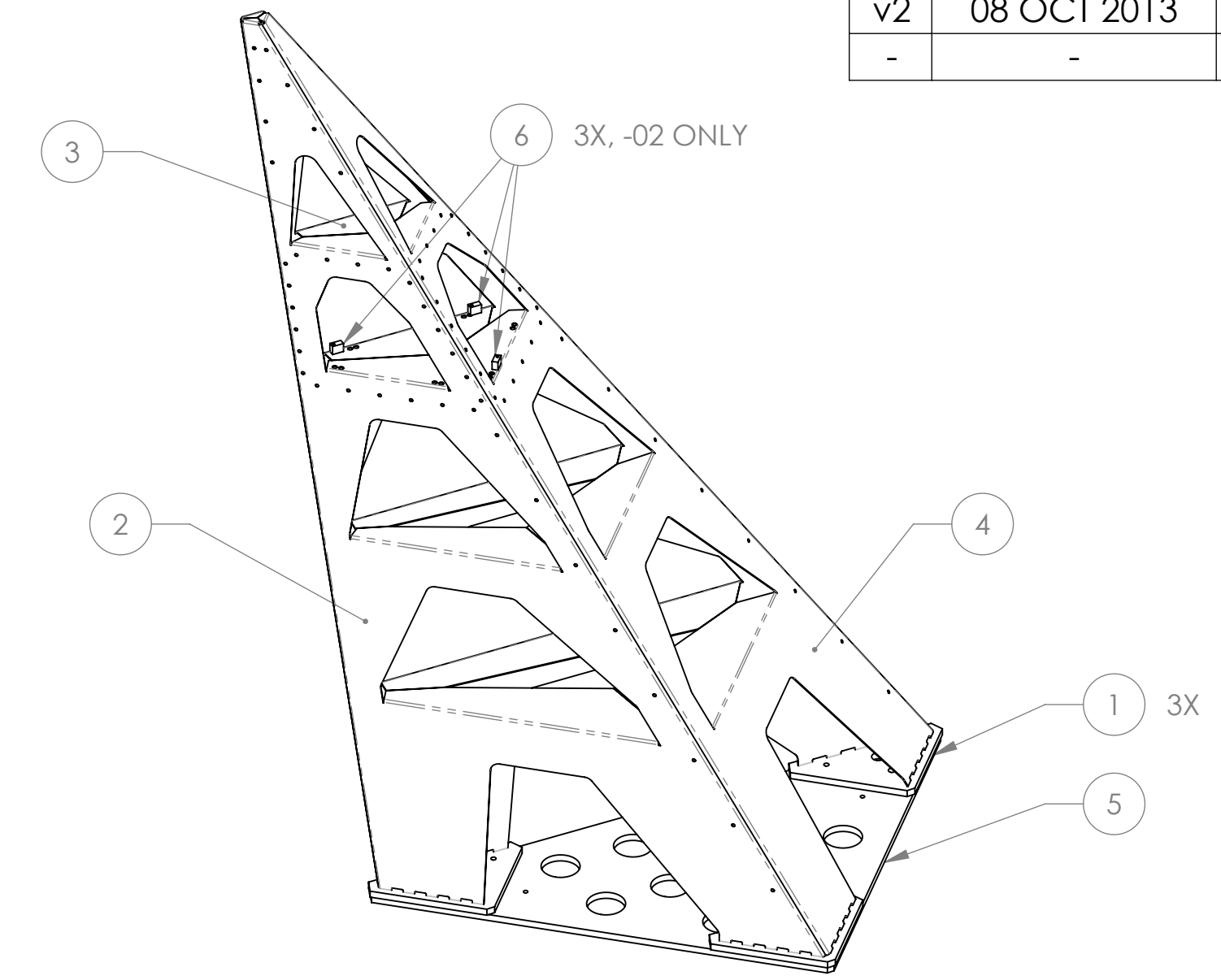
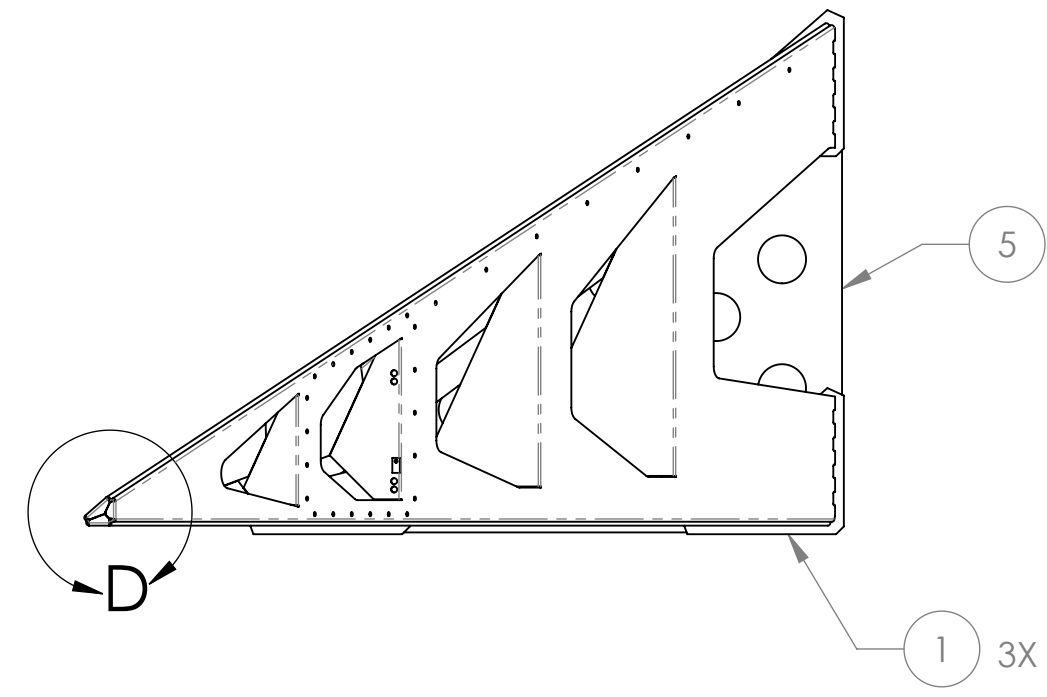
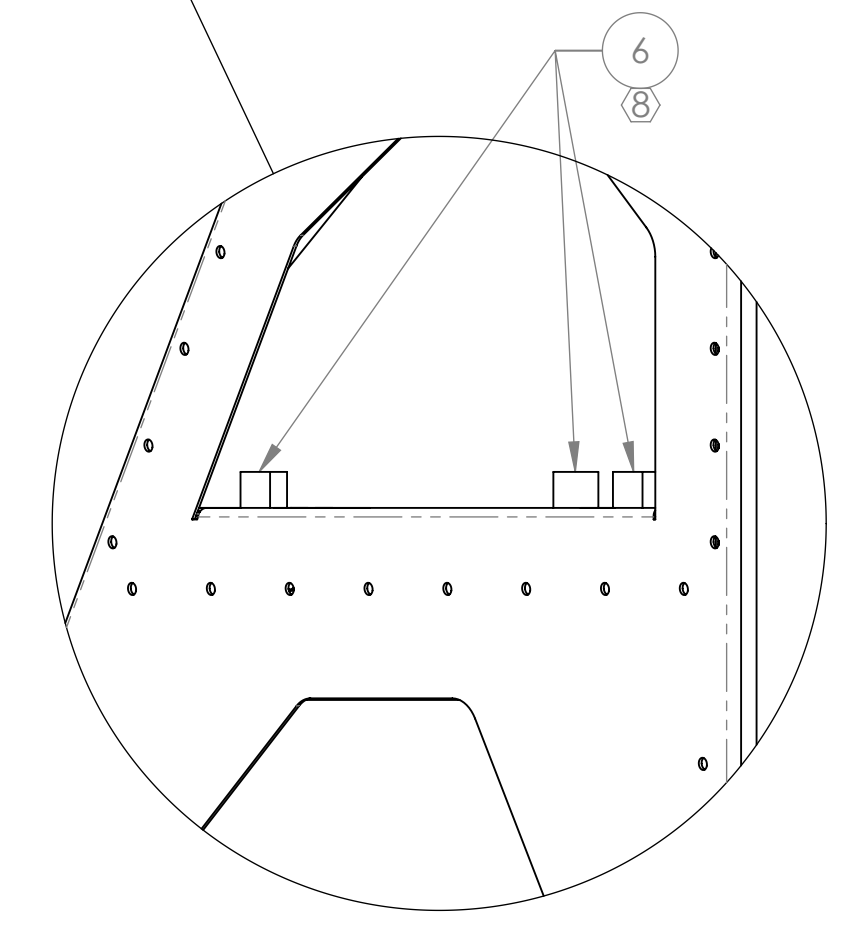
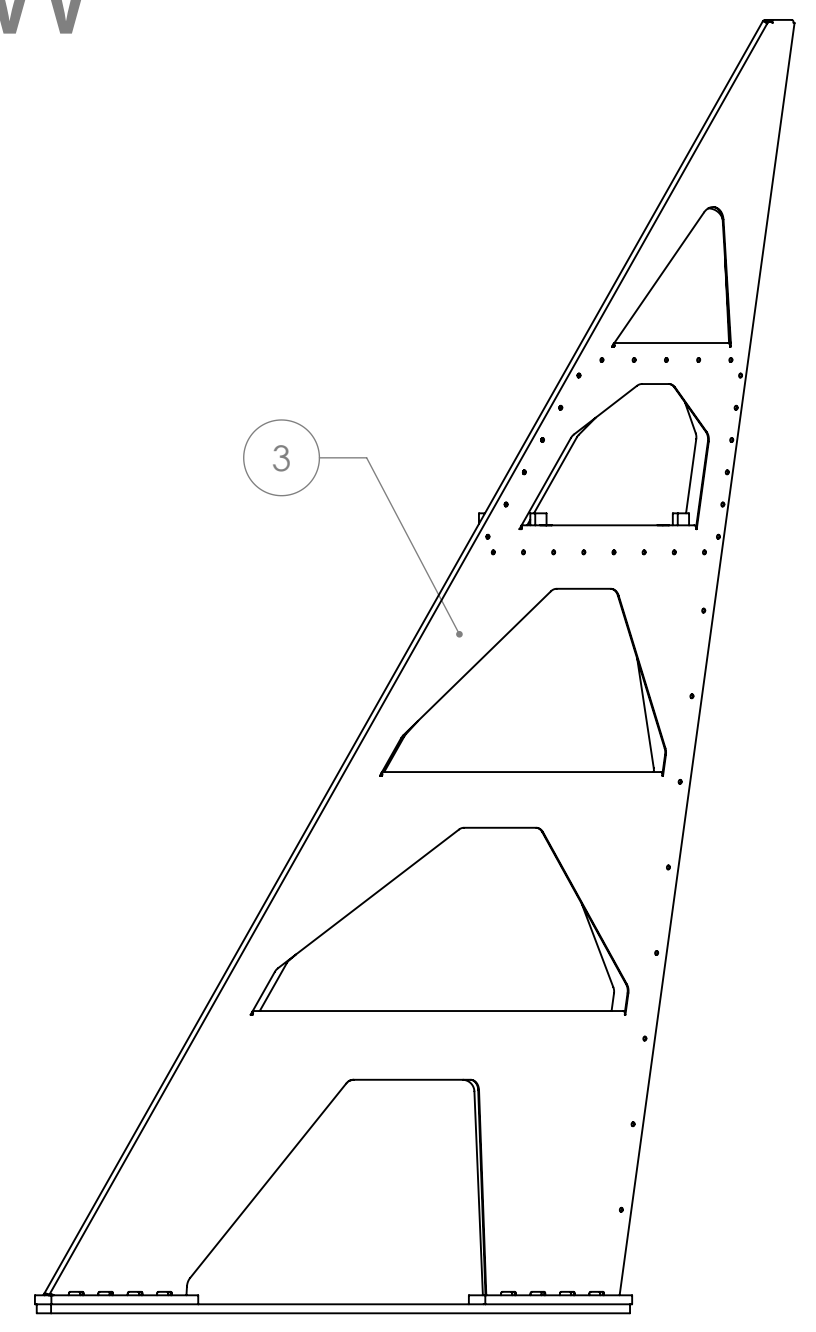
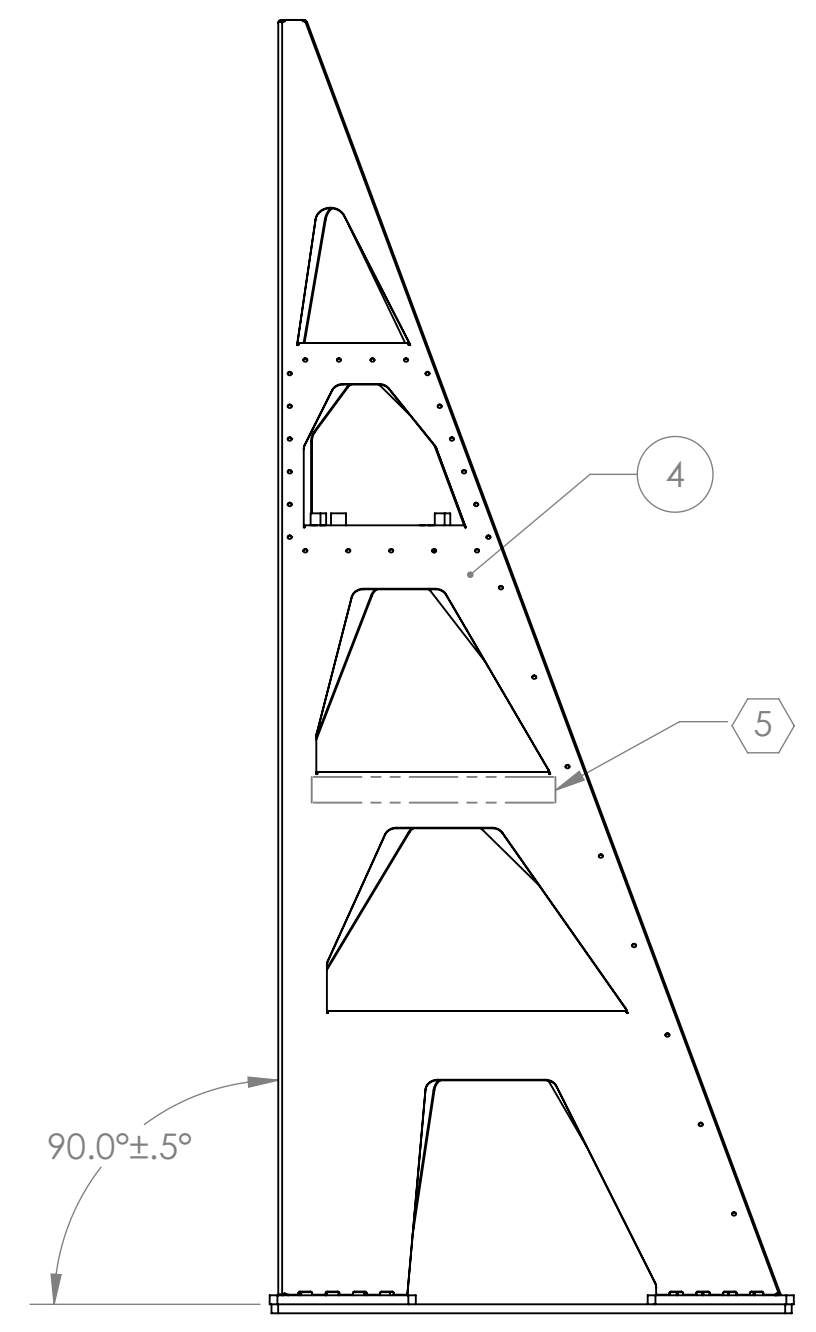
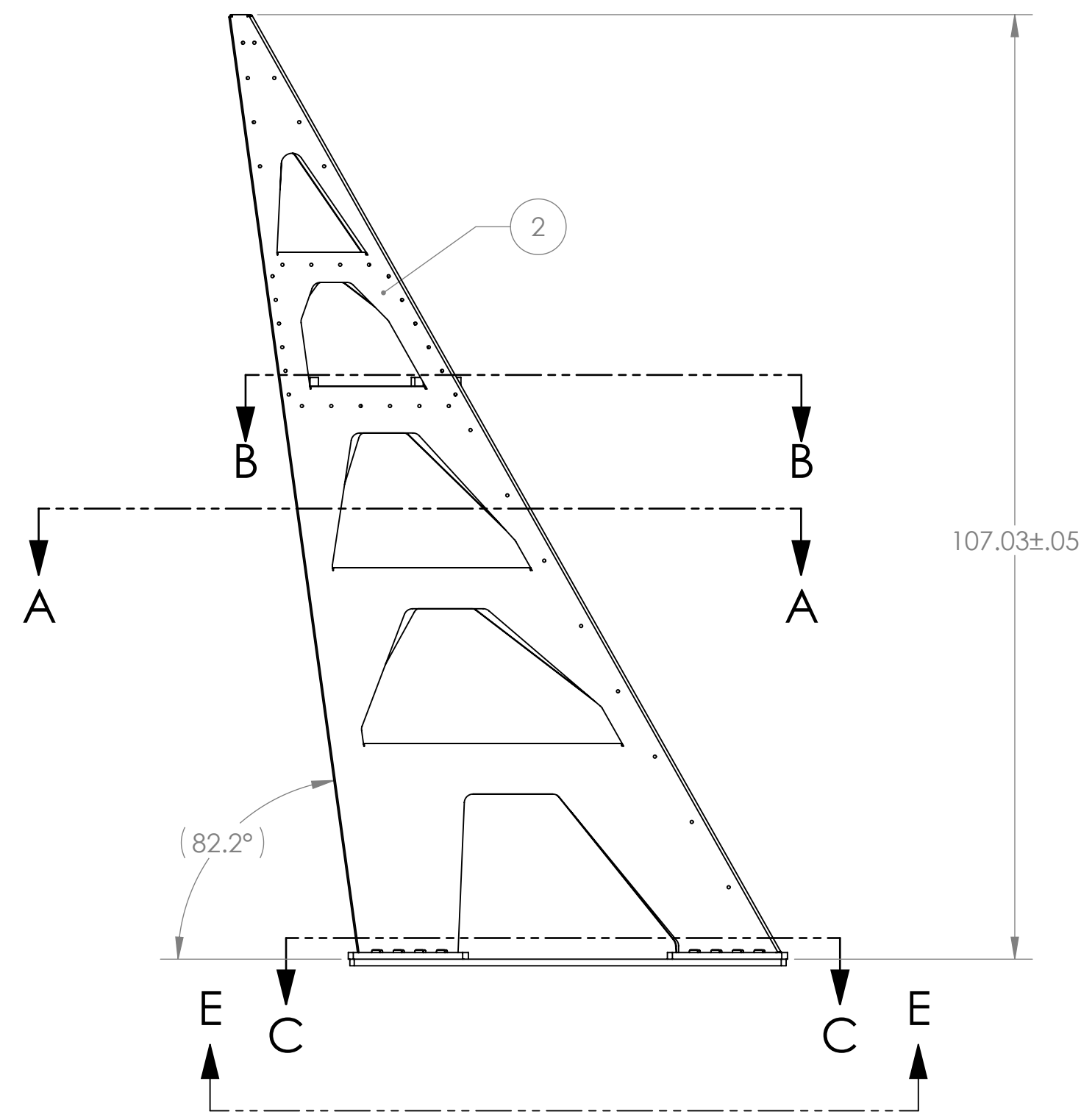
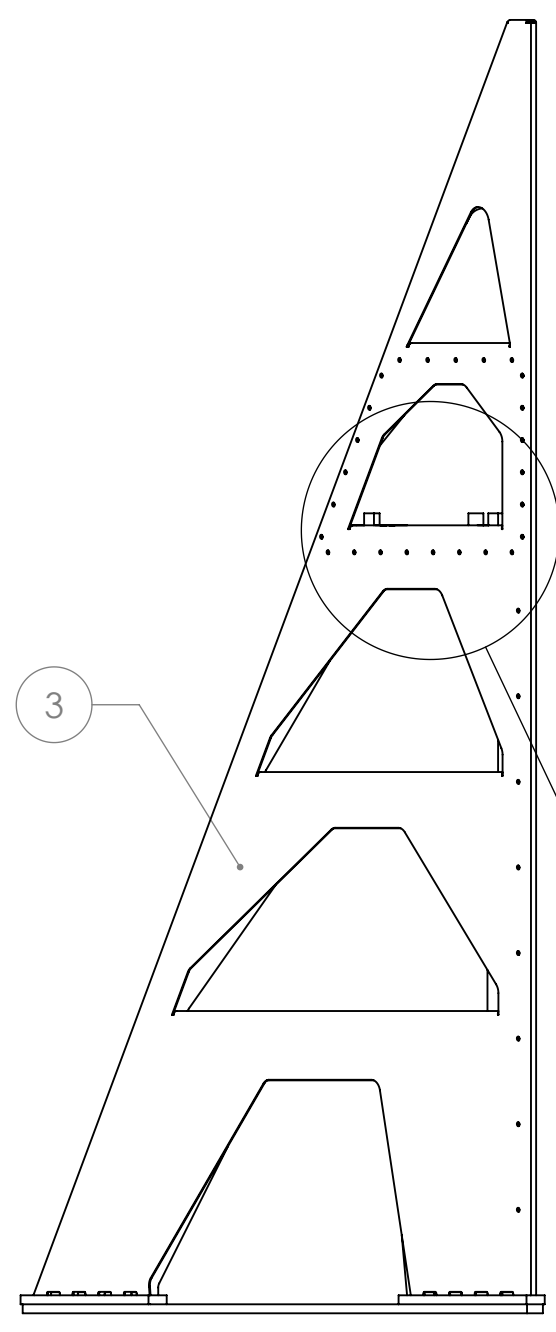


- NOTES (CONTINUED):**
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION, AND TYPE (DASH) NUMBER ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. EXAMPLE: D1001292-V2, TYPE-01, S/N 001
  - ⑥ FASTEN ITEMS ① TO ITEM ⑤ BEFORE APPLYING NOTED WELDS, TO ENSURE ALIGNMENT. FOR EACH ITEM ①, USE THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN ITEM ⑤. ITEM ⑤ MUST BE REMOVEABLE & RE-ATTACHABLE POST-WELD, WITH NO BINDING OF SCREWS. TO BE DELIVERED WITH ITEM ⑤ ATTACHED.
  - ⑦ WARPAGE OF ITEM ① & ITEM ⑤ TO BE MINIMIZED USING PREFERRED METHODS, IE. HEAT SINKING.
  - ⑧ APPLY ITEMS ⑥ TO -02 WELDMENTS ONLY, USING TOOLING FIXTURE D1300525-v1 PER PROCEDURE E1300593-v2.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 AUG 2010	E1000182-v1	-
v2	08 OCT 2013	E1300649	-
-	-	-	-



ISO VIEW



-02 SHOWN, ALL VIEWS

ITEM NO.	PART NO.	DESCRIPTION	REV.	MATERIAL	-01 (ITMX) /QTY.	-02 (ETMY) /QTY.
6	D1300499	ALIGO PCAL RECEIVER MOUNTING BLOCK	v2	304 SSSL	-	3
5	D1000836	ALIGO AOS PIER FOOTING 4	v3	302 SSSL	1	1
4	D1000596-1	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL3 (LLO)	v1	304 SSSL	1	1
3	D1000595-1	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL2 (LLO)	v2	304 SSSL	1	1
2	D1000594-1	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL1 (LLO)	v2	304 SSSL	1	1
1	D1000835	ALIGO AOS PIER BASE 4	v1	304 SSSL	3	3

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN TOLERANCES: .XX ± N/A .XXX ± N/A ANGULAR ± N/A °		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.		ALIGO AOS OPLEV & PCAL RX PIER WELDMENT LH	
MATERIAL		SYSTEM		DESIGNER	
N/A		ADVANCED LIGO		C. CONLEY	
FINISH		SUB-SYSTEM		DATE	
N/A μinch		AOS		16 AUG 2010	
NEXT ASSY		DRAFTER		SIZE	
D1001325		N. KILPATRICK		DWG. NO.	
		CHECKER		D	
		APPROVAL		REV.	
				v2	
				SCALE: NONE PROJECTION:	
				SHEET 1 OF 5	

D1001292.dwg: AOS Oplev & Pcal Rx Pier Weldment LH, PART PDM, REV: X-02, DRAWING PDM REV: X-024

8

7

6

5

4

3

2

1

H

G

F

E

D

C

B

A

H

G

F

E

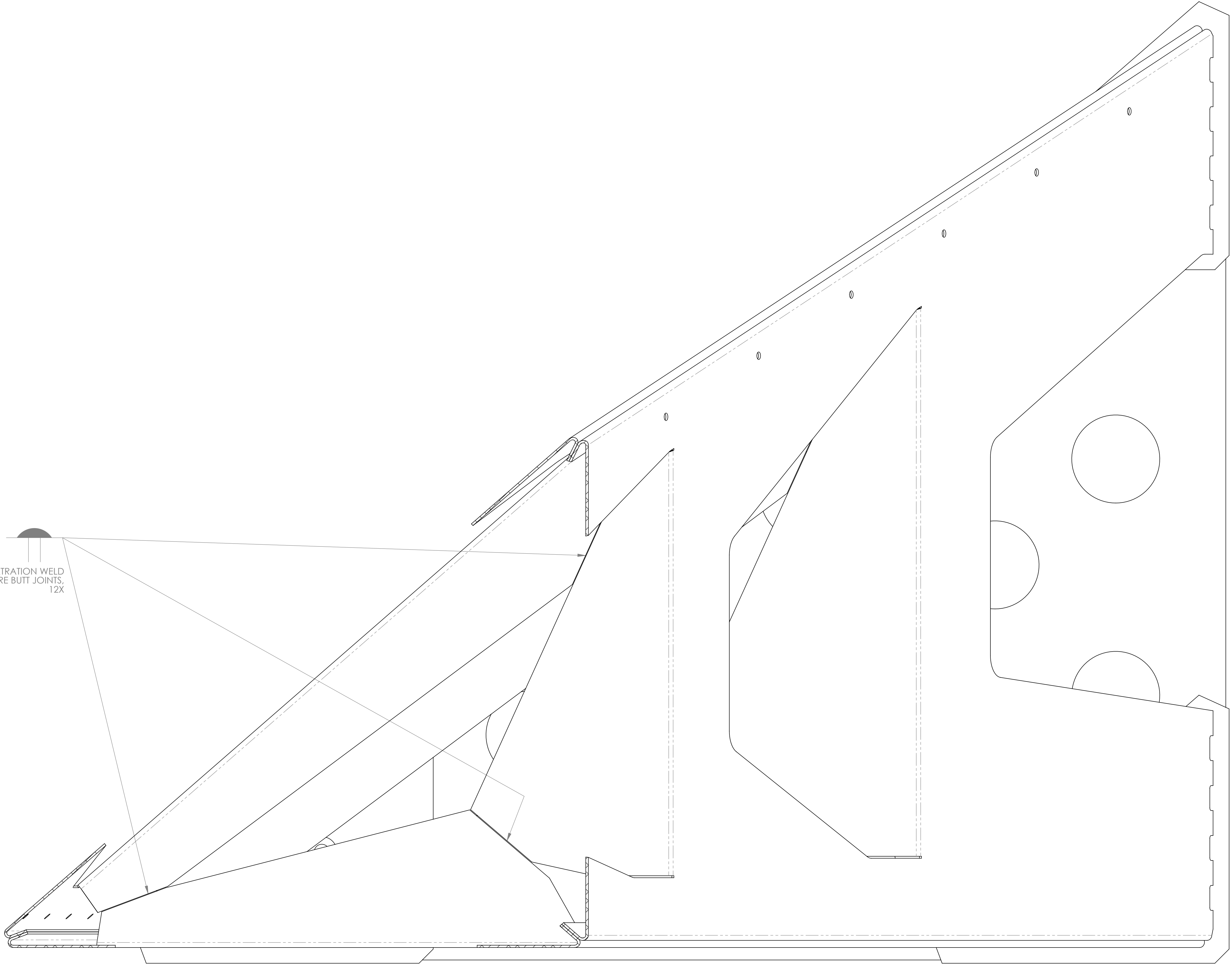
D

C


B

A

FULL PENETRATION WELD  
ENTIRE BUTT JOINTS,  
12X

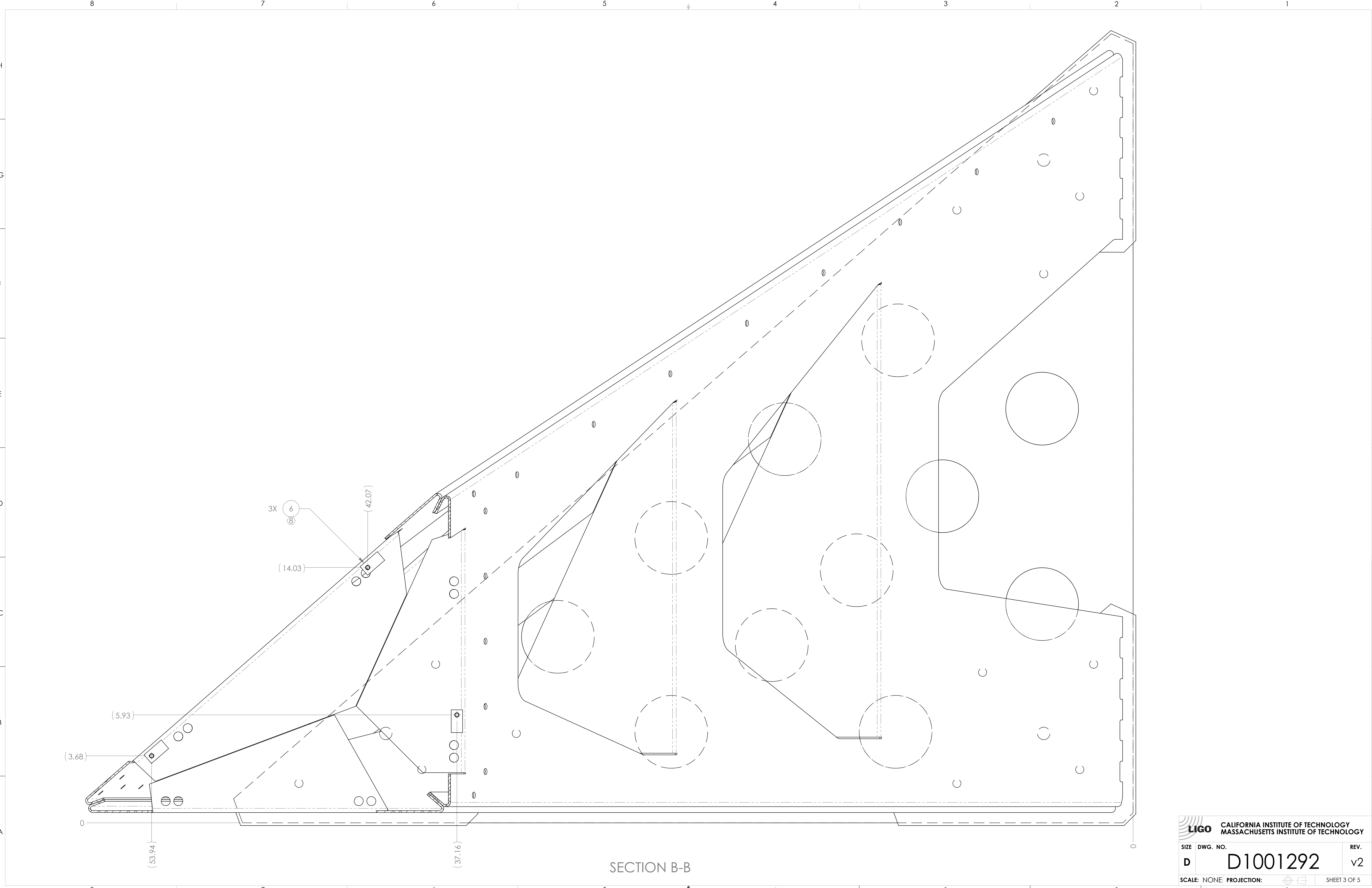


SECTION A-A

 <b>CALIFORNIA INSTITUTE OF TECHNOLOGY</b> <b>MASSACHUSETTS INSTITUTE OF TECHNOLOGY</b>		REV.
SIZE	DWG. NO.	REV.
D	D1001292	v2
SCALE: NONE	PROJECTION:	SHEET 2 OF 5

D:\001292.dwg ACS Octave & Pochiraju Weldment LH\_PART.PDM REV:K-032 DRAWING.PDM REV:X-024

D:\001292.dwg ACS Civil & Pwr IPR For Weldment LH\_PART.PDM REV-K-032.DRAWING.PDM REV-X-024



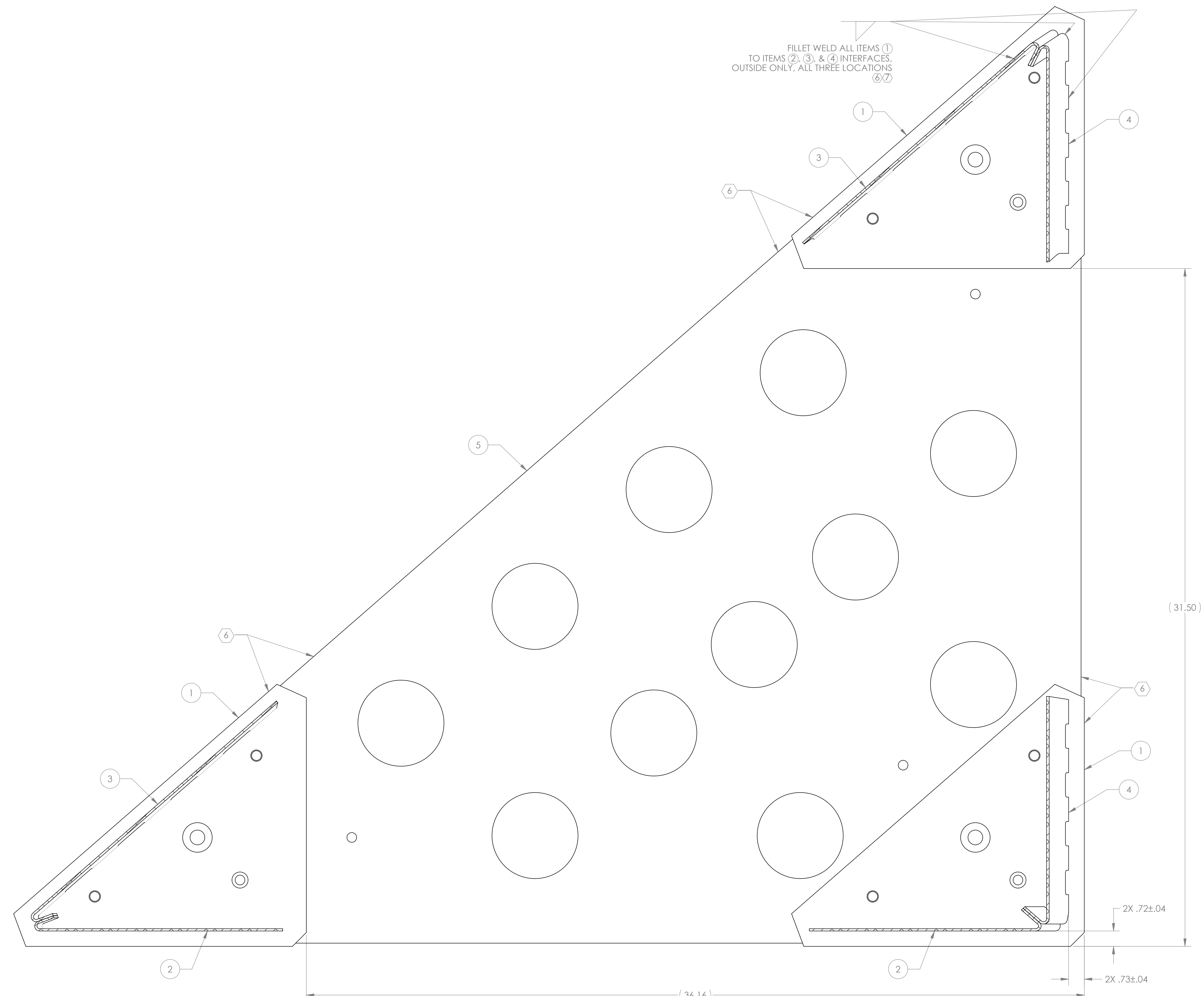
<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1001292	v2
SCALE: NONE	PROJECTION:	SHEET 3 OF 5

8 7 6 5 4 3 2 1

H  
G  
F  
E  
D  
C  
B  
A

H  
G  
F  
E  
D  
C  
B  
A

FILLET WELD ALL ITEMS ①  
TO ITEMS ②, ③, & ④ INTERFACES,  
OUTSIDE ONLY, ALL THREE LOCATIONS  
⑥⑦



(31.50)

(36.16)

SECTION C-C

2X .72±.04

2X .73±.04

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	<b>D1001292</b>	v2
SCALE: NONE	PROJECTION:	SHEET 4 OF 5

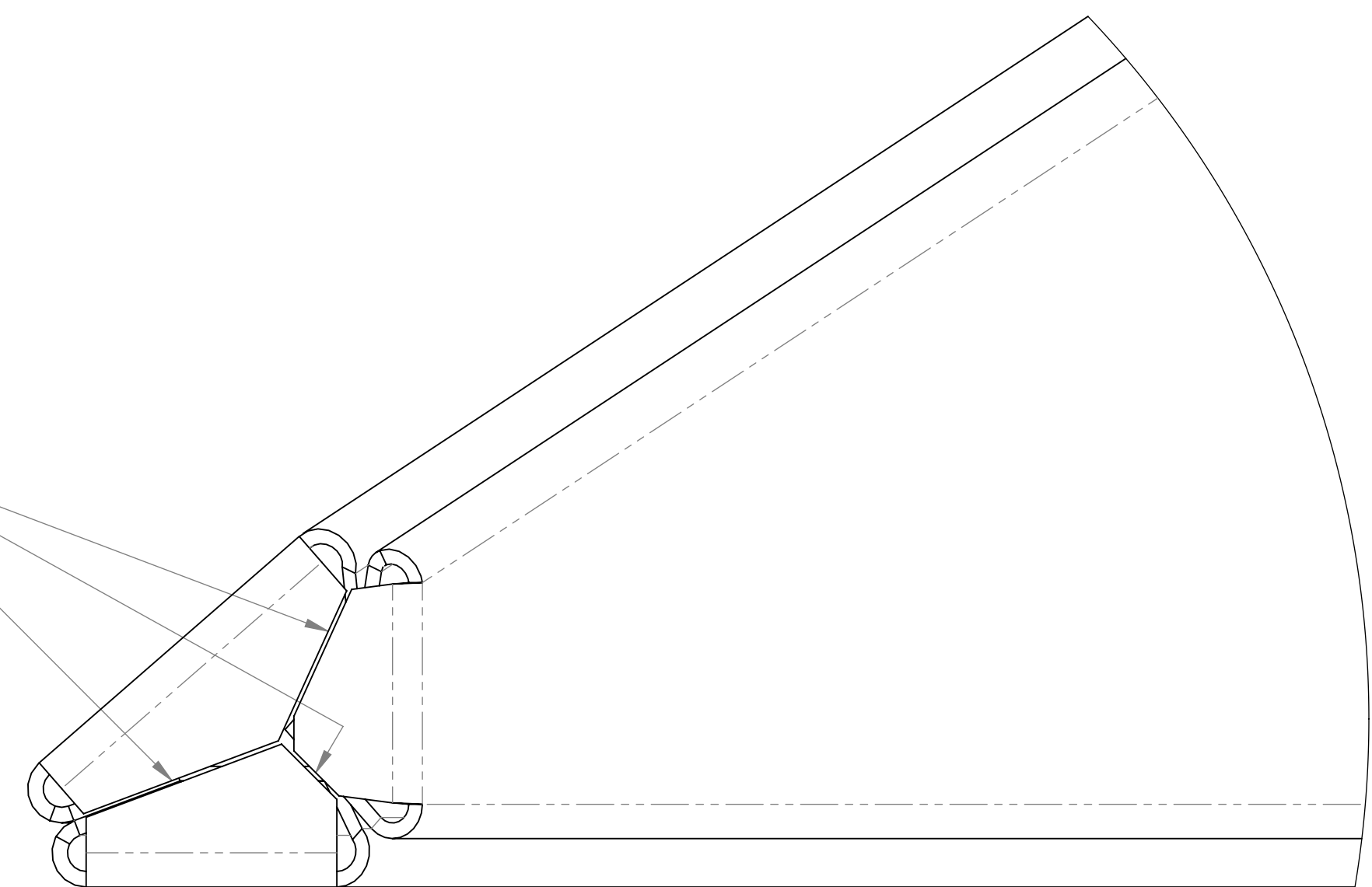
D:\001292\ligo\ACS\Ocleve & Pochiraju\Weldment LH\_PART.PDM\_REV-K-032\_DRAWING.PDM\_REV-X-024

8 7 6 5 4 3 2 1

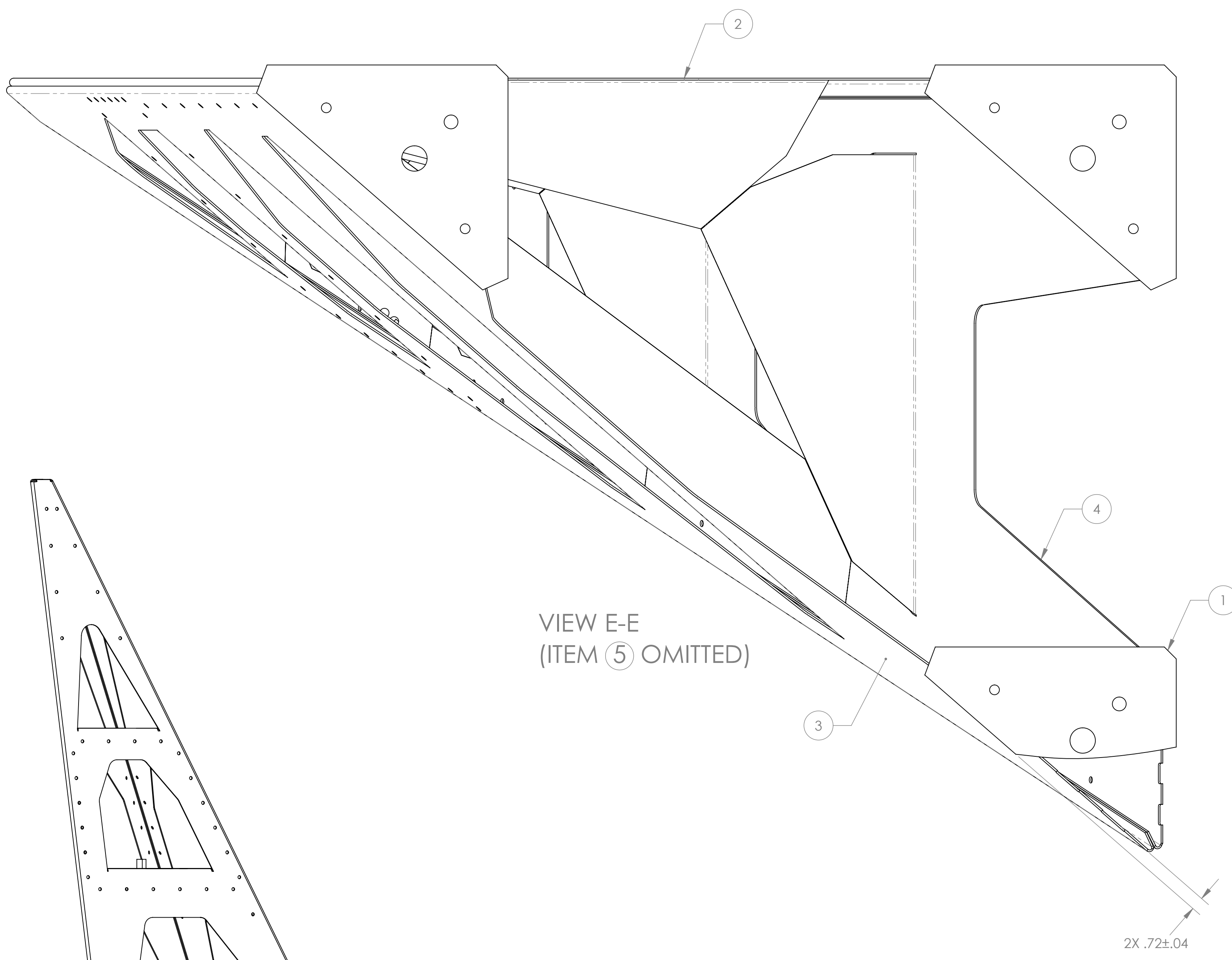
8 7 6 5 4 3 2 1

H  
G  
F  
E  
D  
C  
B  
A

FULL PENETRATION  
WELD ENTIRE BUTT  
JOINTS,  
12X



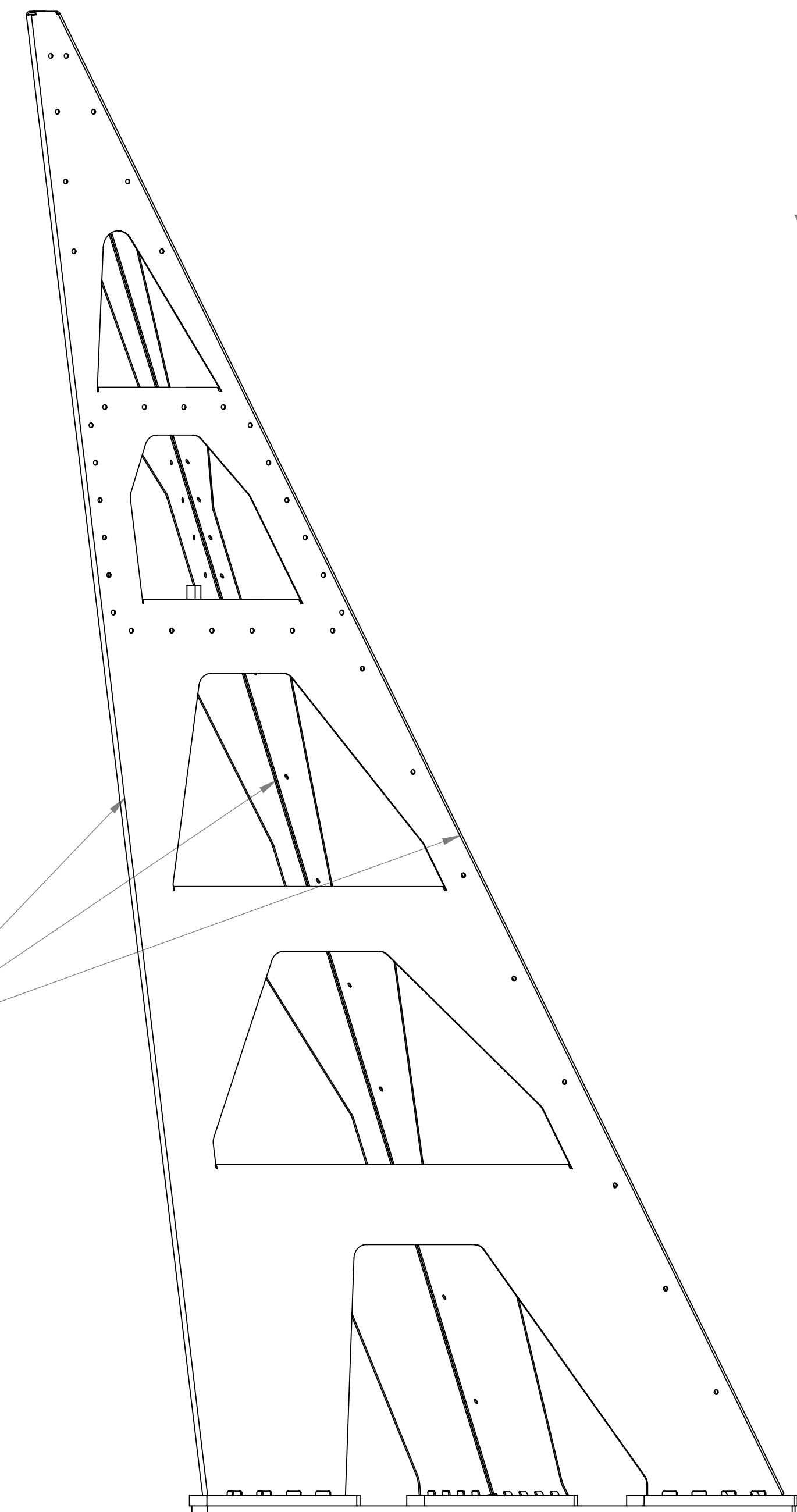
DETAIL D



VIEW E-E  
(ITEM ⑤ OMITTED)

2X .72±.04

1-2  
3/8-2  
3 VERTICAL SEAMS.  
INTERNAL & EXTERNAL  
INCLUDE ENDS



<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
<b>D</b> <b>D1001292</b>	<b>v2</b>
SCALE: NONE PROJECTION:	SHEET 5 OF 5

8 7 6 5 4 4 3 2 1

D:\001292.dwg ACS Octave & Pccir Fix Weldment LH PART PDM REV: X-032 DRAWING PDM REV: X-024