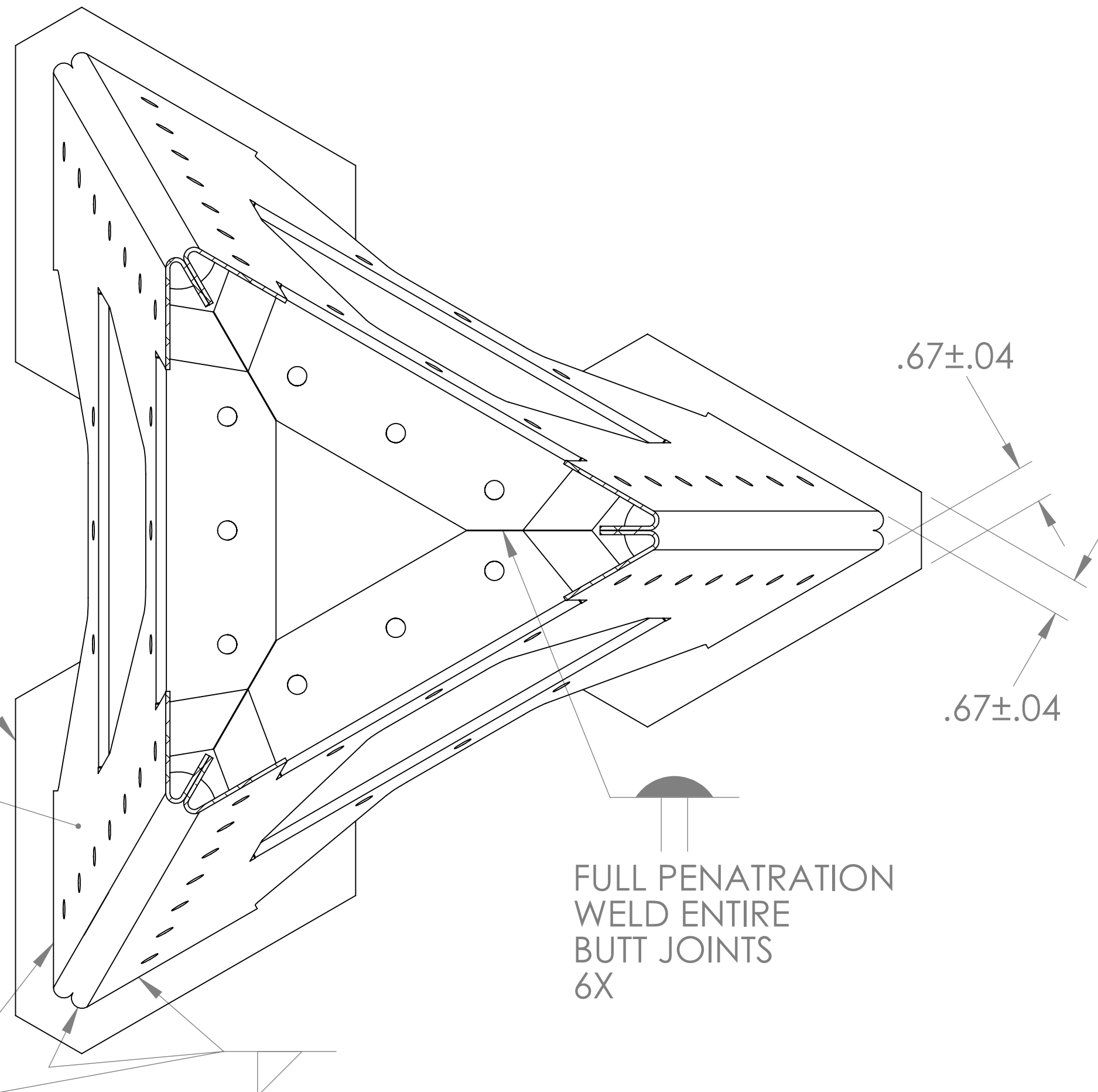


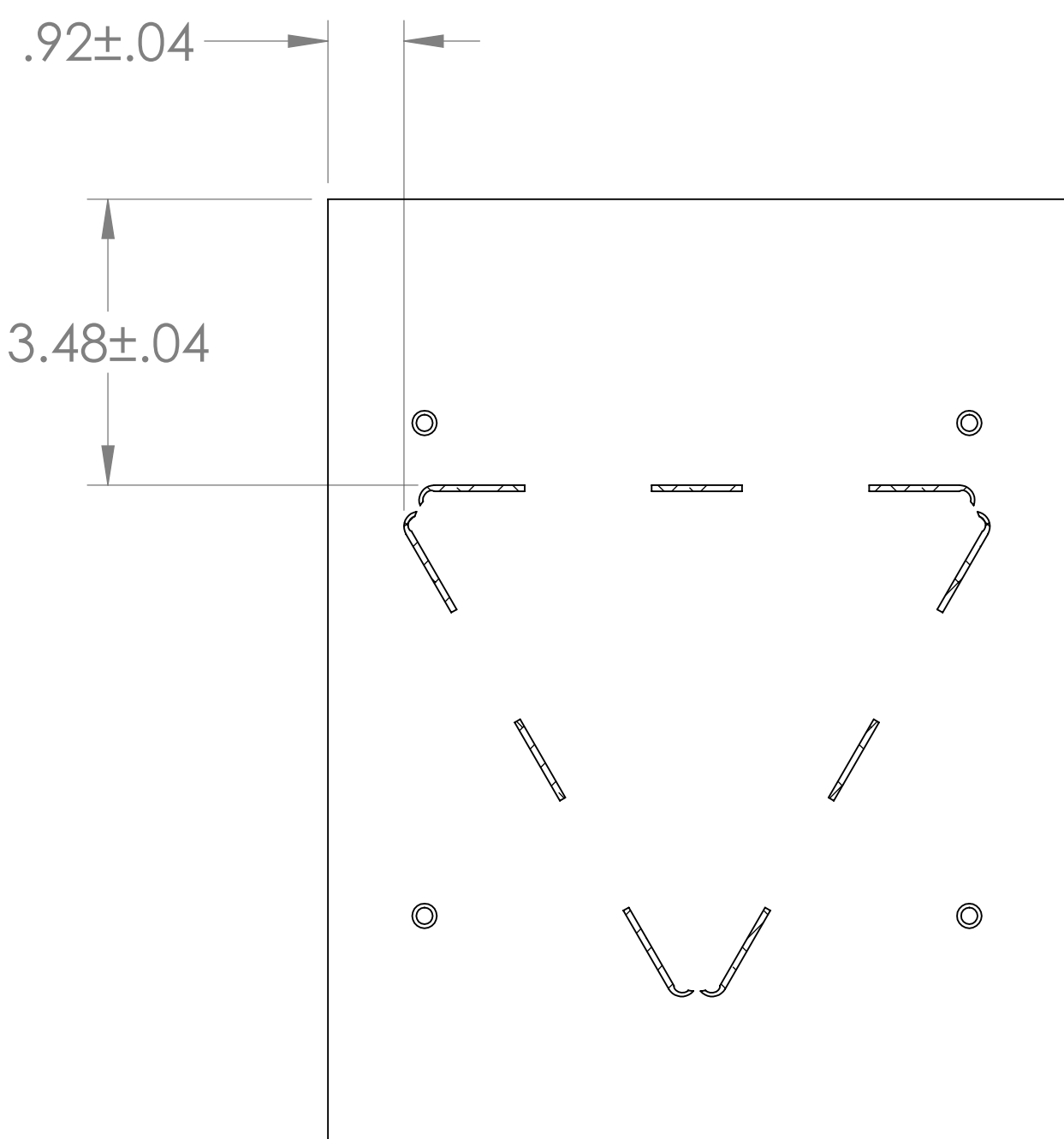
- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 AFTER COMPLETION OF THE WELDMENT, MACHINE AT TOP OF ITEM 3 TO NOTED SPECIFICATIONS IF NECESSARY. LEVEL THE UPPER FACE OF ITEM 3 (SQUARE WITH MACHINING HEAD) BEFORE MACHINING.
 - ⑦ FASTEN ITEMS 2 TO D1000434 FOOTING BEFORE APPLYING NOTED WELDS, TO ENSURE ALIGNMENT. FOR EACH ITEM 2, USE THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN FOOTING. FOOTING MUST BE REMOVABLE & RE-ATTACHABLE POST-WELD, WITH NO BINDING OF SCREWS. TO BE DELIVERED WITH FOOTING ATTACHED.
 - ⑧ WARPAGE OF ITEMS 2, 3, & FOOTING TO BE MINIMIZED USING PREFERRED METHODS, IE. HEAT SINKING.

REV.	DATE	DCN #	DRAWING TREE #
v1	05 AUGUST 2010	E1000182-v1	-
-	-	-	-
-	-	-	-

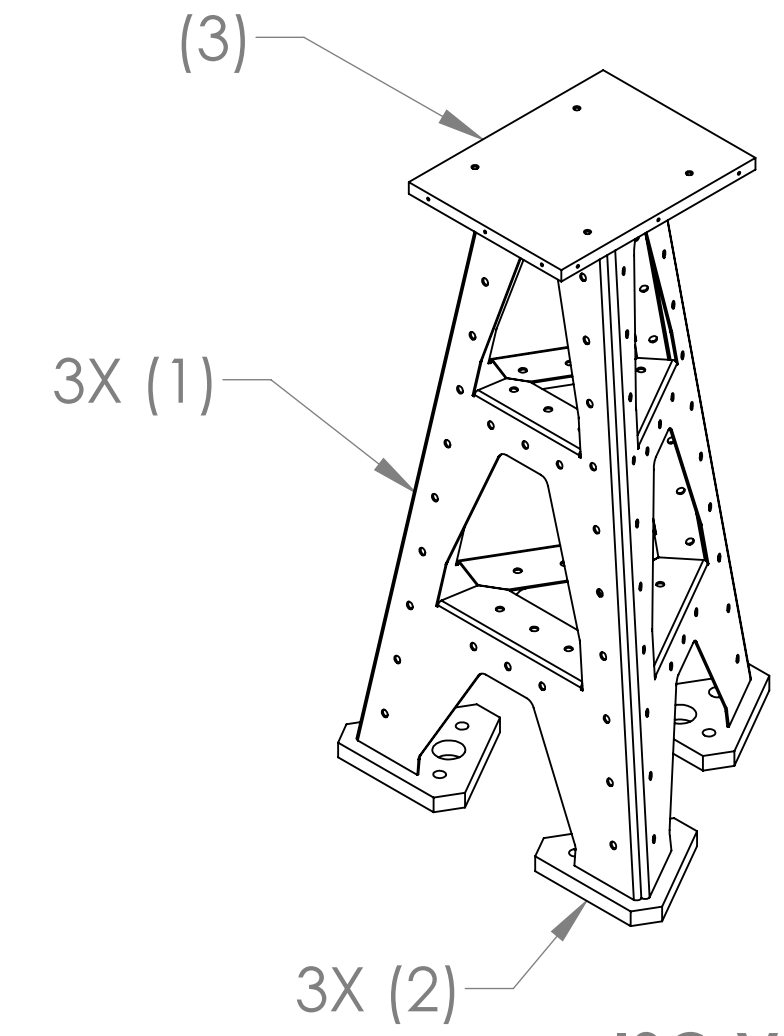
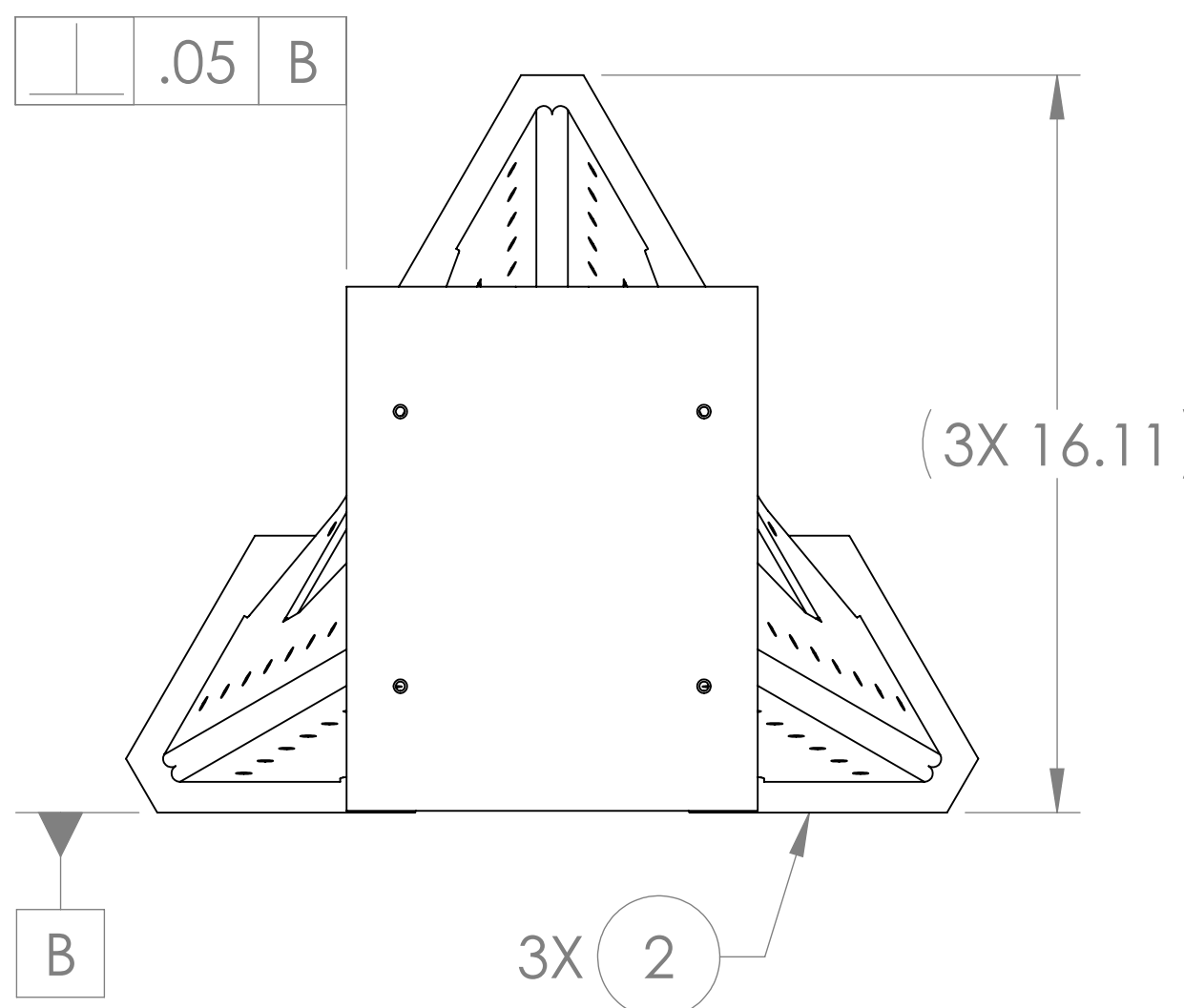


FILLET WELD ALL ITEM 1 / ITEM 2 INTERFACES (OUTSIDE ONLY) ALL THREE LOCATIONS

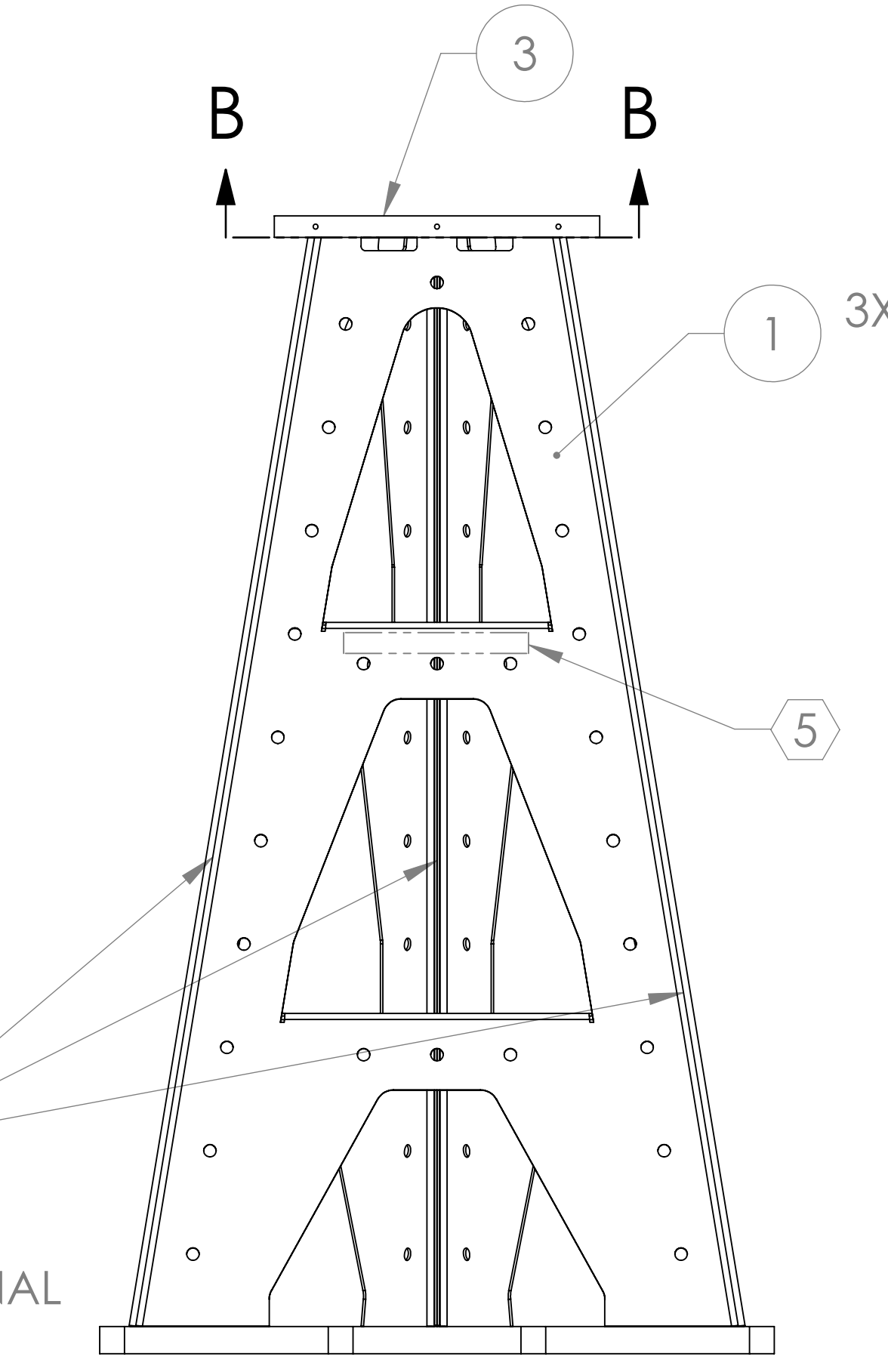
SECTION A-A



SECTION B-B
SCALE 1 : 2

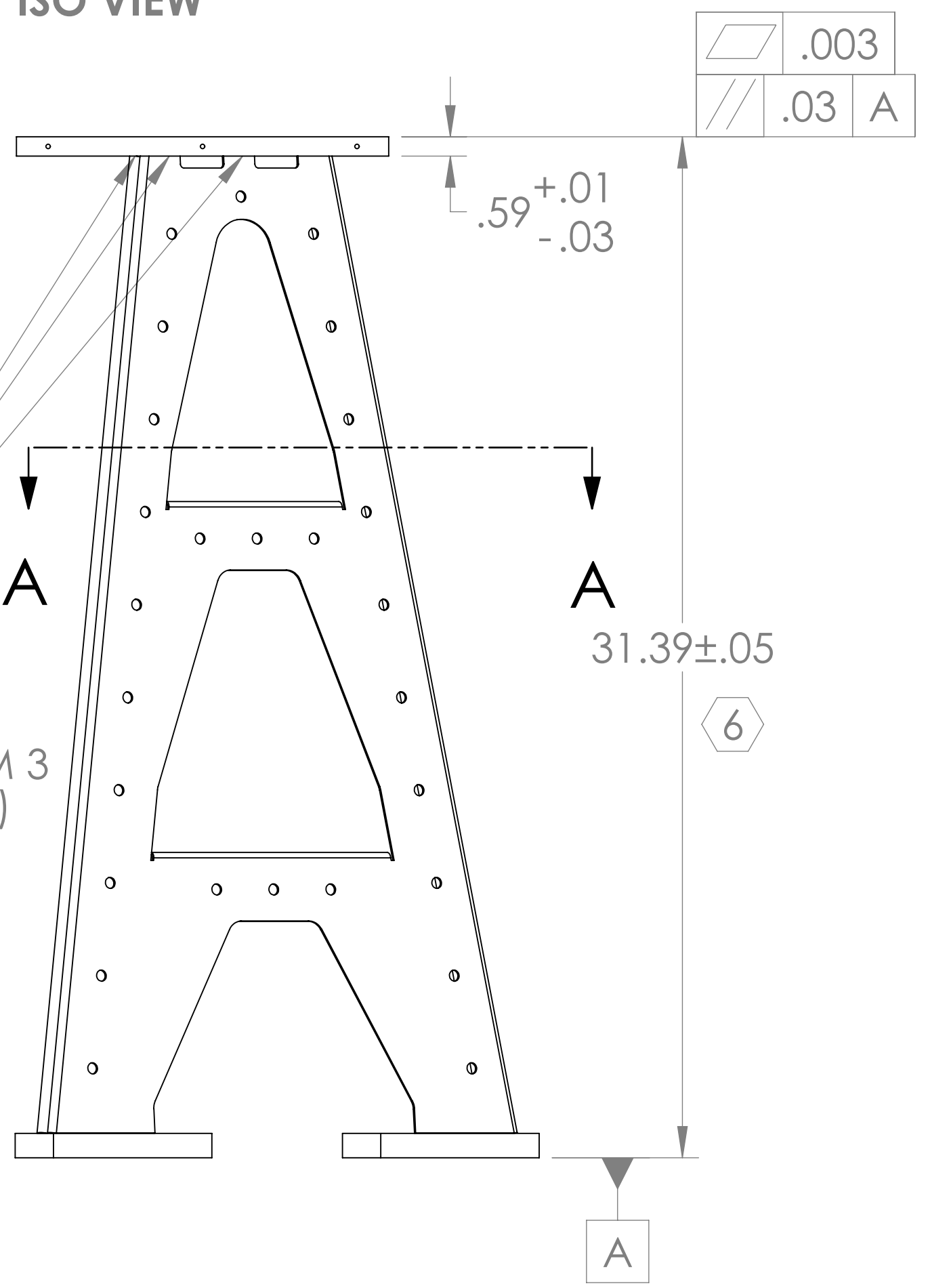


ISO VIEW



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

FILLET WELD ALL ITEM 1 / ITEM 3 INTERFACES (OUTSIDE ONLY) ALL THREE LOCATIONS



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES	TOLERANCES:	ANGULAR ± N/A°
.XX ± N/A	.XXX ± N/A	
MATERIAL	FINISH	
N/A	N/A μinch	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1001851

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Q/LL O/RE Q	SPARE	TOTAL
3	D1001611-1	ALIGO AOS OPLEV TRX PIER TABLE (HAM)	304 SSSL	1		0
2	D1000426	ALIGO AOS PIER BASE 1	304 SSSL	3		0
1	D1001853	ALIGO AOS OPLEV TRX PIER SIDE PANEL (HAM-LLO)	304 SSSL	3		0

PARTS LIST

PART NAME		DESIGNER	DATE	SIZE	DWG. NO.	REV.
ALIGO AOS OPLEV TRX PIER WELDMENT (HAM)		C. CONLEY	5 AUG 2010	D	D1001854	v1
DRAFTER	CHECKER	APPROVAL				
N. KILPATRICK						

SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1001854.dwg: AOS Oplev Trx Pier Weldment (HAM-LLO). PART PDM REV: X-003. DRAWING PDM REV: X-007