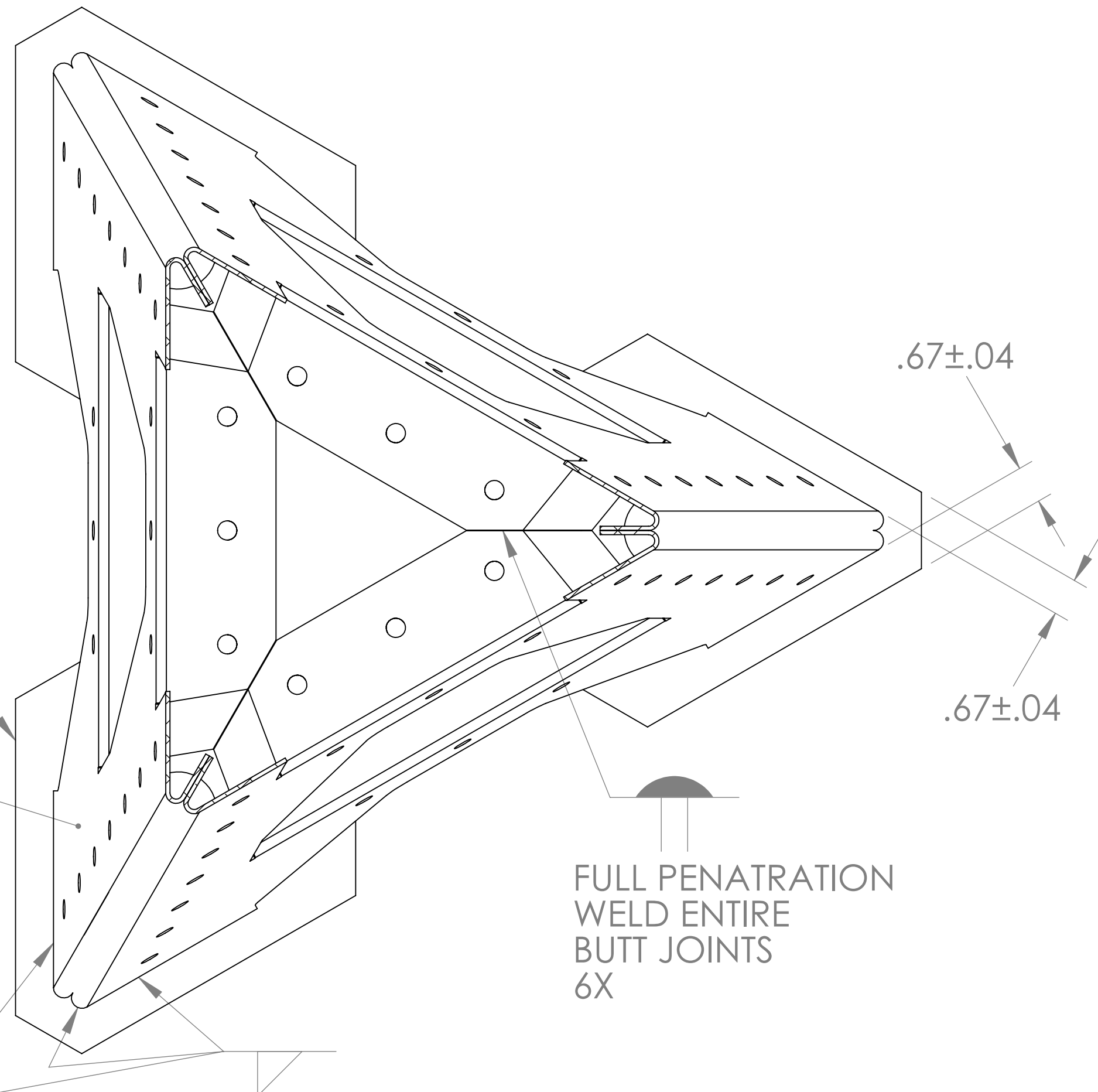


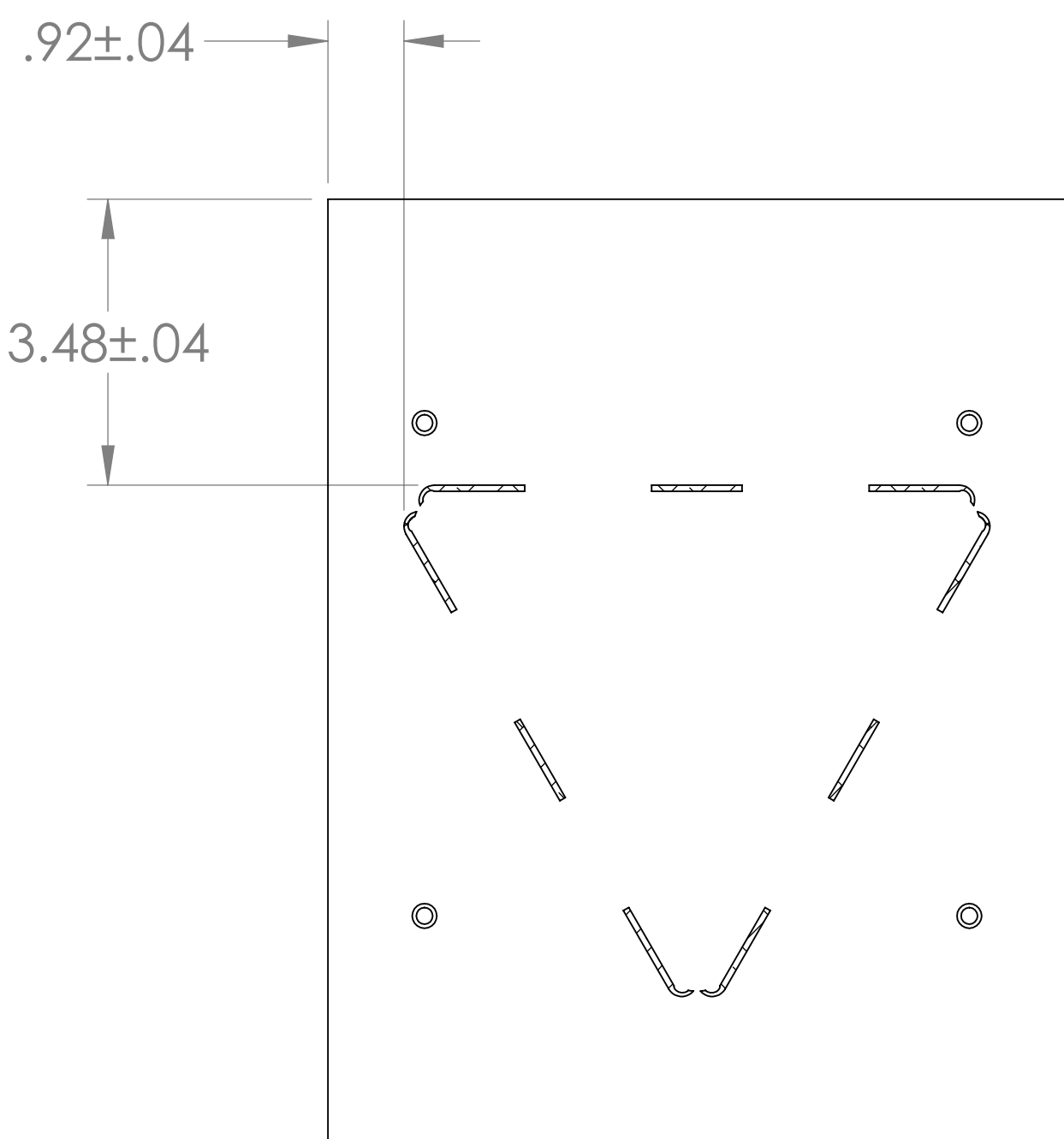
- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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	-
-	-	-	-
-	-	-	-

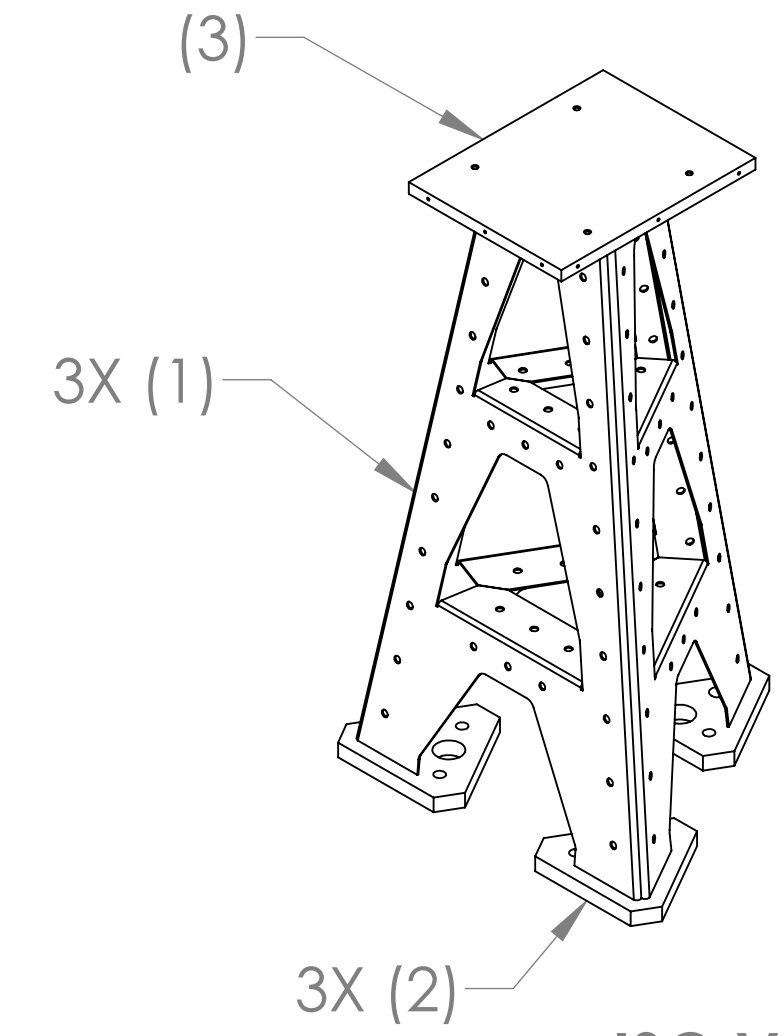
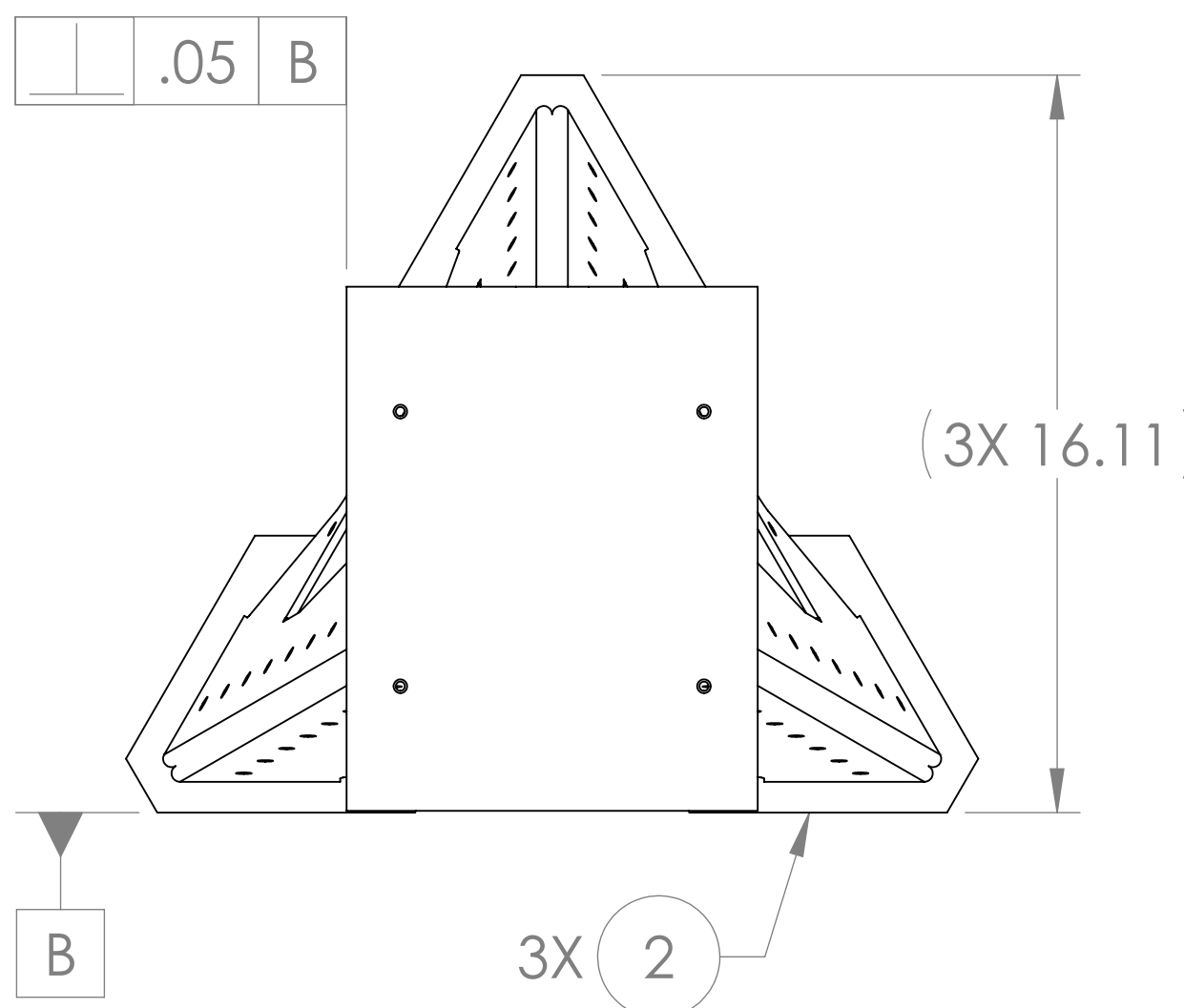


FILLET WELD ALL ITEM 1 / ITEM 2 INTERFACES (OUTSIDE ONLY) ALL THREE LOCATIONS

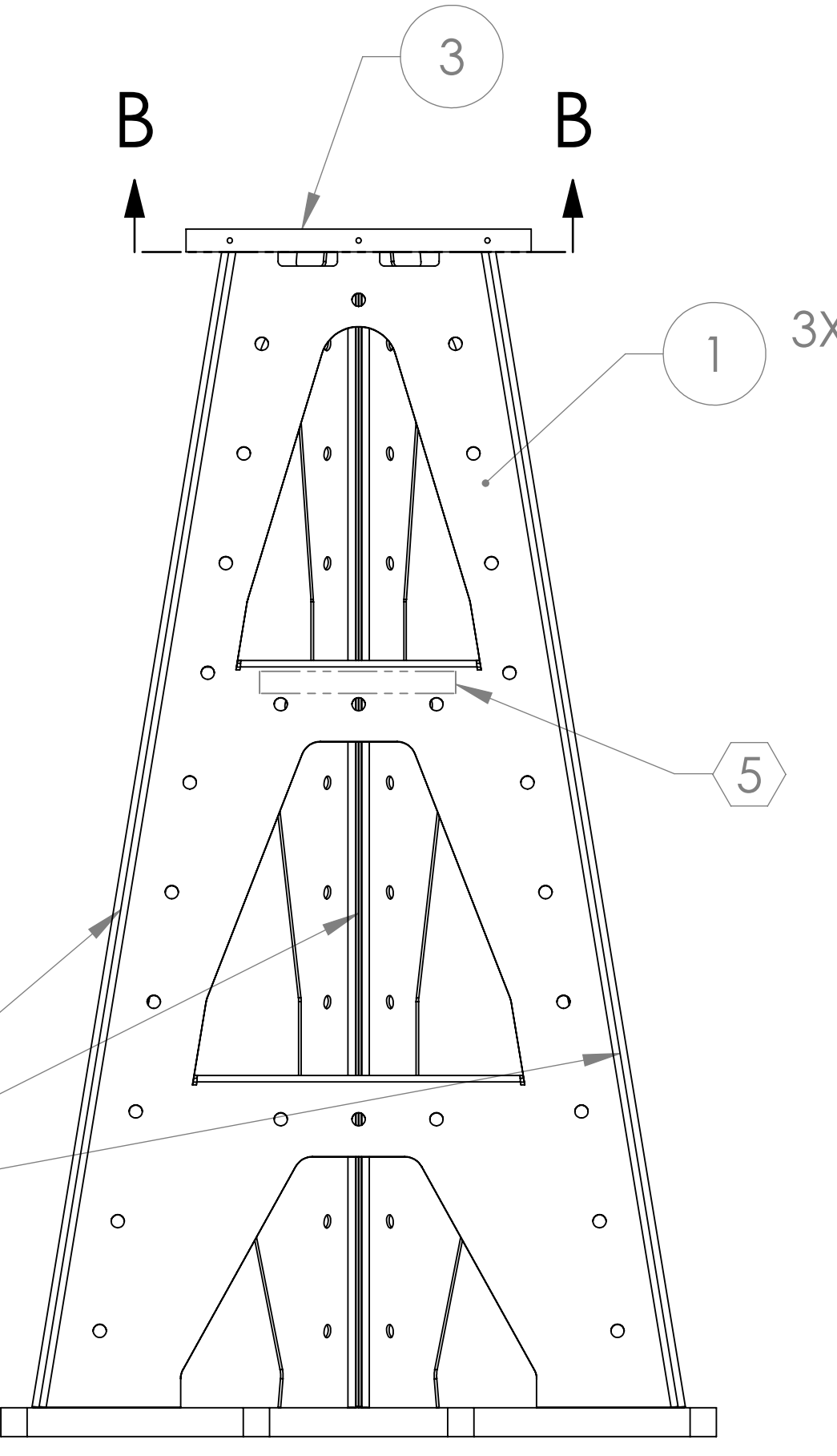
⑦ ⑧ SECTION A-A



SECTION B-B
SCALE 1 : 2



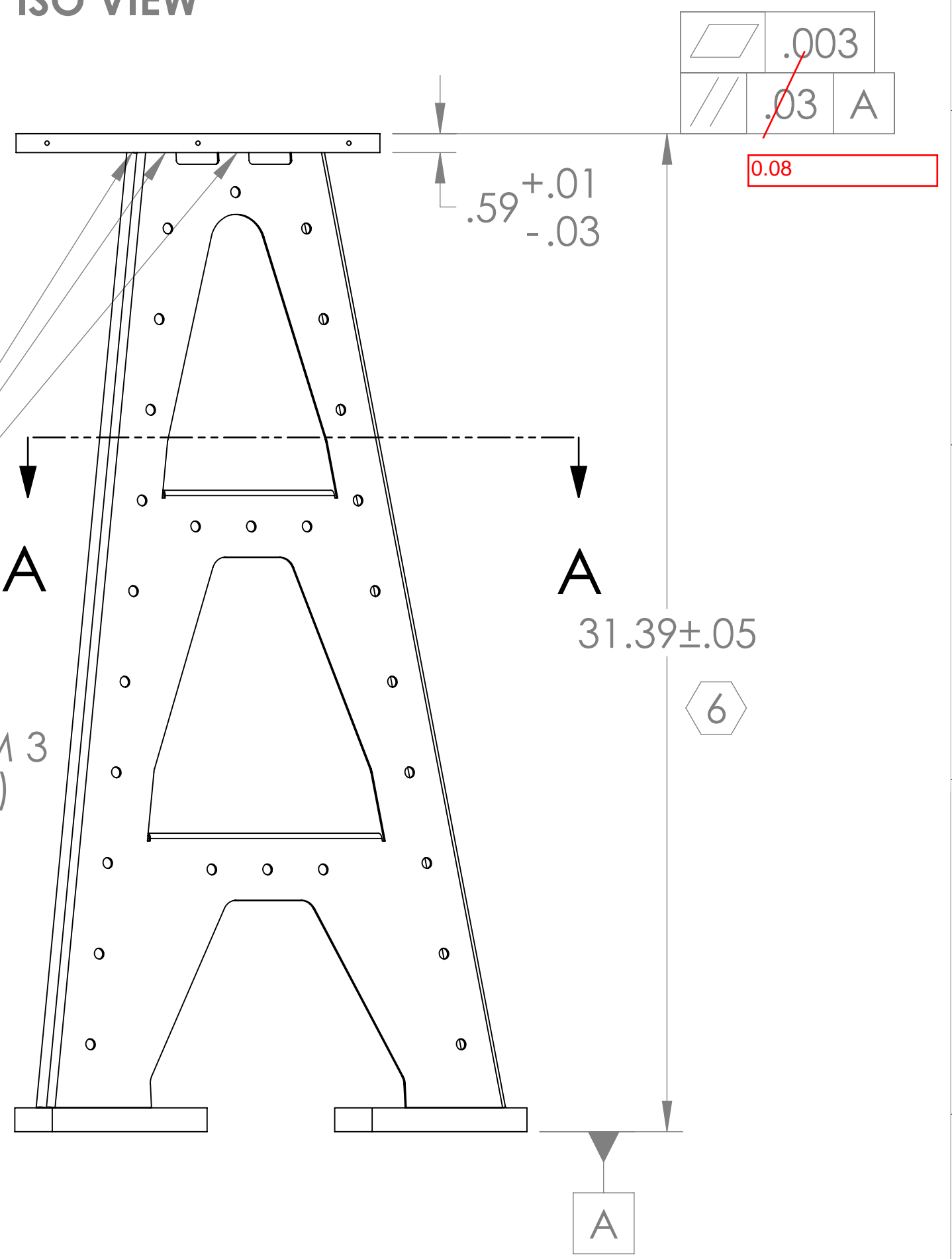
ISO VIEW



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

⑧



.003
.03 A
0.08

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY	0/LL O 0/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

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± N/A .XXX ± N/A	
ANGULAR ± N/A°	
MATERIAL	FINISH
N/A	N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D1001851	

PART NAME		ALIGO AOS	
OPLEV TRX PIER WELDMENT (HAM)		DWG. NO.	
DESIGNER	C. CONLEY	DATE	5 AUG 2010
DRAFTER	N. KILPATRICK	DATE	09 AUG 2010
CHECKER		SIZE	D
APPROVAL		SCALE	1:4
		PROJECTION	
		SHEET	1 OF 1

REV. V2

D1001853.dwg: AOS Oplev Trx Pier Weldment (HAM-LLO). PART PDM REV: X-003. DRAWING PDM REV: X-007