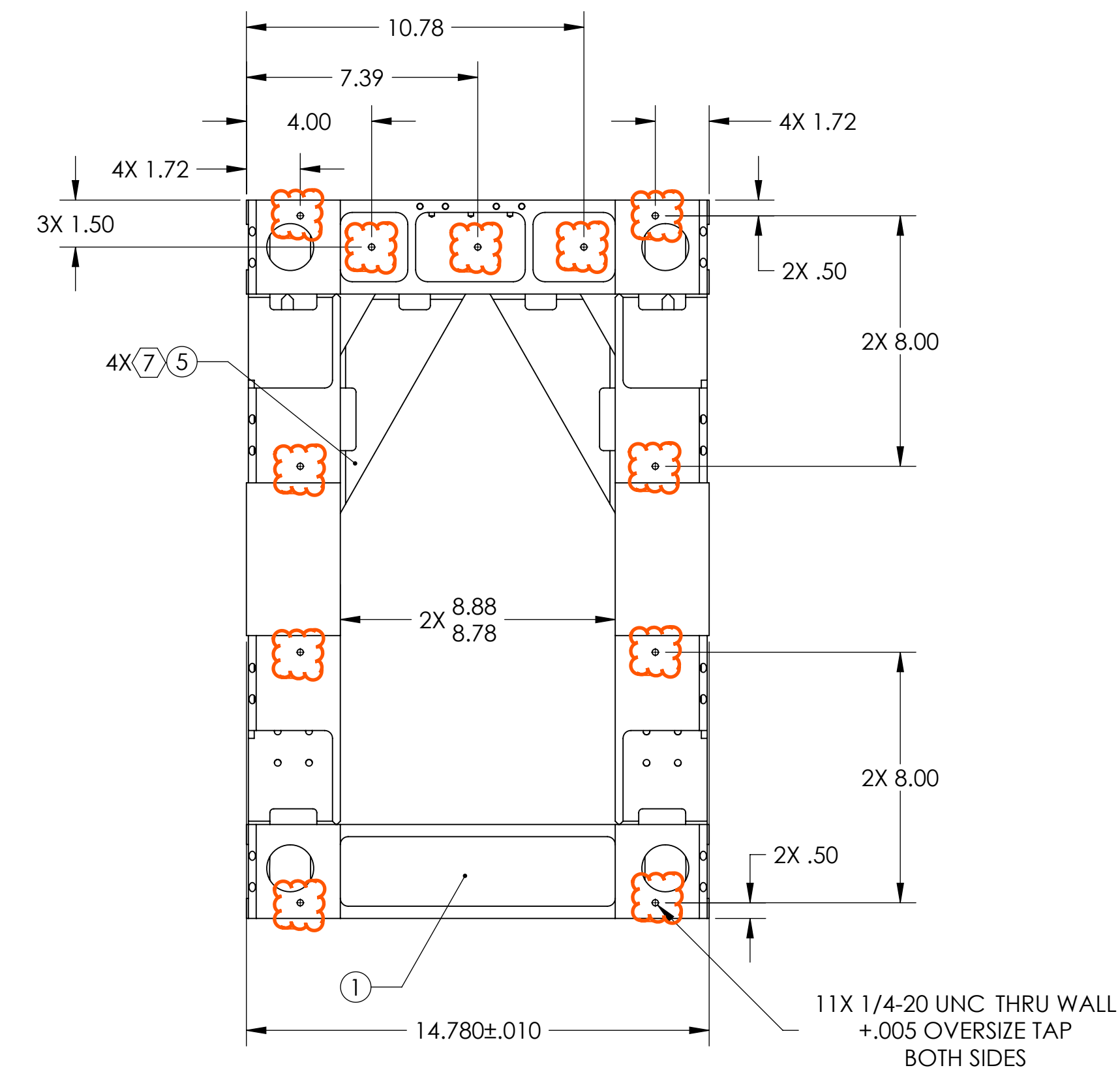
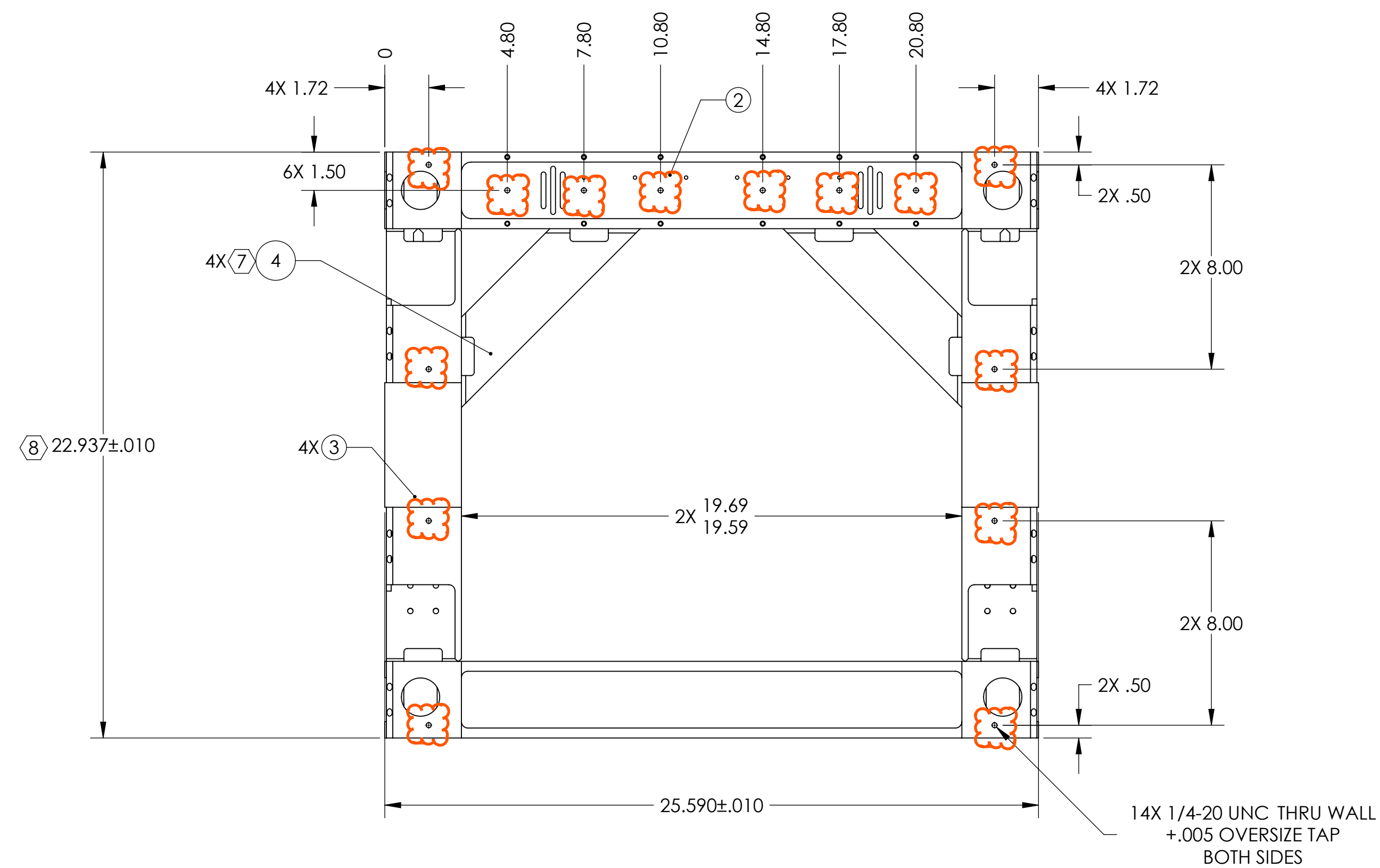


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. 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
v3	10 FEB 2010	E1000033	E0900052
v4	02 MAR 2010	E1000060	E0900052



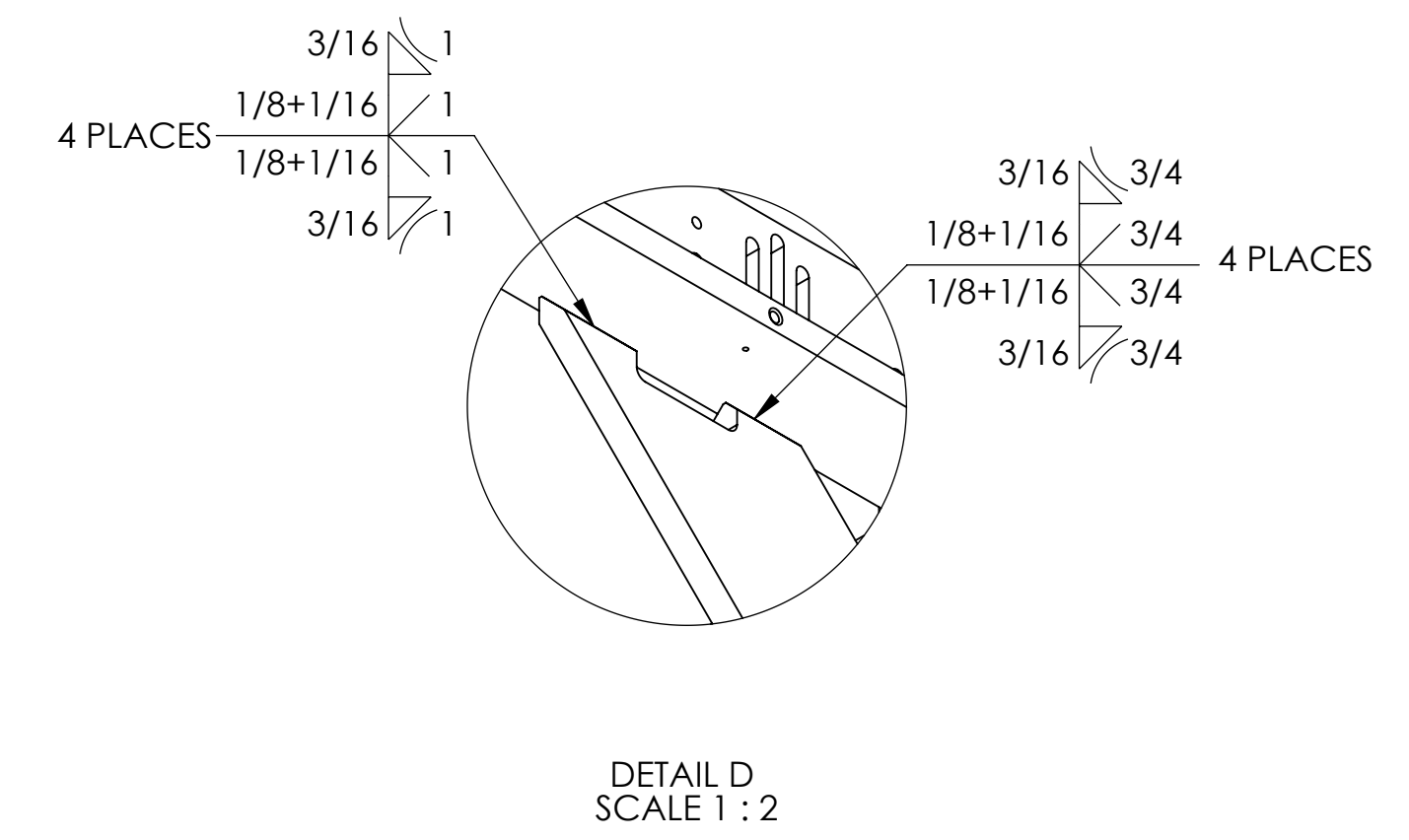
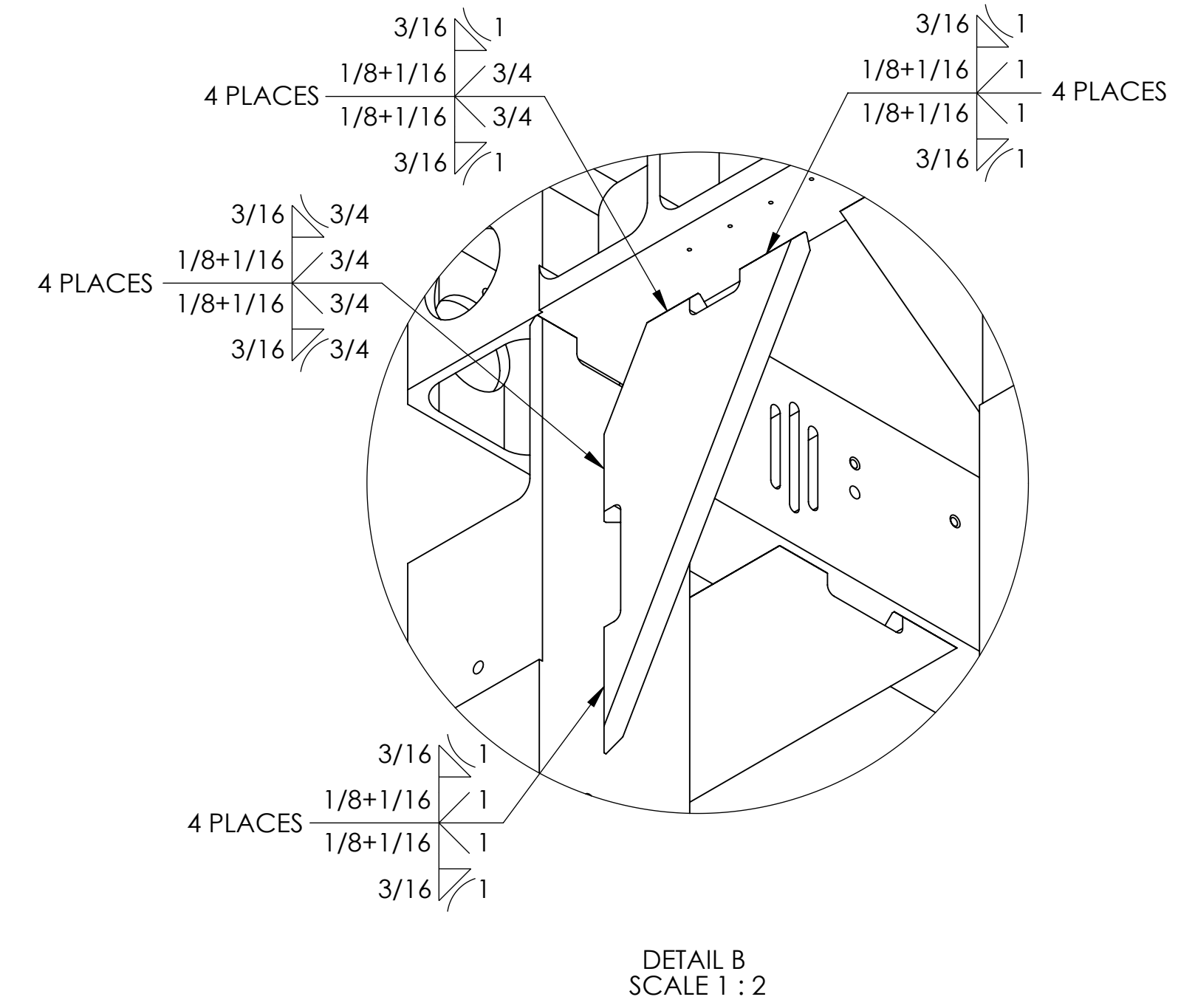
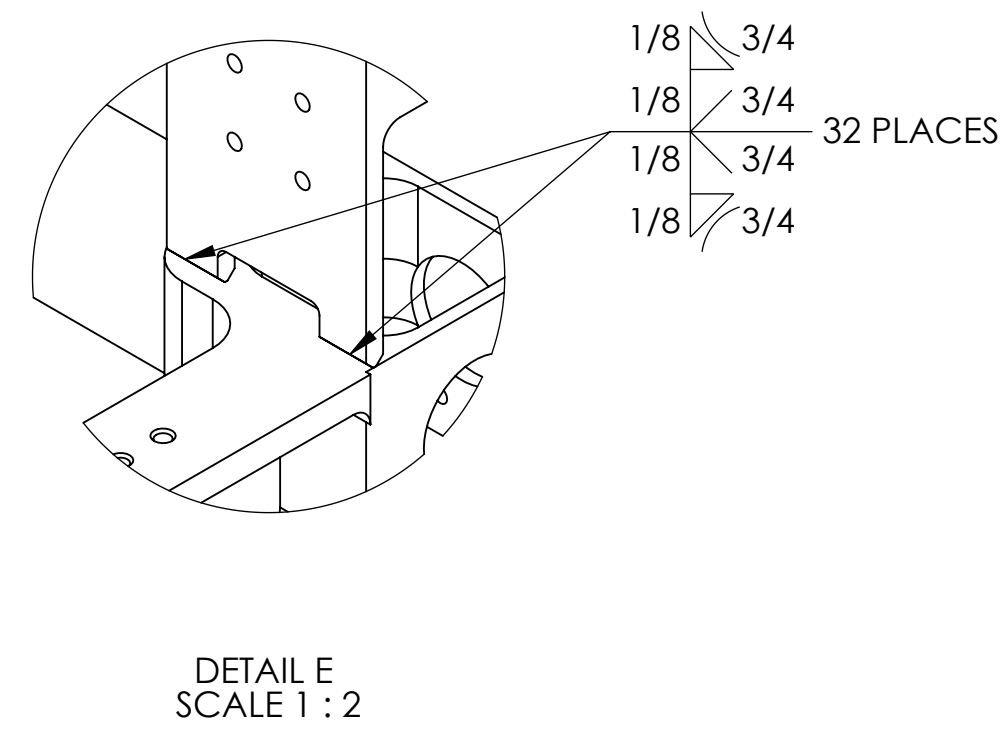
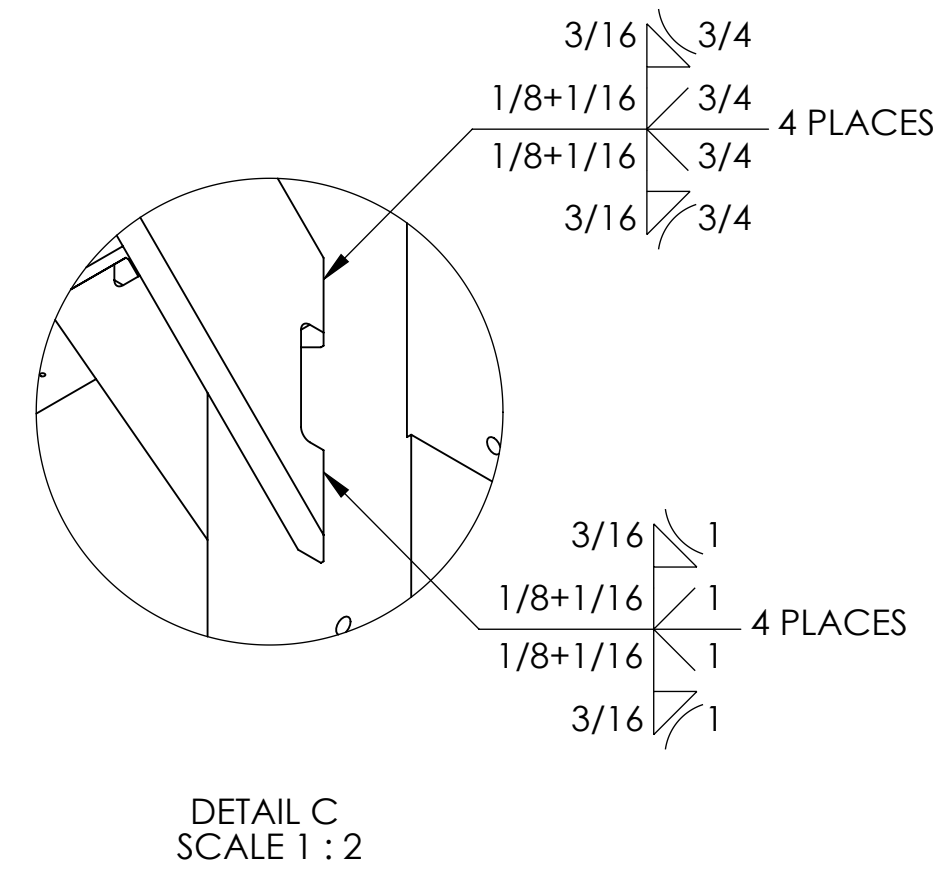
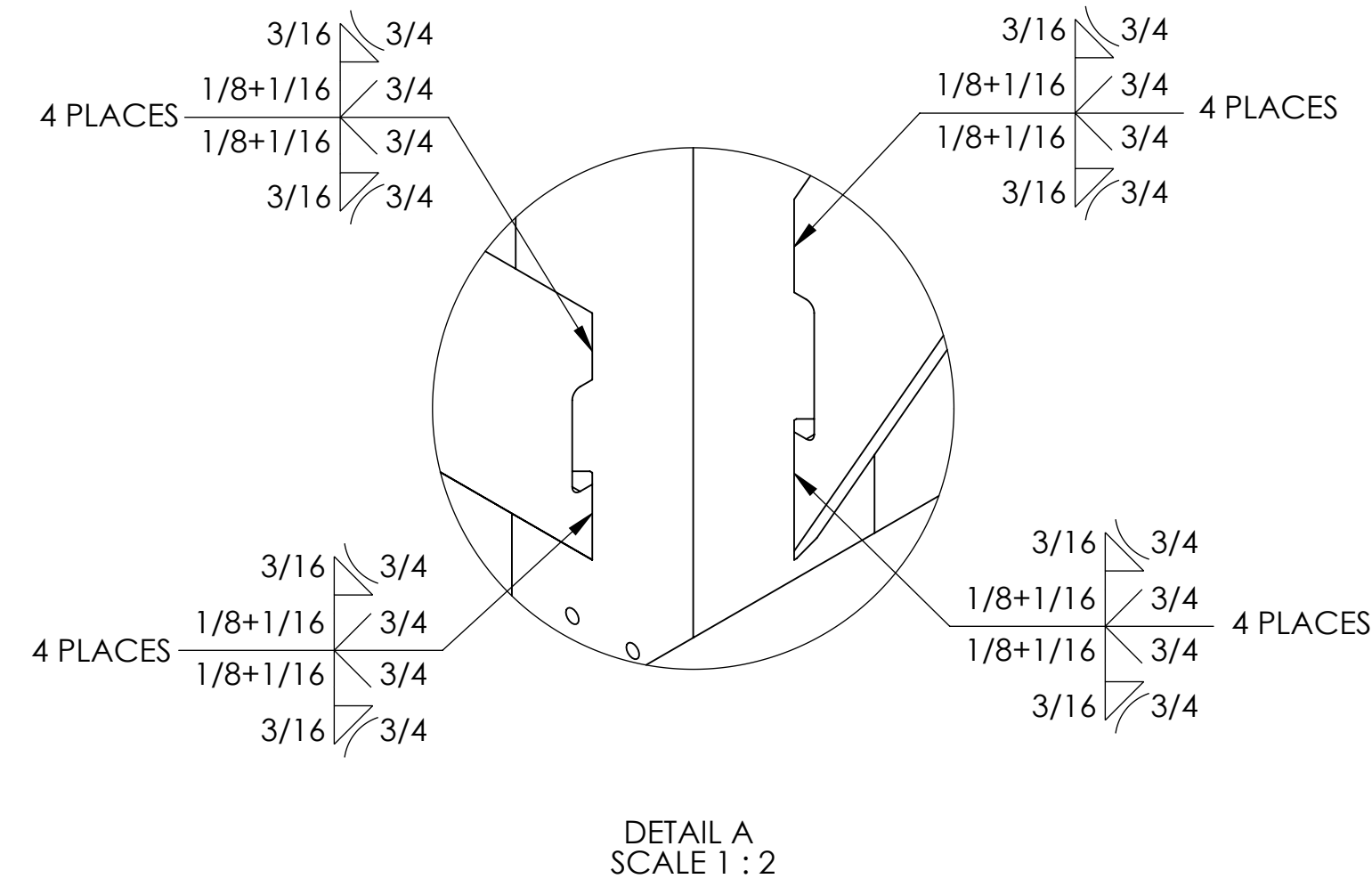
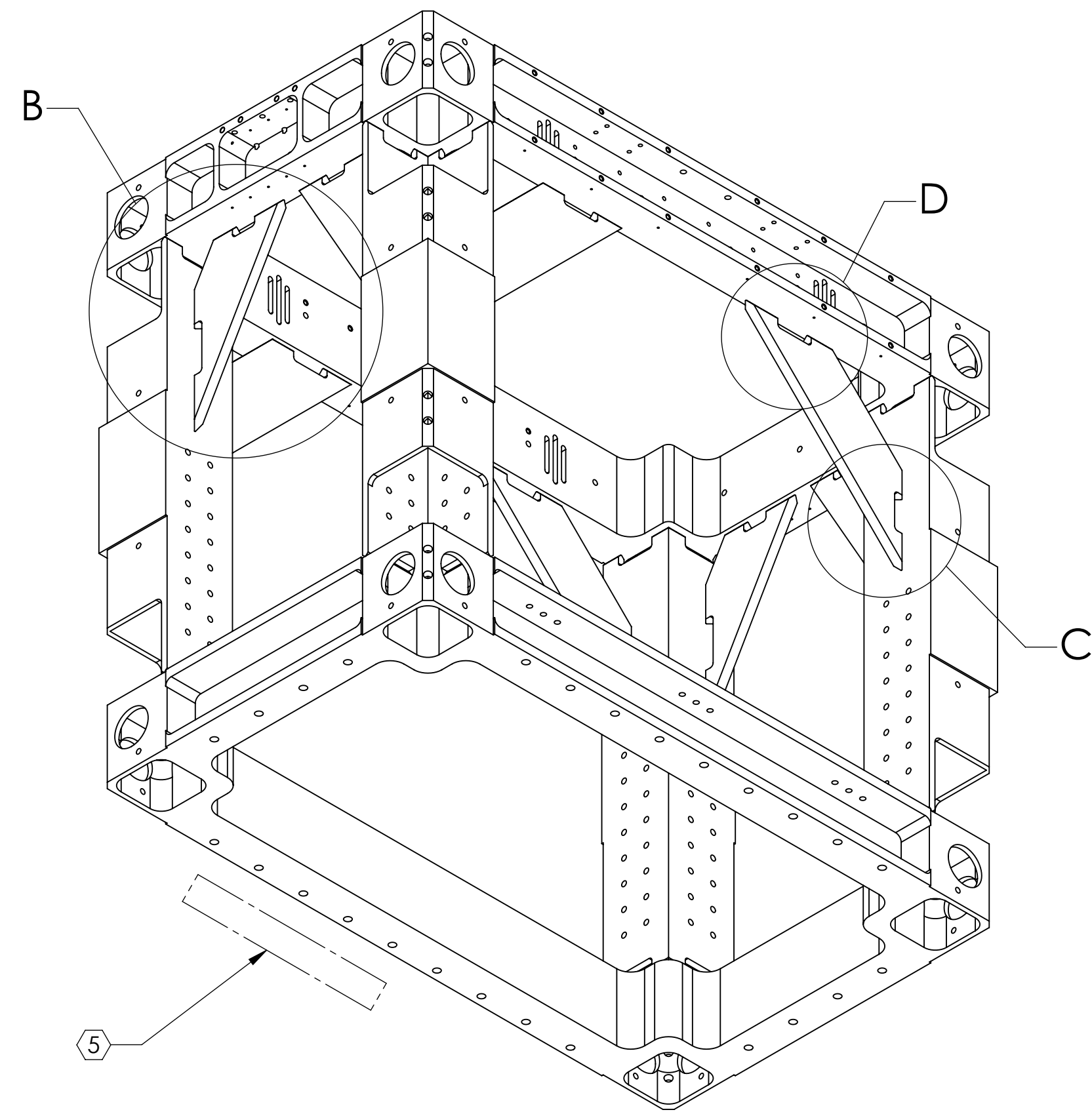
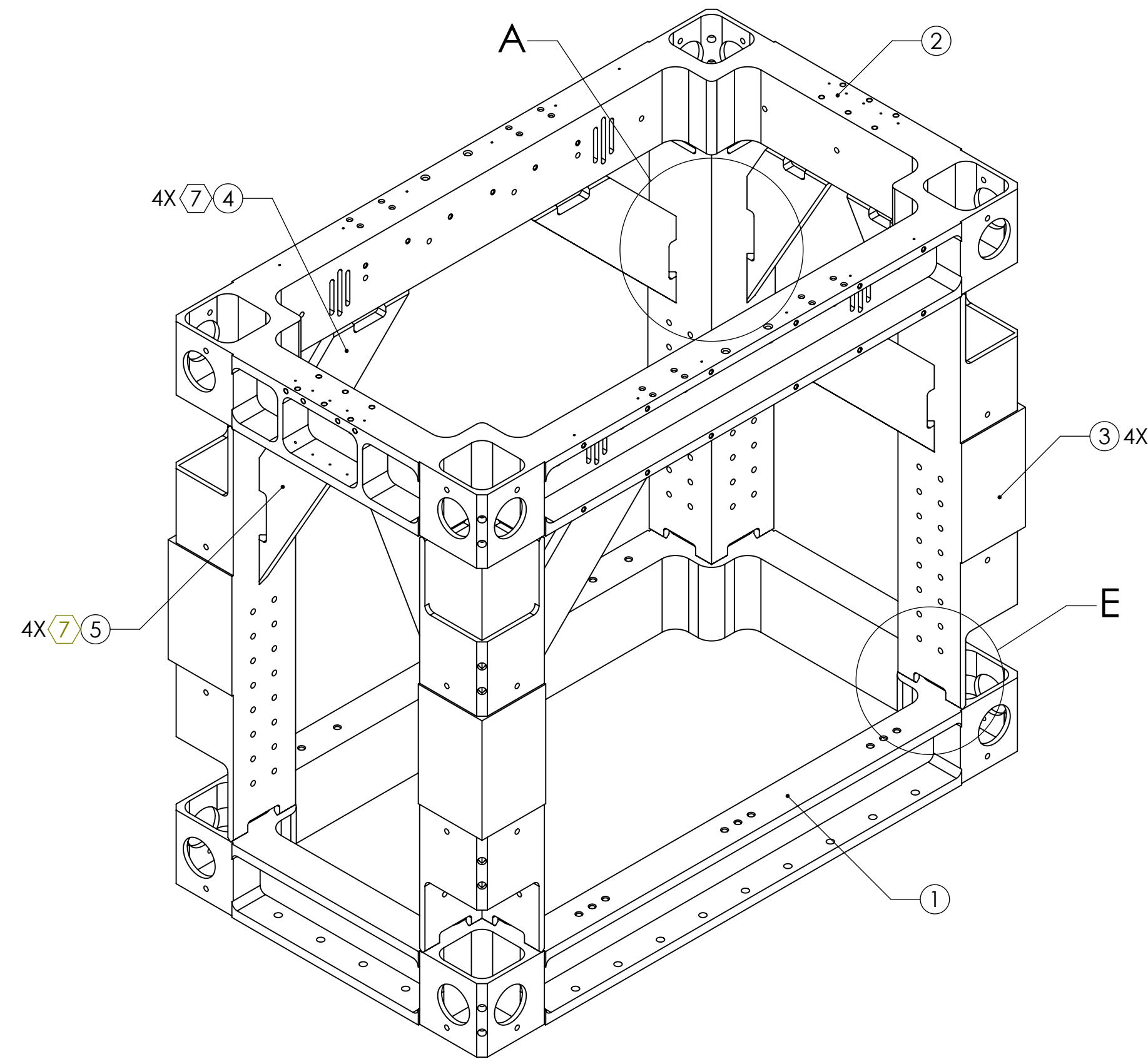
QTY	PART NUMBER	DESCRIPTION	MATL	F/N
4	D0900350	7" X 4" GUSSET	6061-T6 AL	5
4	D0900349	7" X 7" GUSSET	6061-T6 AL	4
4	D0900348	LEG, OMC STRUCTURE	6061-T6 AL	3
1	D0900347	TOP PLATE, OMC STRUCTURE	6061-T6 AL	2
1	D0900346	BASE PLATE, OMC STRUCTURE	6061-T6 AL	1

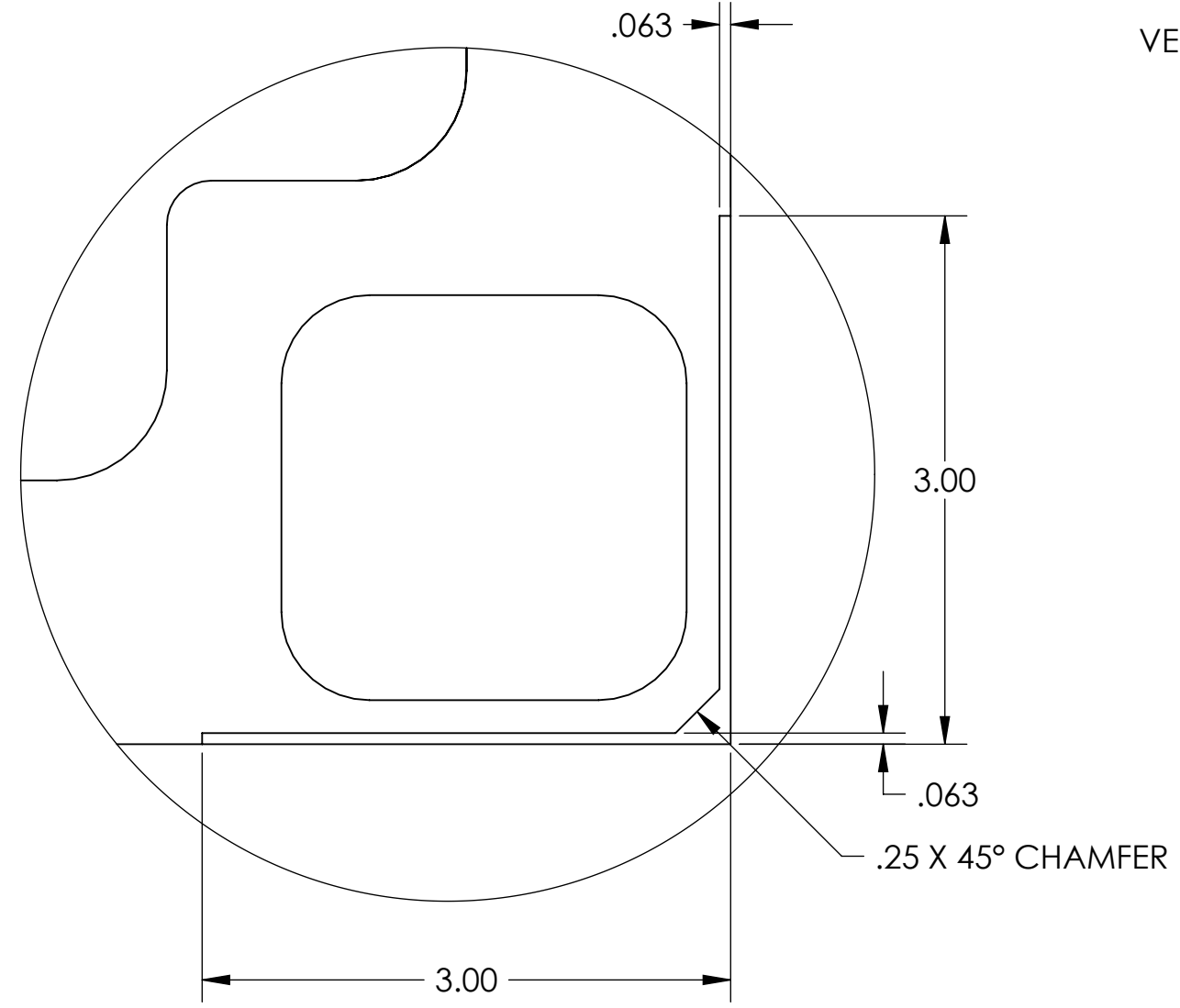
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± .5°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.	
MATERIAL	FINISH
6061-T6 AL	32 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SUS
NEXT ASSY	
D0900655	

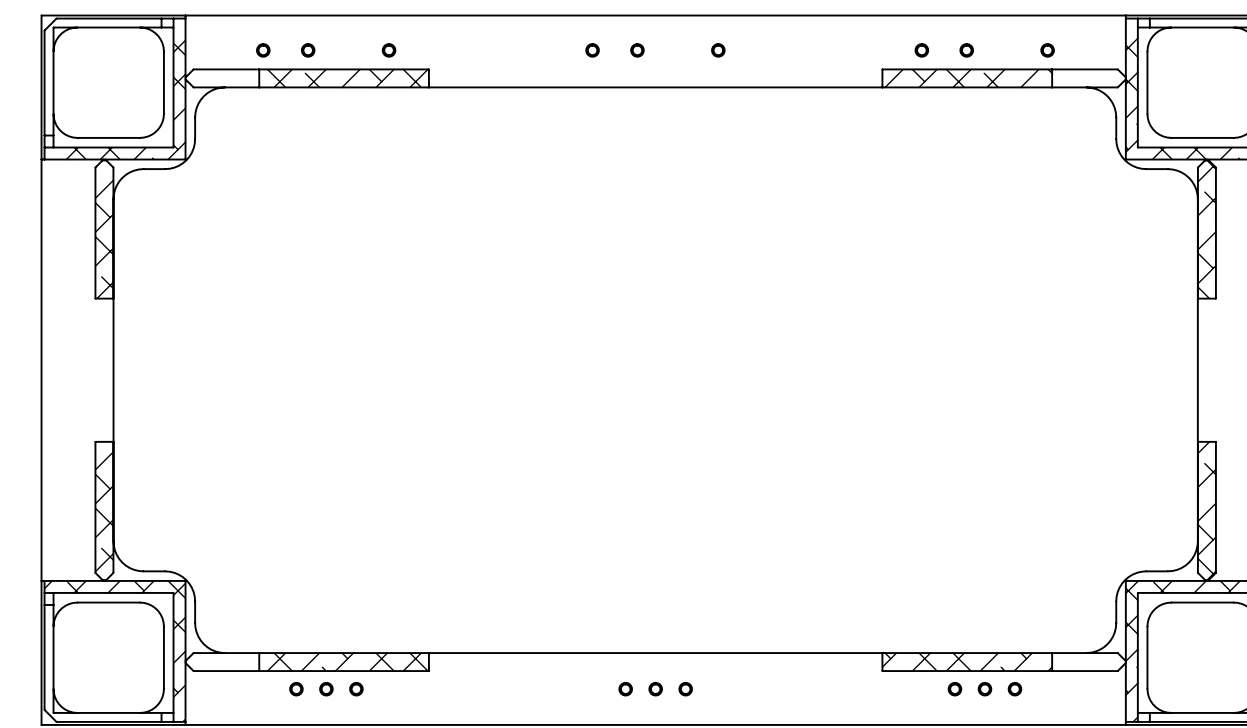
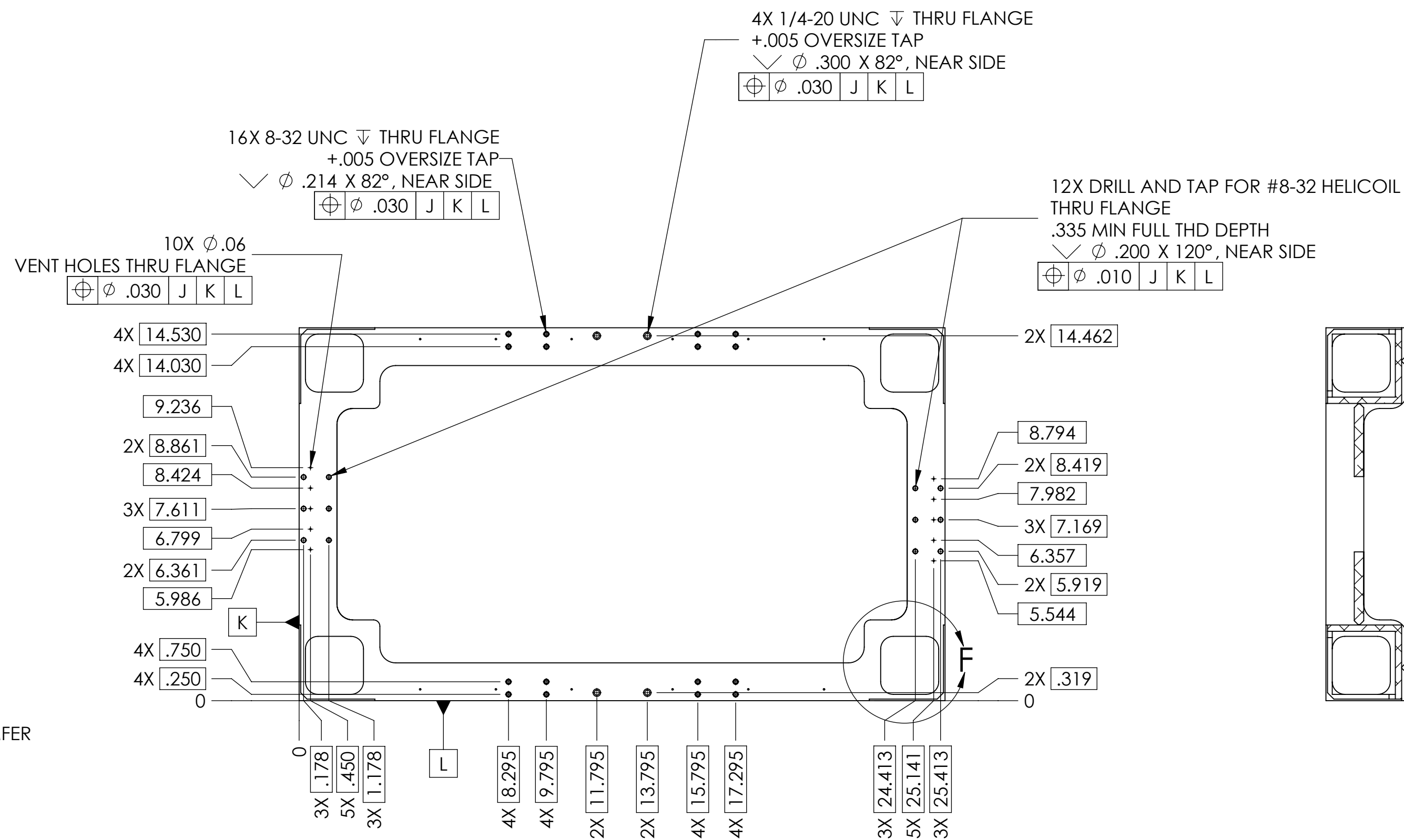
PART NAME		OMC STRUCTURAL WELDMENT	
DESIGNER	C. ECHOLS	17 DEC 2006	SIZE DWG. NO.
DRAFTER	B. MOORE	19 MAR 2009	D
CHECKER	M. MEYER	20 MAR 2009	D0900308
APPROVAL			REV. v4
SCALE: 1:4		PROJECTION:	SHEET 1 OF 4

D0900308_AsdLIGO_OMC_StructuralWeldment_PART_PDM_REV-V3-001_DRAWING_PDM_REV-V3-004

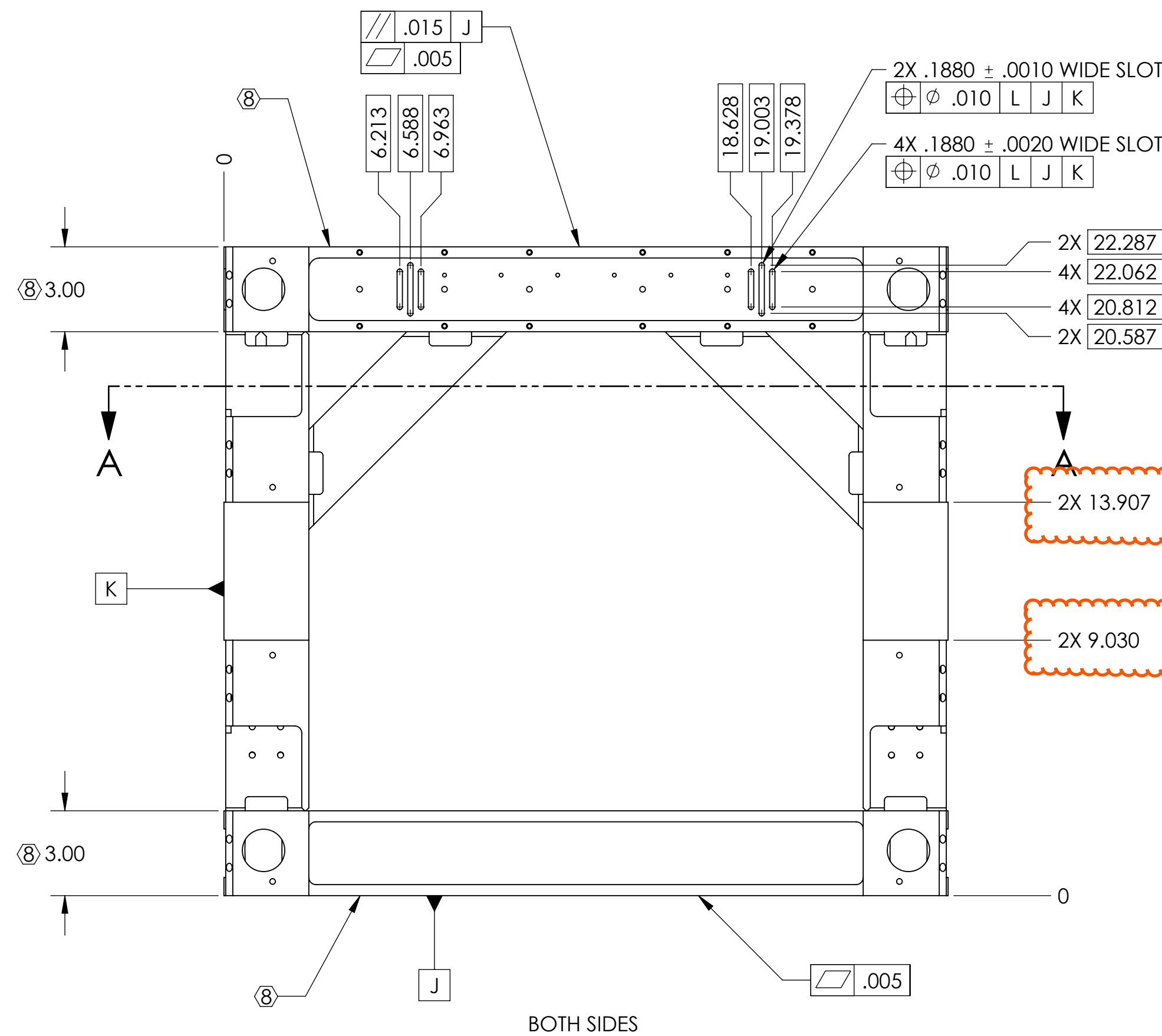
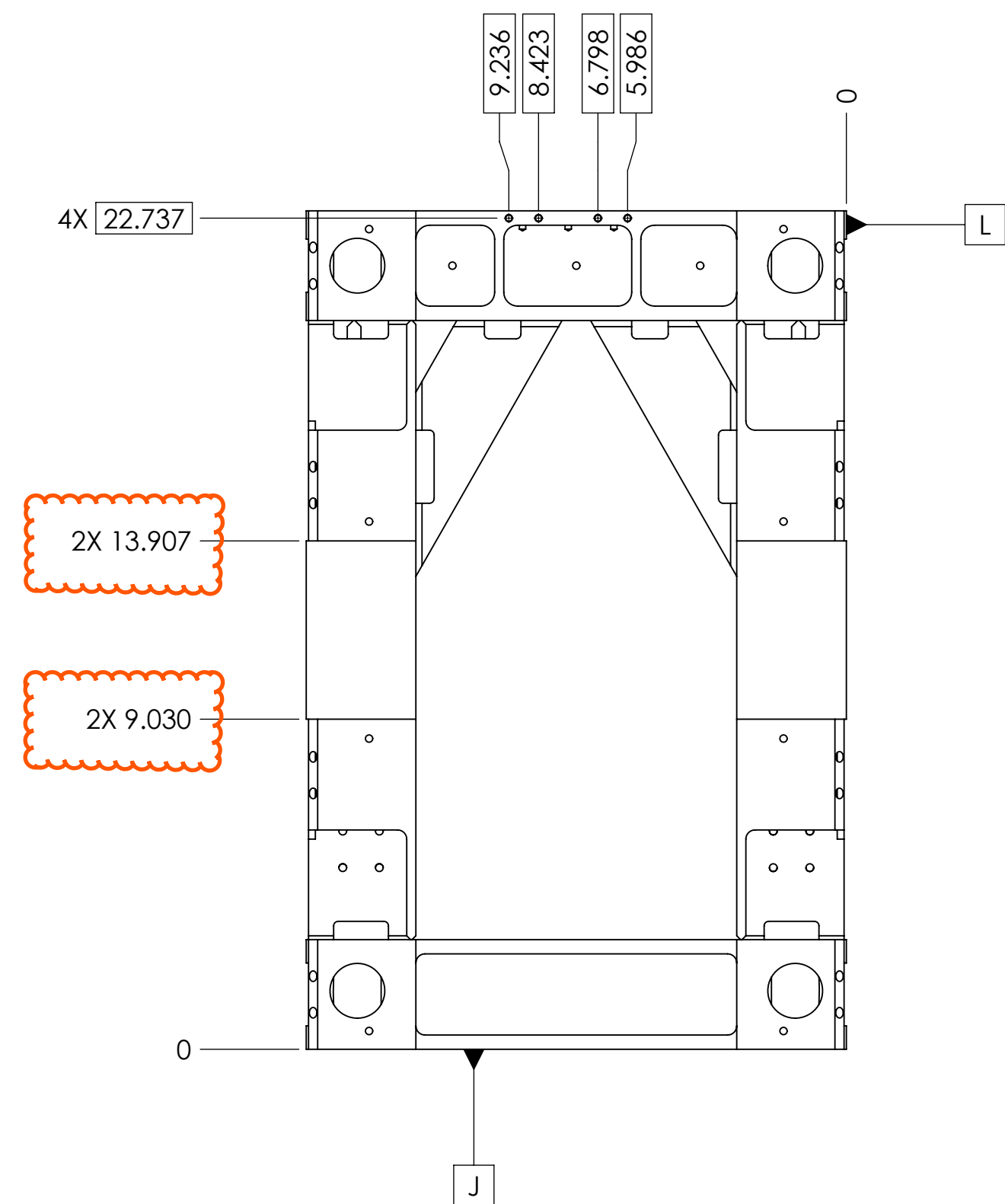




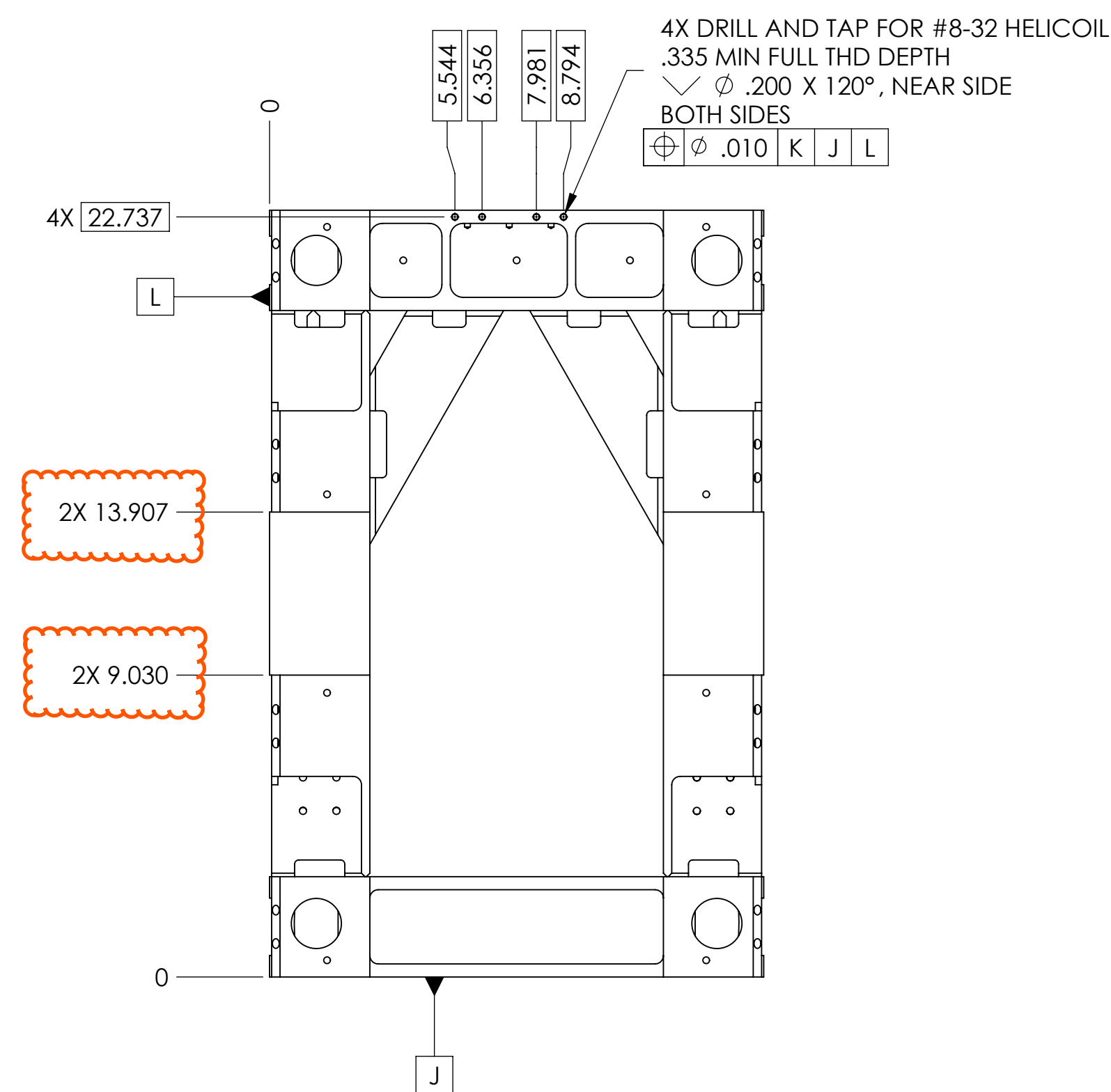
DETAIL F
SCALE 1:1



SECTION A-A



POST-WELD MACHINING



8

7

6

5

4

3

2

1

H

G

F

E

D

C

B

A

H

G

F

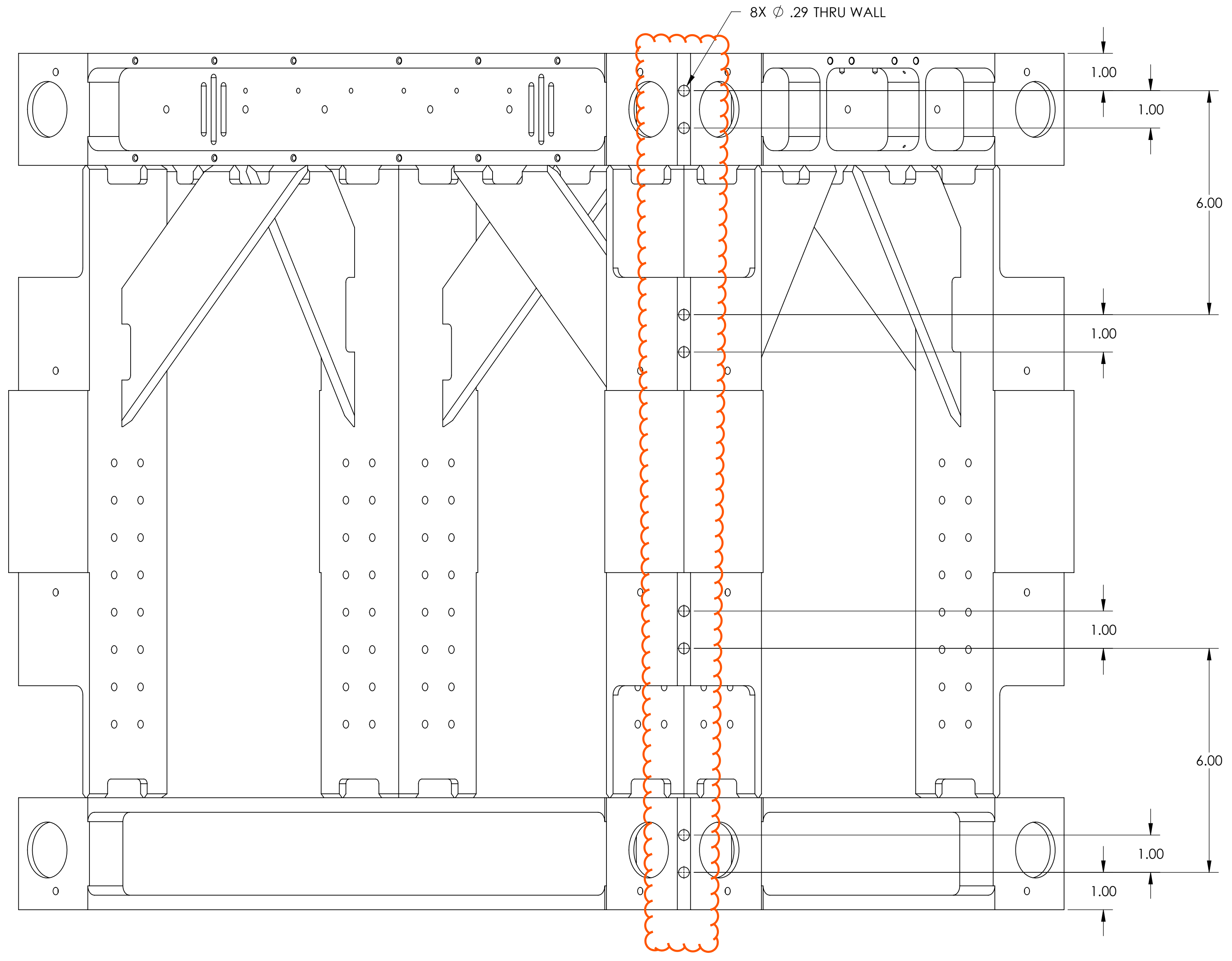
E

D


C

B

A



ALL FOUR CORNERS

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D0900308	v4
SCALE: 1:2	PROJECTION:  SHEET 4 OF 4

DDP00308_Asd\LIGO_CIVIL_Structural Weldment_PART.FDW.REV:V3-001.DRAWING.FDW.REV:V3-004