTH OR STONES IS PERMITTED. NO PARTS SHALL BE CAST OR MOLDED (NO TOOLING PLATE IS PERMITTED). BLANCHARD GRINDING IS ACCEPTABLE IF ALL GROUND SURFACES ARE MACHINED AFTERWARDS.
 - 7) ALL WELDING SHALL BE PERFORMED IN ACCORDANCE WITH LIGO SPECIFICATION EDP000048.
 - 8) TUBING IS 2.00" SQUARE WITH WALL THICKNESS OF .12" ± .01".
 - 9) TUBING IS 2.00" SQUARE WITH WALL THICKNESS OF .188" ± .01".
 - 10) AFTER WELDING, STRESS RELIEF AND HEAT TREATMENT FLY-CUT INDICATED SURFACE TO MEET REQUIRED DIMENSION.
 - 11) INDICATED FEATURES ARE TO BE ADDED AFTER ALL WELDING, HEAT TREATMENT AND ALL OTHER MACHINING OPERATIONS, INCLUDING FLY-CUTTING, ARE COMPLETED.
 - 12) SCRIBE LINE WHERE INDICATED. LINE SHOULD BE .04" WIDE X .02" DEEP AND RUN THE LENGTH OF THE FACE AS SHOWN.
 - 13) HOLE THROUGH OUTER WALL OF TUBE ONLY.
 - 14) HOLE THROUGH BOTH WALLS OF TUBE.
 - 15) HOLE THROUGH INNER WALL OF TUBE ONLY.
 - 16) ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
 - 17) ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

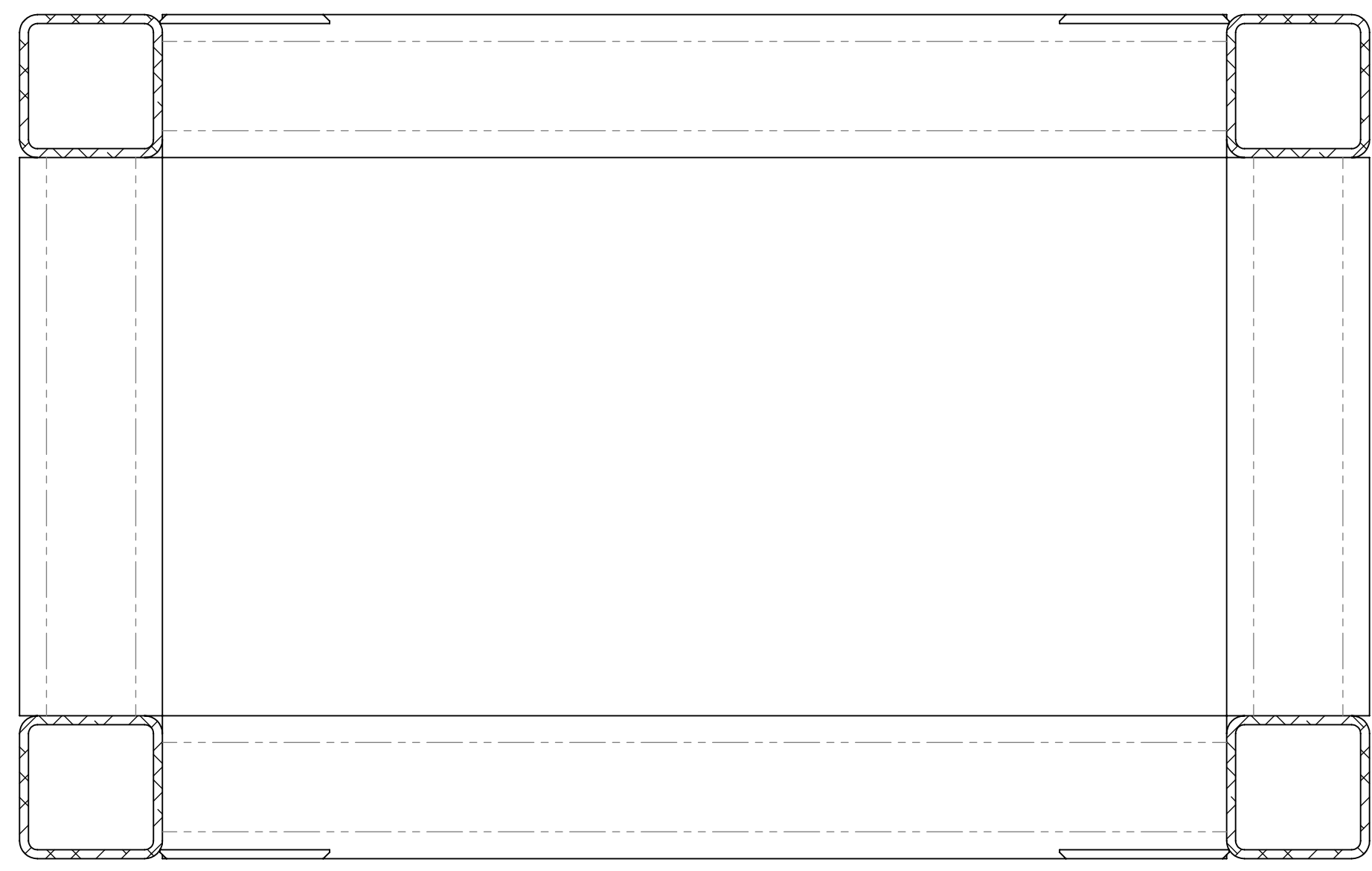


WELDMENT ISOMETRIC VIEWS

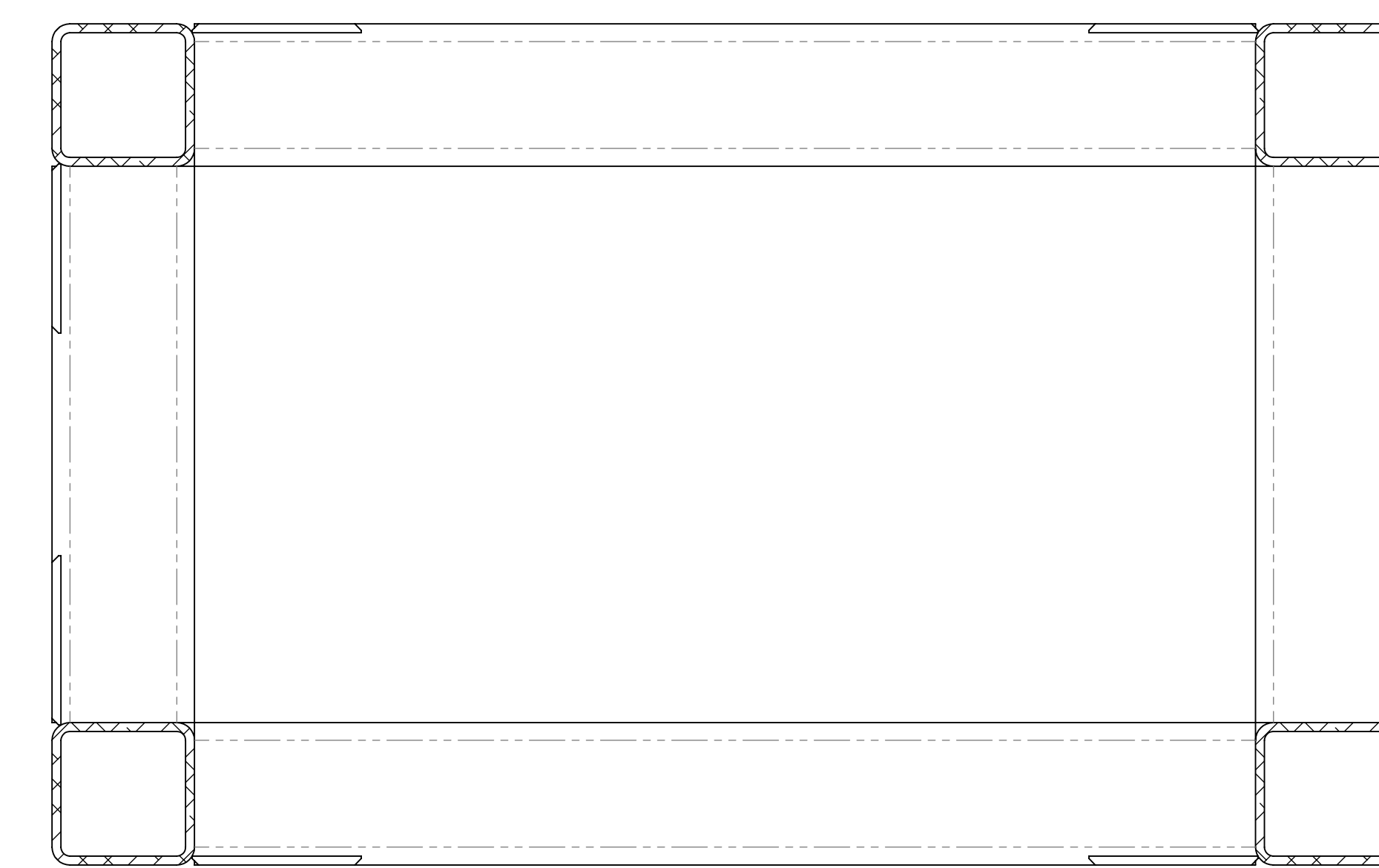
REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	02 DEC 2009	E0900446	E080191
v3	-	INTERNAL REVISION	-
v4	29 AUG 2010	E1000371	E080191

ITEM NO.	PART NUMBER	DESCRIPTION	TOTAL
8	D070577	SIDE GUSSET	4
7	D070578	SIDE STRUT	2
6	D070576	LOWER FRONT GUSSET	4
5	D070579	UPPER FRONT GUSSET	8
4	D070580	TOP GUSSET	28
3	-	2.00" SQUARE TUBE - .188" WALL THICKNESS @	-
2	-	2.00" SQUARE TUBE - .12" WALL THICKNESS @	-
1	D070575	BASE PLATE	1
PARTS LIST			TOTAL

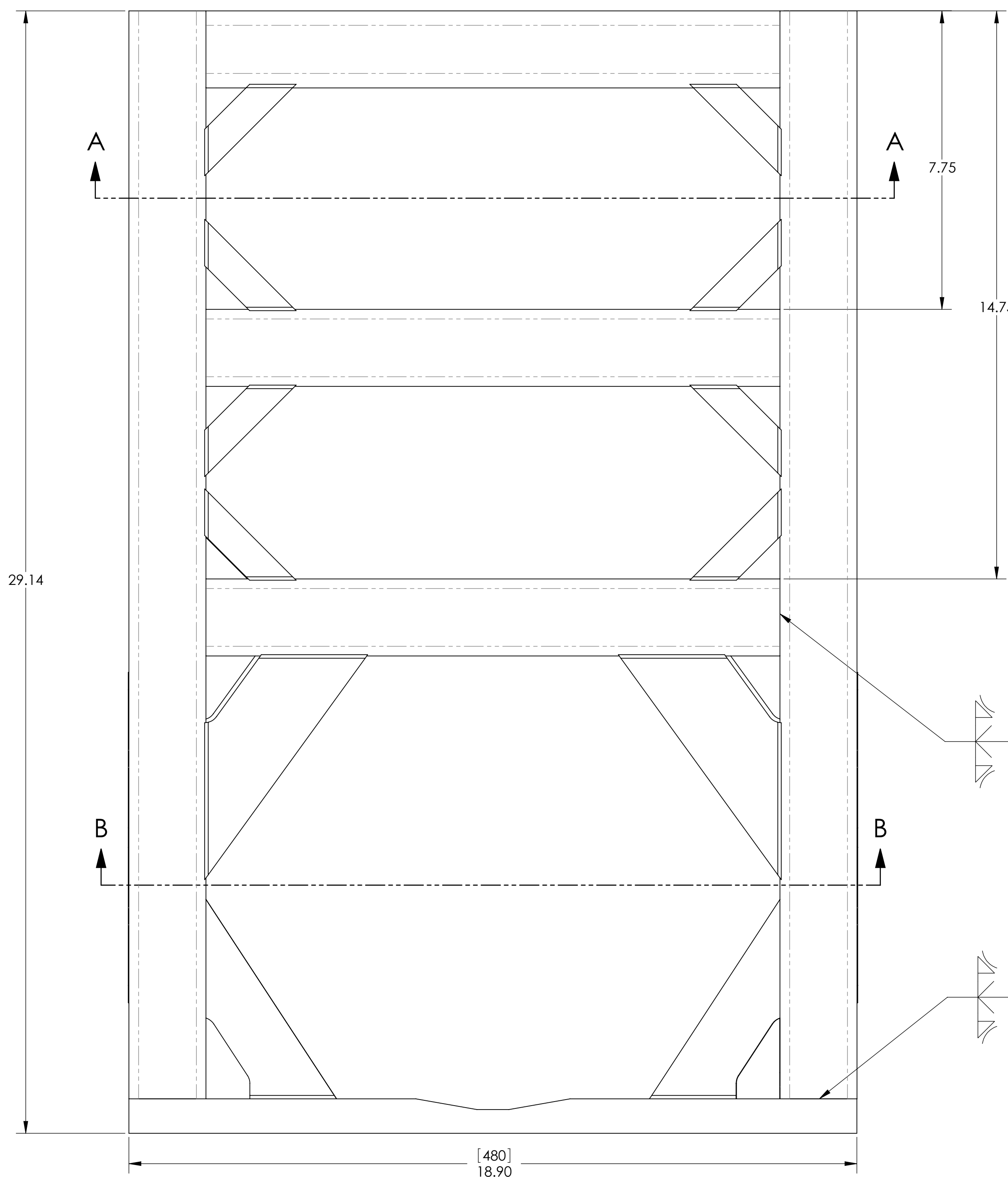
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY LIGO		PART NAME STRUCTURAL WELDMENT, HLTS	
DIMENSIONS ARE IN INCHES [MM] TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°		SYSTEM ADVANCED LIGO		SUB-SYSTEM SUS	
MATERIAL 304 OR 304L SSTL		FINISH N/A μinch		NEXT ASSY STRUCTURE, HLTS	
DESIGNER D. BRIDGES 26 AUG 2010		DRAFTER D. BRIDGES 27 AUG 2010		SIZE DWG. NO. E D070442	
CHECKER M. MEYER 31 AUG 2010		APPROVAL		SCALE: 1:2 PROJECTION: SHEET 1 OF 8	
				REV. v4	



SECTION A-A



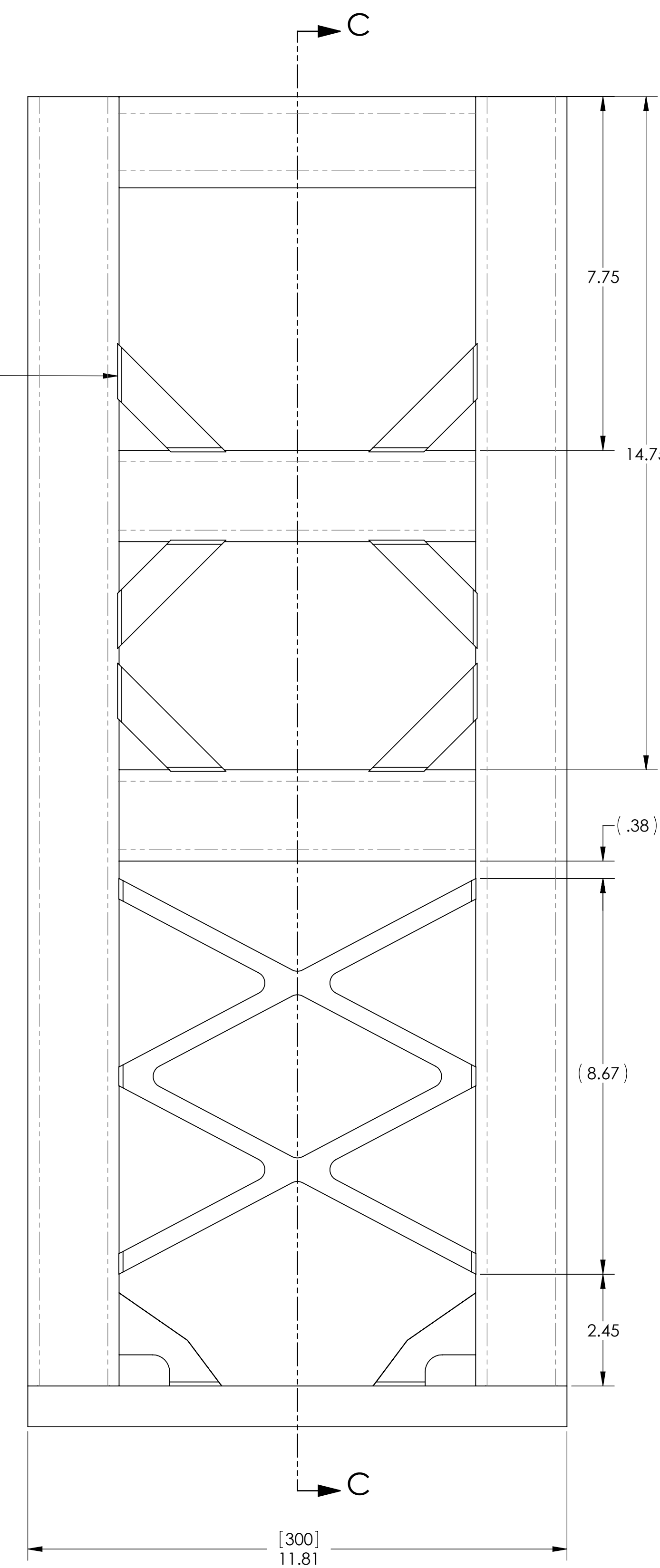
SECTION D-D



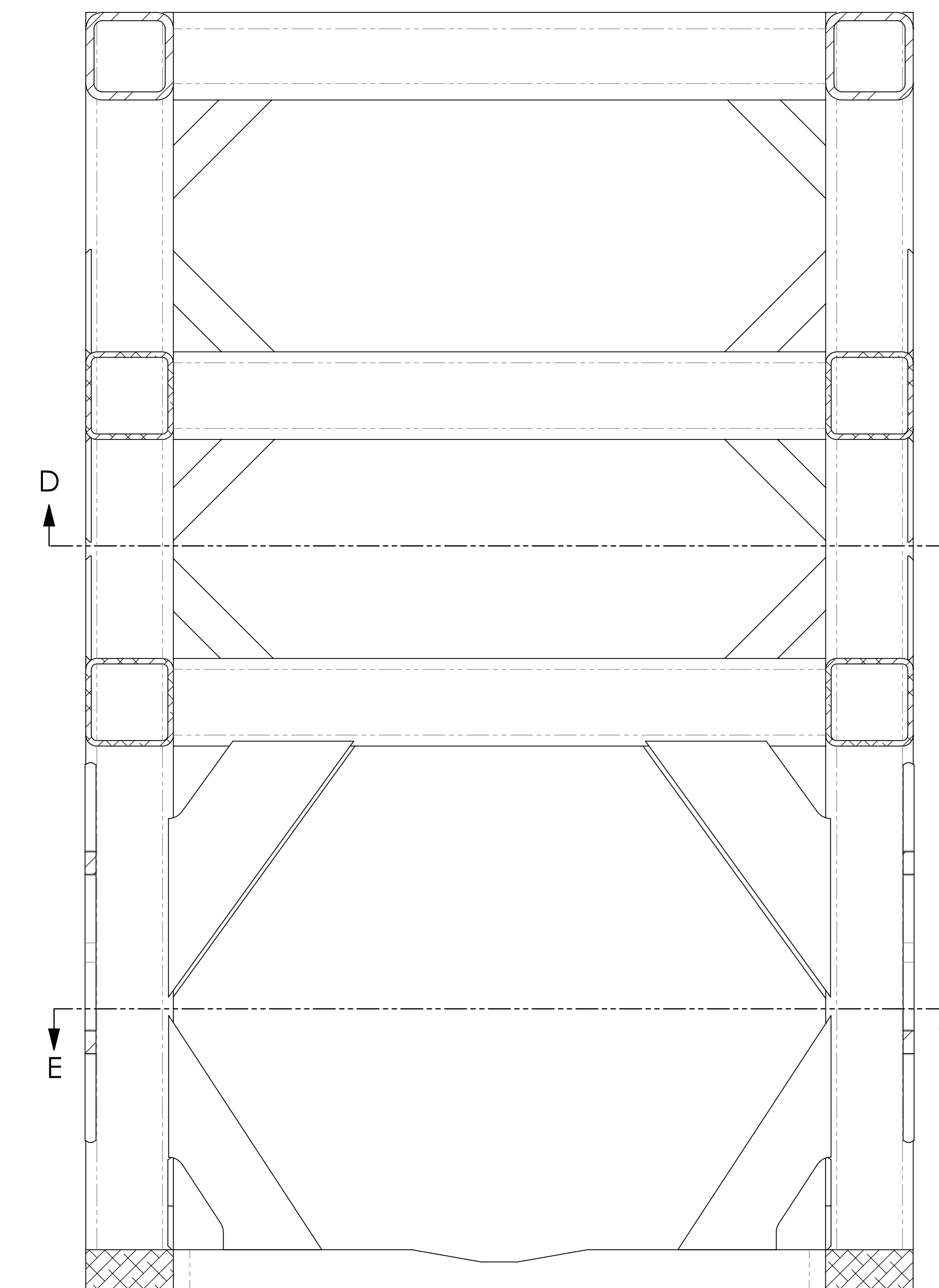
FULL LENGTH BOTH SIDES ALL PLACES

FULL LENGTH BOTH SIDES ALL PLACES

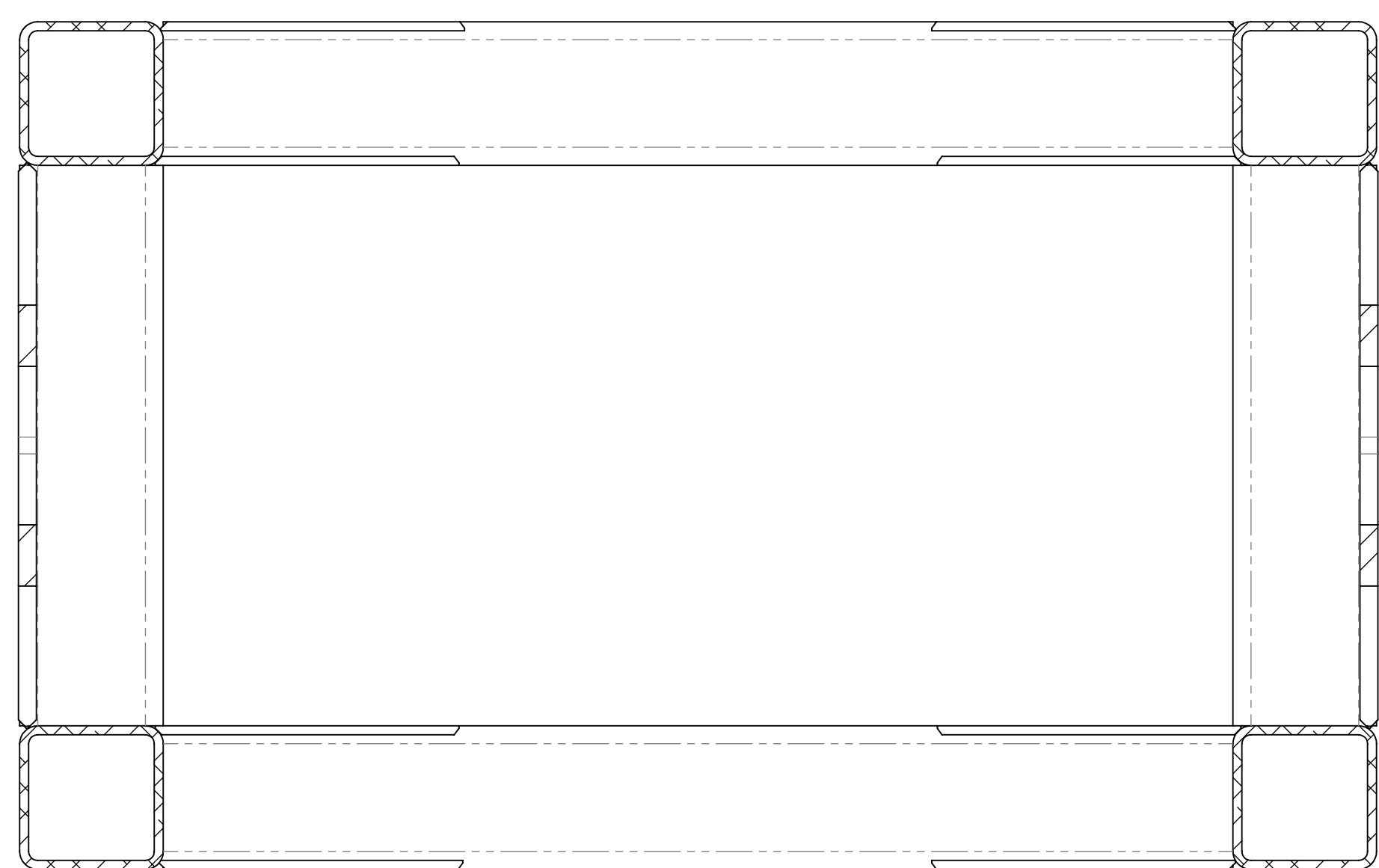
FULL LENGTH BOTH SIDES ALL PLACES



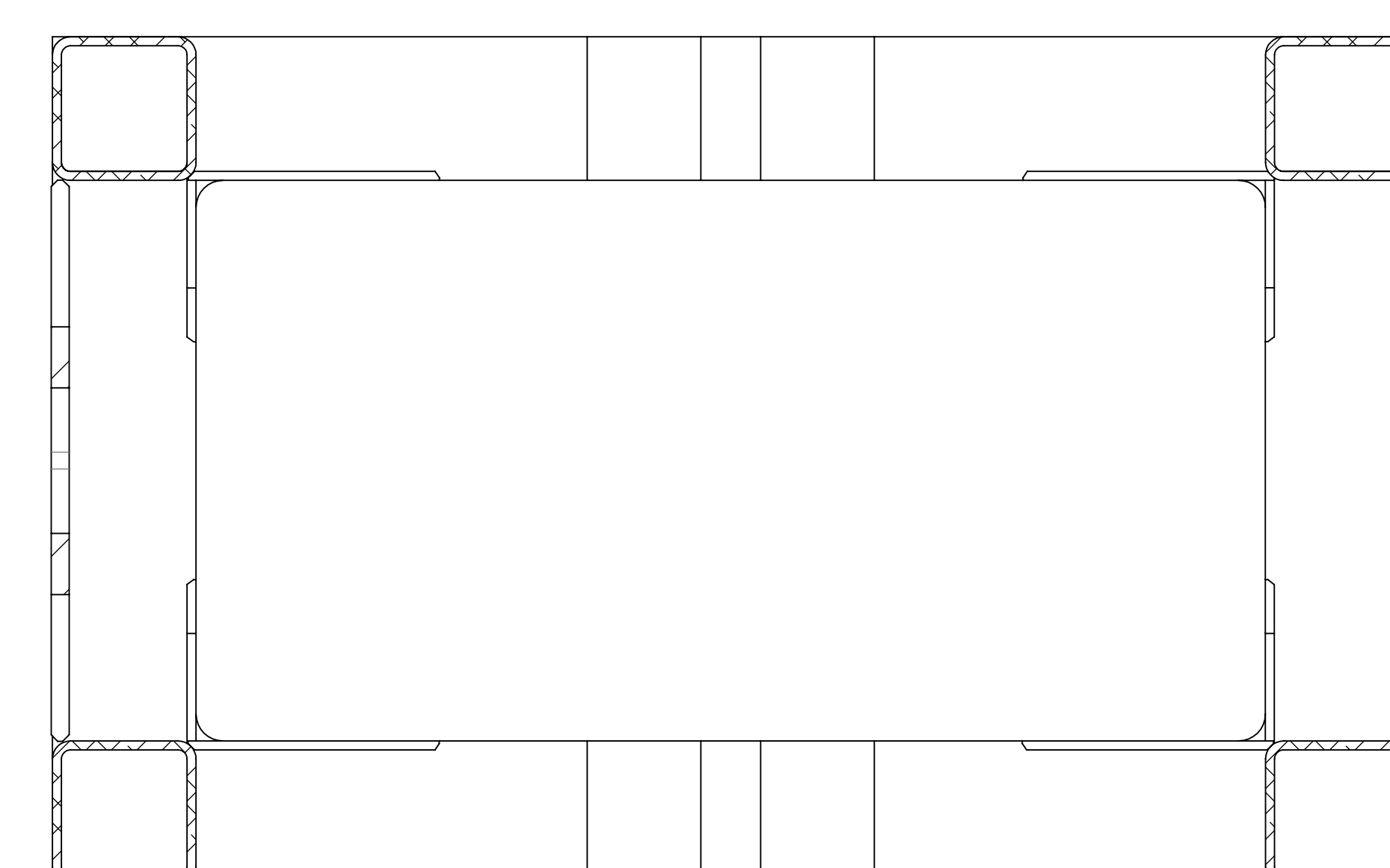
WELDMENT LAYOUT



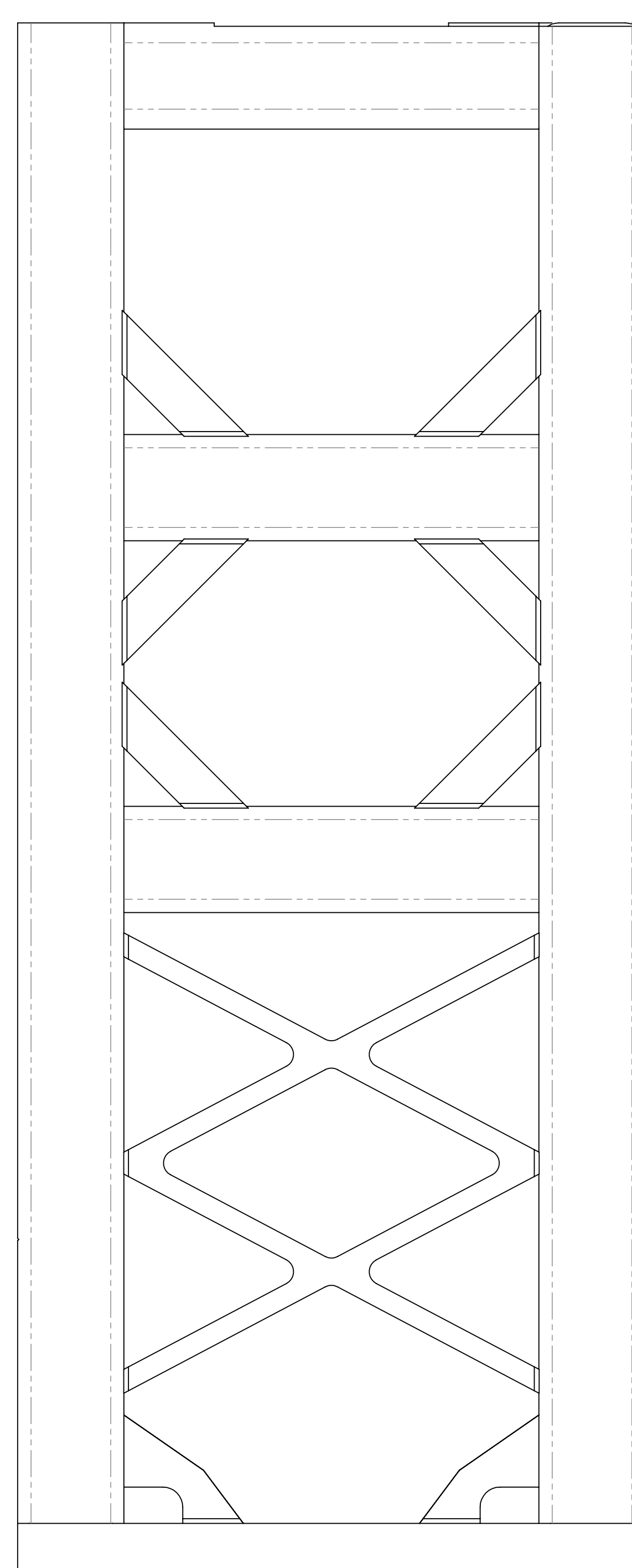
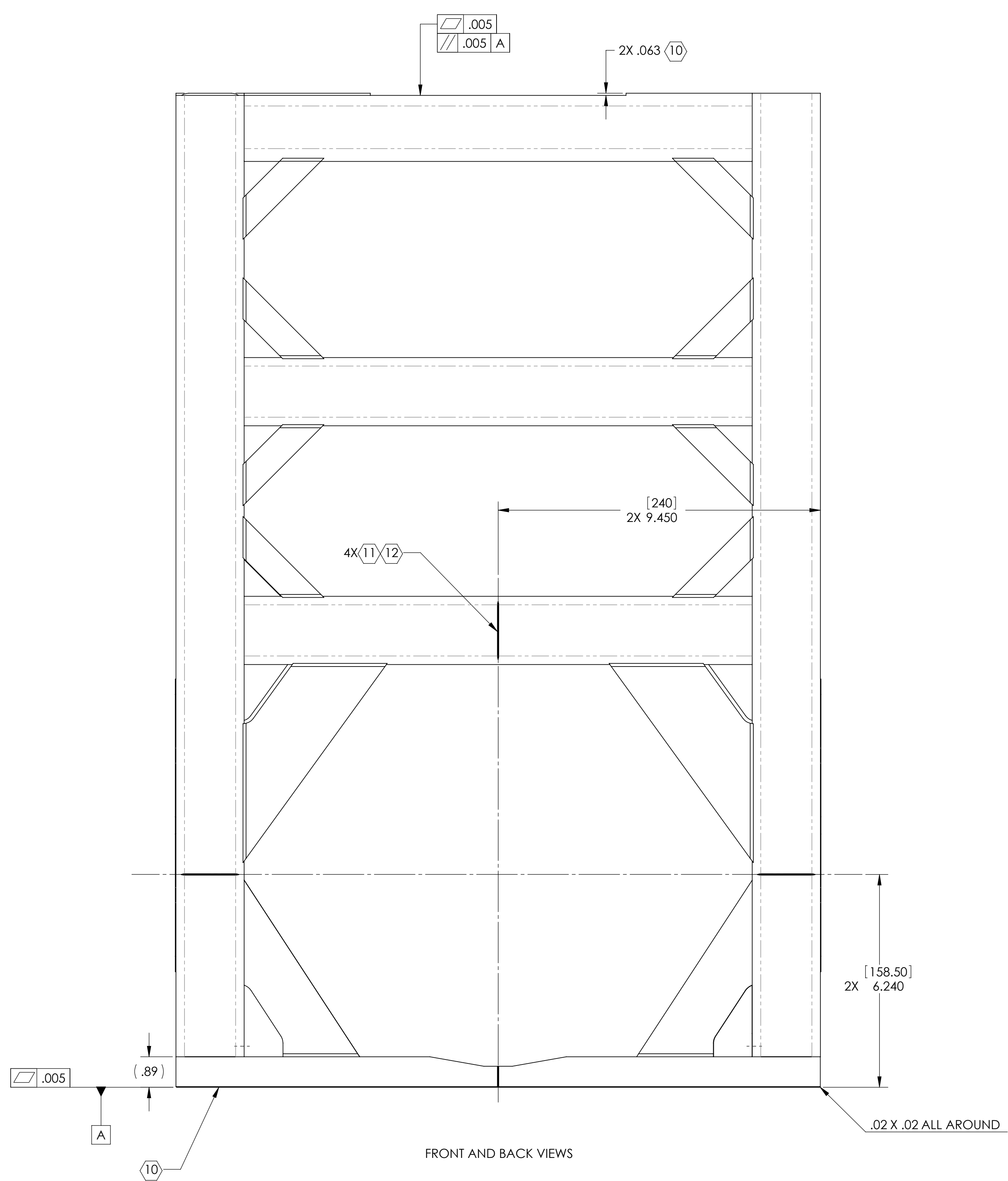
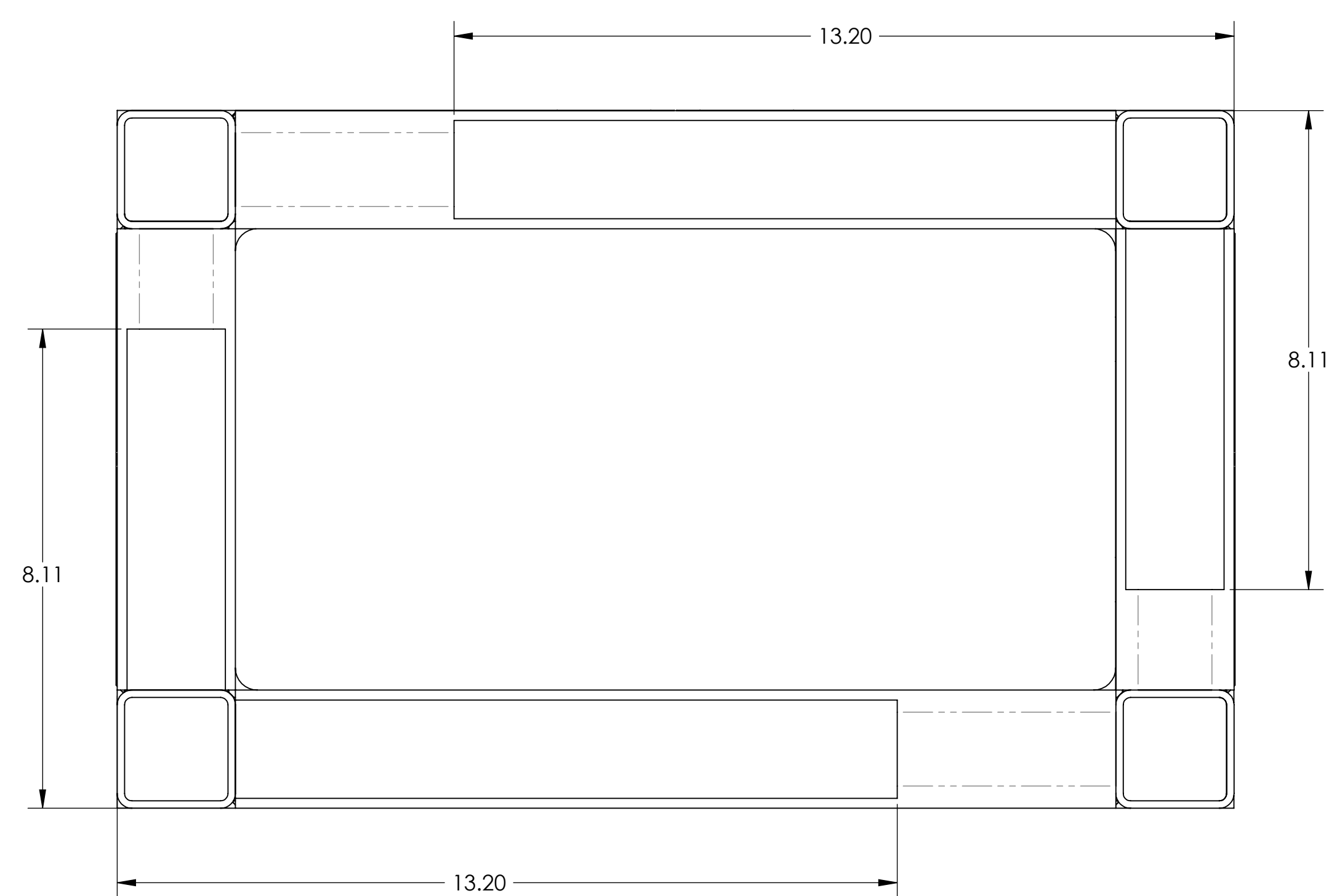
SECTION C-C



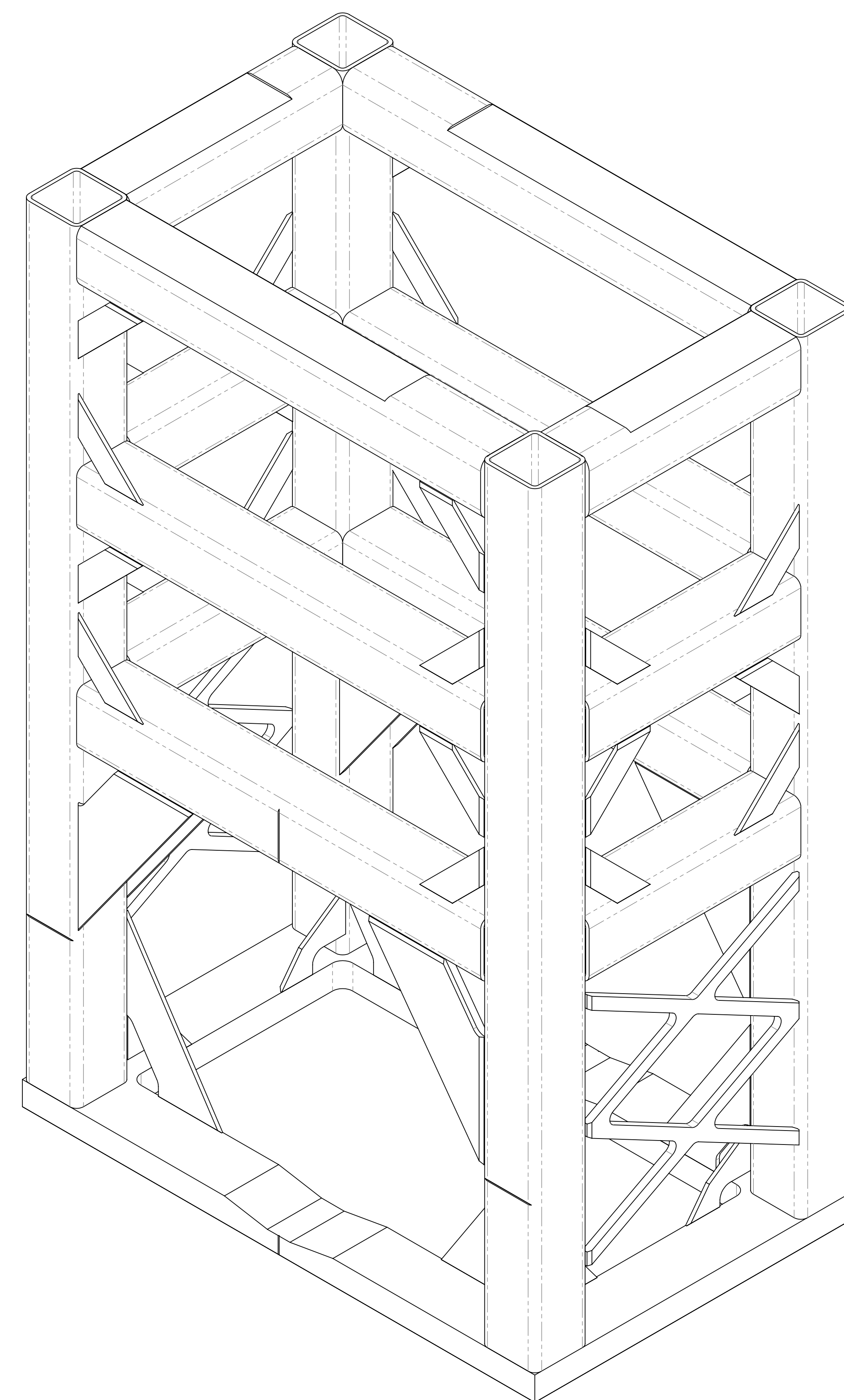
SECTION B-B

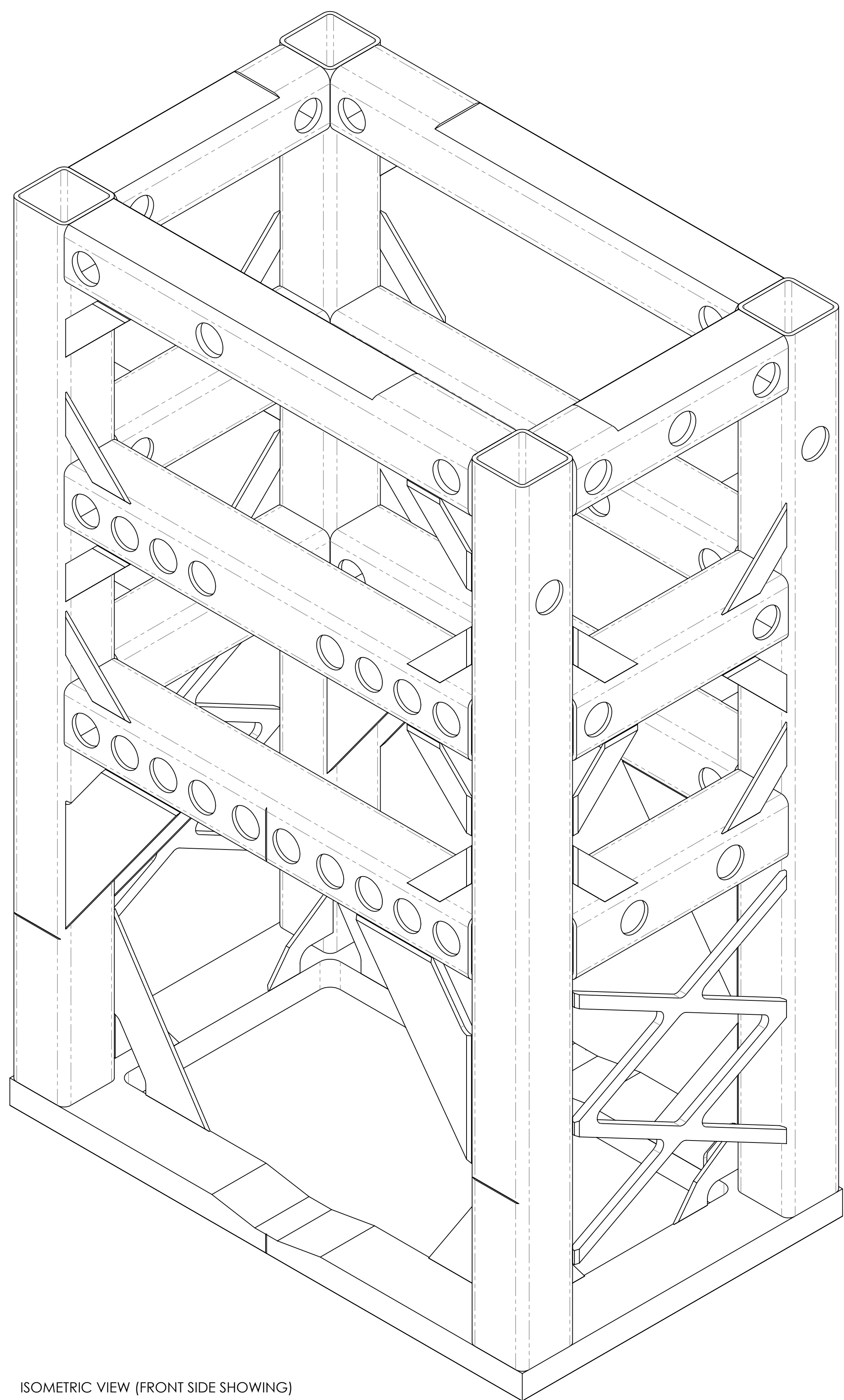


SECTION E-E

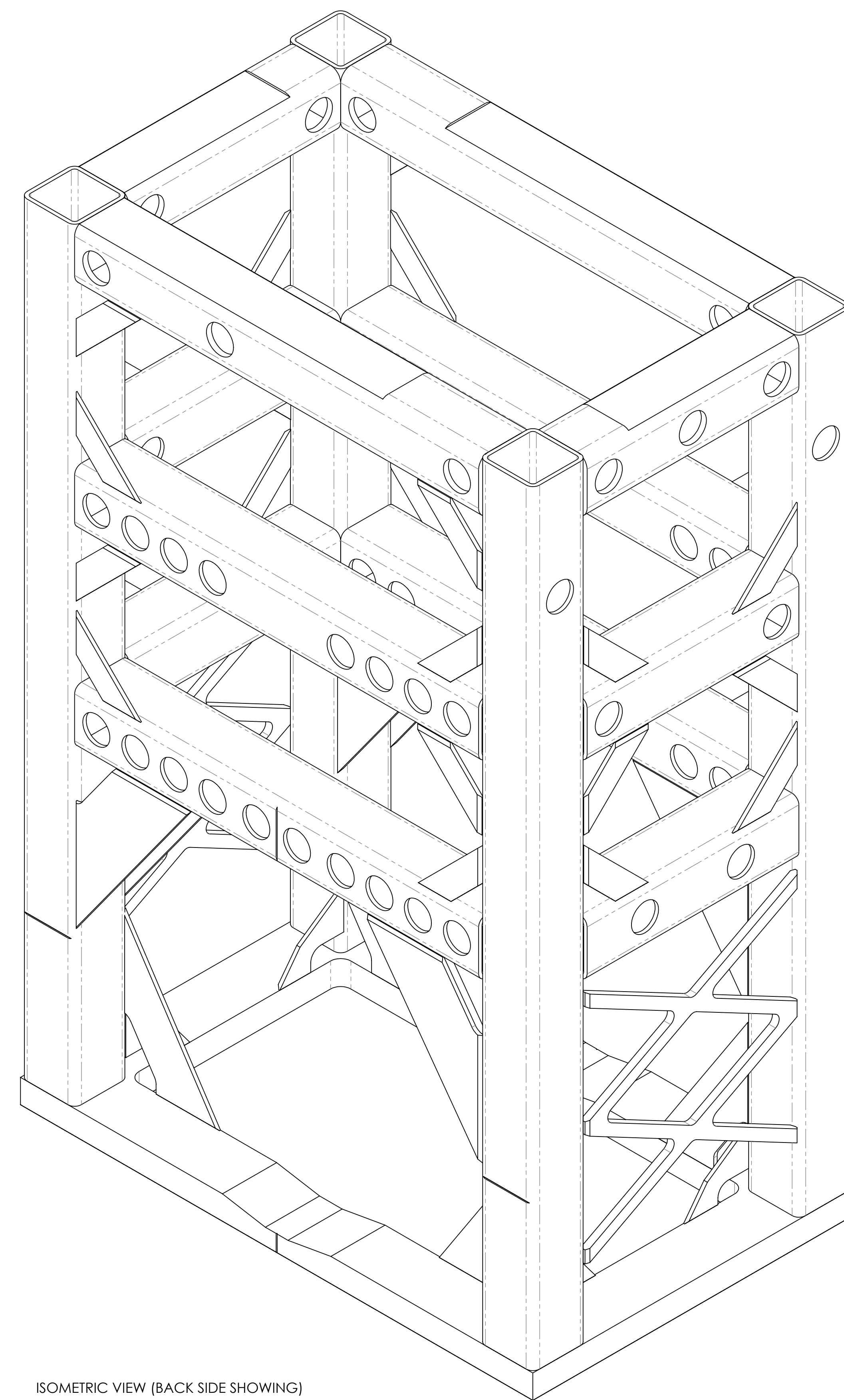


MACHINING LAYOUT



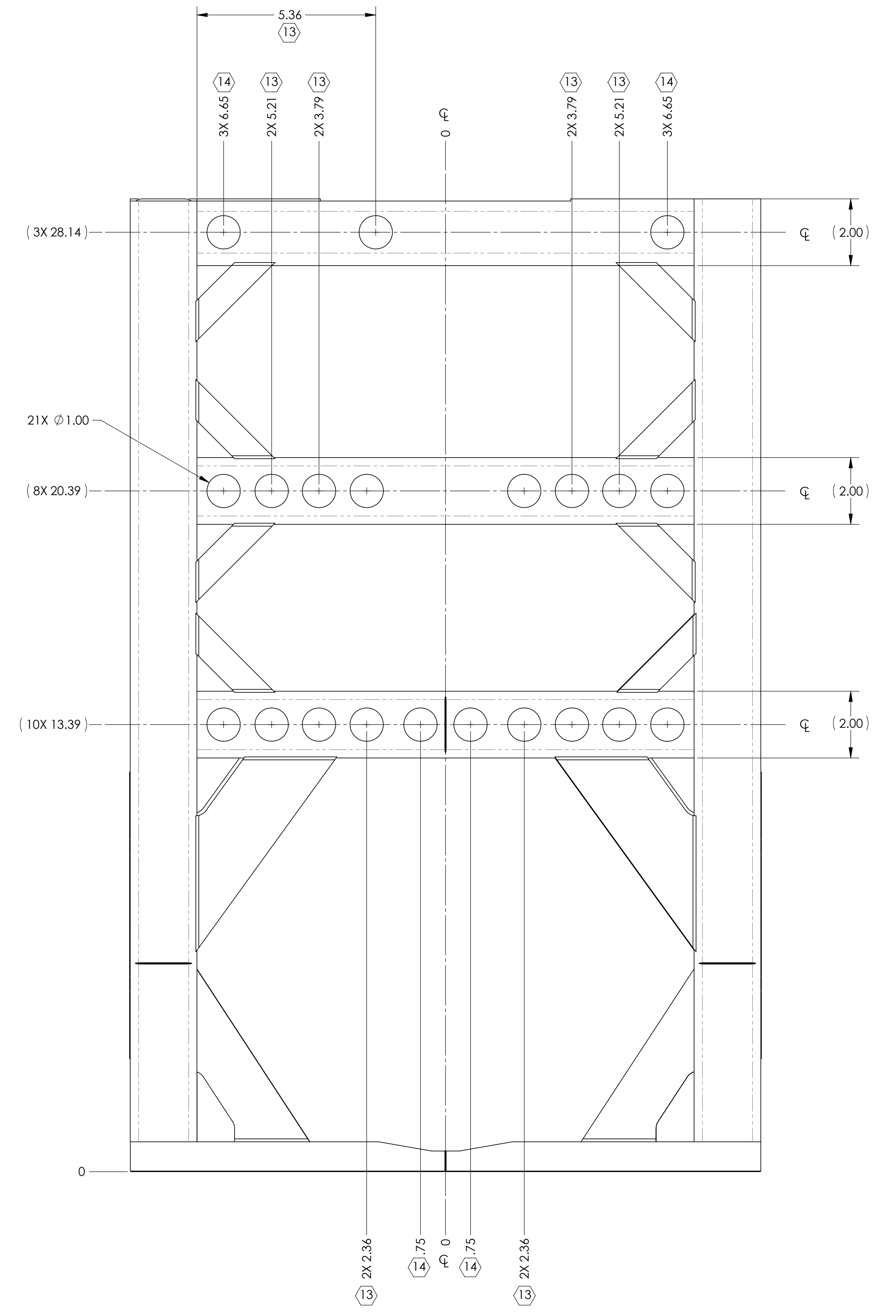
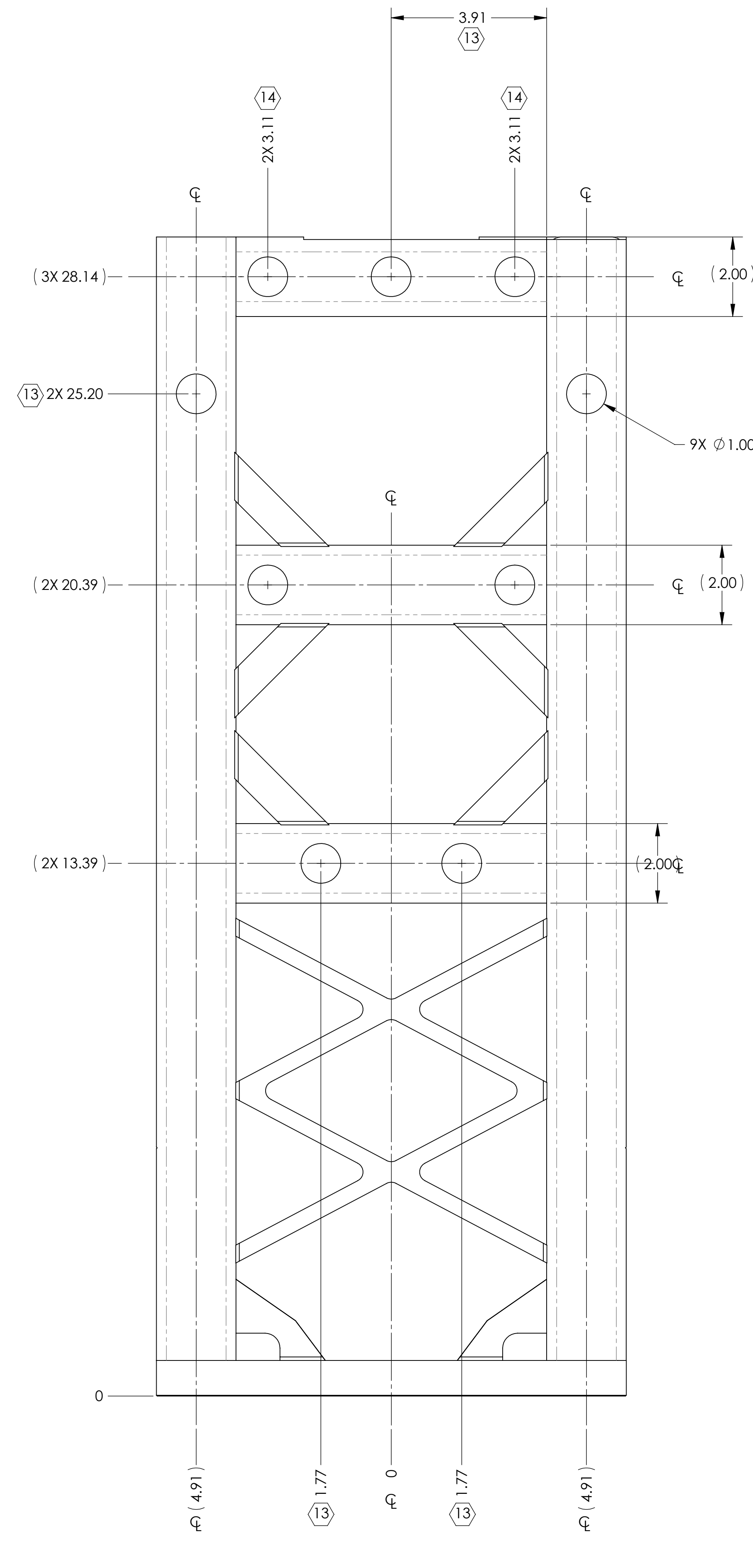
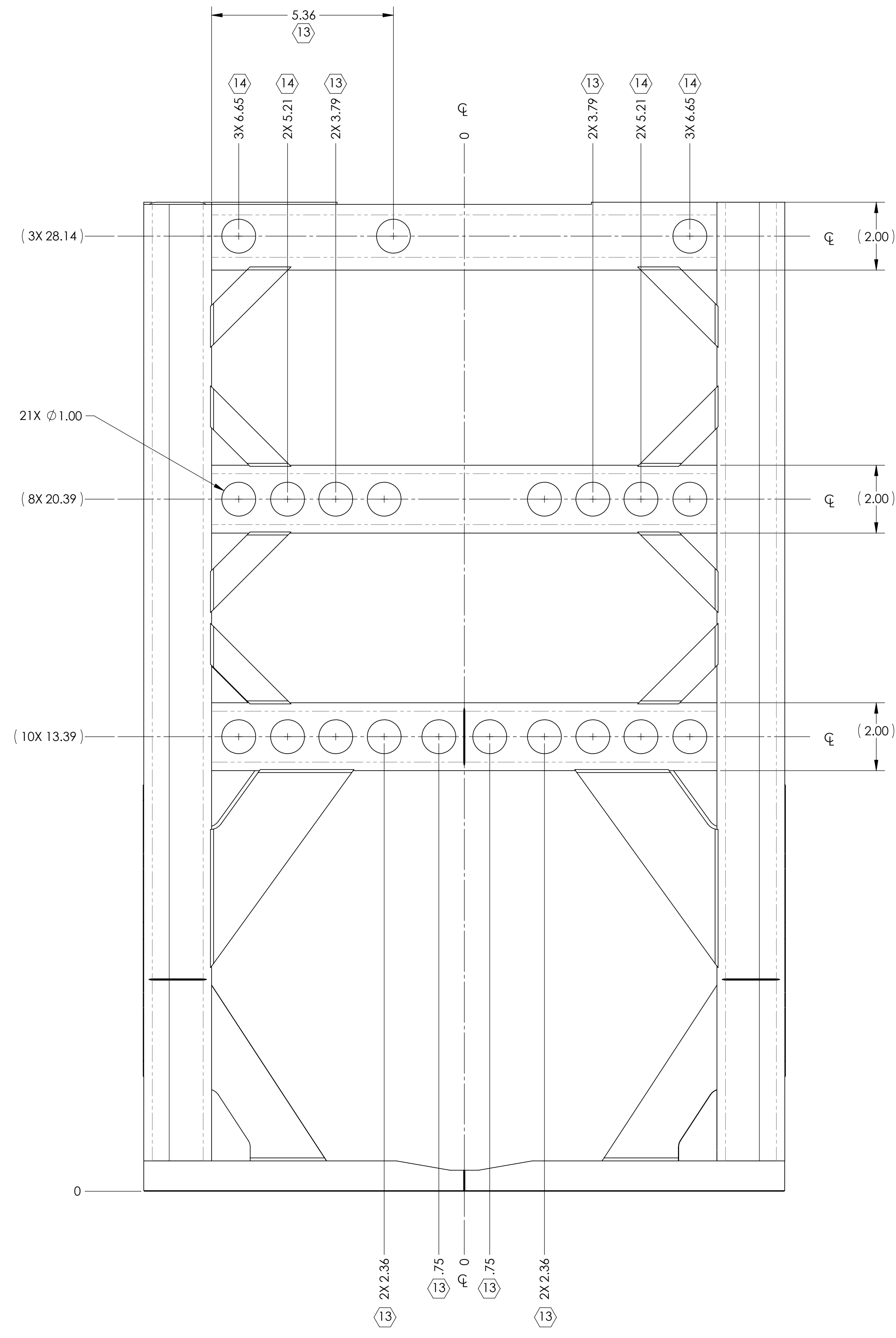


ISOMETRIC VIEW (FRONT SIDE SHOWING)

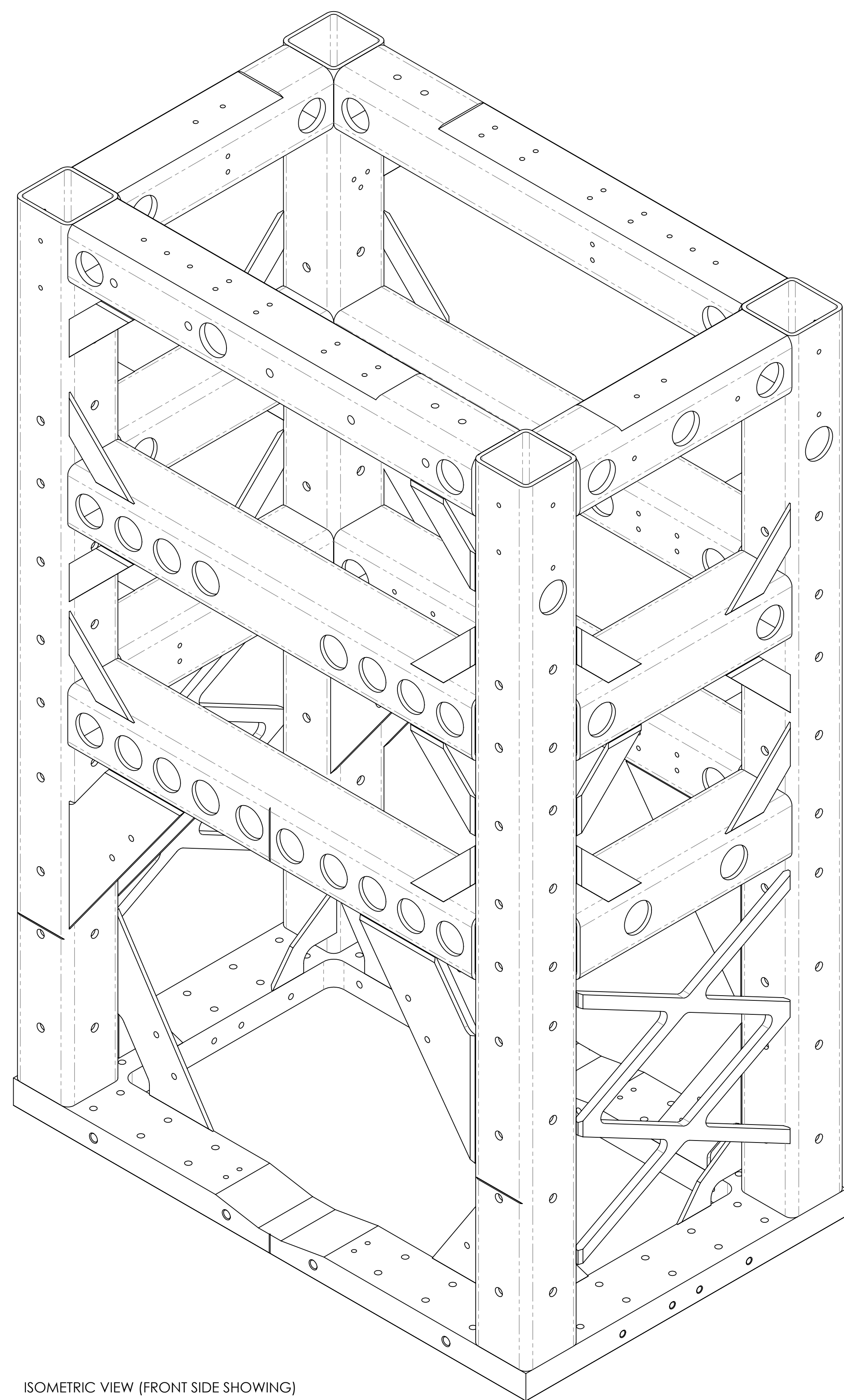


ISOMETRIC VIEW (BACK SIDE SHOWING)

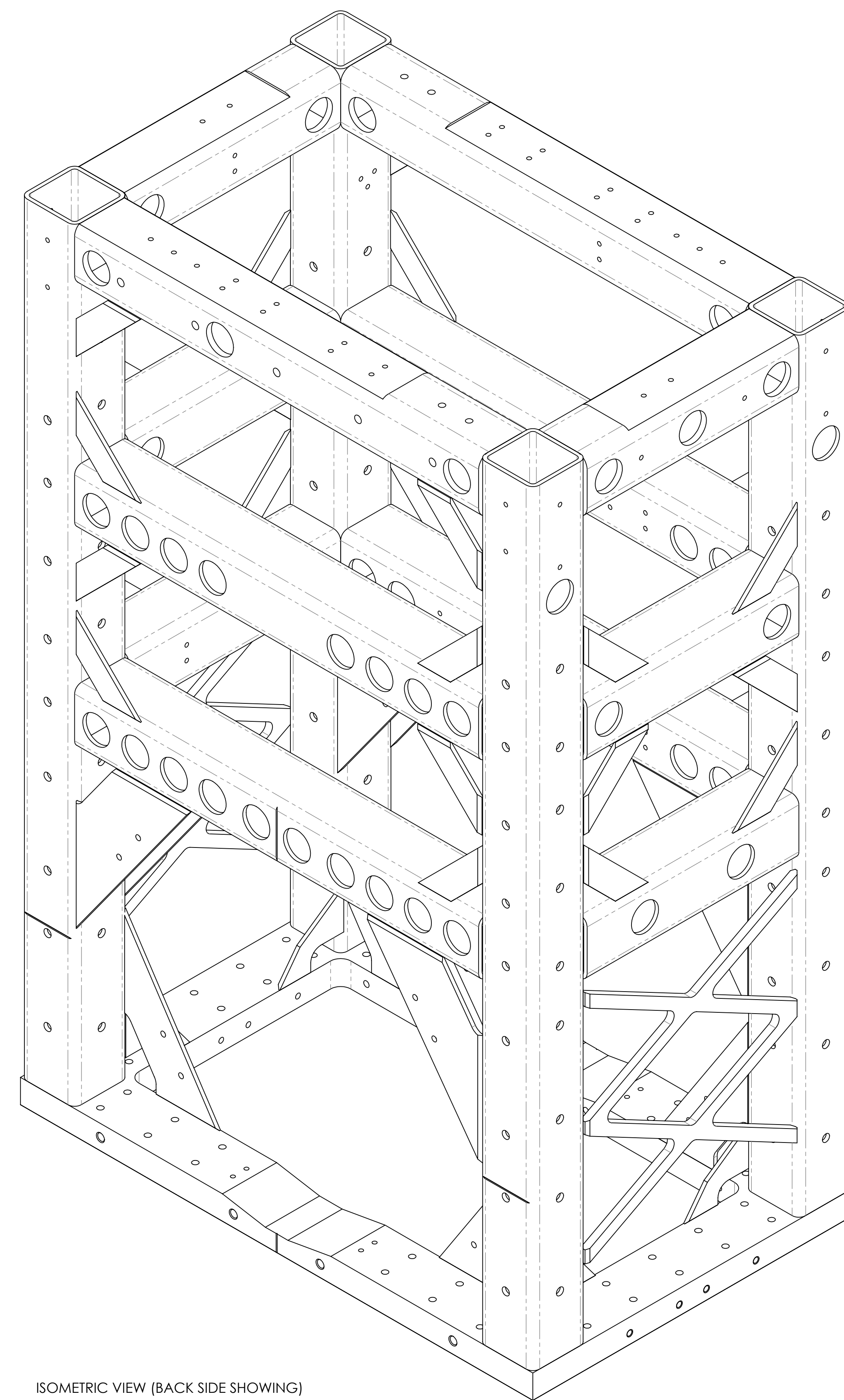
ISOMETRIC VIEWS FOR LARGE HOLE PLACEMENT



LARGE HOLE LAYOUT



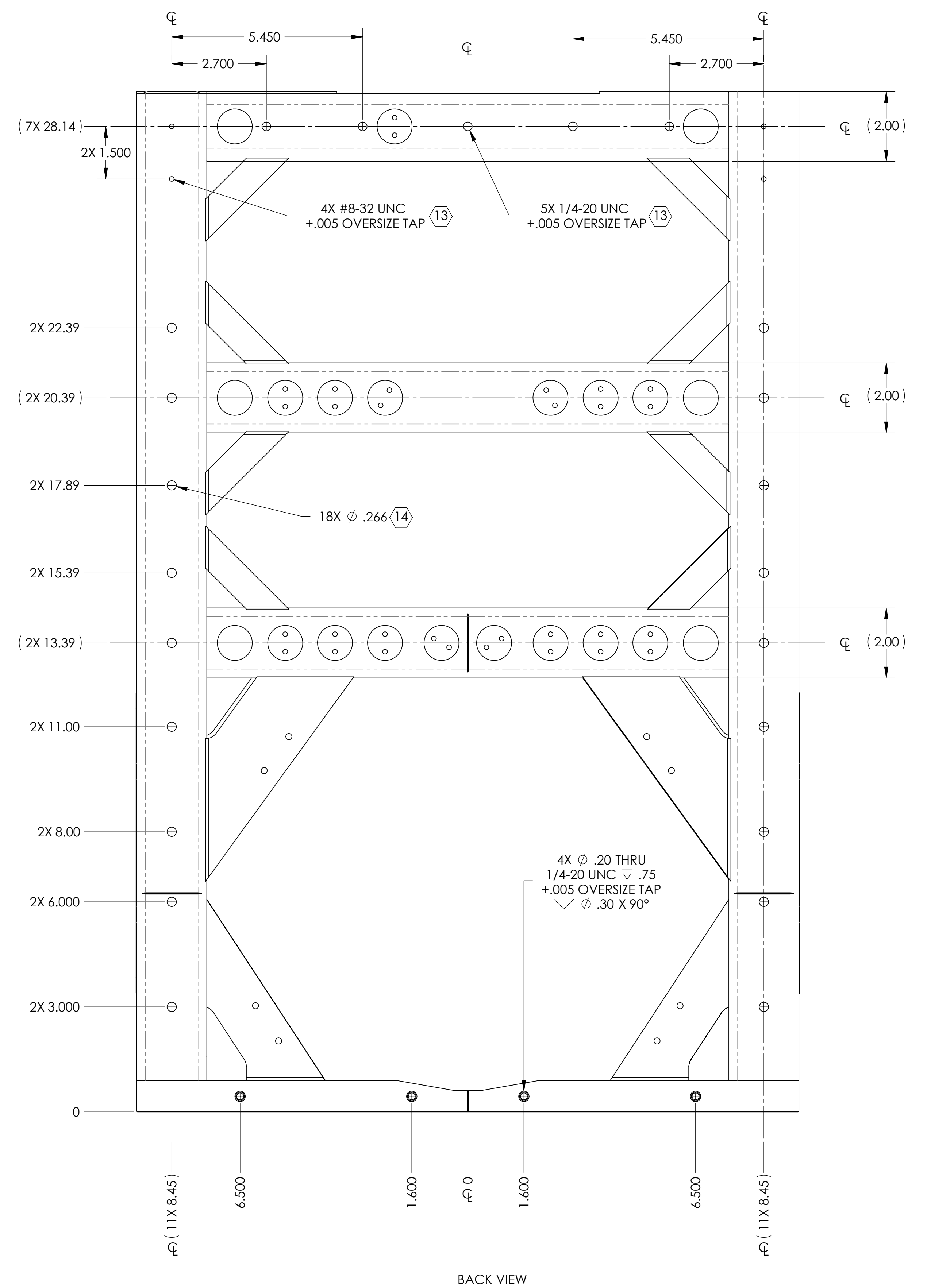
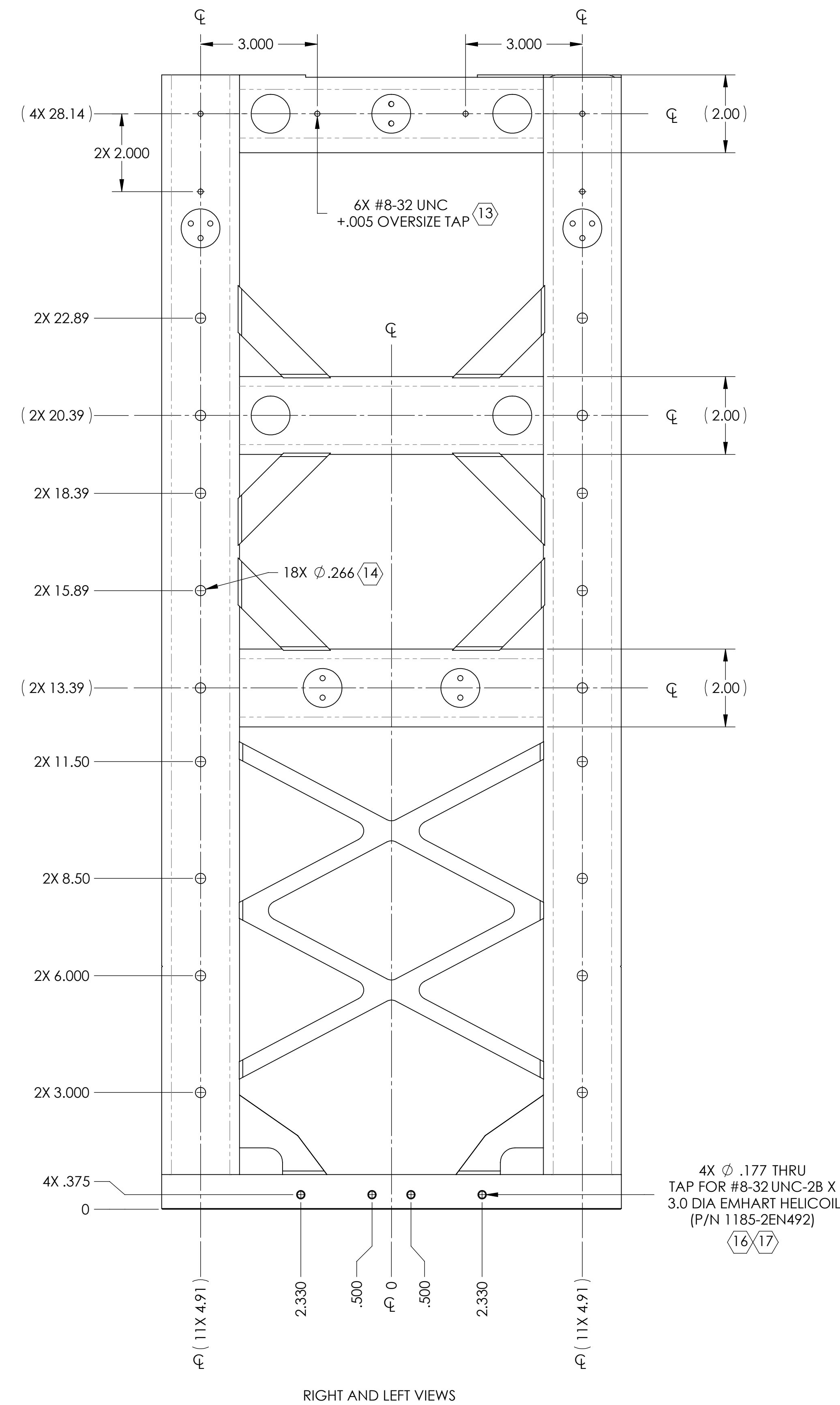
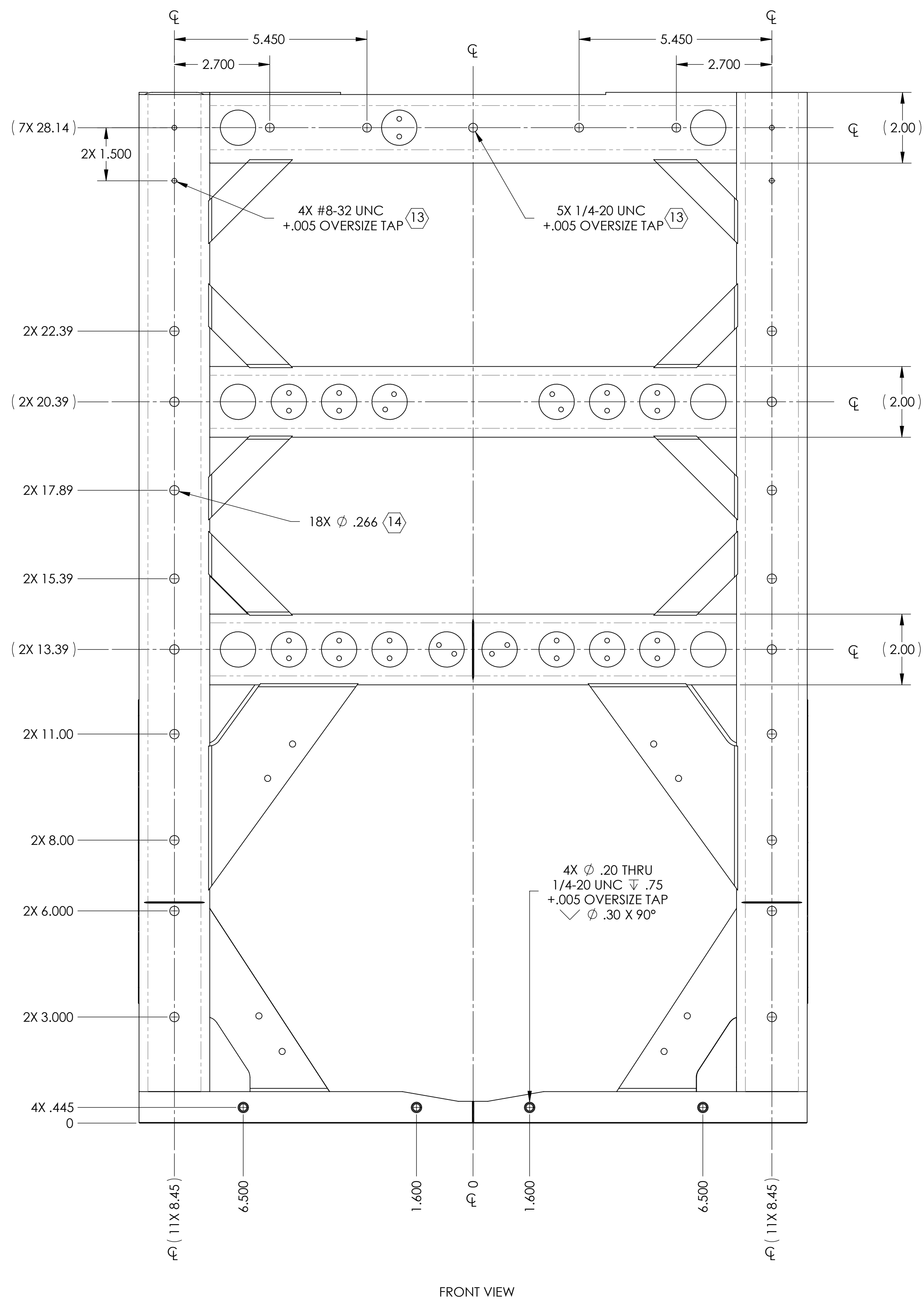
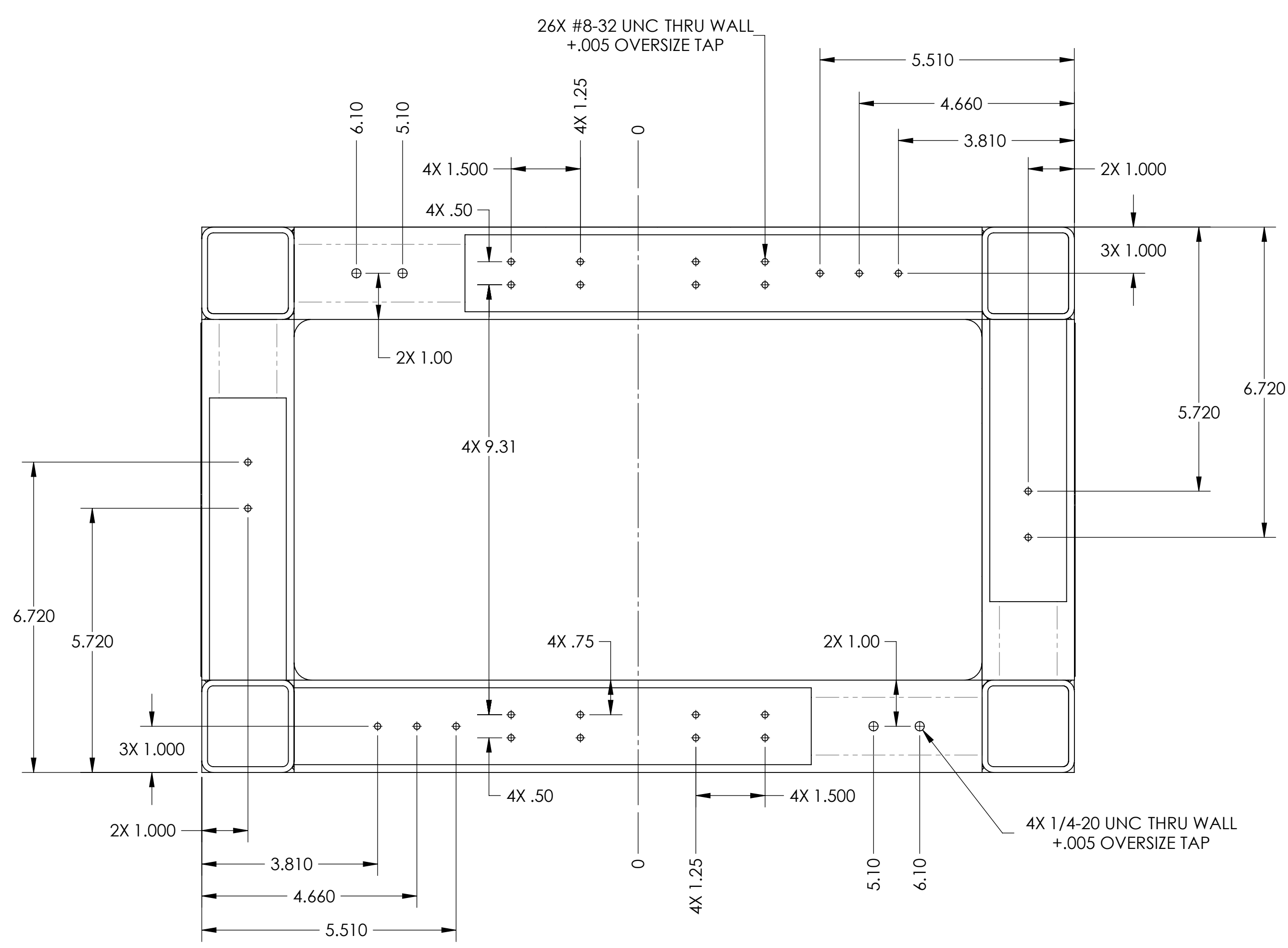
ISOMETRIC VIEW (FRONT SIDE SHOWING)



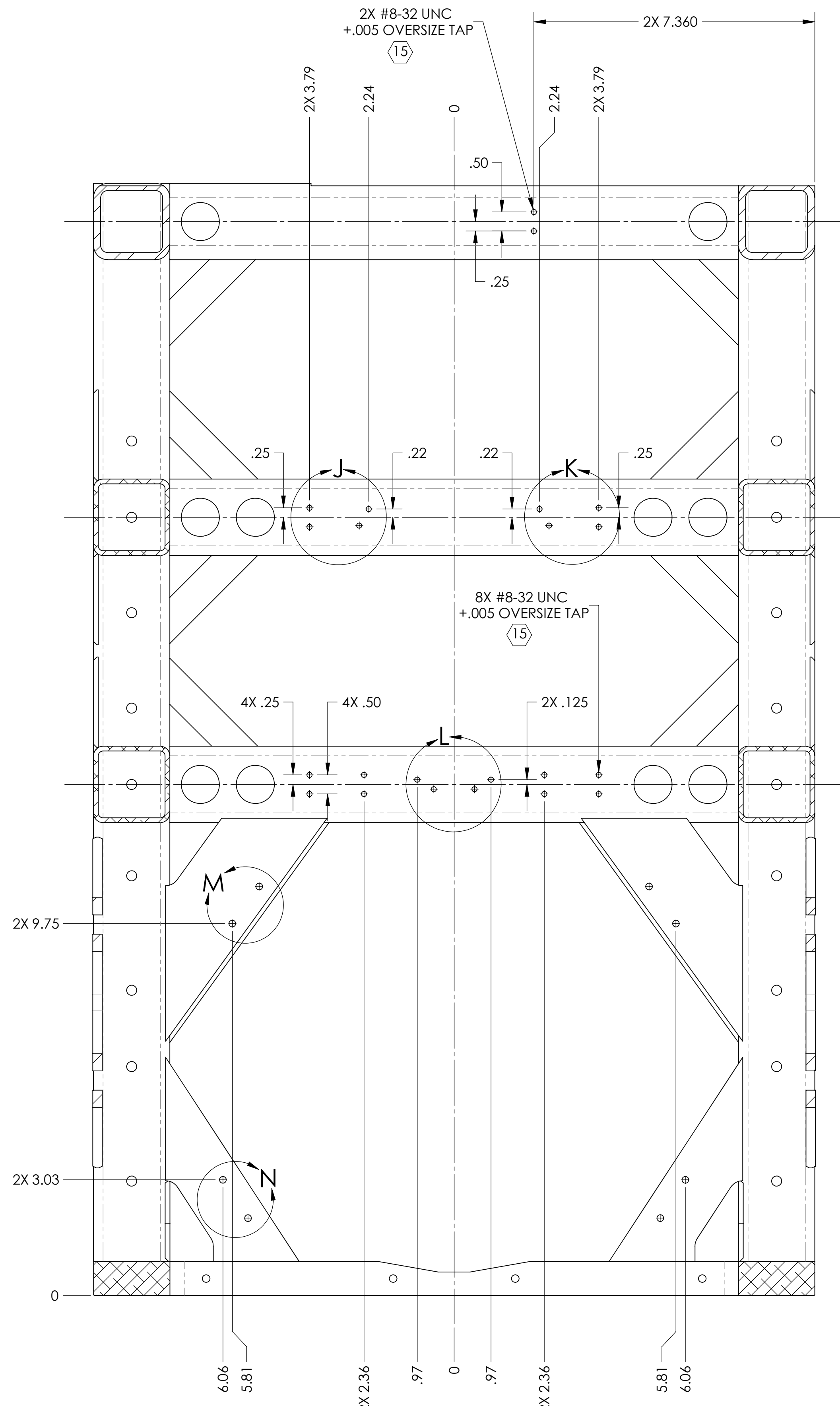
ISOMETRIC VIEW (BACK SIDE SHOWING)

ISOMETRIC VIEWS FOR LARGE HOLE PLACEMENT

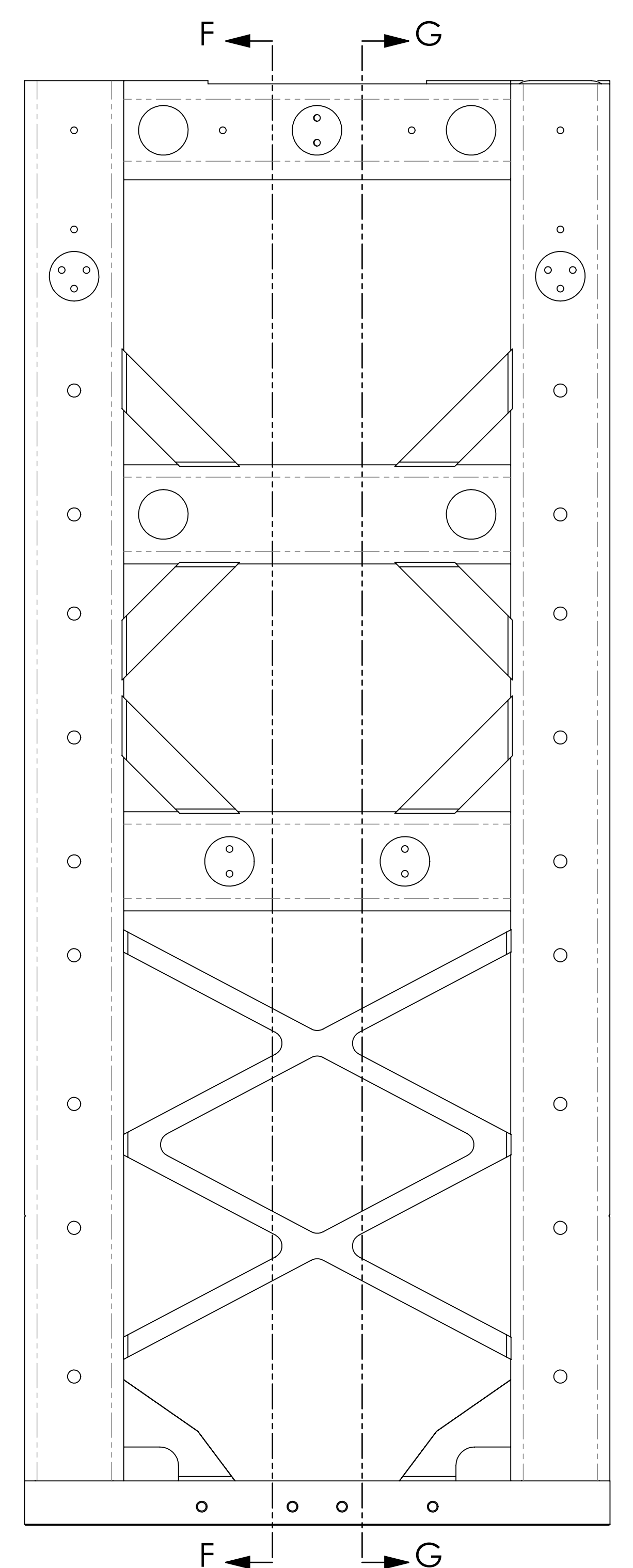
D:\BAGZ_Archived_LIGO_SILENT\Archived_WebContent_PAPERWORK\REV_12031_DRAWING\FRAME_REV_12035



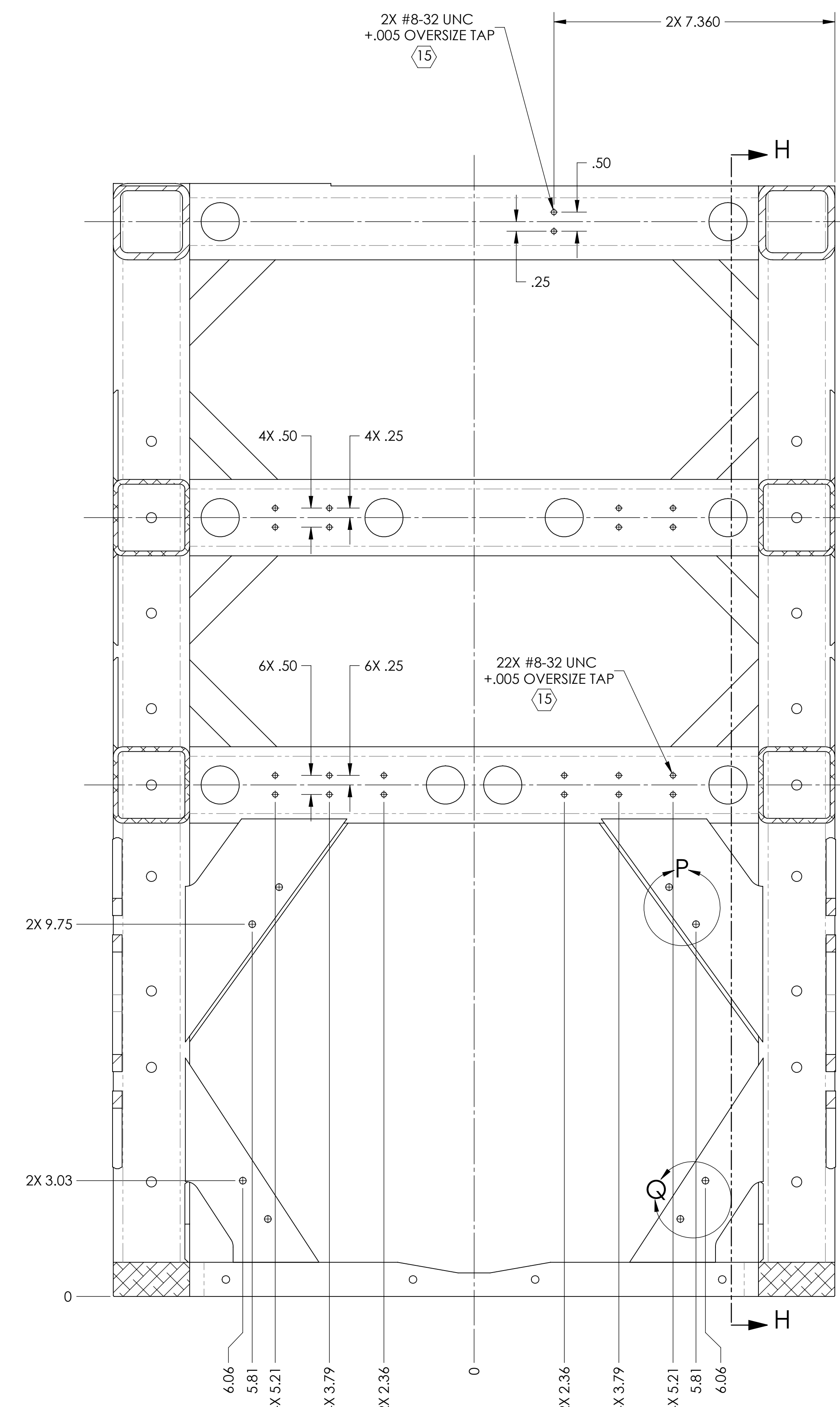
SMALL HOLE LAYOUT



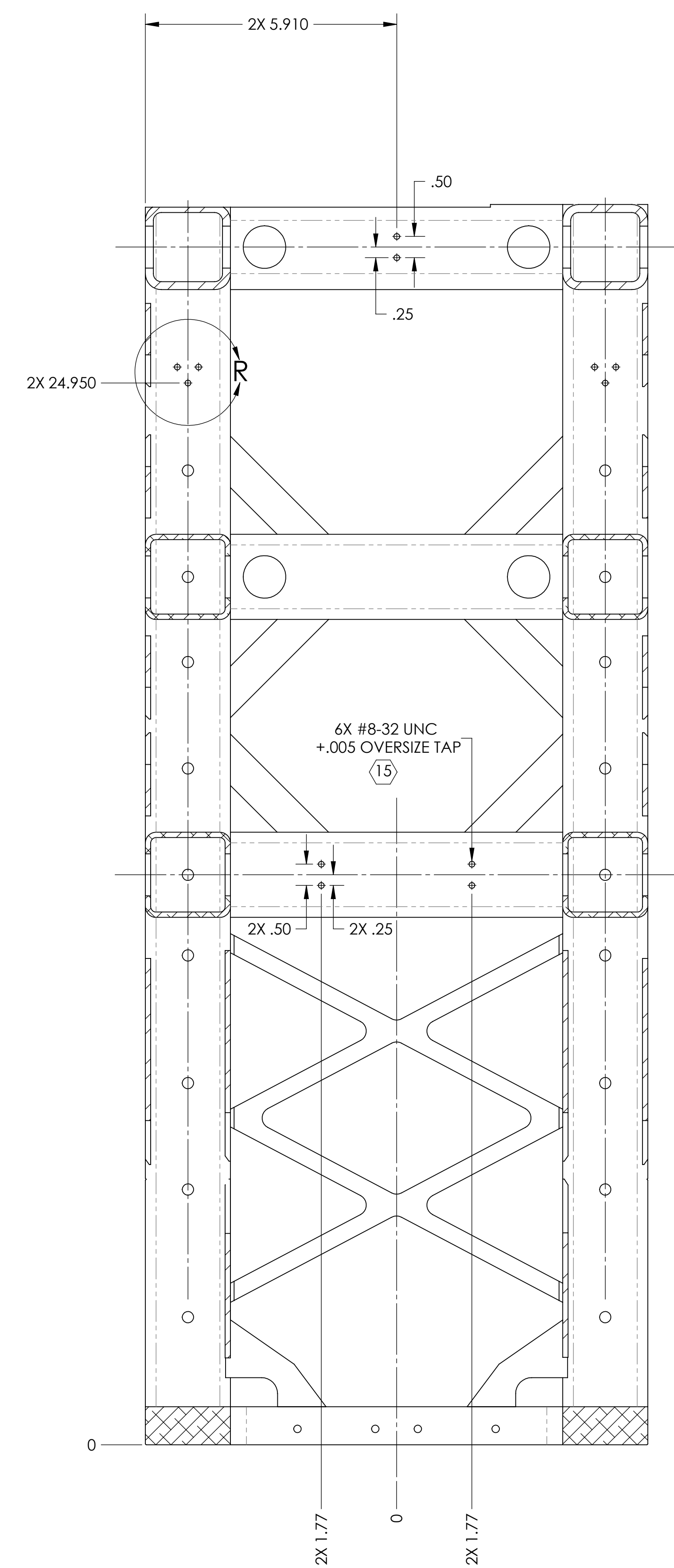
SECTION F-F
FRONT INSIDE VIEW



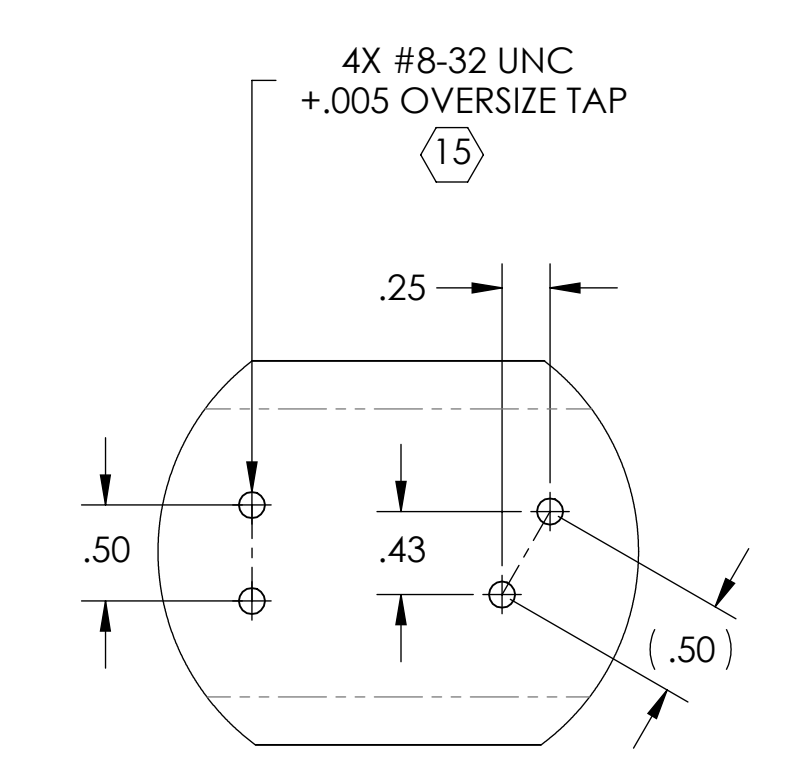
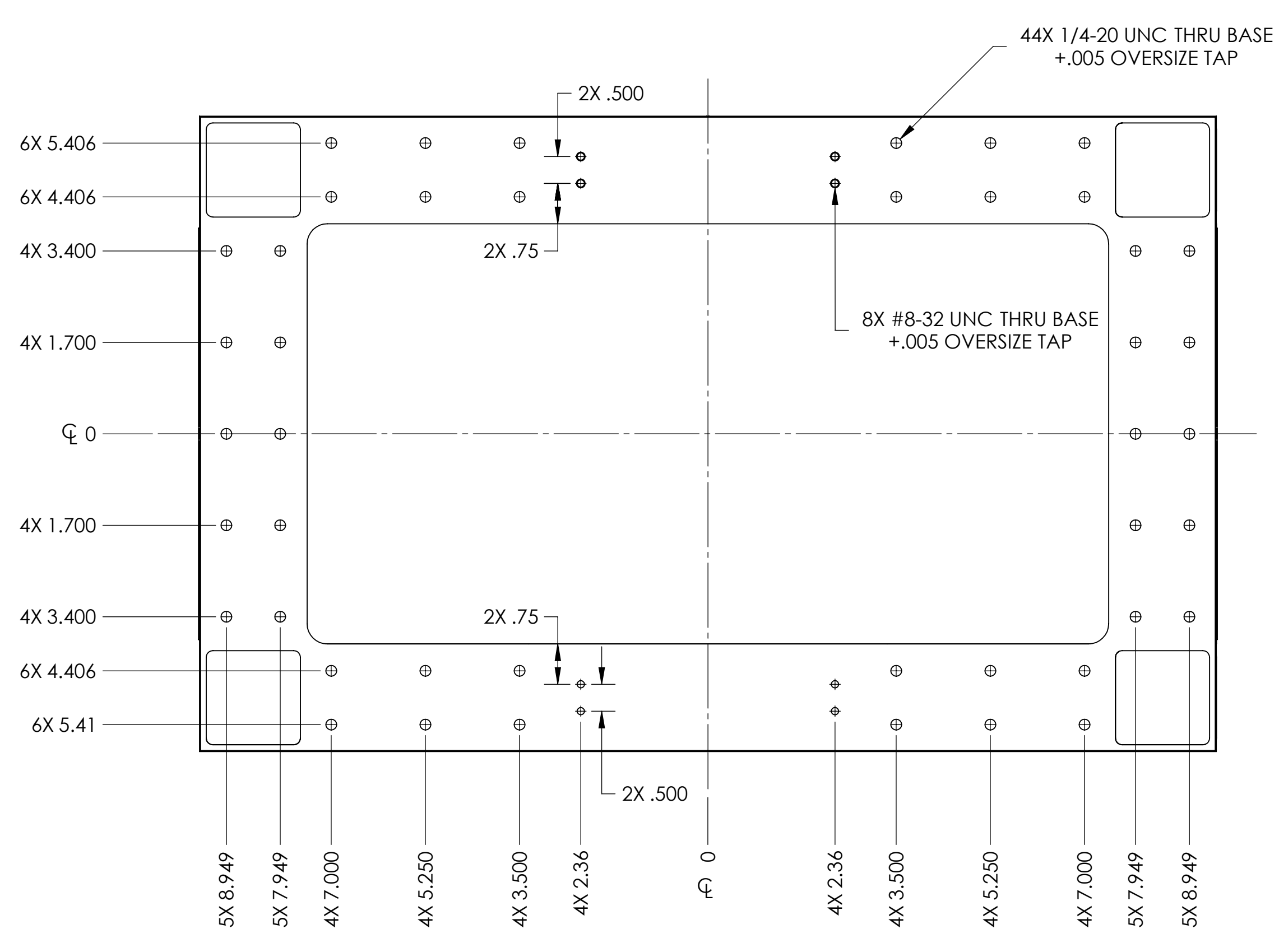
LEFT AND RIGHT VIEWS



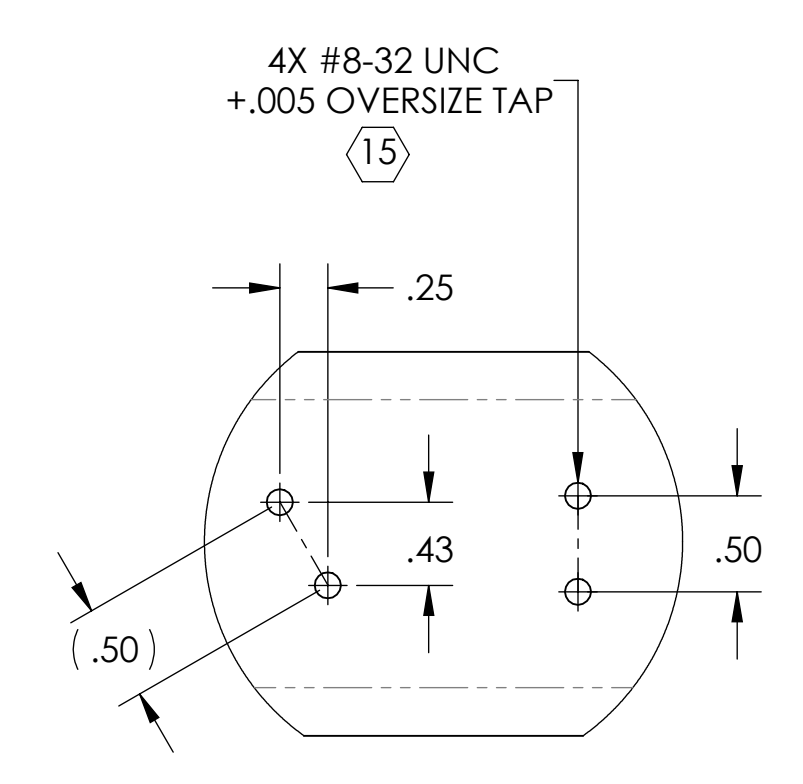
SECTION G-G
BACK INSIDE VIEW



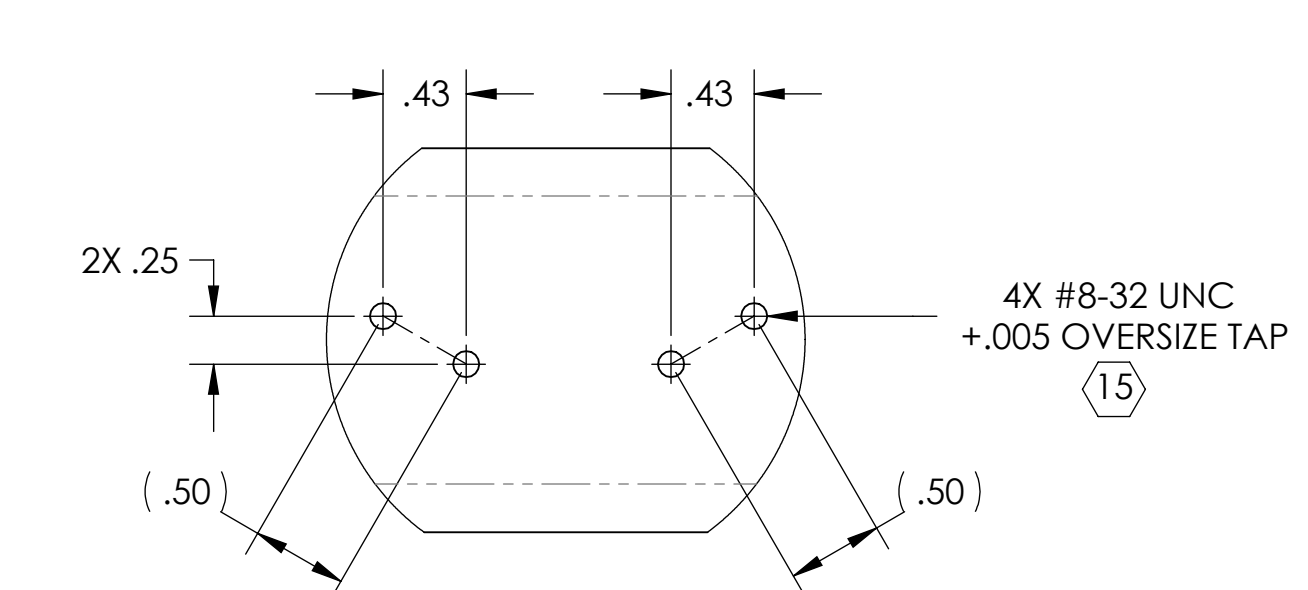
SECTION H-H
LEFT AND RIGHT INSIDE VIEWS



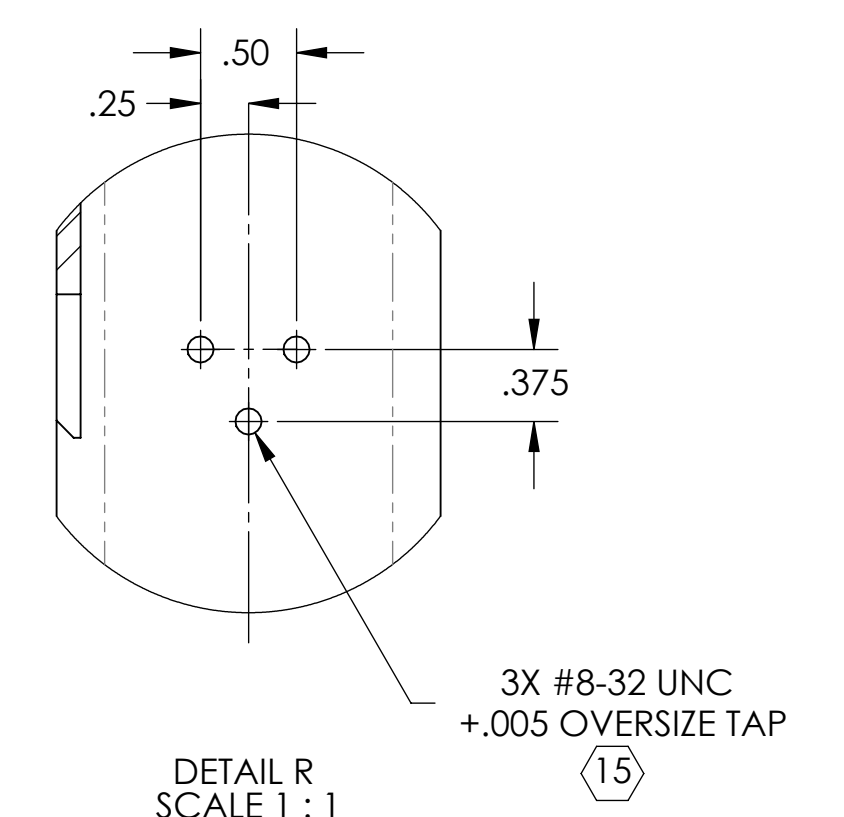
DETAIL J
SCALE 1:1



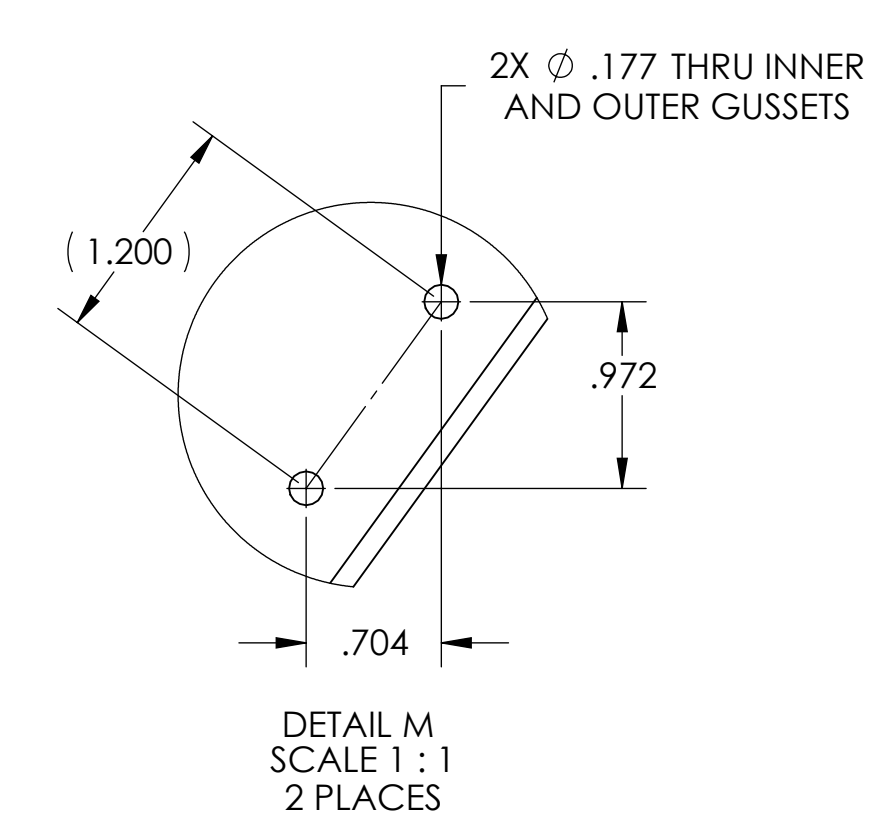
DETAIL K
SCALE 1:1



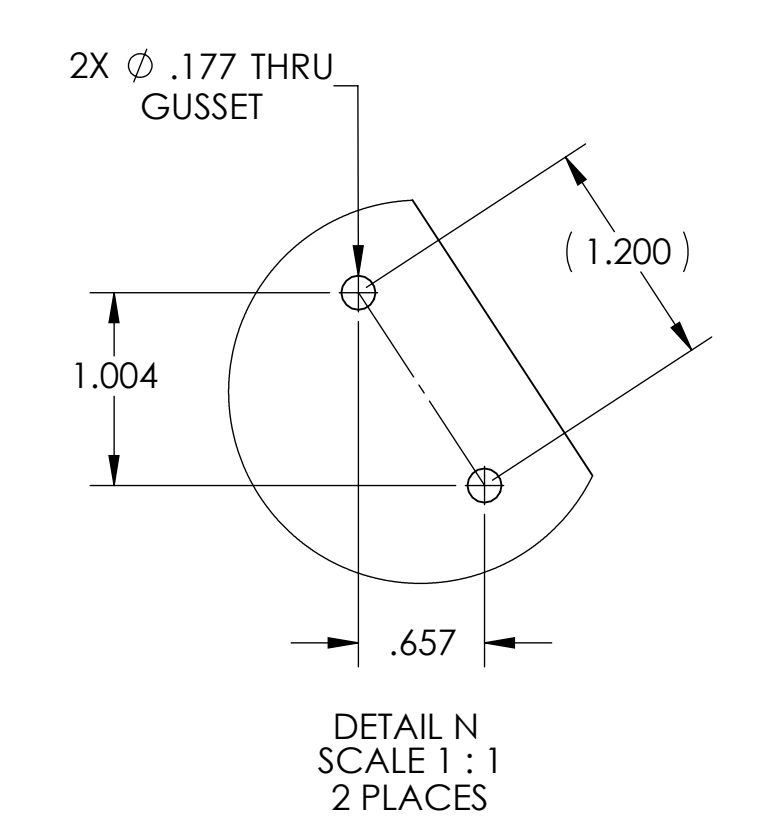
DETAIL L
SCALE 1:1



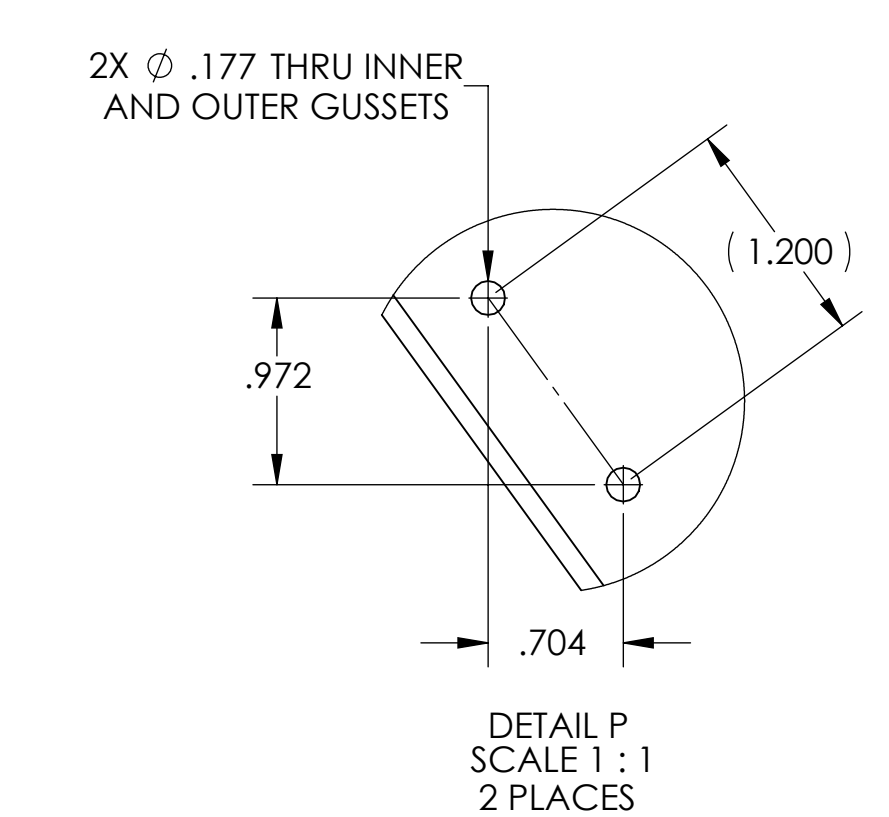
DETAIL R
SCALE 1:1



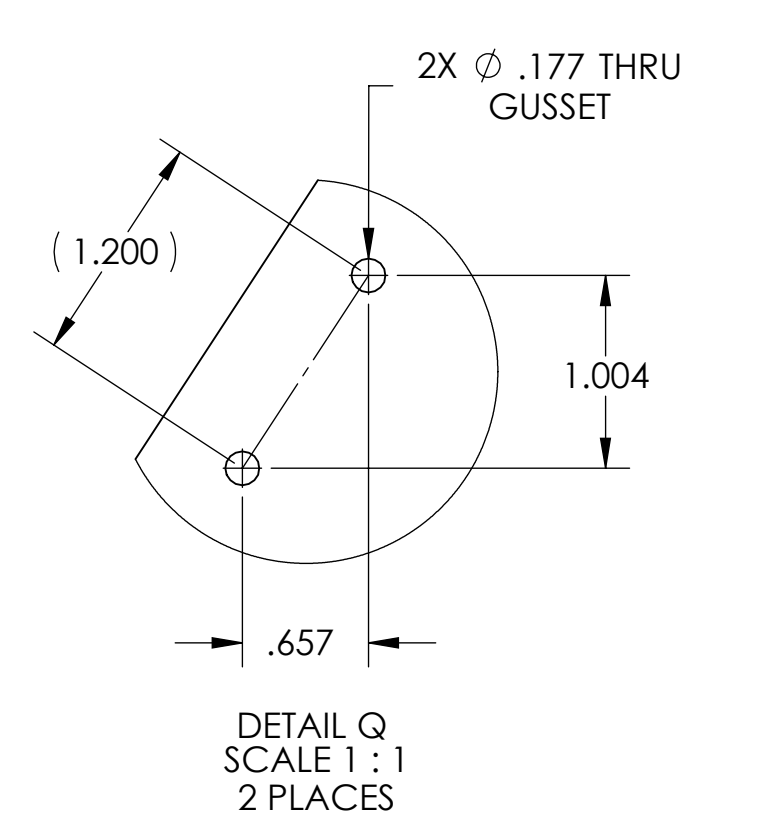
DETAIL M
SCALE 1:1
2 PLACES



DETAIL N
SCALE 1:1
2 PLACES



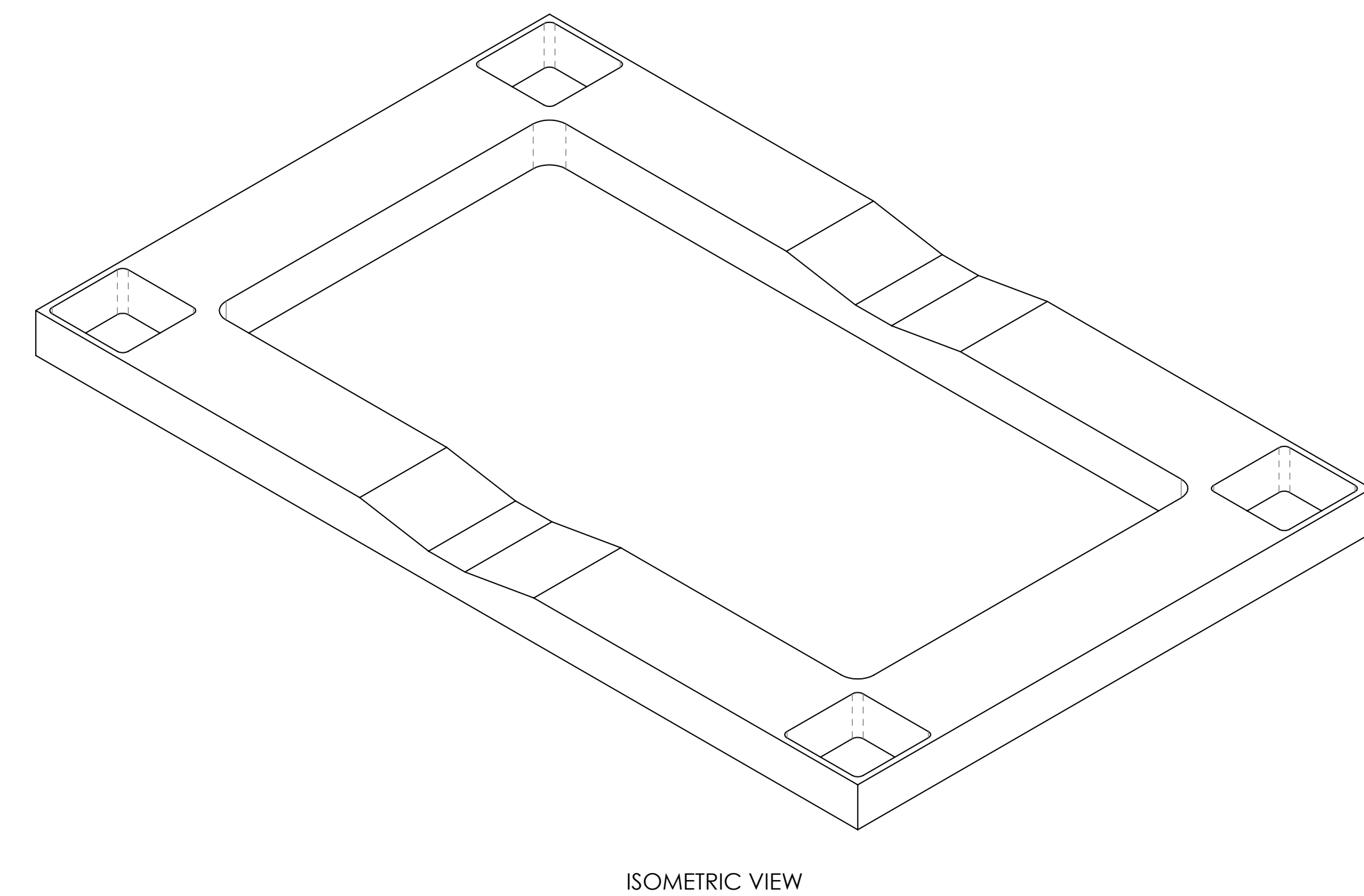
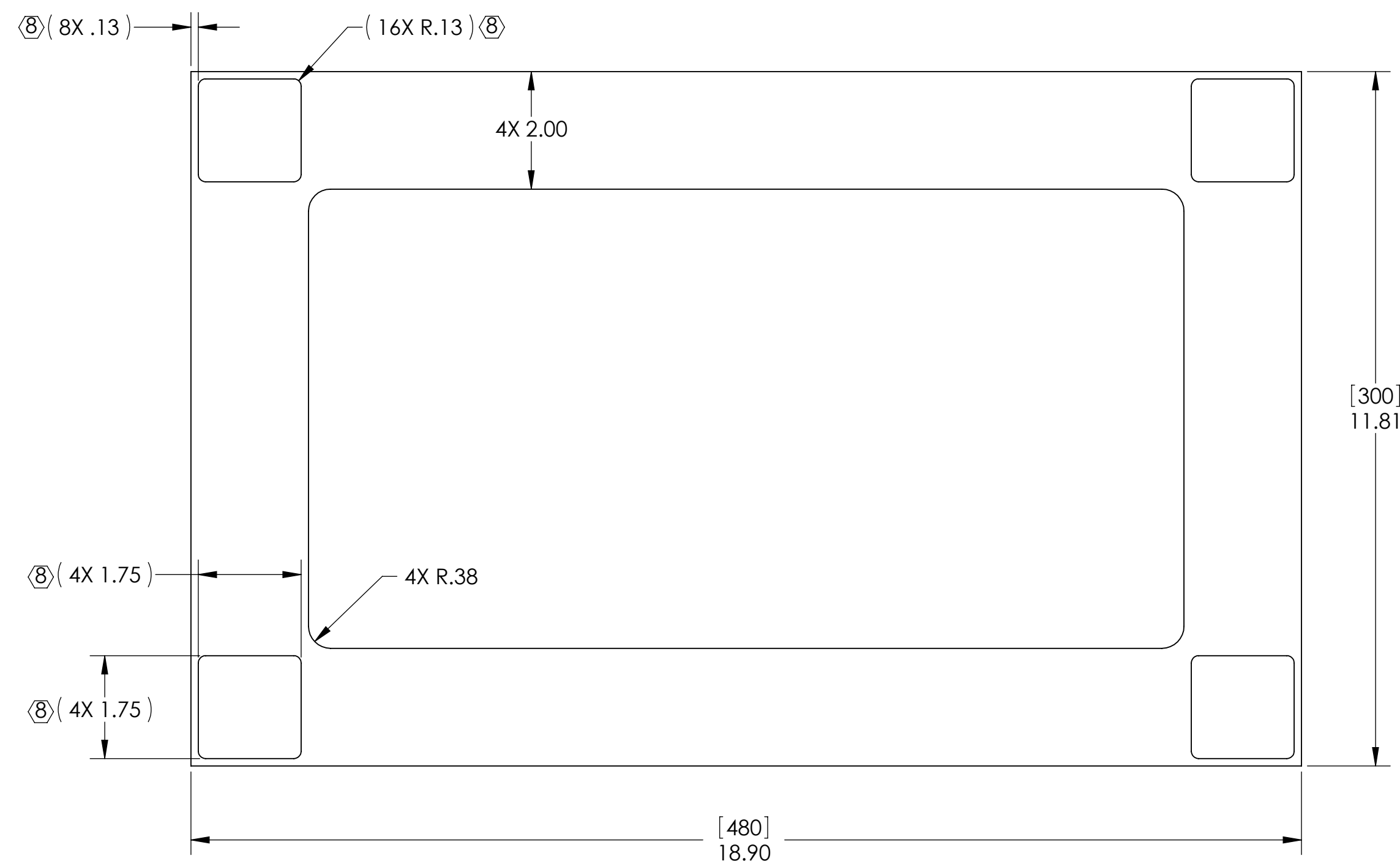
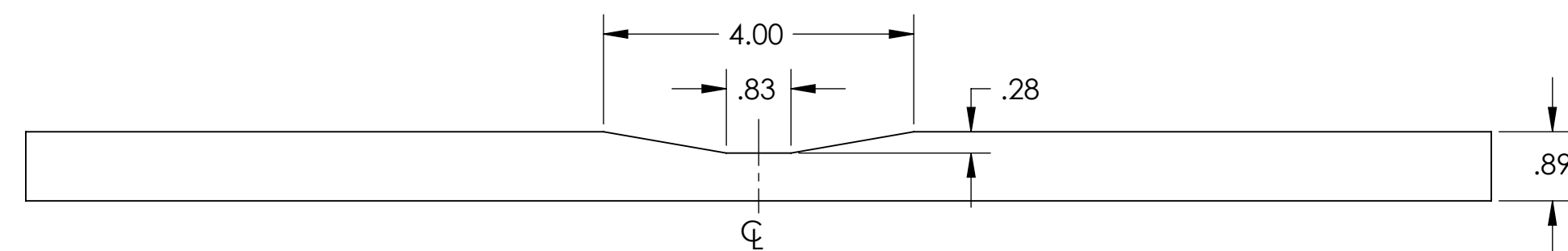
DETAIL P
SCALE 1:1
2 PLACES



DETAIL Q
SCALE 1:1
2 PLACES

NOTES CONTINUED:
 5. THIS PRICE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD REDUCED SHRINKAGE OR FILL AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE E070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ISO SPECIFICATION ISO9004.
 8. MACHINE CUTOFF TO MATCH INNER PROFILE OF LEG TUBE. DIMENSIONS PROVIDED ARE FOR REFERENCE ONLY.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES [MM]	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
304 OR 304L SSSL	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: STRUCTURAL WELDMENT, HLTS

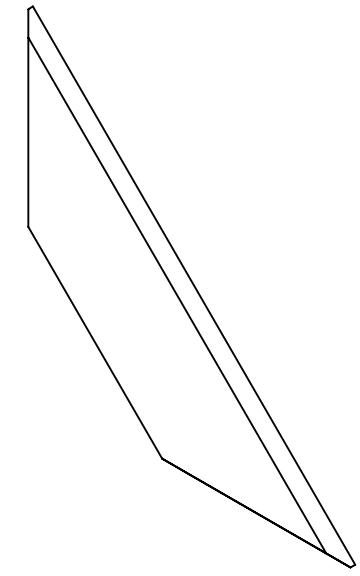
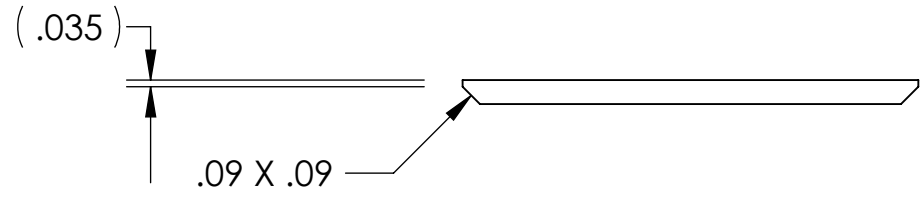
PART NAME				BASE PLATE	
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	
DRAFTER	D. BRIDGES	29 AUG 2010	D	D070575	
CHECKER	M. MEYER	30 AUG 2010			
APPROVAL			SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

DD070575-AdvancedLIGO_SUS_HLTS_Structure_Base_Plate_PART PDM REV: V1-002, DRAWING PDM REV: V1-002

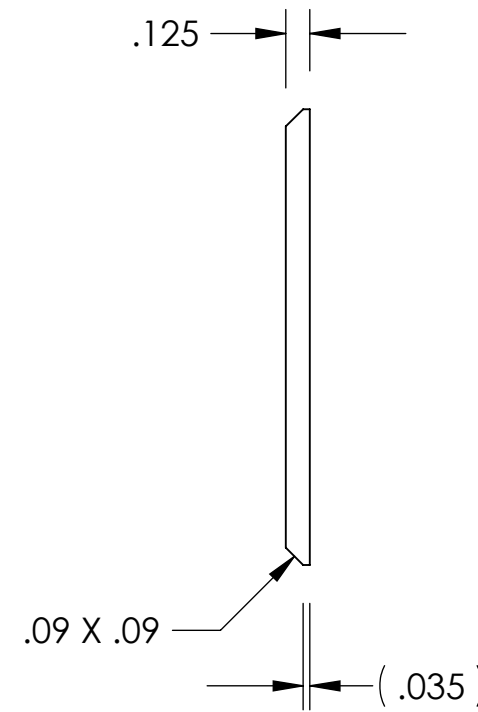
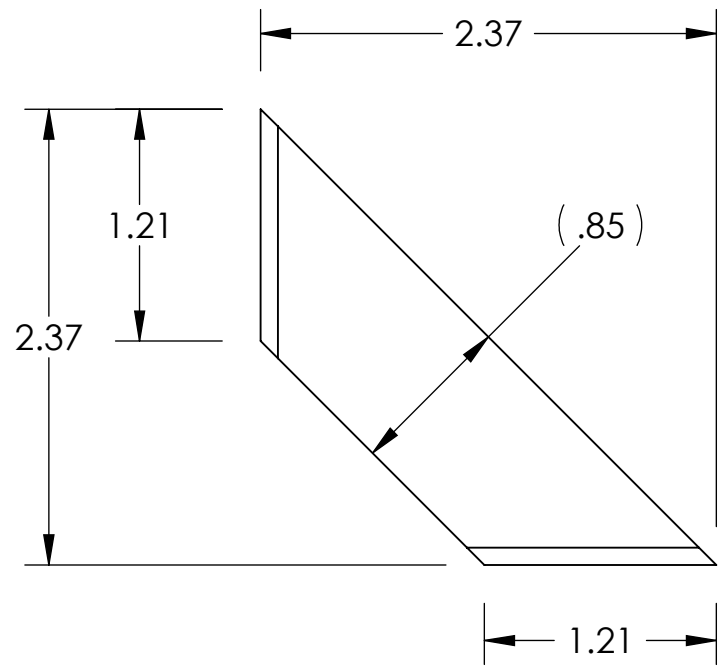
D070580_Advanced_LIGO_SUS_HLTS_Structure_Top_Gusset, PART PDM REV: V1-003, DRAWING PDM REV: V1-001

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
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.	
MATERIAL	FINISH
304 OR 304L SSSL	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

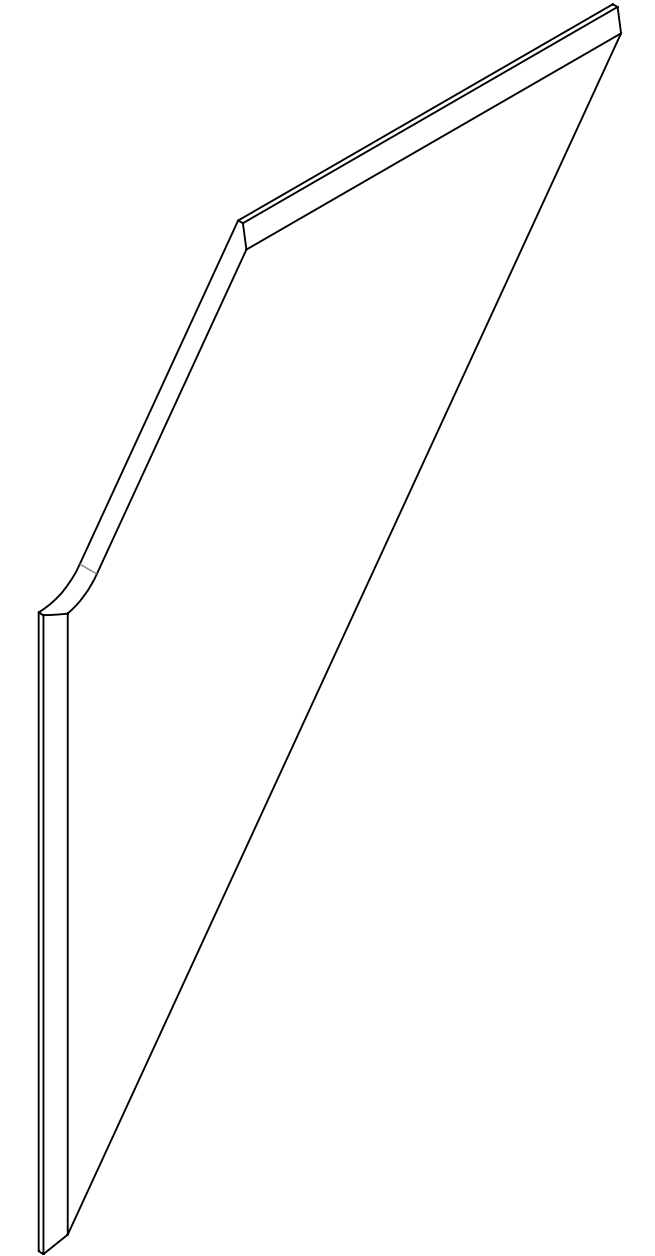
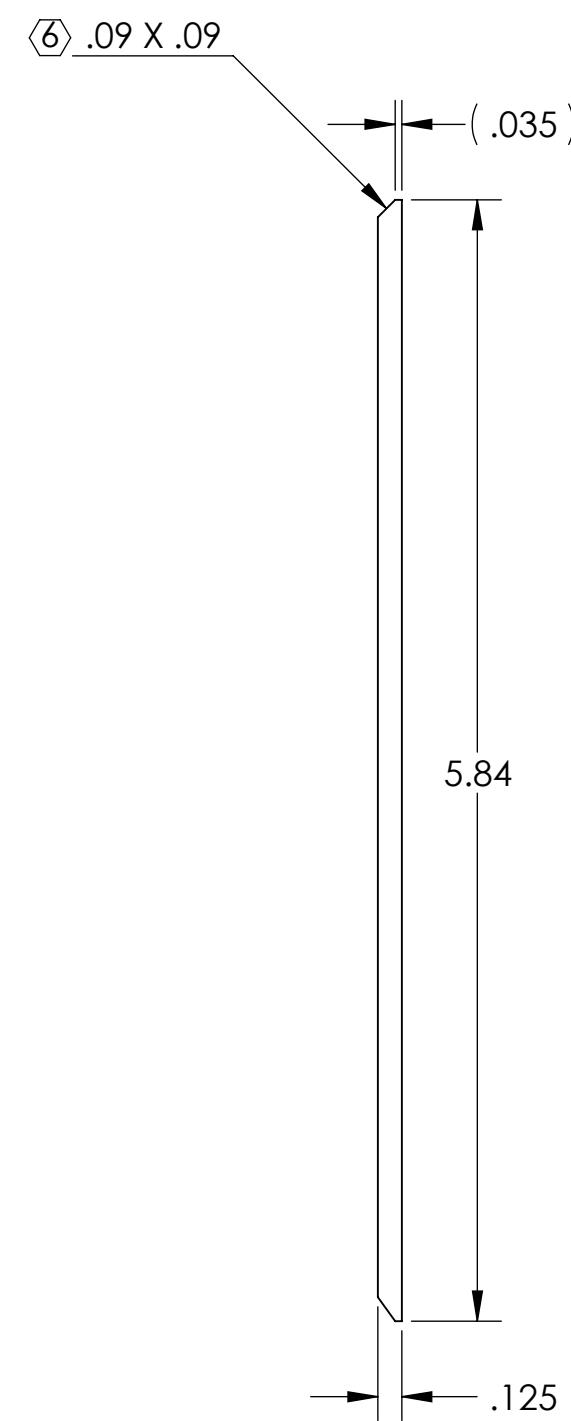
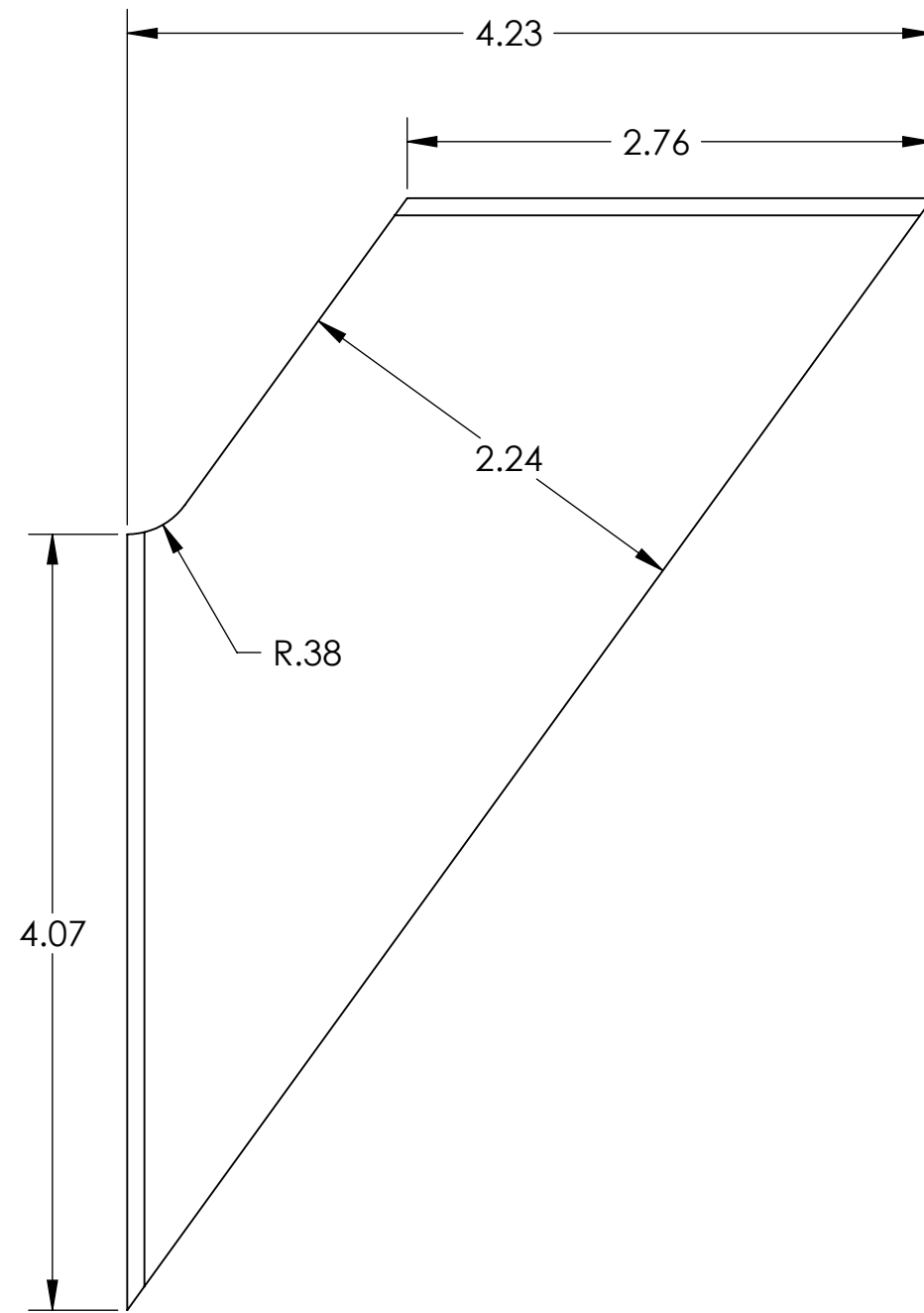
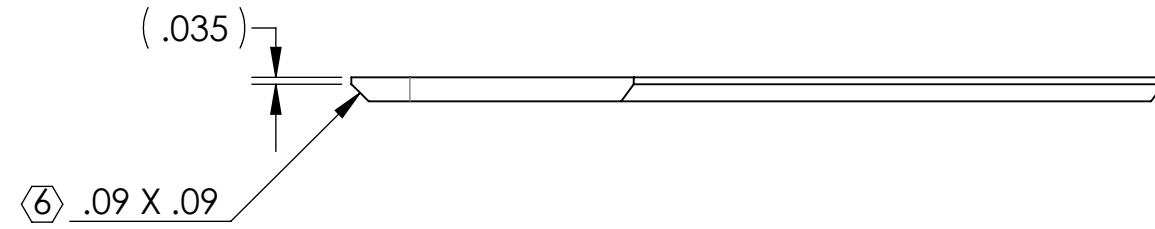
SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SUS**

NEXT ASSY: **STRUCTURAL WELDMENT, HLTS**

PART NAME			TOP GUSSET		
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	B	D070580	v2
CHECKER	M. MEYER	30 AUG 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. HALF OF ALL UPPER FRONT GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
 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 E090364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

MATERIAL 304 OR 304L SSSL
FINISH 63 μinch



SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS

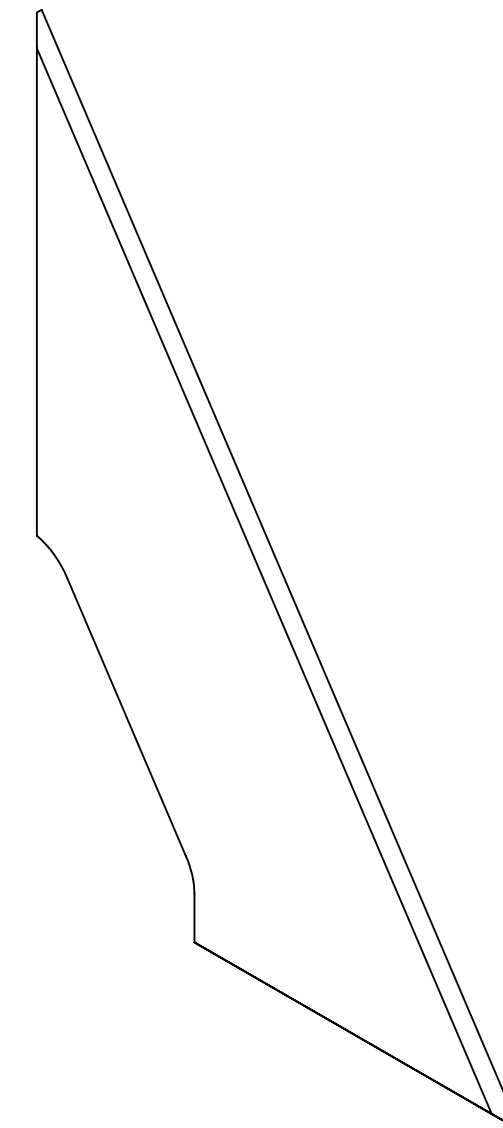
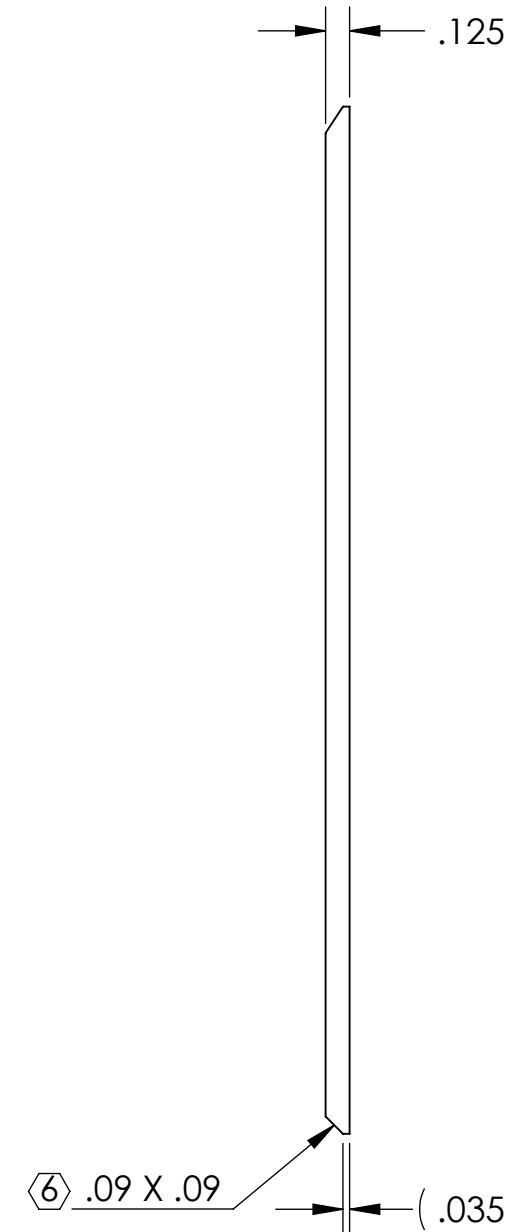
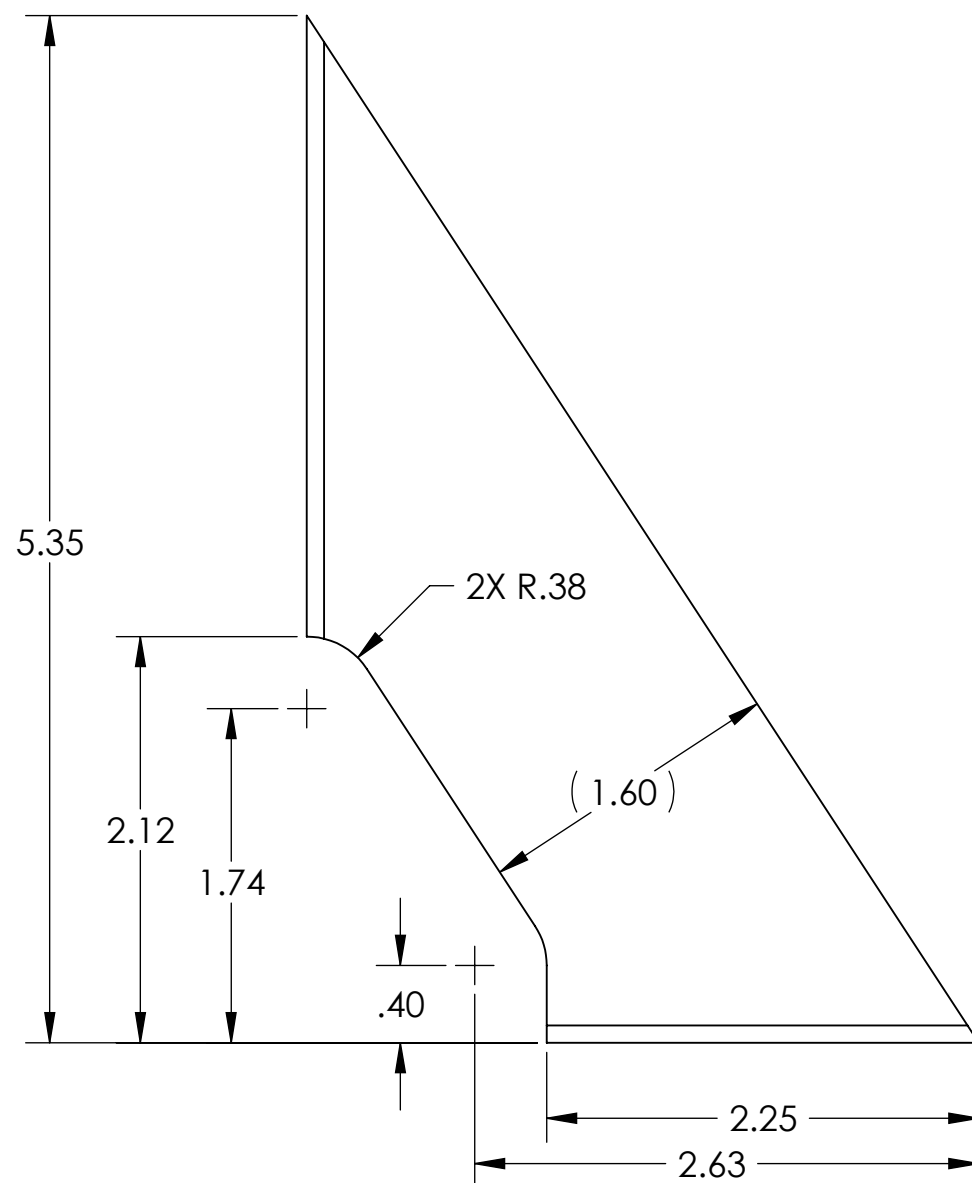
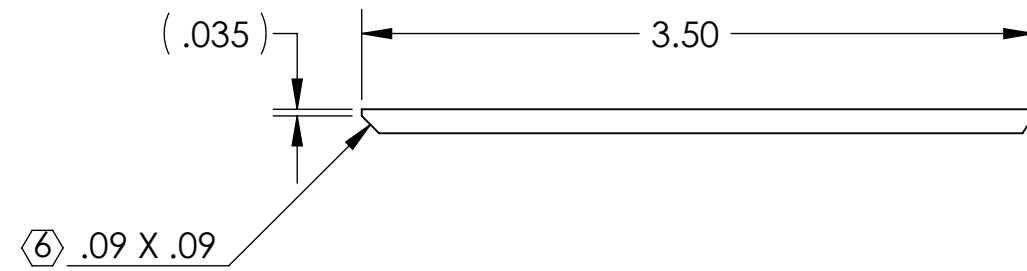
NEXT ASSY STRUCTURAL WELDMENT, HLTS

PART NAME			UPPER FRONT GUSSET		REV.
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO.	v2
DRAFTER	D. BRIDGES	29 AUG 2010	c	D070579	
CHECKER	M. MEYER	30 AUG 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

NOTES CONTINUED:

- 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
- 6. HALF OF ALL LOWER FRONT GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
- 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX $\pm .01$
 .XXX $\pm .005$

ANGULAR $\pm 0.5^\circ$

- 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.

MATERIAL 304 OR 304L SSSL **FINISH** 63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS

NEXT ASSY STRUCTURAL WELDMENT, HLTS

PART NAME

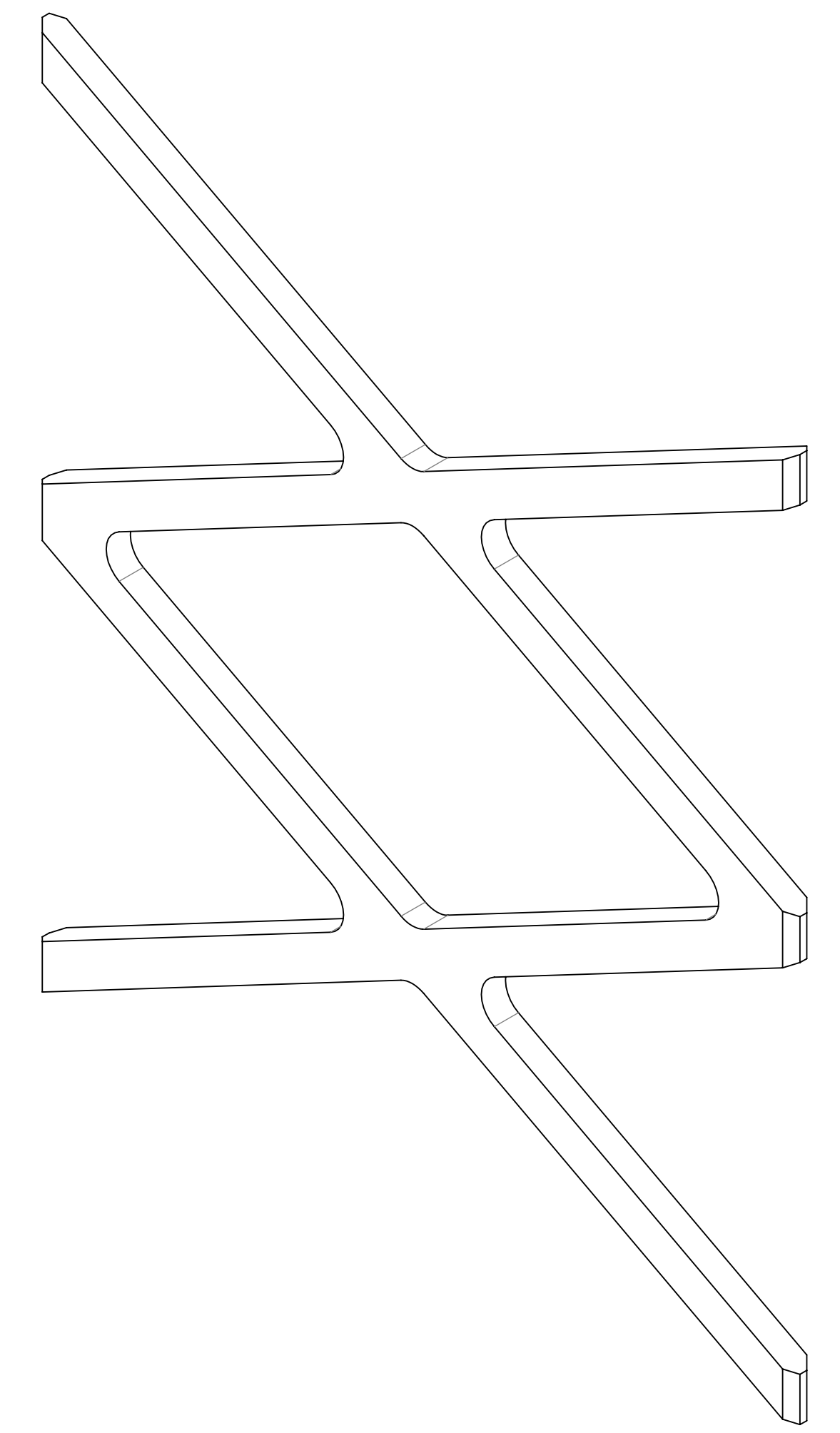
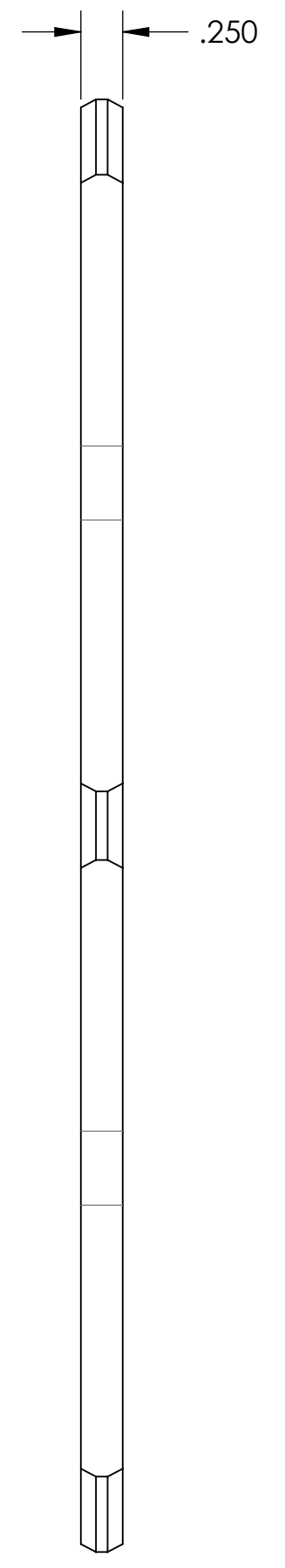
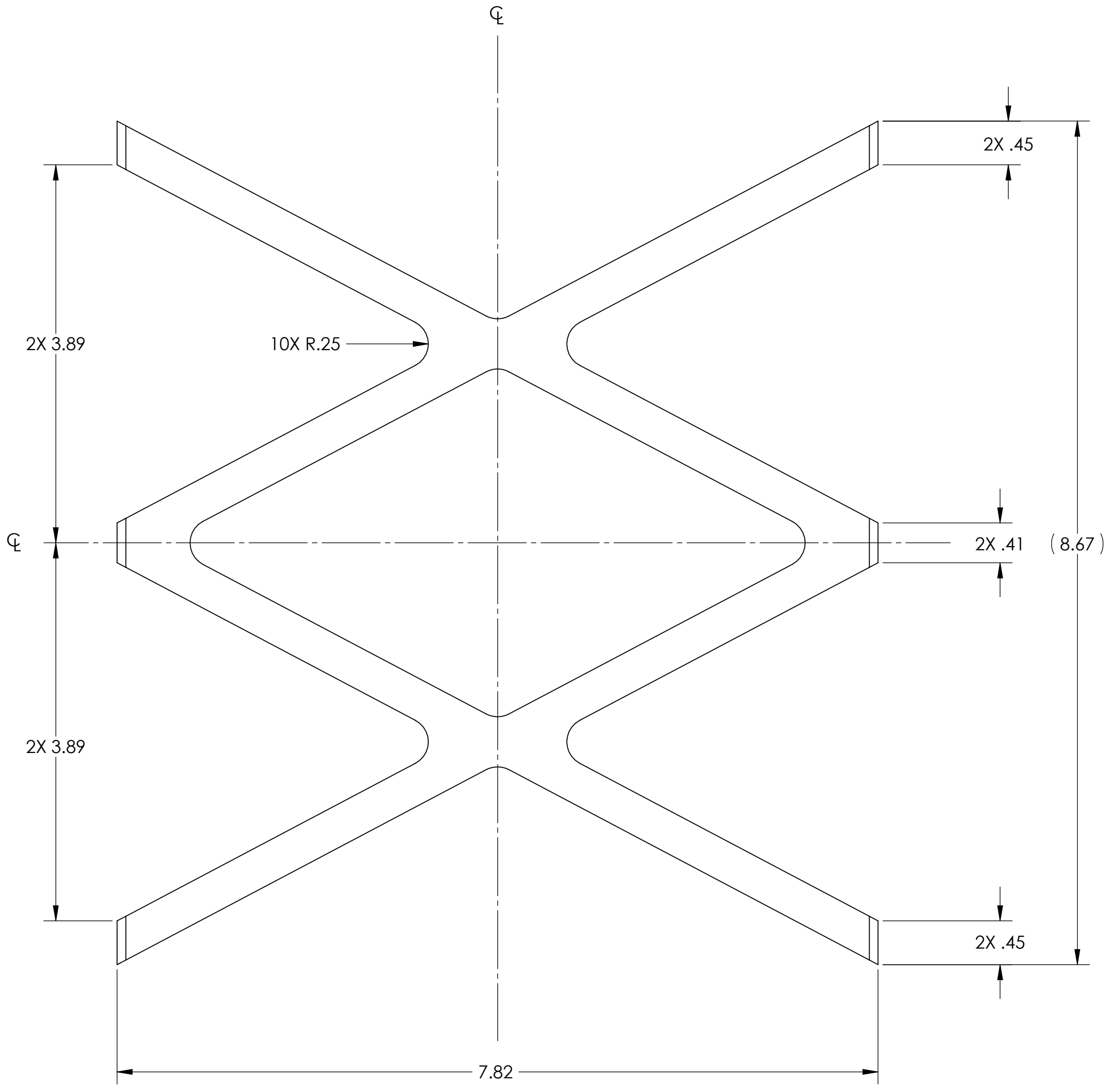
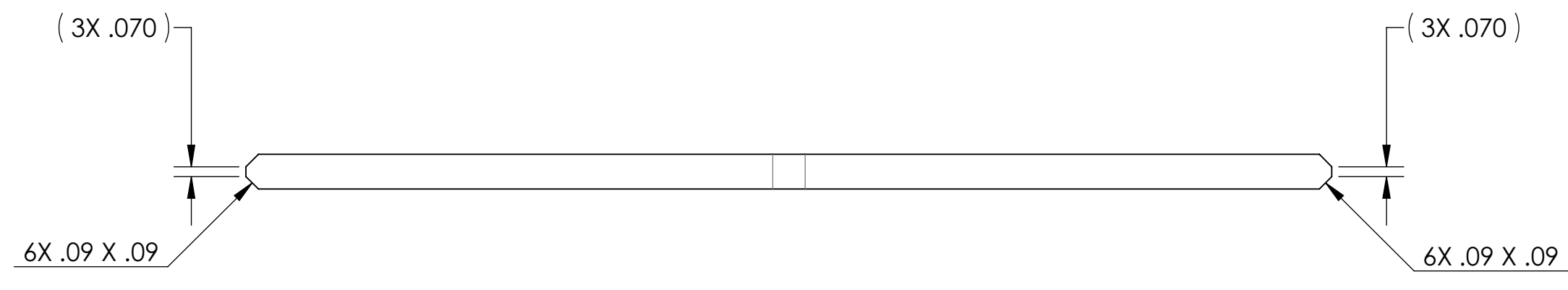
LOWER FRONT GUSSET

DESIGNER D. BRIDGES 29 AUG 2010
DRAFTER D. BRIDGES 29 AUG 2010
CHECKER M. MEYER 30 AUG 2010
APPROVAL

SIZE c **DWG. NO.** D070576 **REV.** v2
SCALE: 1:1 **PROJECTION:** **SHEET 1 OF 1**

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ISOMETRIC VIEW

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES: .XX ± .01 .XXX ± .005		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.	
MATERIAL	FINISH	NEXT ASSY	
304 OR 304L SSSL	63 μinch	STRUCTURAL WELDMENT, HLTS	
ANGULAR ± 0.5°			

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: STRUCTURAL WELDMENT, HLTS

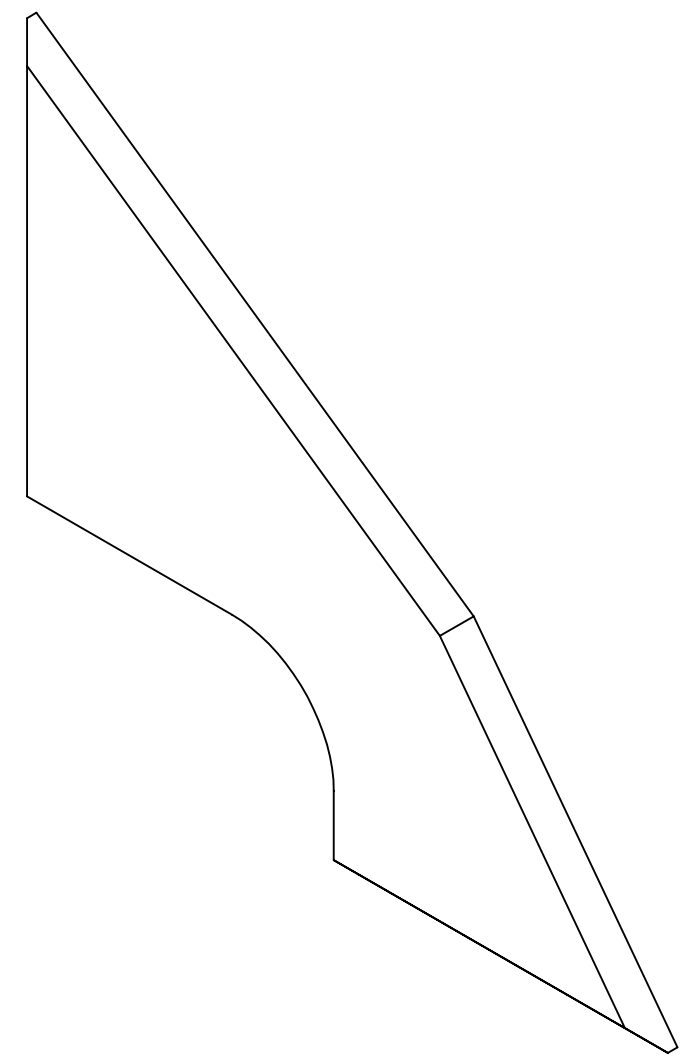
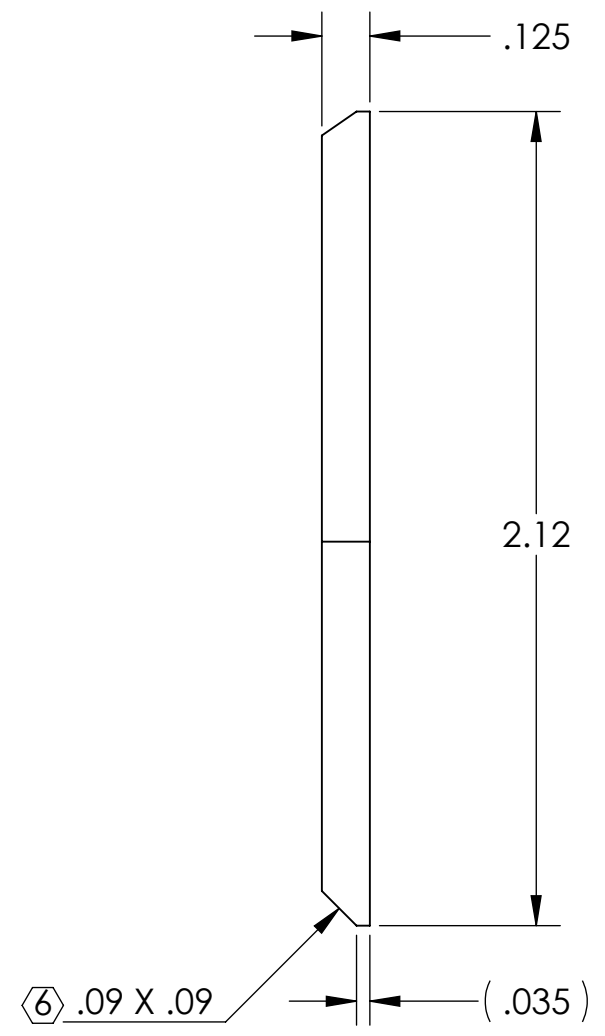
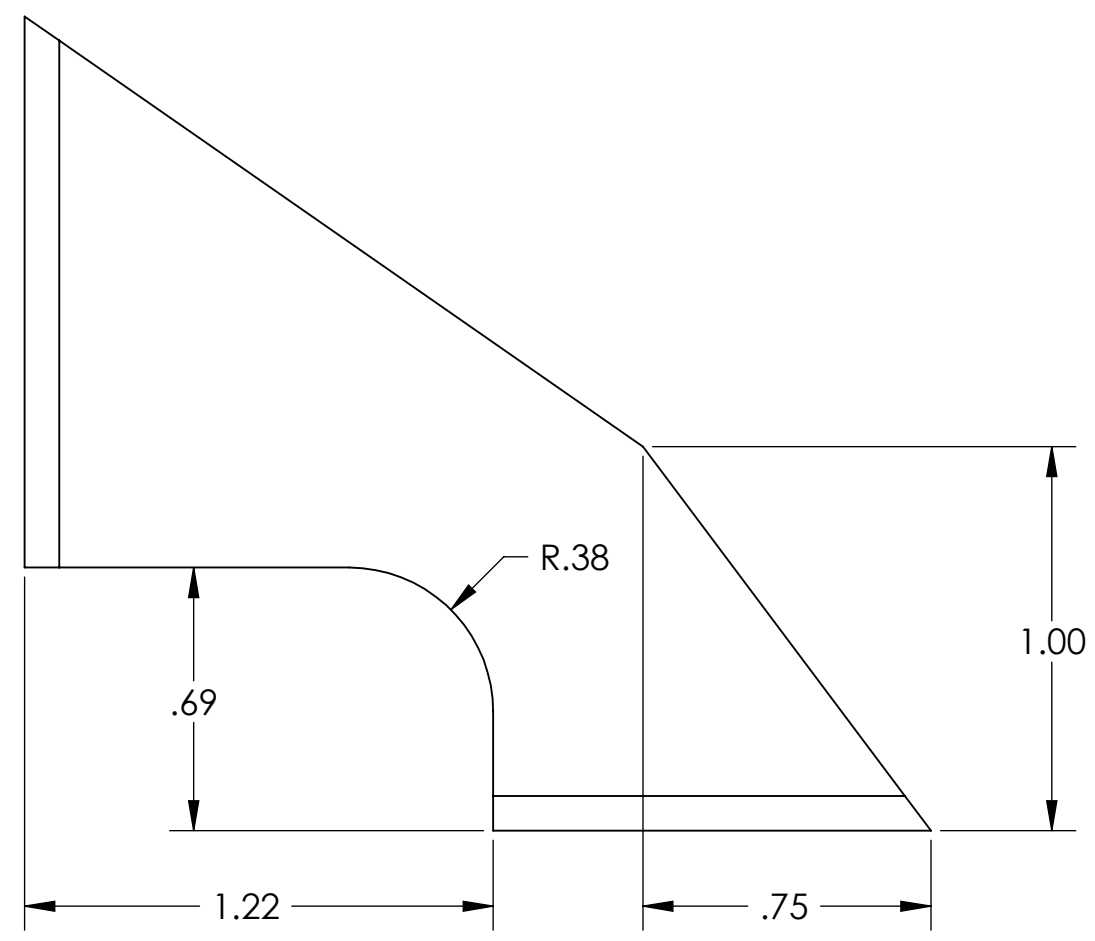
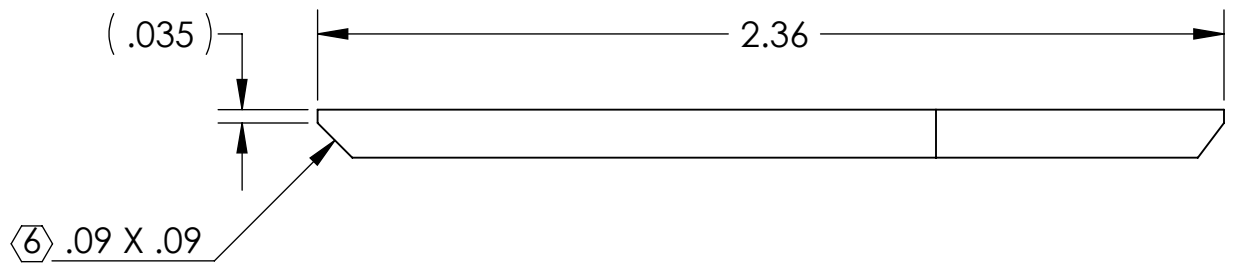
PART NAME: SIDE STRUT			
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE DWG. NO.
DRAFTER	D. BRIDGES	29 AUG 2010	D D070578
CHECKER	M. MEYER	30 AUG 2010	REV. v2
APPROVAL			SCALE: 1:1 PROJECTION:

D070578-AdvancedLIGO_SUS_HLTS_Structure_Side_Std1_PART PDM REV: V1-003 DRAWING PDM REV: V1-000

D070577_Advanced_LIGO_SUS_HLTS_Structure_Side_Gusset, PART PDM REV: V1-004, DRAWING PDM REV: V1-000

NOTES CONTINUED:
 5. THIS PIECE IS ONE PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE. WELD INDUCED SHRINKAGE OR FILL, AND POST-WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D070442 (STRUCTURAL WELDMENT, HLTS) FOR REQUIRED DIMENSIONS AFTER WELDING.
 6. HALF OF ALL SIDE GUSSETS TO HAVE CHAMFER ON OPPOSITE FACE (MIRROR IMAGE OF PART SHOWN).
 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E080446	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-

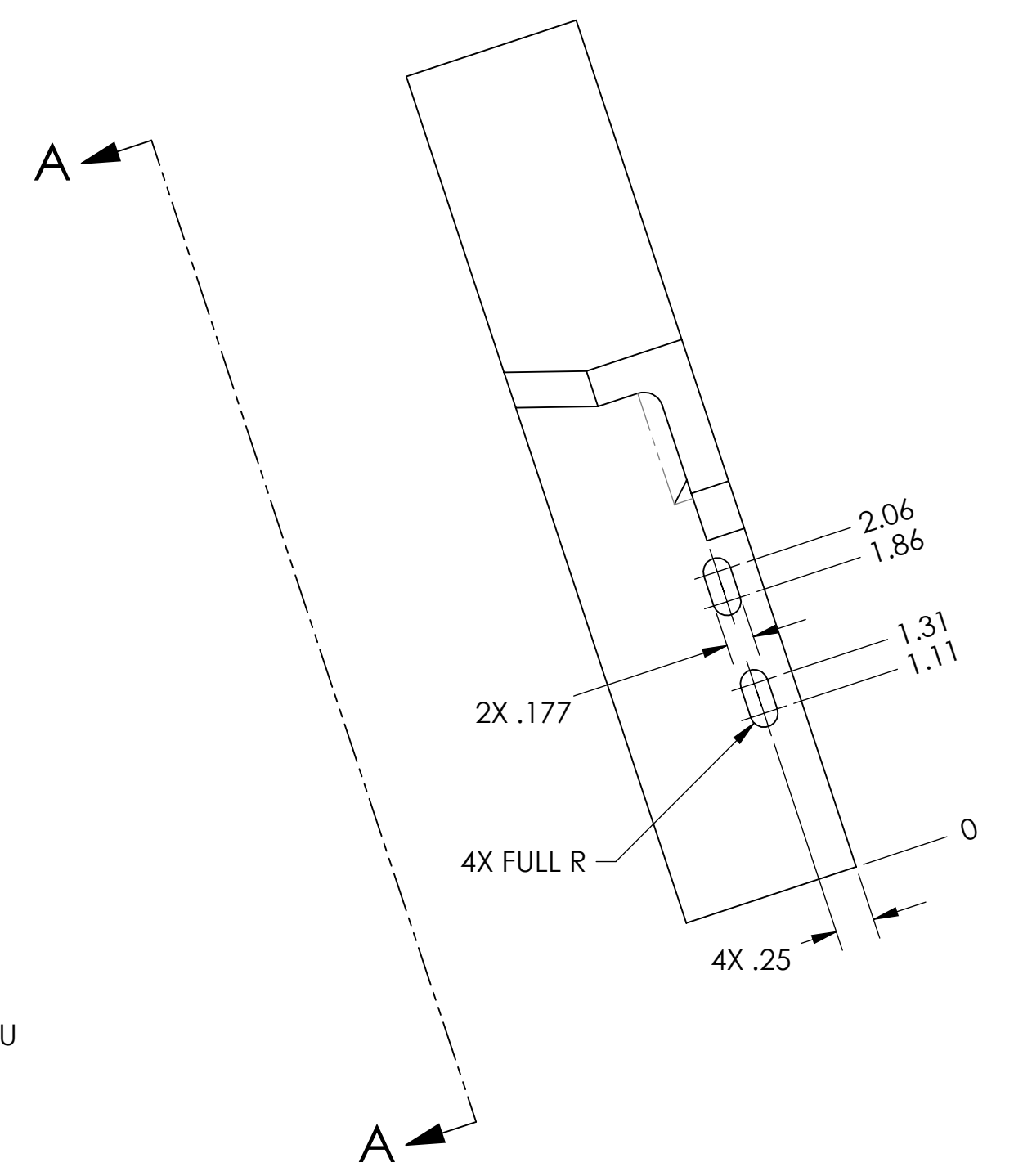
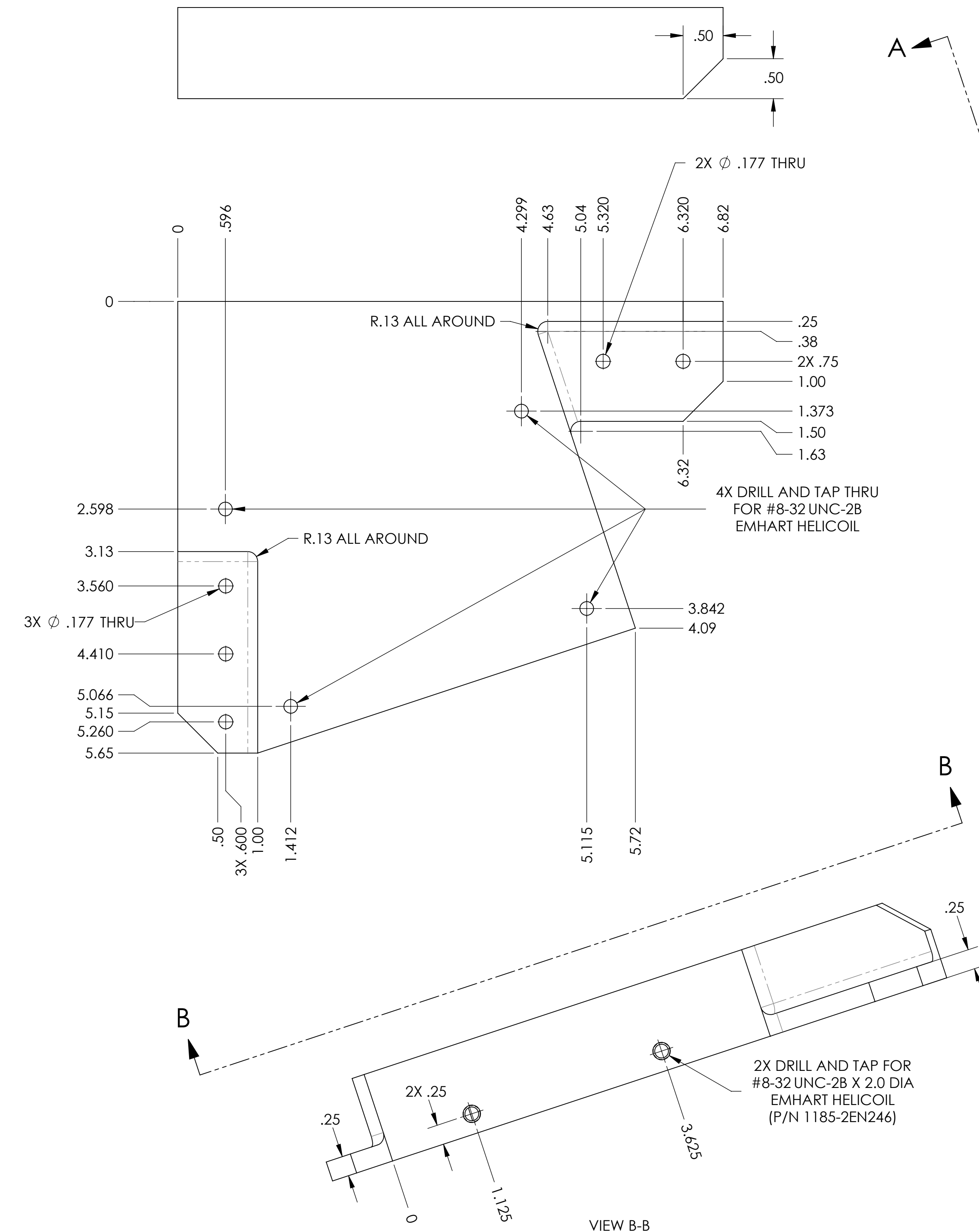
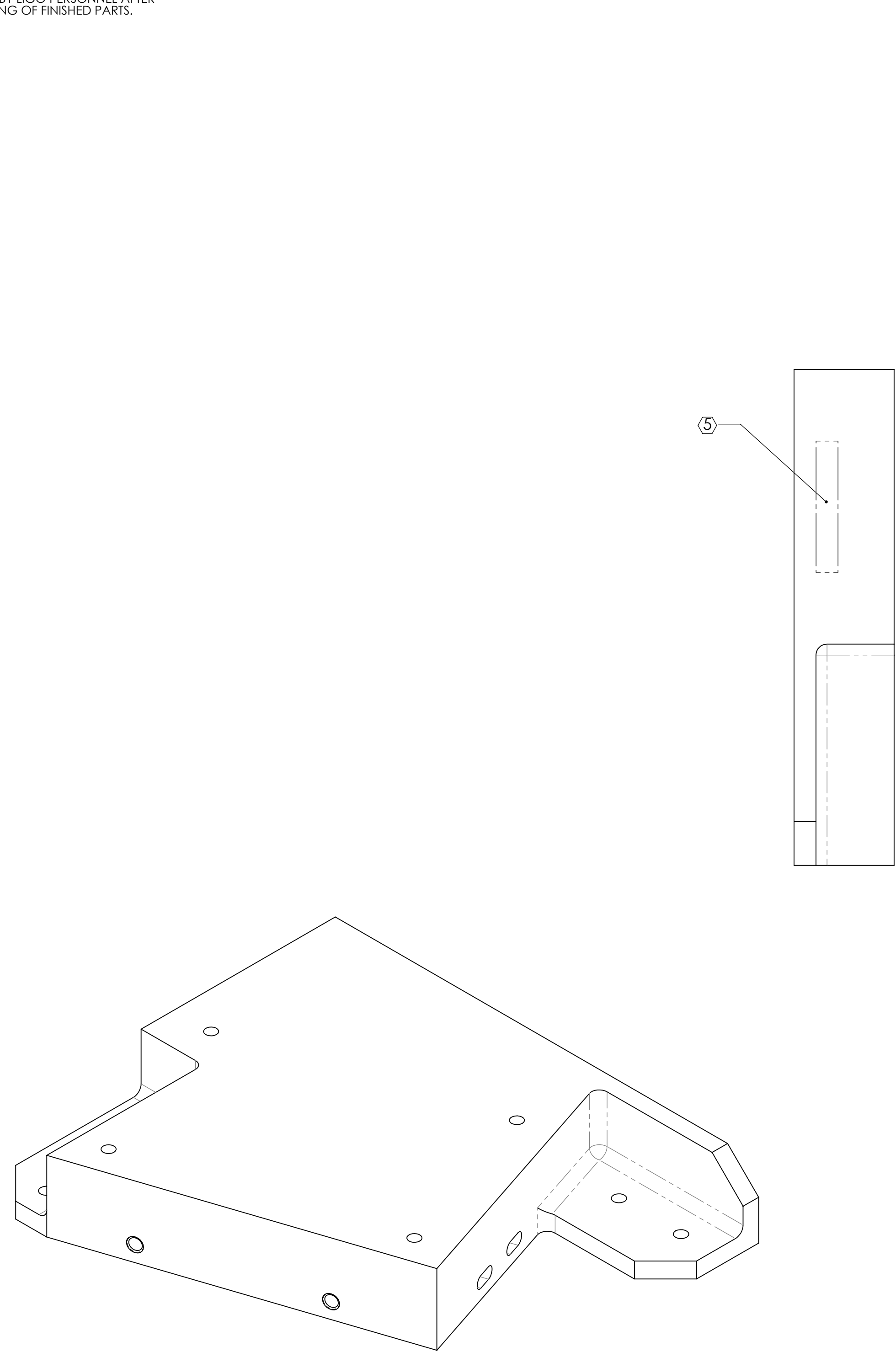


DIMENSIONS ARE IN INCHES		TOLERANCES:		MATERIAL		FINISH	
.XX	$\pm .01$	ANGULAR $\pm 0.5^\circ$		304 OR 304L SSSL		63 μinch	

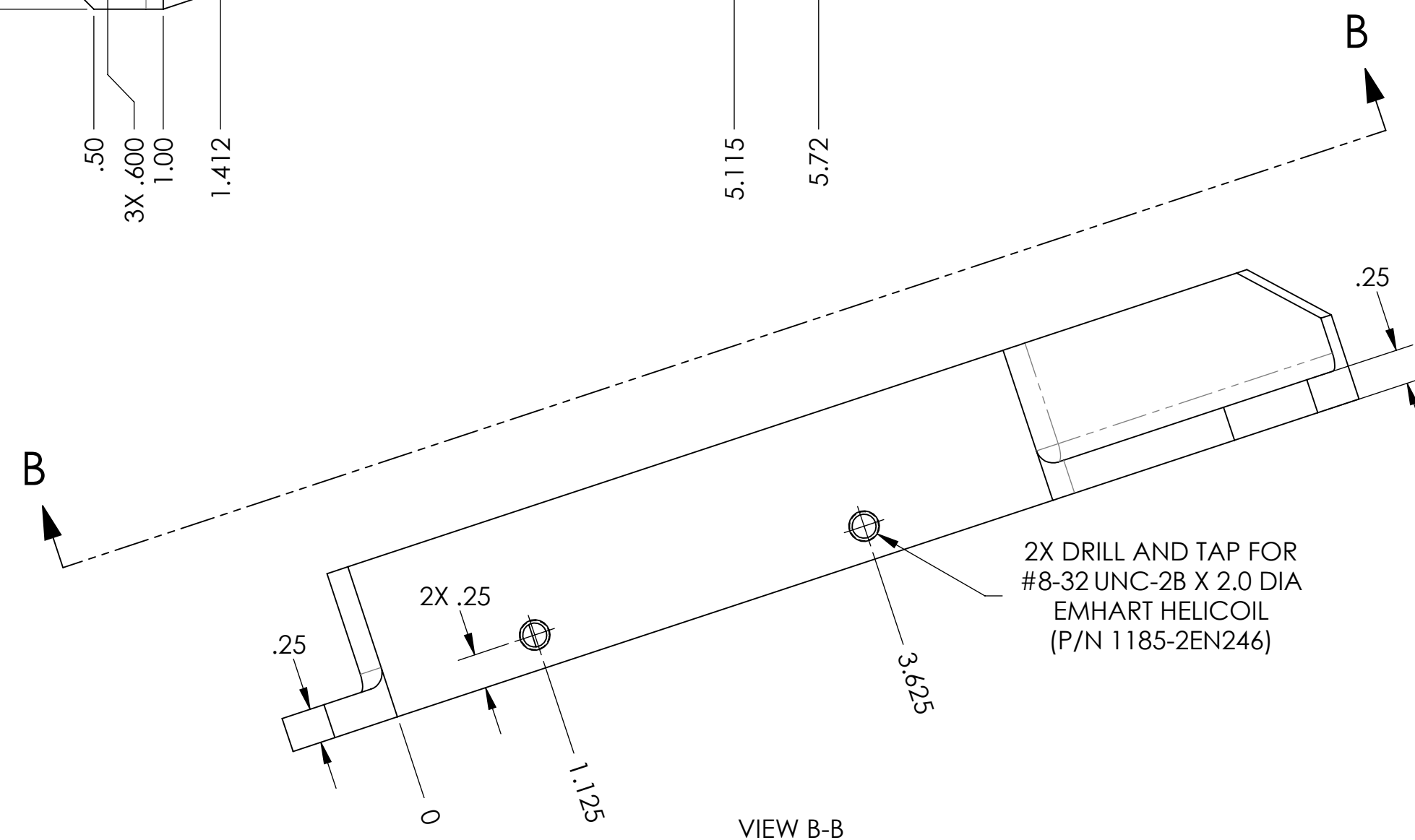
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)			PART NAME		
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.			SIDE GUSSET		
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY			ADVANCED LIGO SUS		
DESIGNER	D. BRIDGES	29 AUG 2010	SIZE	DWG. NO. D070577	
DRAFTER	D. BRIDGES	29 AUG 2010	REV.	v2	
CHECKER	M. MEYER	30 AUG 2010	SCALE	2:1	
APPROVAL			PROJECTION:	SHEET 1 OF 1	

- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E0900066	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



VIEW A-A



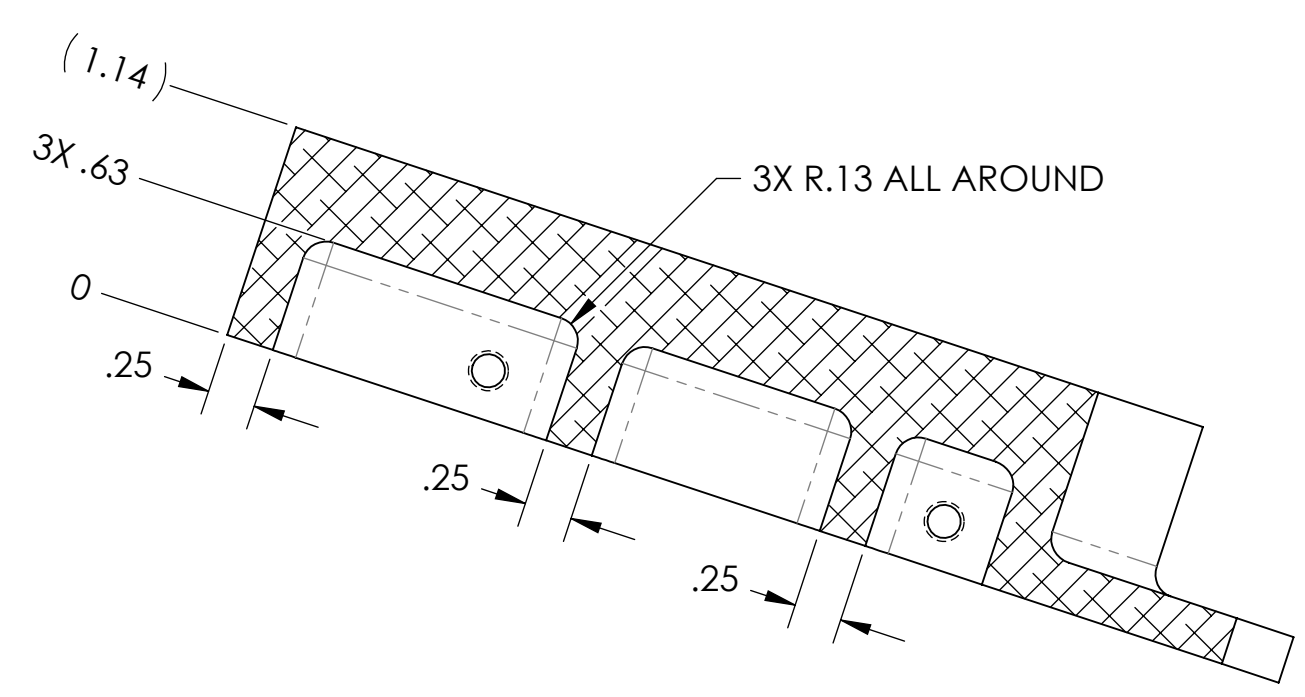
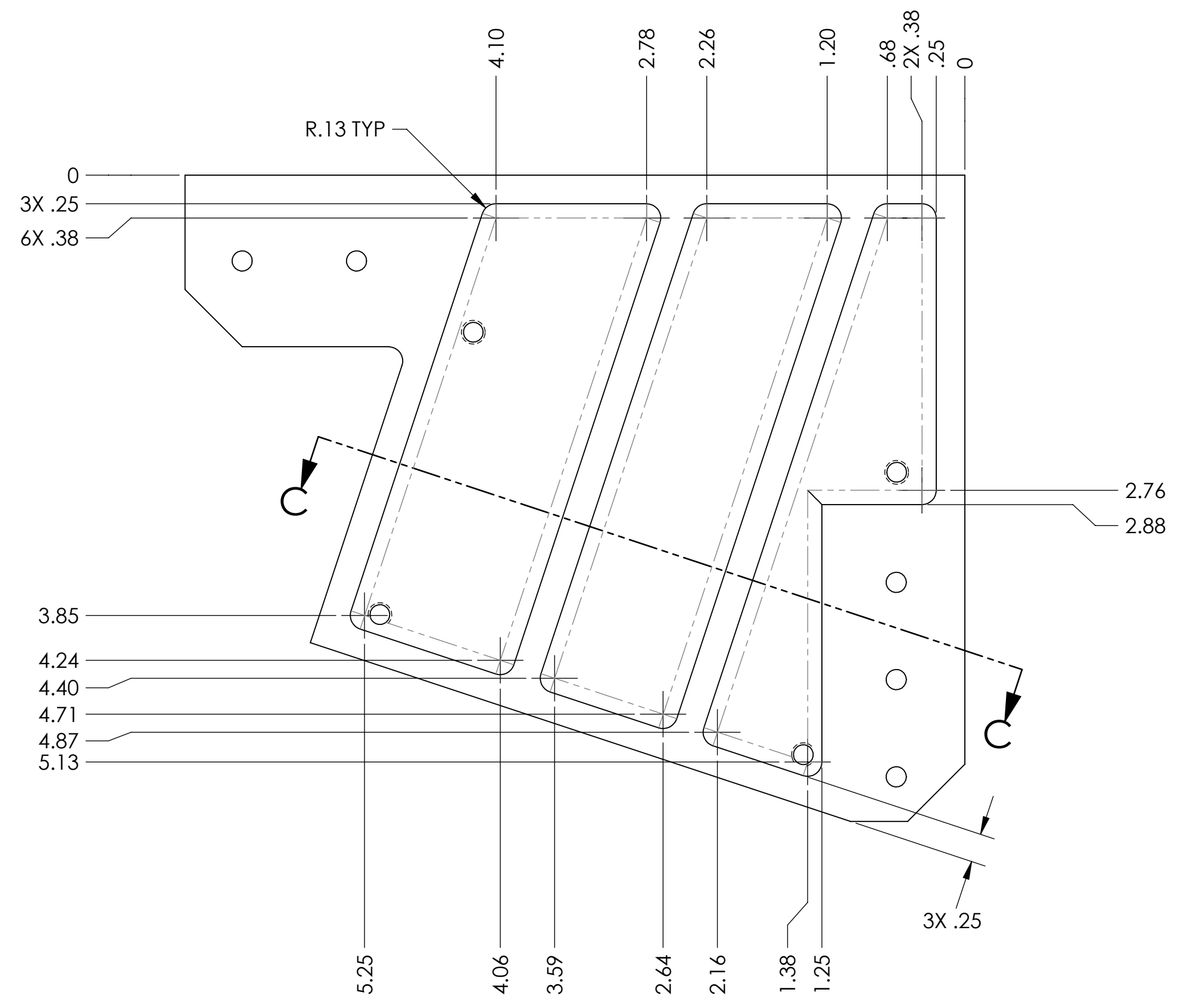
VIEW B-B

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		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.		SYSTEM ADVANCED LIGO SUB-SYSTEM SUS		MOUNTING PAD BODY	
ANGULAR ± 0.5°		MATERIAL 6061-T6 Al	FINISH 32 μinch	NEXT ASSY MOUNTING PAD ASSY		DESIGNER D. BRIDGES 27 AUG 2010	SIZE DWG. NO. D D070374
				CHECKER M. MEYER 30 AUG 2010		REV. v2	
				APPROVAL		SCALE: 1:1	PROJECTION:
						SHEET 1 OF 2	

D070374-Advanced LIGO_SUS_HITS_Mounting_Pad_Body_PART PDM REV-V1-001, DRAWING PDM REV-V1-003

8 7 6 5 4 3 2 1

H G F E D C B A



SECTION C-C

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D070374	v2
SCALE: 1:1	PROJECTION:	SHEET 2 OF 2

8 7 6 5 4 3 2 1

D070374_Advanced_LIGO_SUS_HIT3_Mounting_Pod_Body_PART_PDM_REV-V1-001_DRAWING_PDM_REV-V1-003