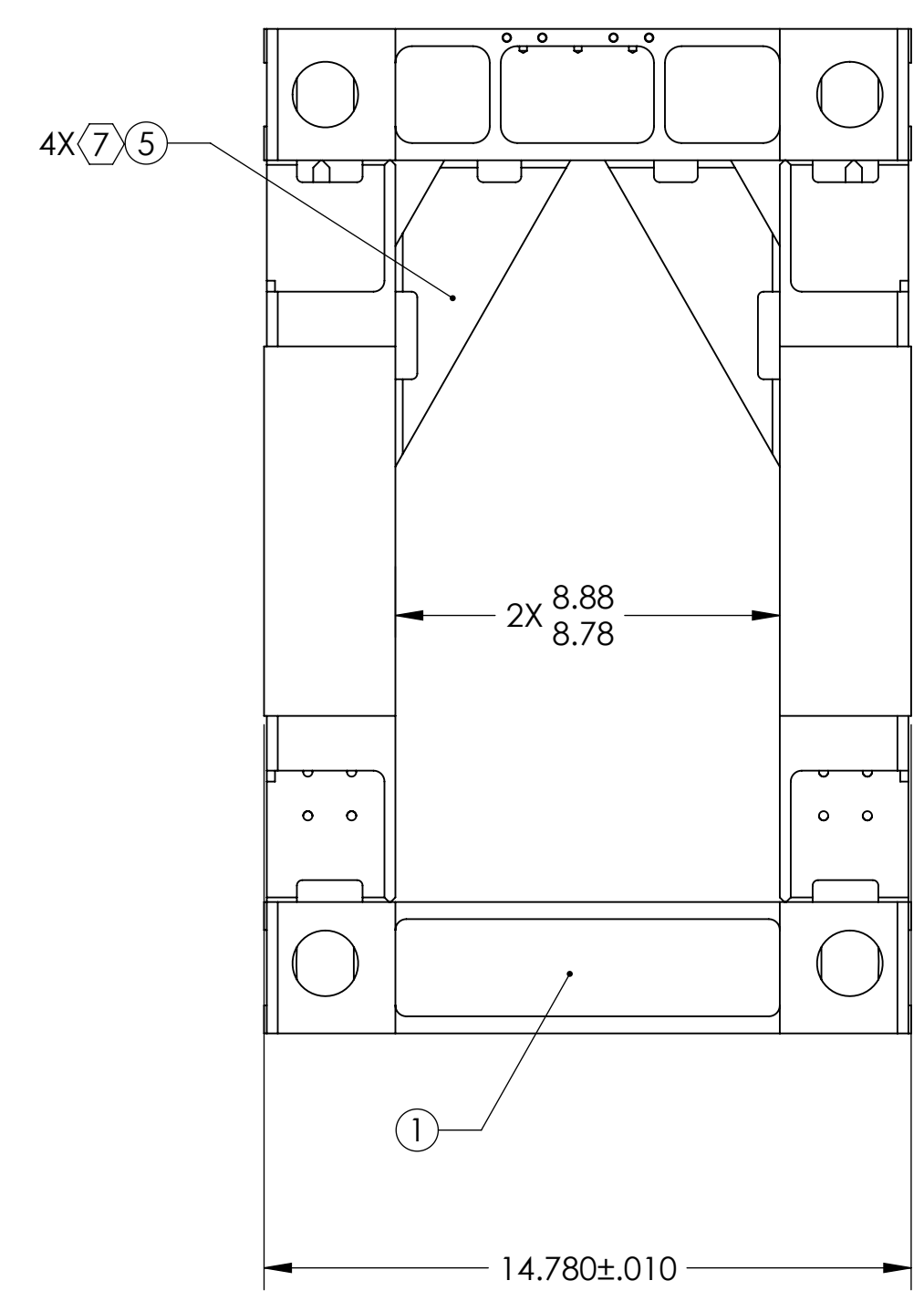
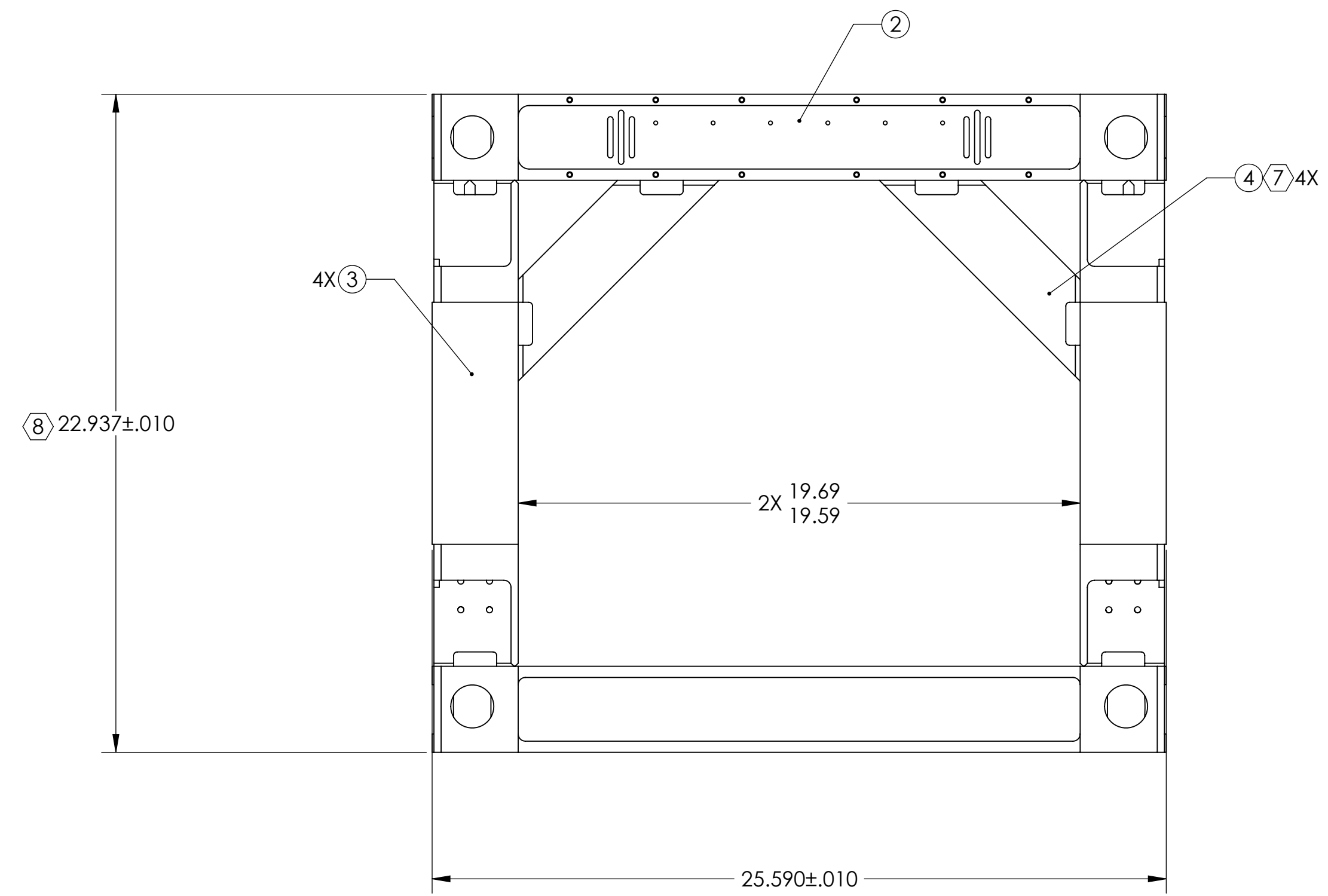


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE 07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
 6. FABRICATE WELDMENT IN ACCORDANCE WITH LIGO E0900048.
 ⑦ POSITION FLUSH TO THE INSIDE SURFACE OF F/N 2.
 ⑧ AFTER WELDING, MACHINE INDICATED SURFACES TO ACHIEVE NOTED DIMENSIONS.

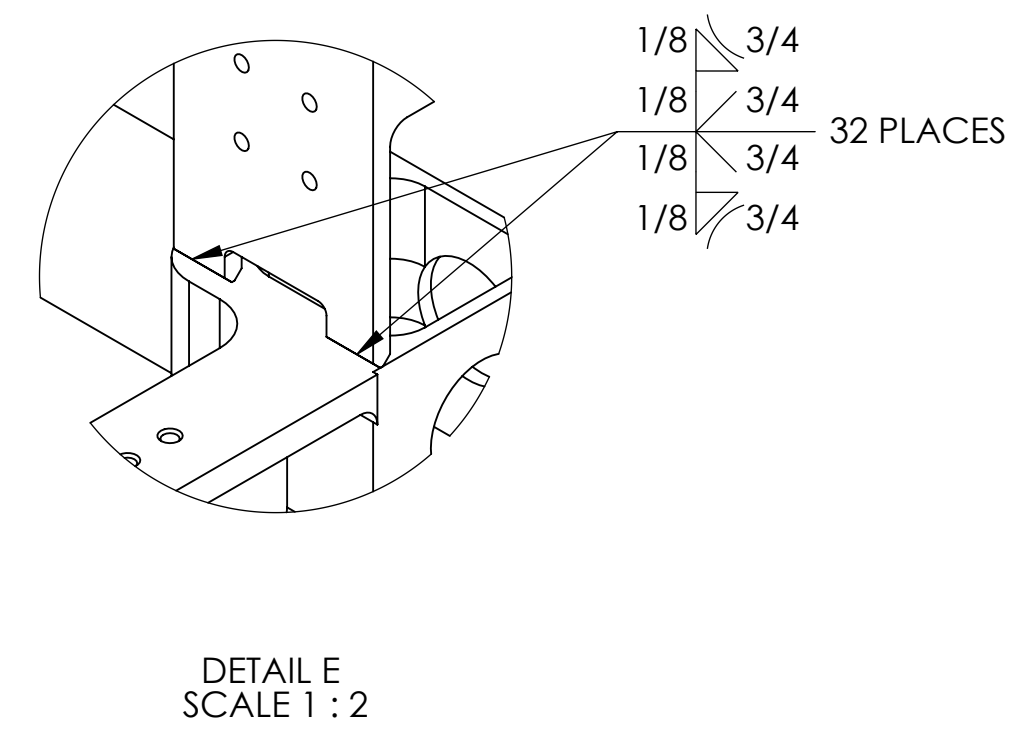
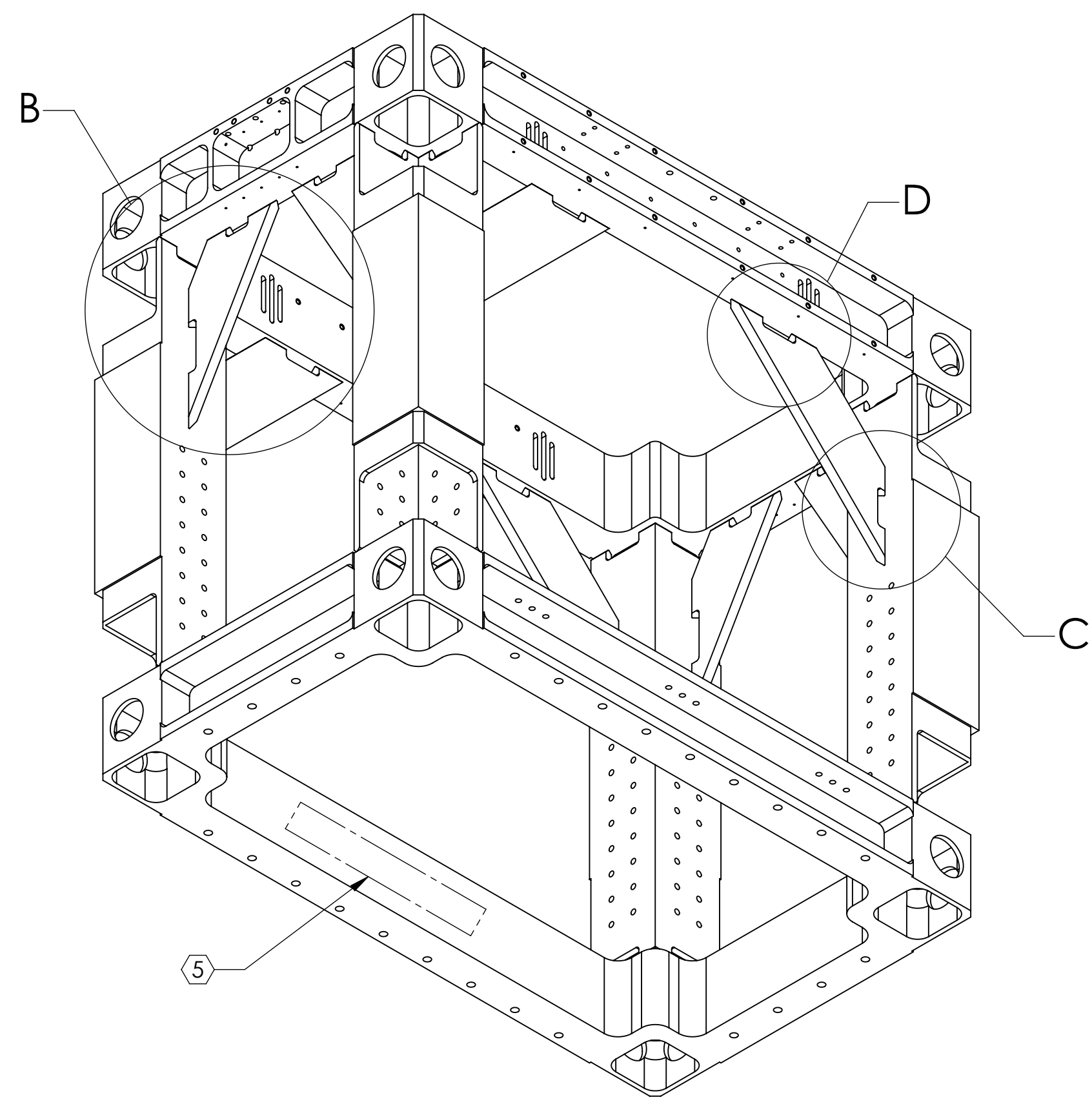
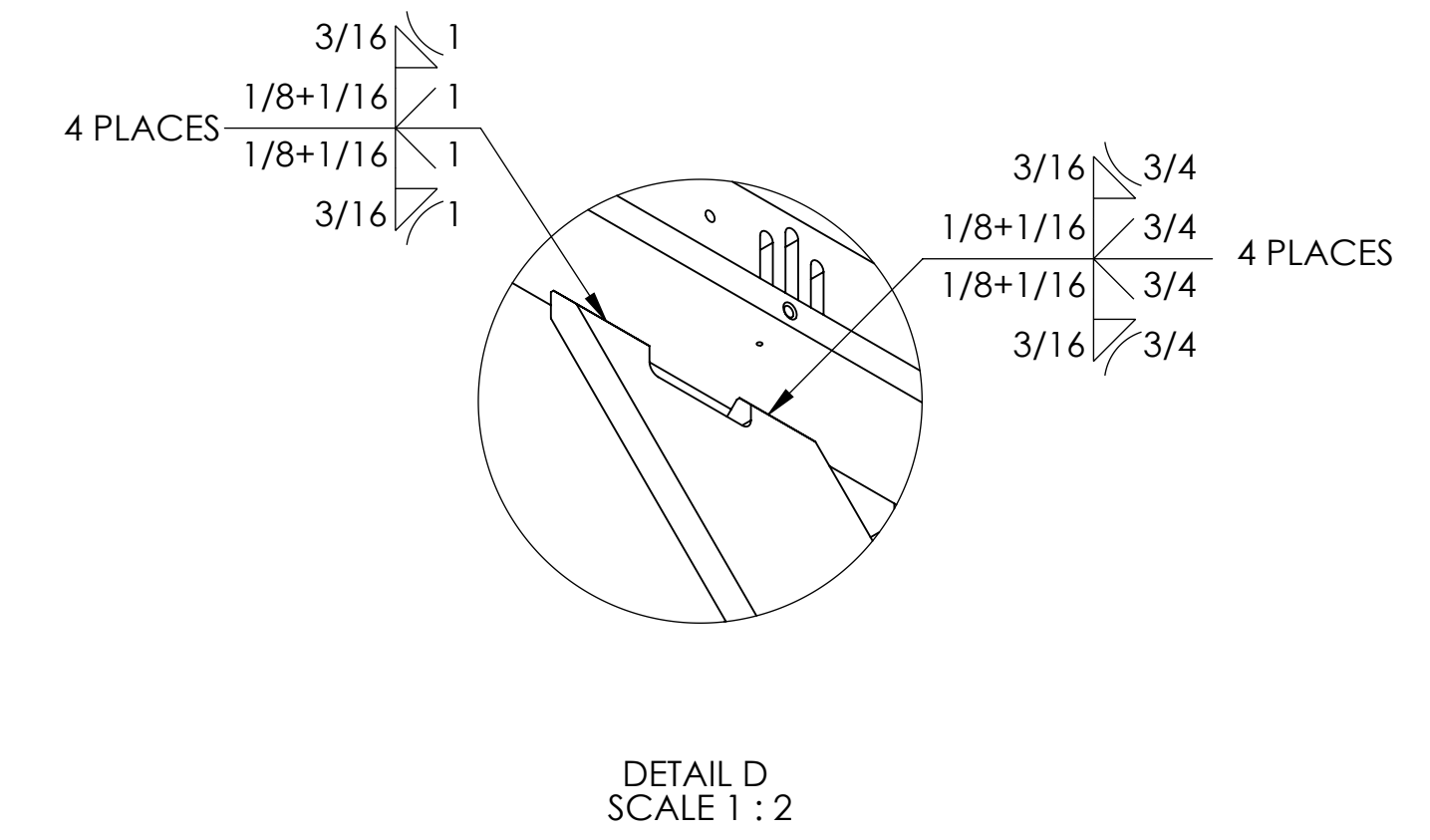
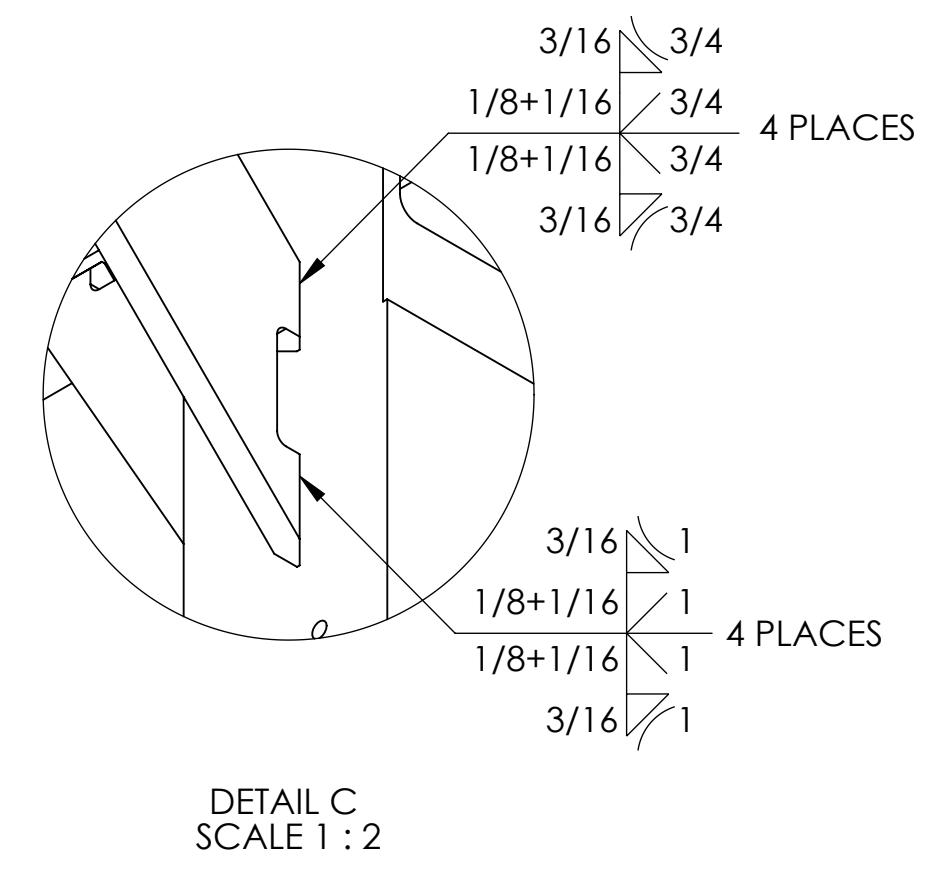
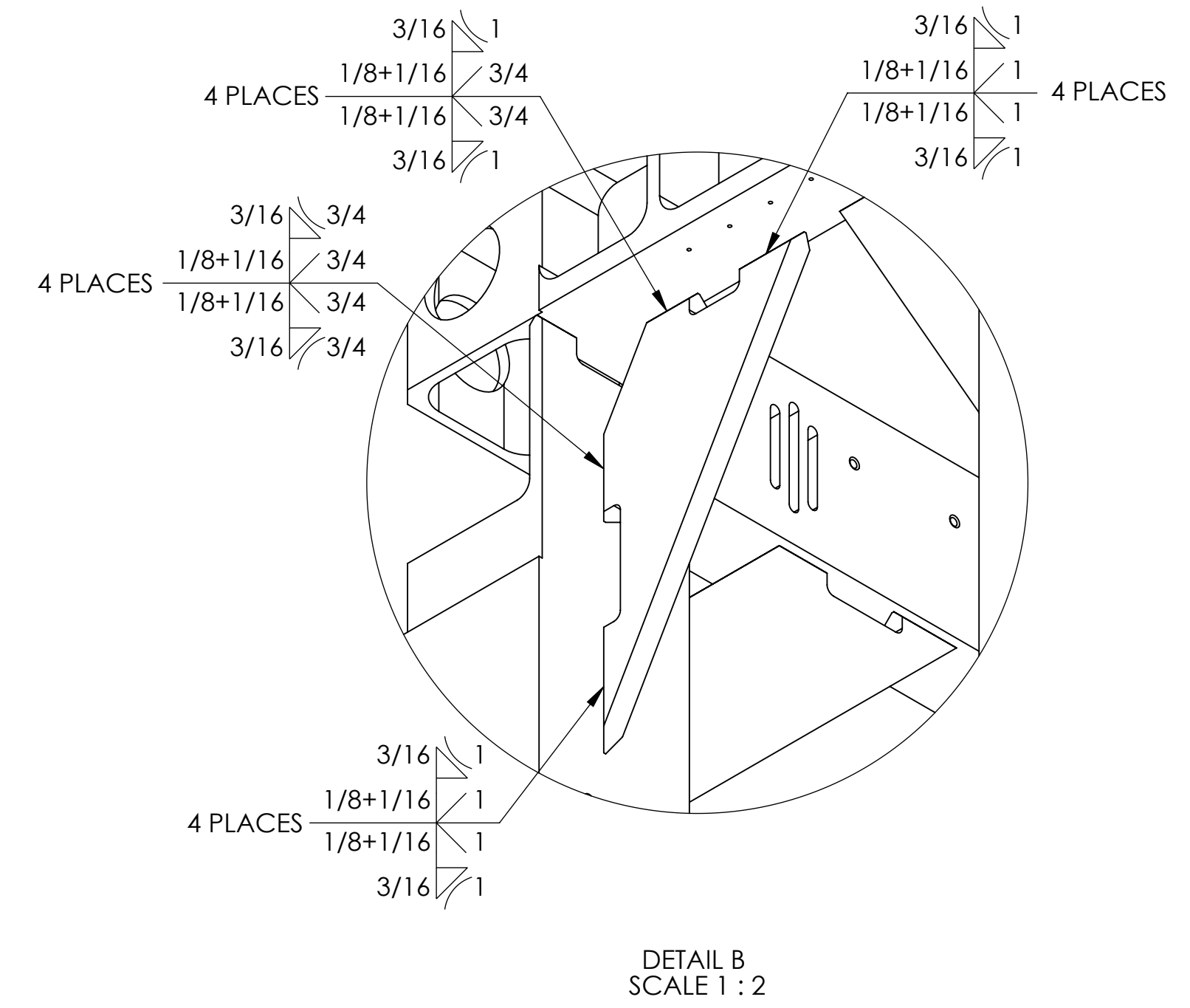
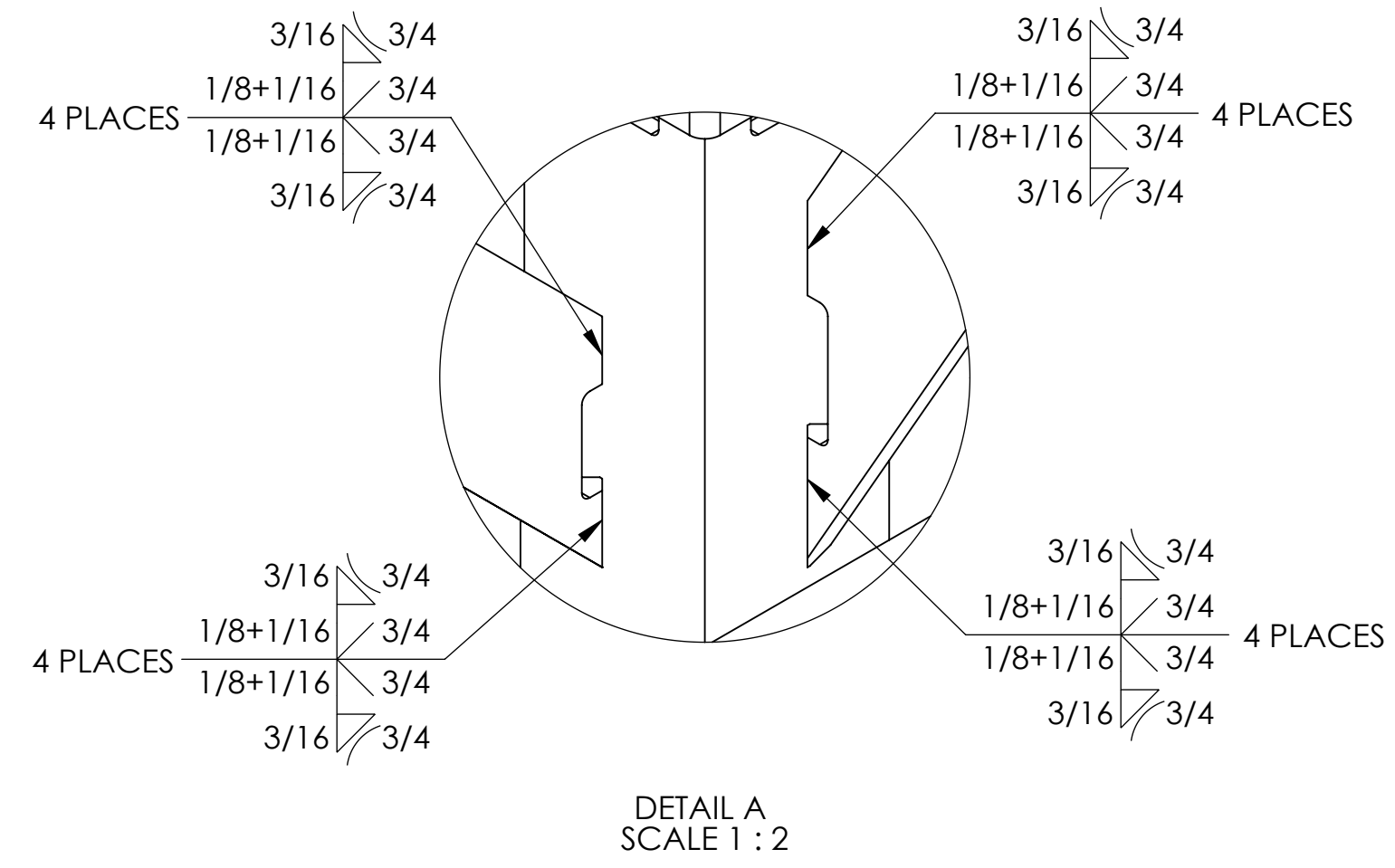
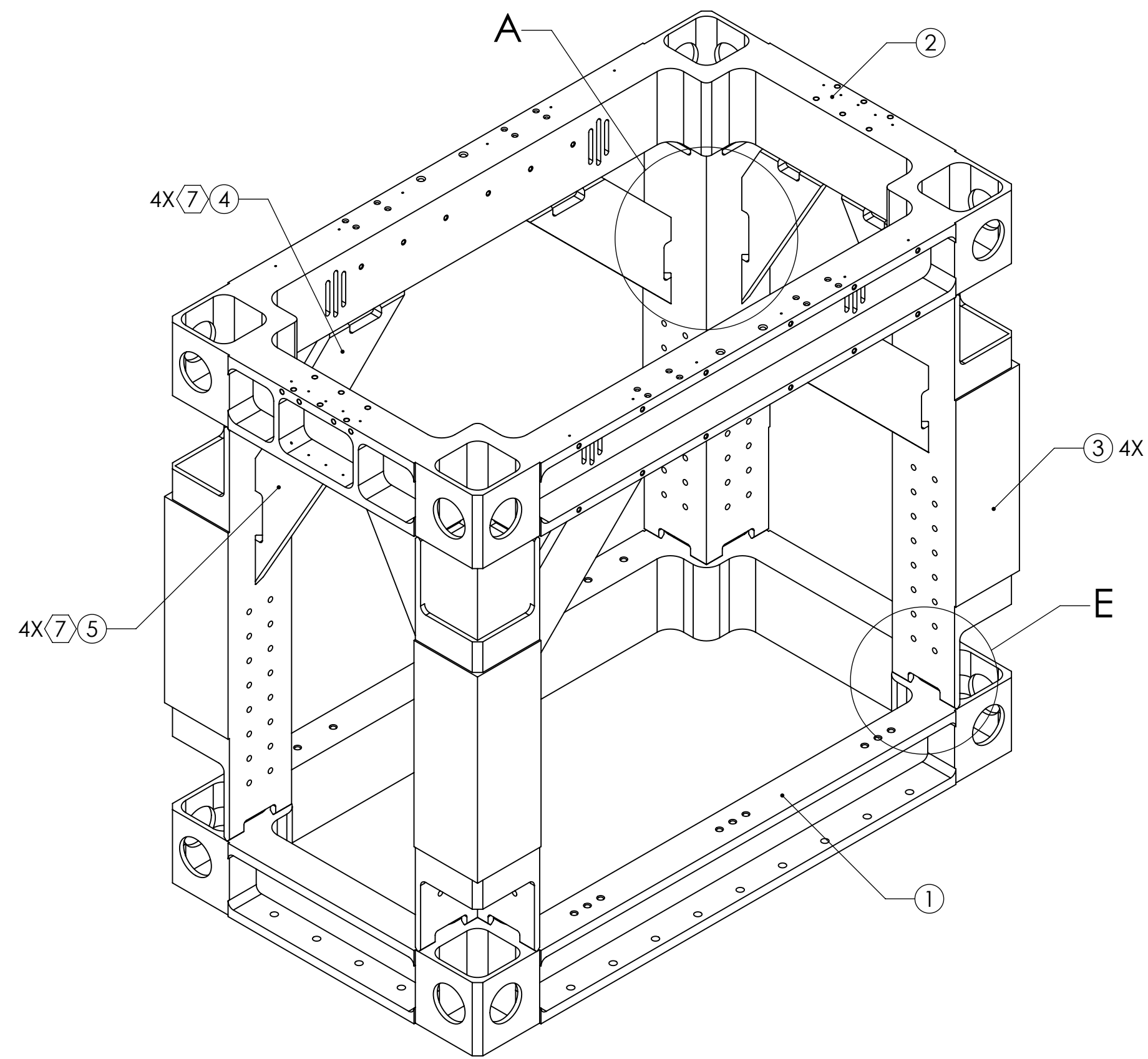
REV.	DATE	DCN #	DRAWING TREE #
v1	16 APR 2009	E0900106	E0900052
v2	11 AUG 2009	E0900238	E0900052

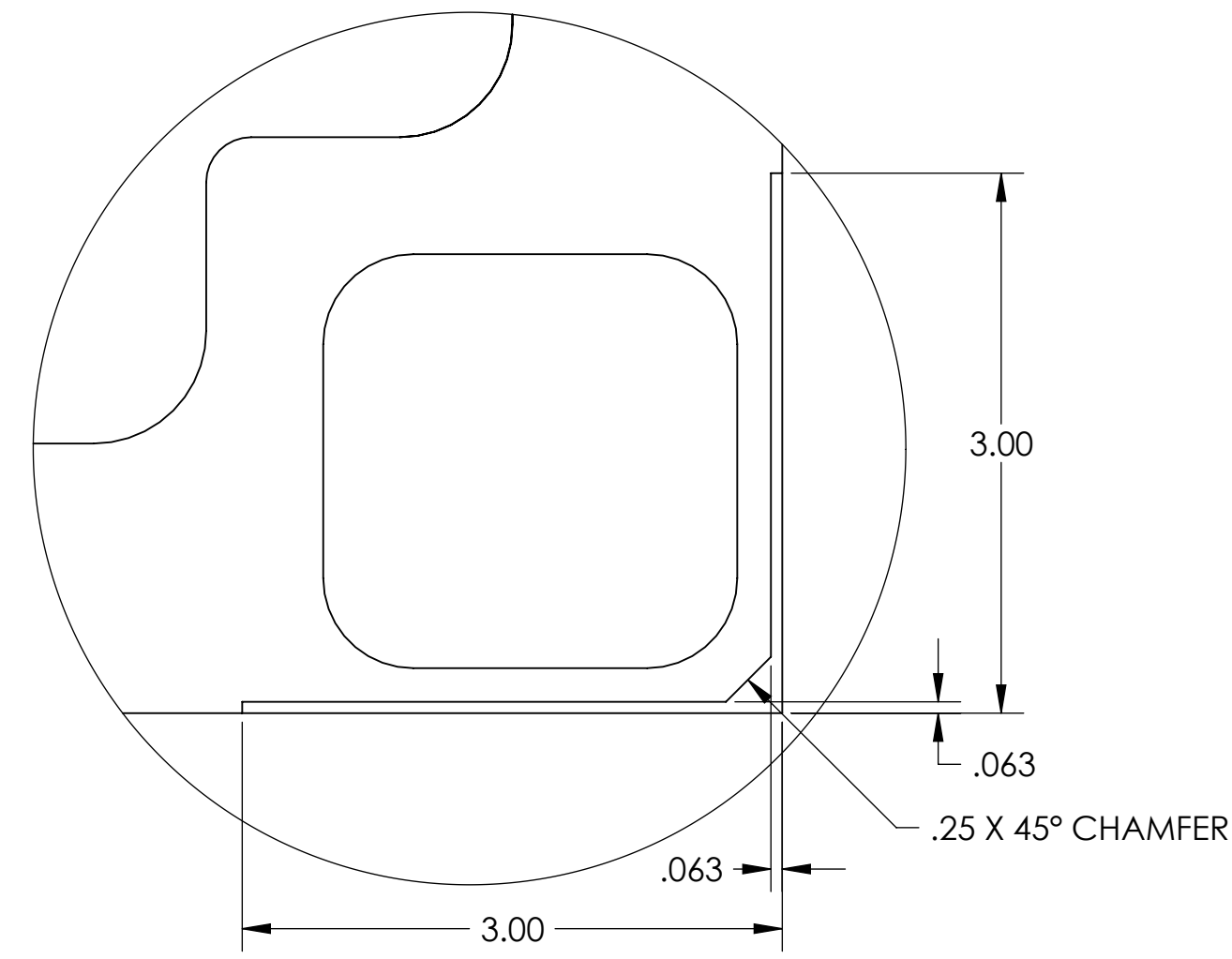


QTY	PART NUMBER	DESCRIPTION	MATL	F/N
4	D0900350	7" X 4" GUSSET	6061-T6 AL	5
4	D0900349	7" X 7" GUSSET	6061-T6 AL	4
4	D0900348	LEG, OMC STRUCTURE	6061-T6 AL	3
1	D0900347	TOP PLATE, OMC STRUCTURE	6061-T6 AL	2
1	D0900346	BASE PLATE, OMC STRUCTURE	6061-T6 AL	1

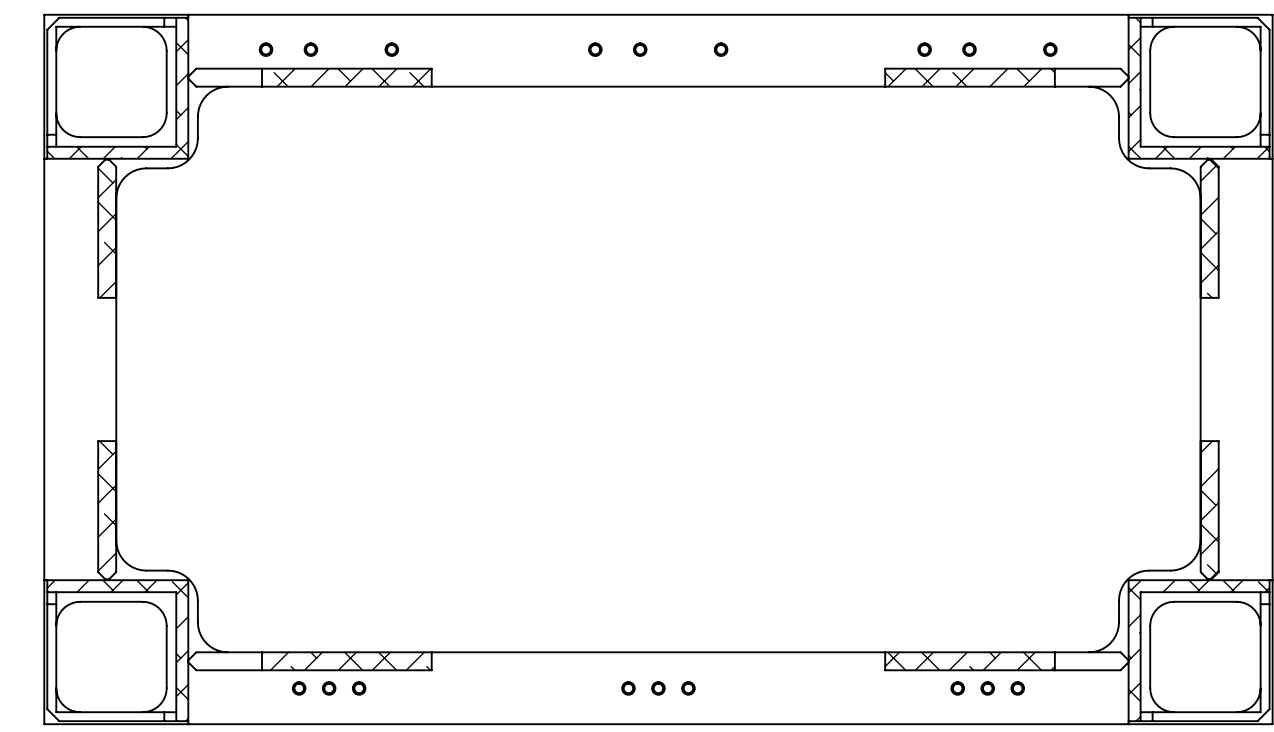
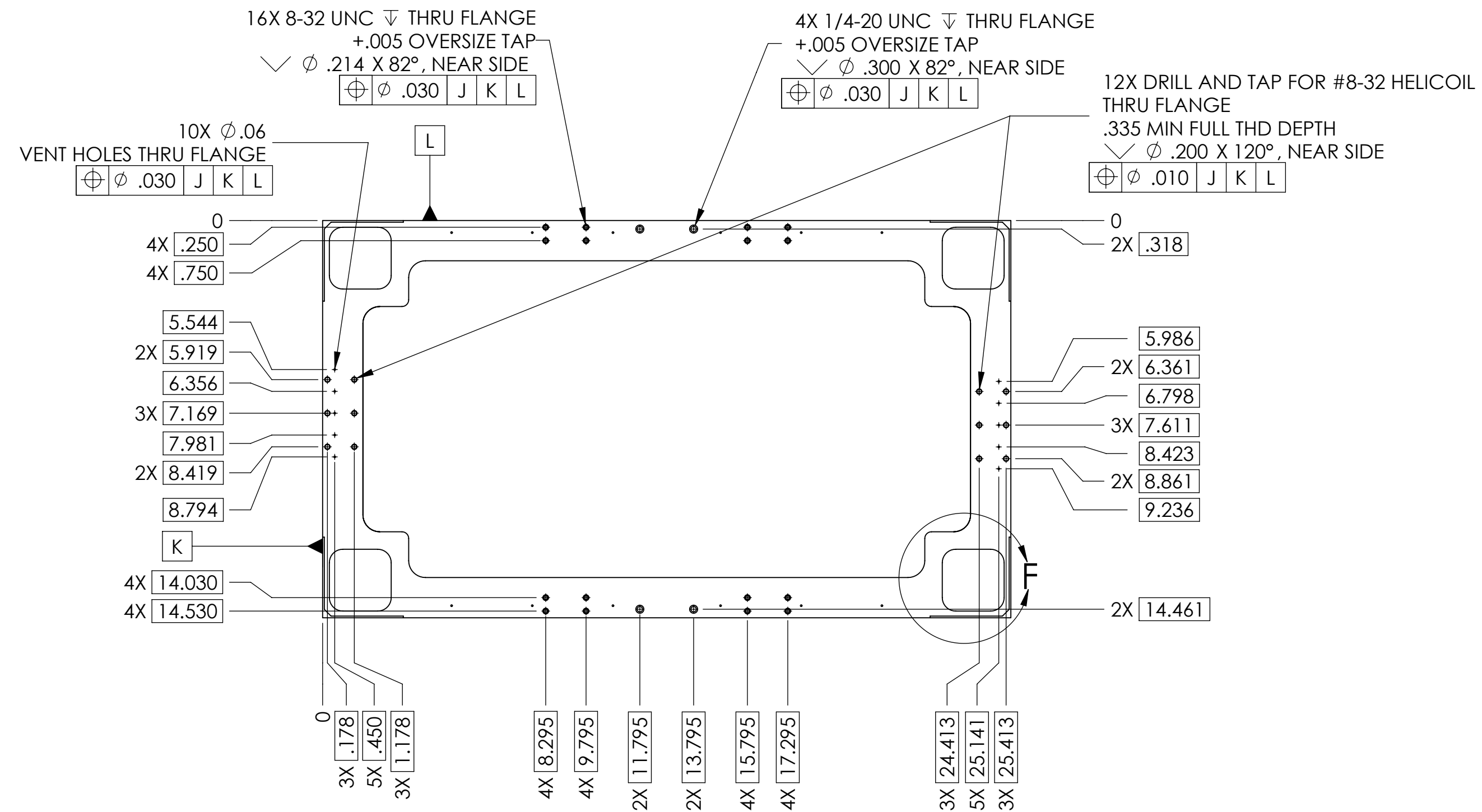
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± .5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME OMC STRUCTURAL WELDMENT	
MATERIAL 6061-T6 AL		FINISH N/A μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM SUS	
NEXT ASSY D0900655		DESIGNER C. ECHOLS		DATE 17 DEC 2006		SIZE D	
APPROVAL		CHECKER M. MEYER		DATE 20 MAR 2009		SCALE 1:4	
PROJECTION				DWG. NO. D0900308		REV. v2	
SHEET 1 OF 3				SCALE 1:4		PROJECTION	

D0900308_AdrLIGO_OMC_StructuralWeldment_PDR_PDM_REV-V1_DRAINING_PDM_REV-V1-002

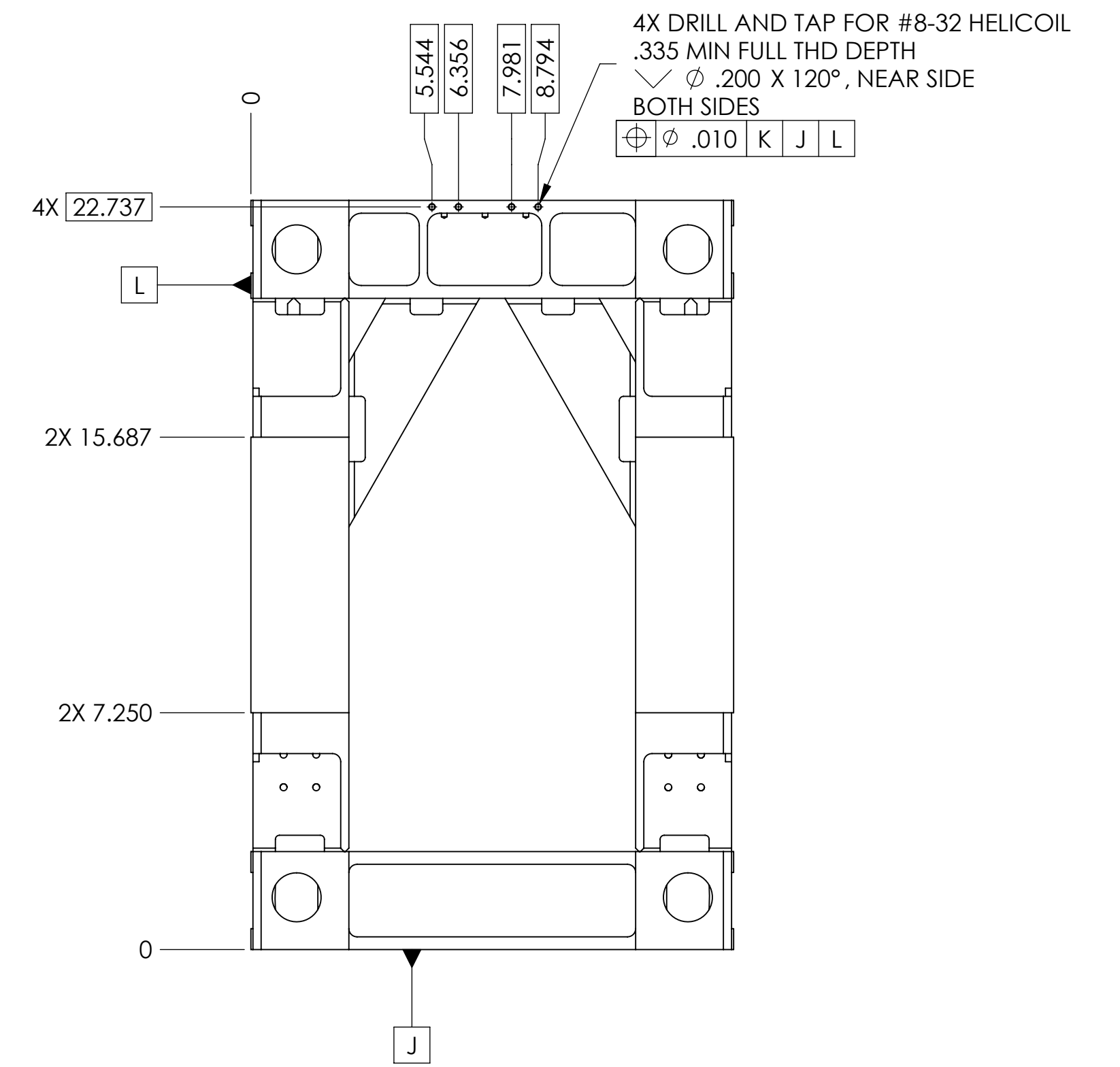
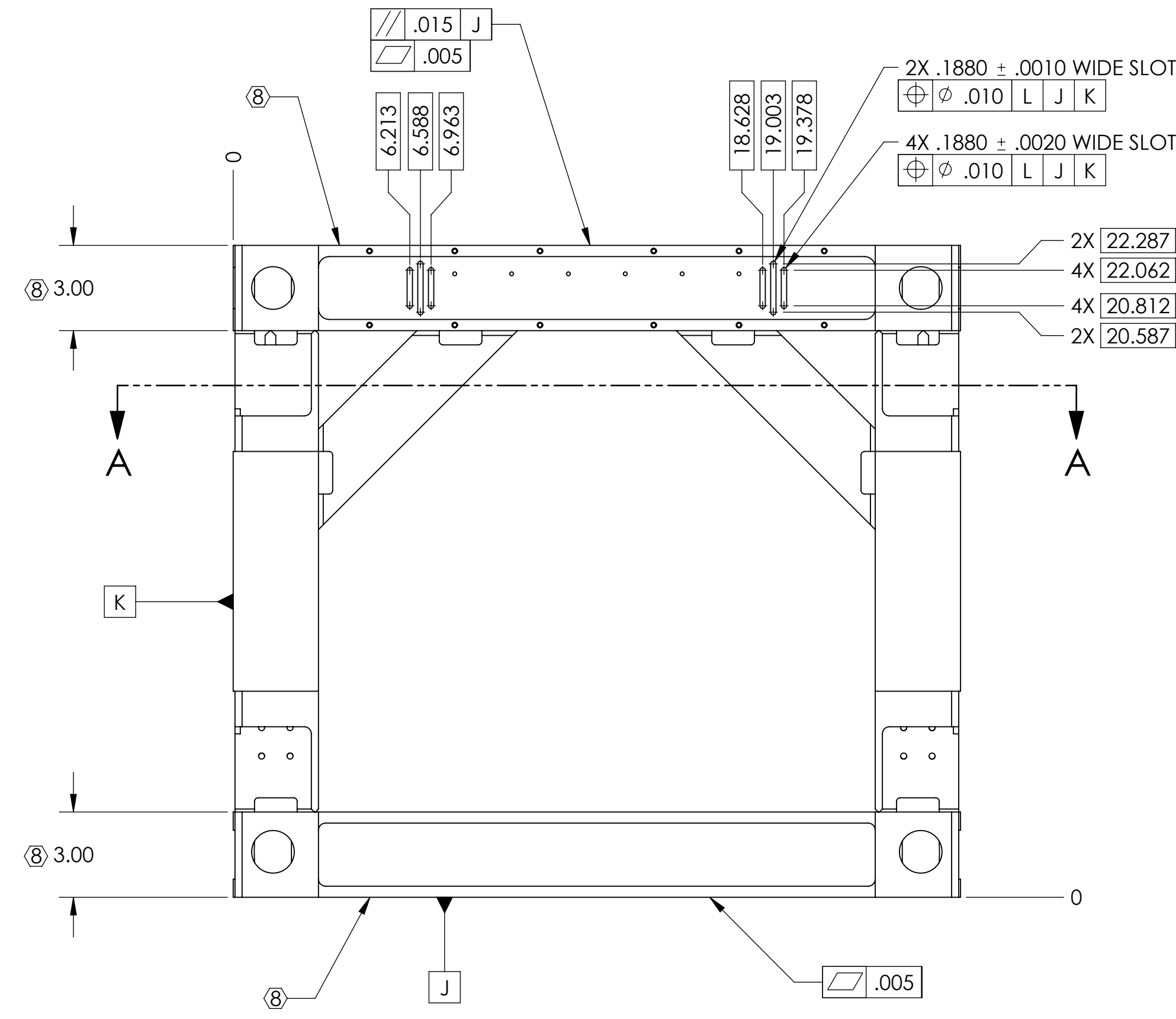
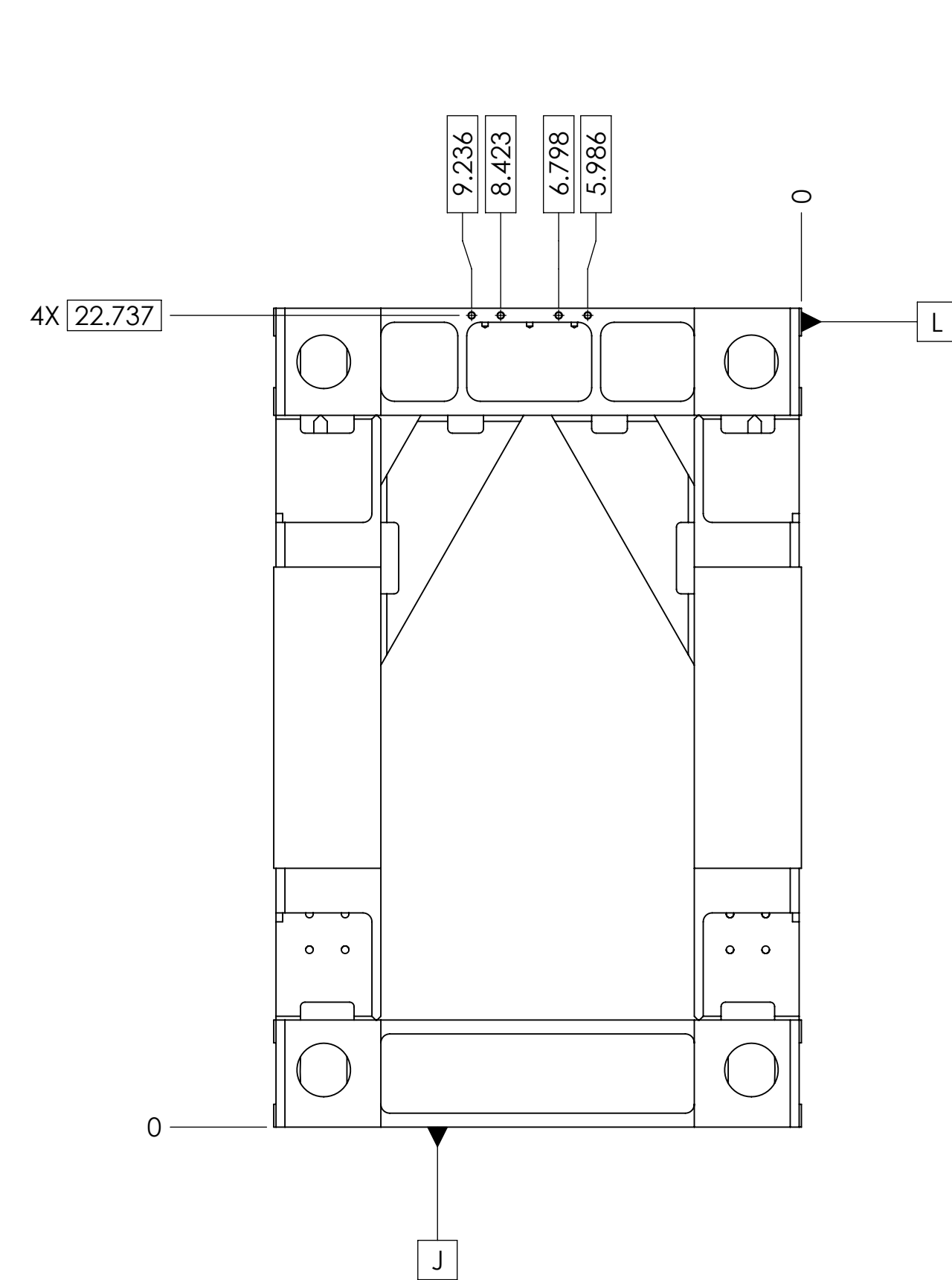




DETAIL F
SCALE 1 : 1



SECTION A-A



POST-WELD MACHINING