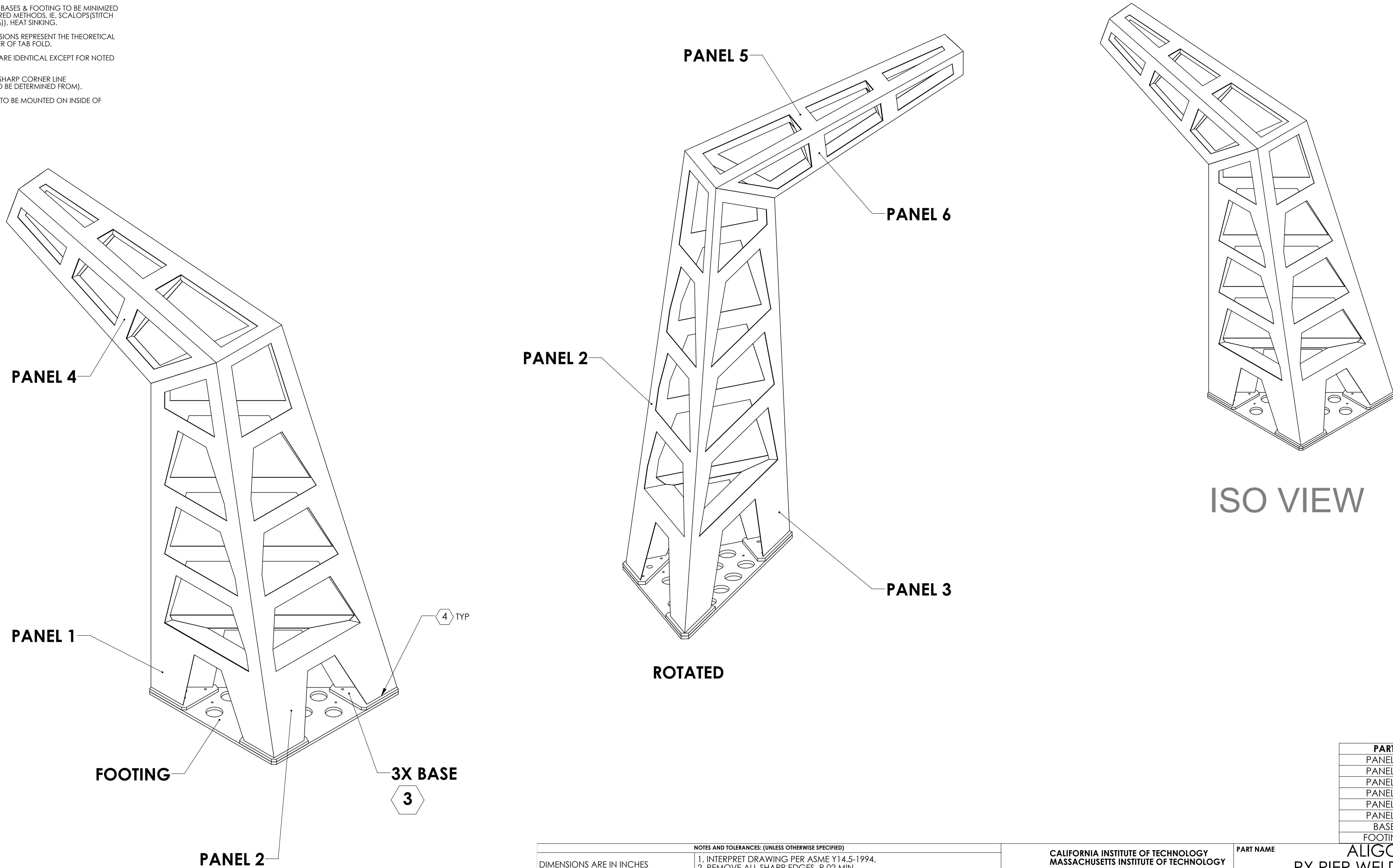


NOTES CONTINUED:

1. STRUCTURE SHOWN & DIMENSIONED WITH SHARP ADJOINING PANEL CORNERS. ACTUAL PANELS TO BE BENT SIMILARLY TO D1001292 PANELS AT ADJOINING CORNERS. DIMENSIONS TO SAID SHARP CORNERS ARE FOR ESTABLISHING STRUCTURAL SIZE & SHAPE ONLY.
2. ALL BEND RADII .125.
- ③ BASES TO BE FASTENED TO FOOTING DURING WELDING OF BASES TO PANELS. FASTEN EACH BASE USING THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN FOOTING. FOOTING MUST BE REMOVABLE & RE-ATTACHABLE. POST-WELD, WITH NO BINDING OF SCREWS. WELDMENT TO BE DELIVERED WITH FOOTING ATTACHED.
- ④ WARPAGE OF BASES & FOOTING TO BE MINIMIZED USING PREFERRED METHODS, IE. SCALOPS(STITCH WELDING (50%)), HEAT SINKING.
- ⑤ NOTED DIMENSIONS REPRESENT THE THEORETICAL SHARP CORNER OF TAB FOLD.
- ⑥ FOLDED TABS ARE IDENTICAL EXCEPT FOR NOTED DIMENSIONS.
- ⑦ THEORETICAL SHARP CORNER LINE (BEND LINES TO BE DETERMINED FROM).
- ⑧ ALL PEM NUTS TO BE MOUNTED ON INSIDE OF WELDMENT.

REV.	DATE	DCN #	DRAWING TREE #
v1	18 AUG 2010	E1000182-v1	-
v2	2 DEC 2010	E1000182-v2	-
-	-	-	-



ISO VIEW

ROTATED

PART	MATERIAL	FINISH
PANEL 1	304 SST SHEET, 12 GAUGE	STOCK FINISH/AS RECEIVED
PANEL 2		
PANEL 3		
PANEL 4		
PANEL 5		
PANEL 6		
BASE	304 SSTL	63 micro inch
FOOTING	302 SSTL	

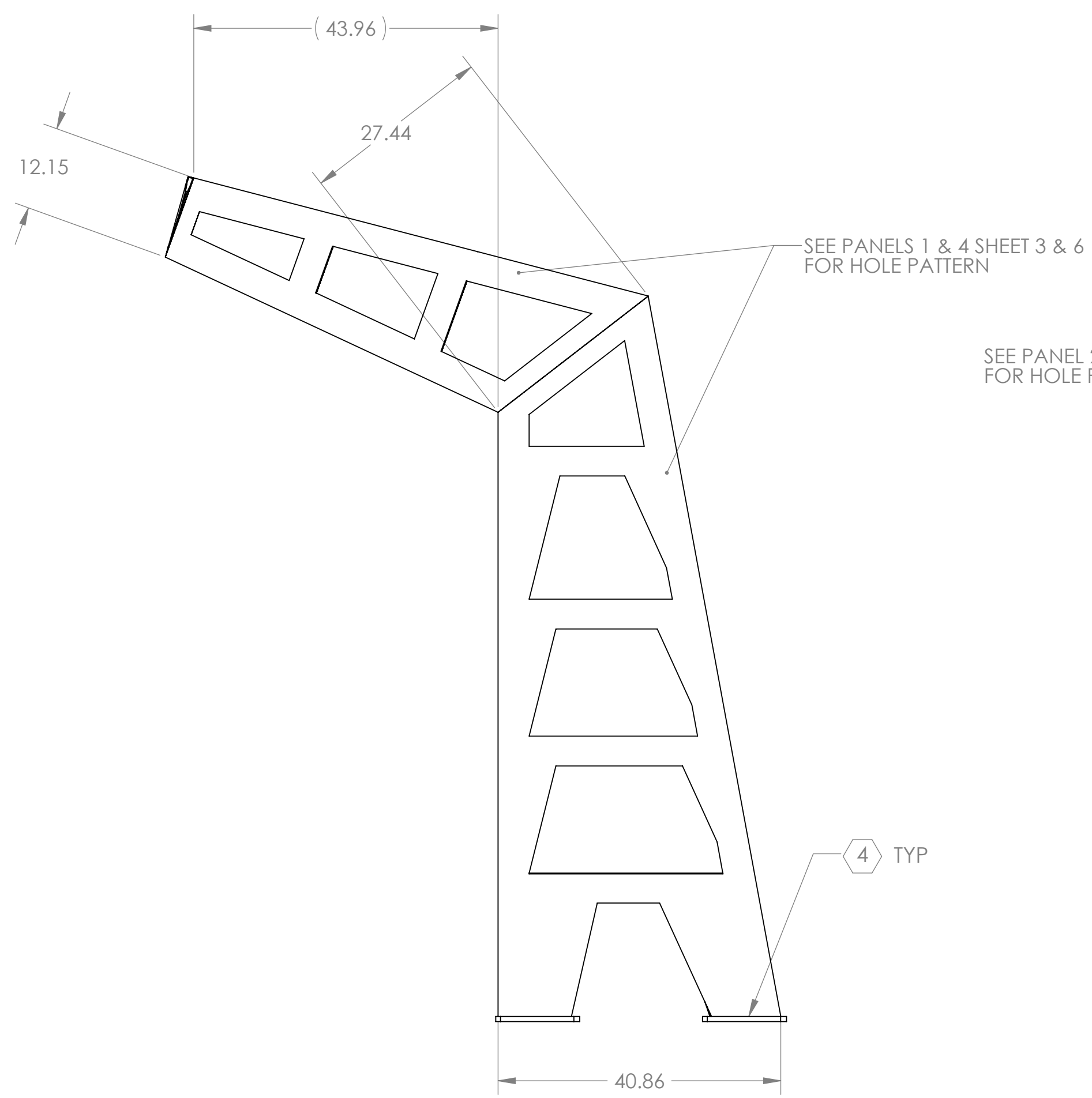
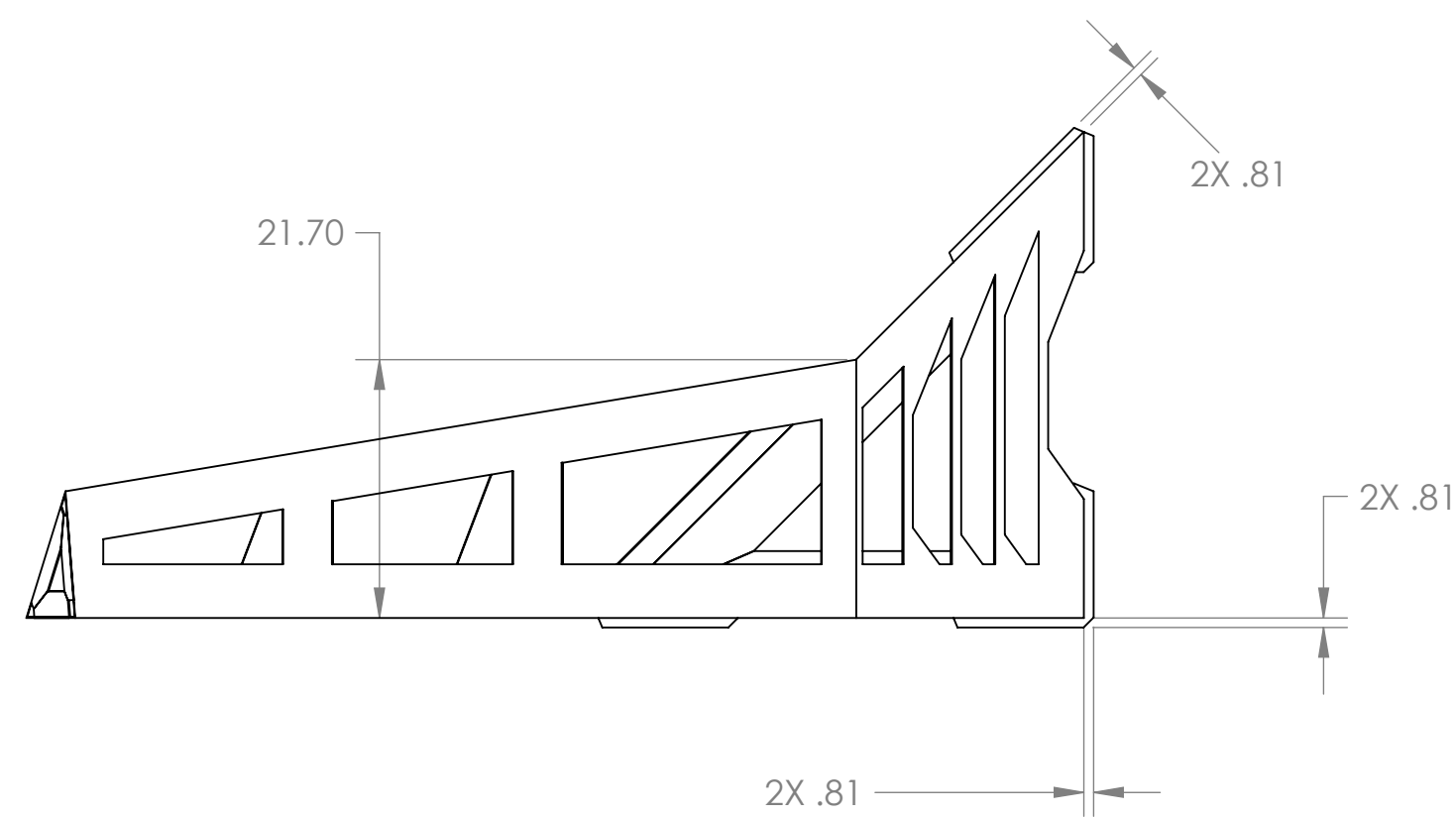
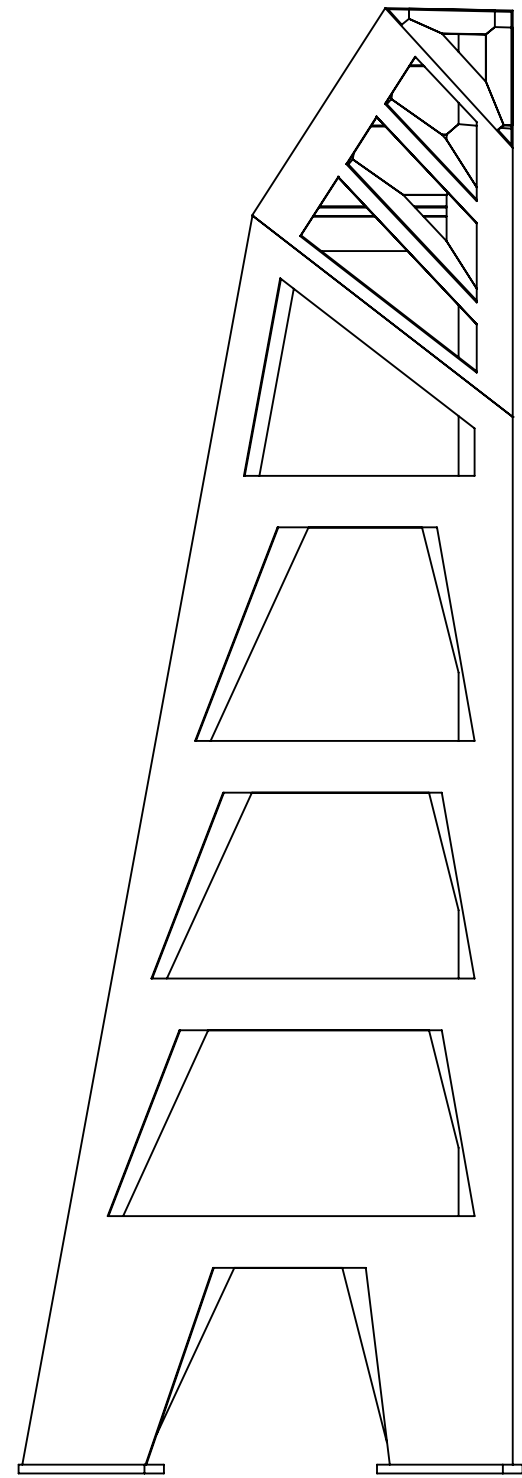
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± N/A °		MATERIAL REFER TO TABLE		FINISH REFER TO TABLE	
		NEXT ASSY		DESIGNER C CONLEY 29 APR 2010	
		CHECKER N. KILPATRICK 18 AUG 2010		SIZE DWG. NO. D D1002207	
		APPROVAL		REV. v2	
		SCALE: 1:12		PROJECTION:	
		SHEET 1 OF 10			

D:\002207\aligo\aos\Oplev\RX Pier Weldment LH (PR3, SR3).PART PDM.REV:K032.DRAWING PDM REV: X035

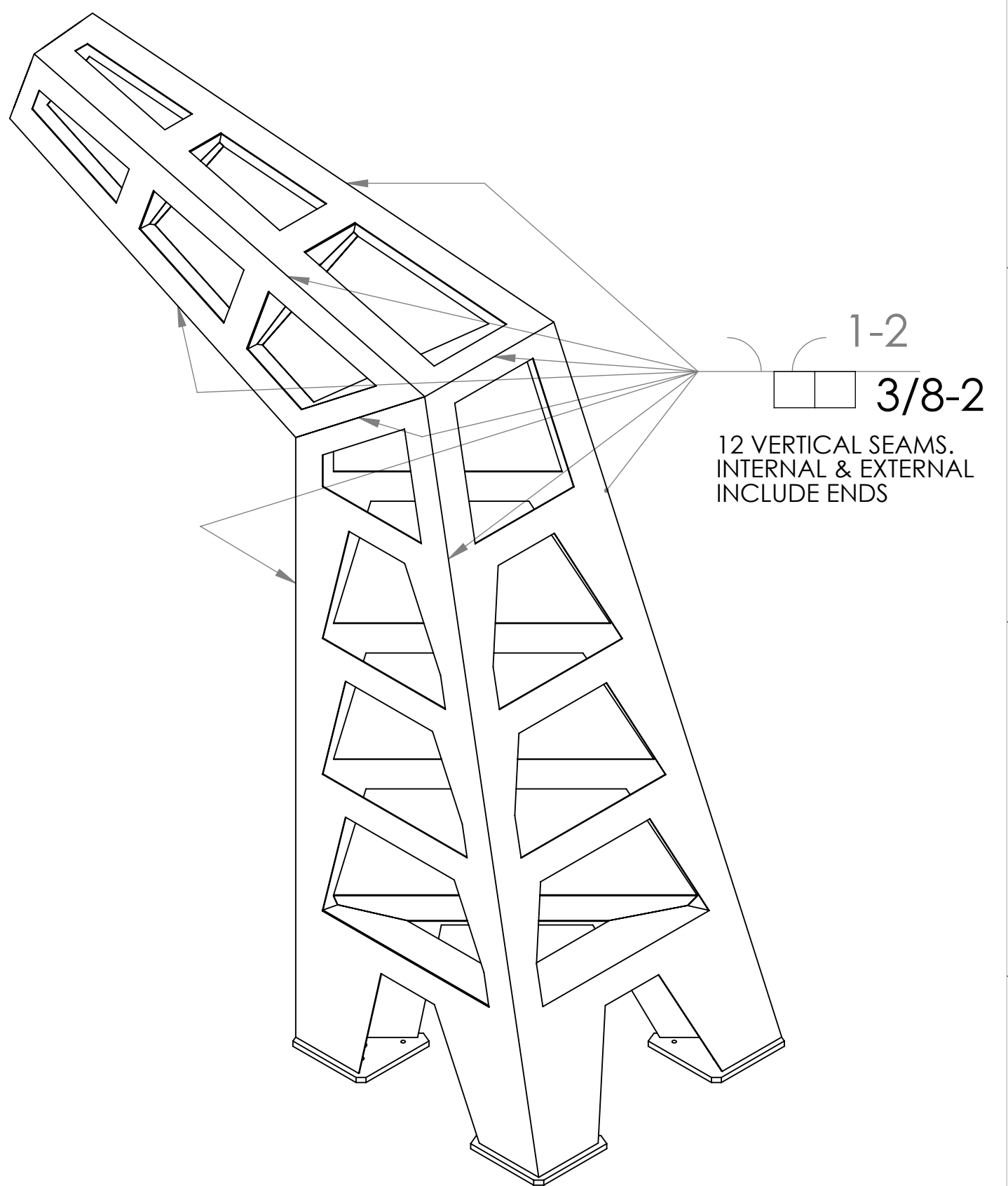
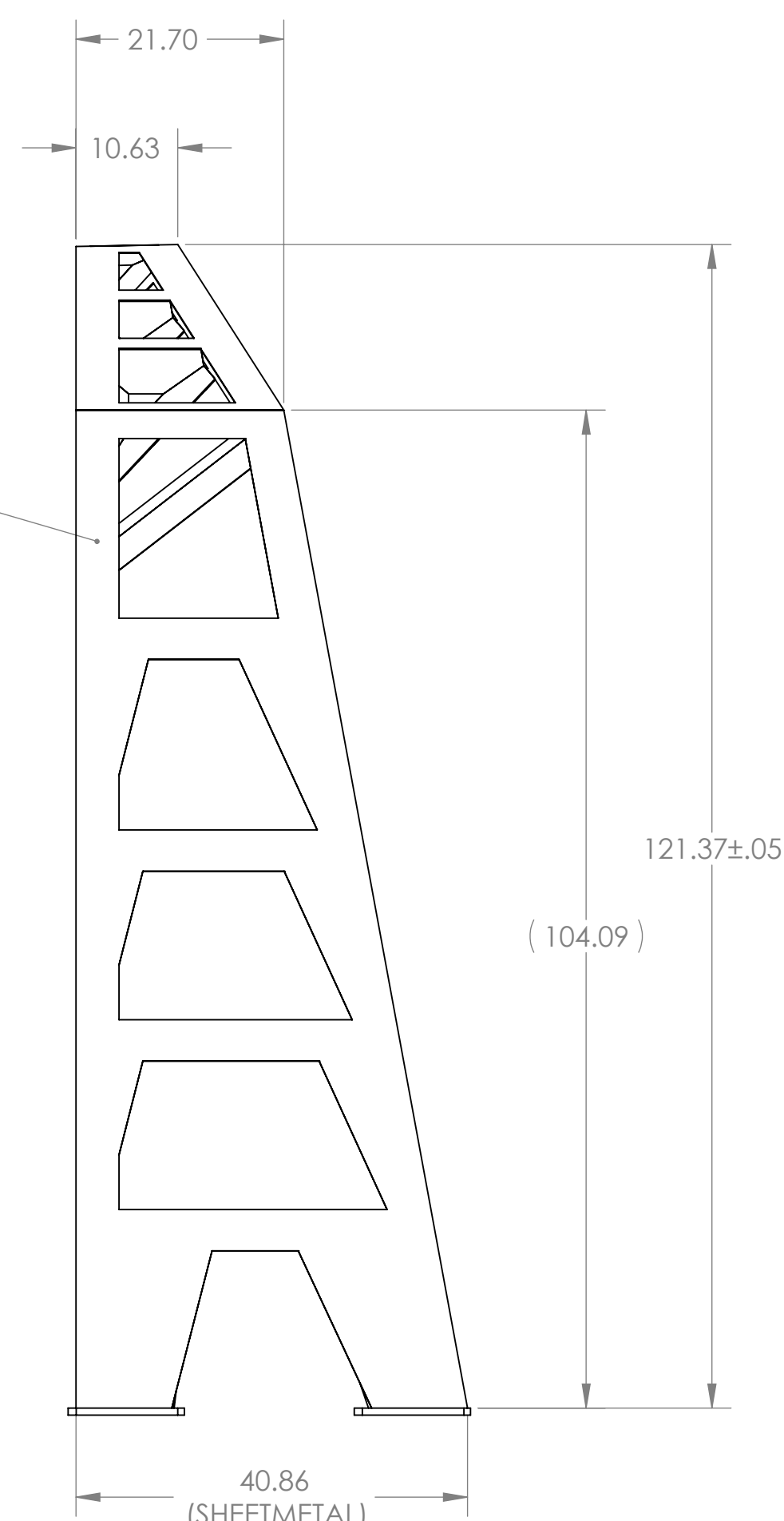
8 7 6 5 4 3 2 1

H G F E D C B A

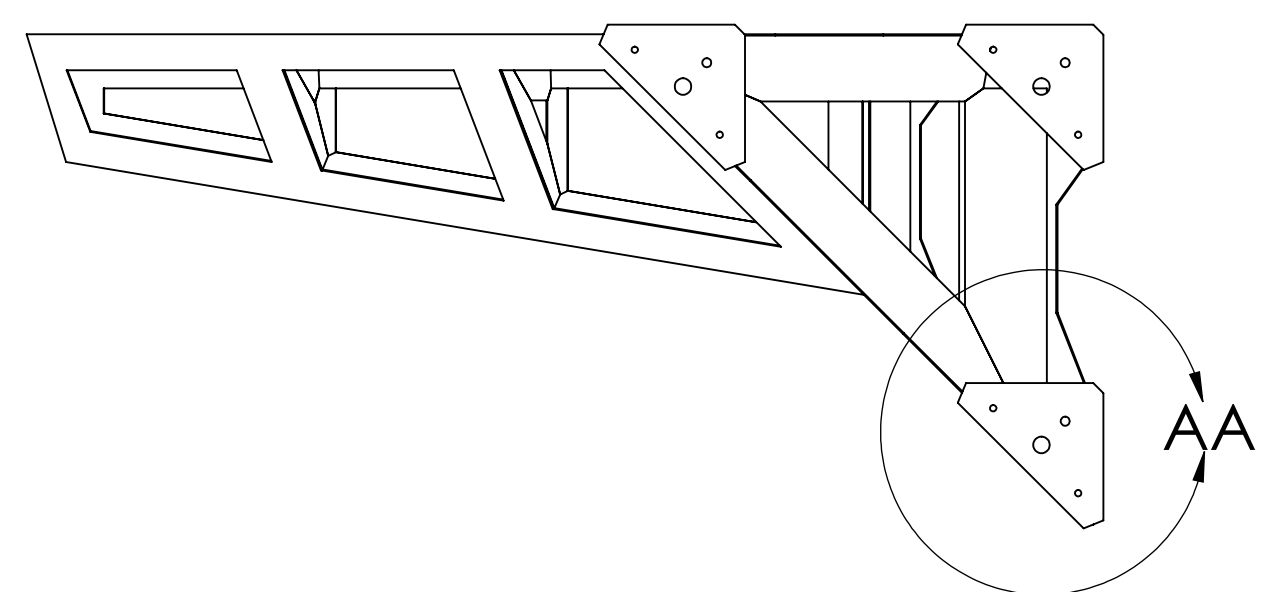
H G F E D C B A



SEE PANEL 2 SHEET 4 FOR HOLE PATTERN



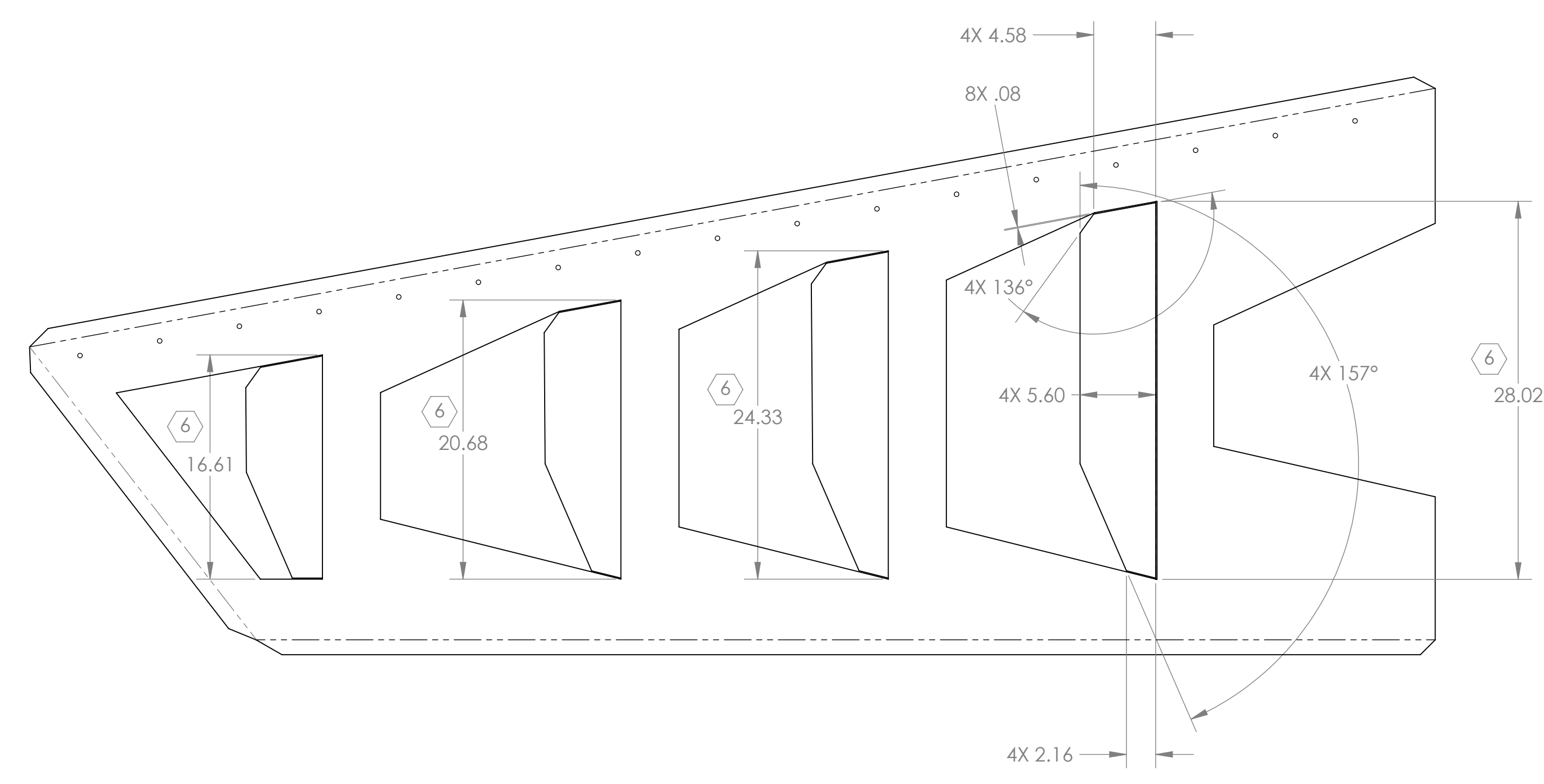
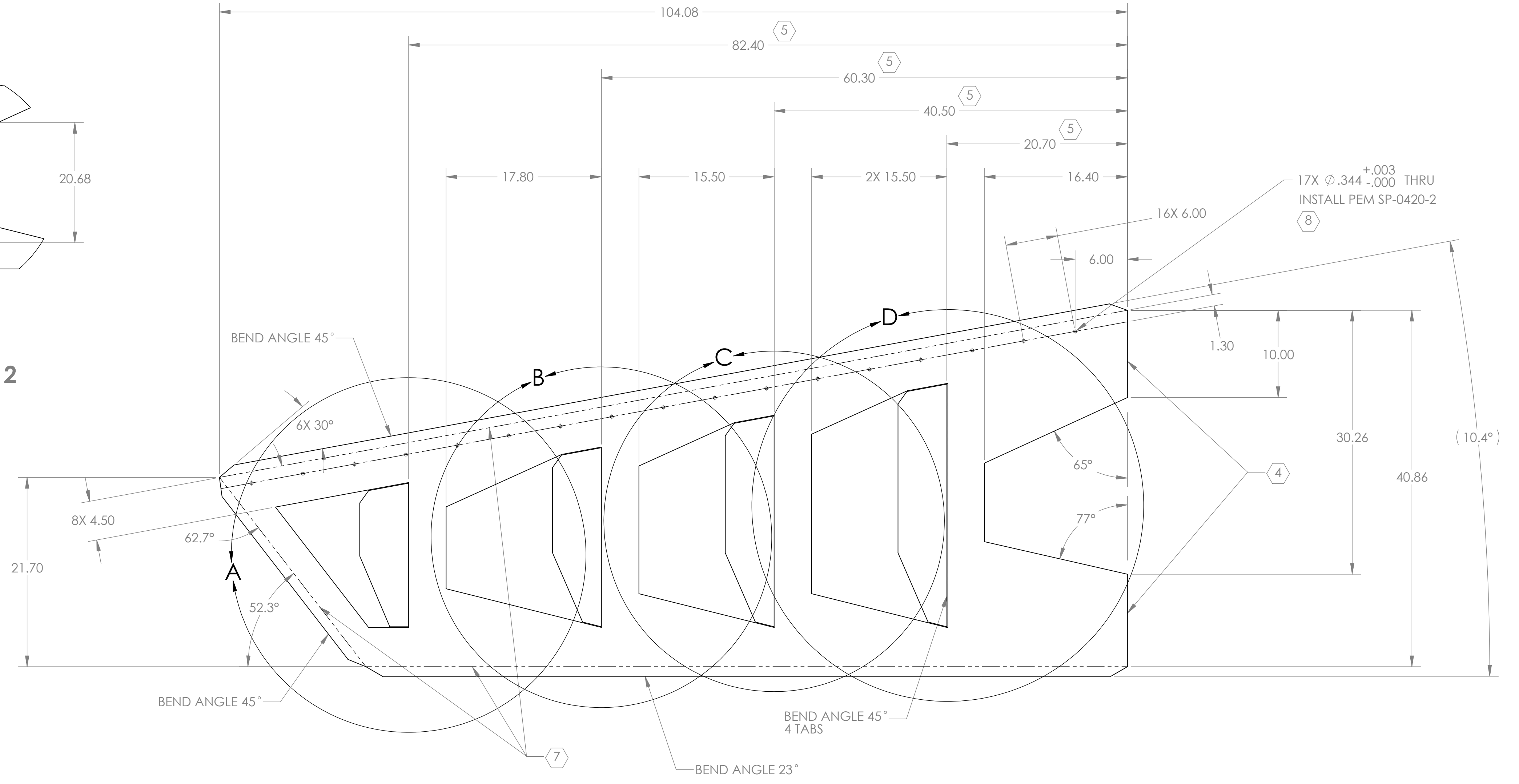
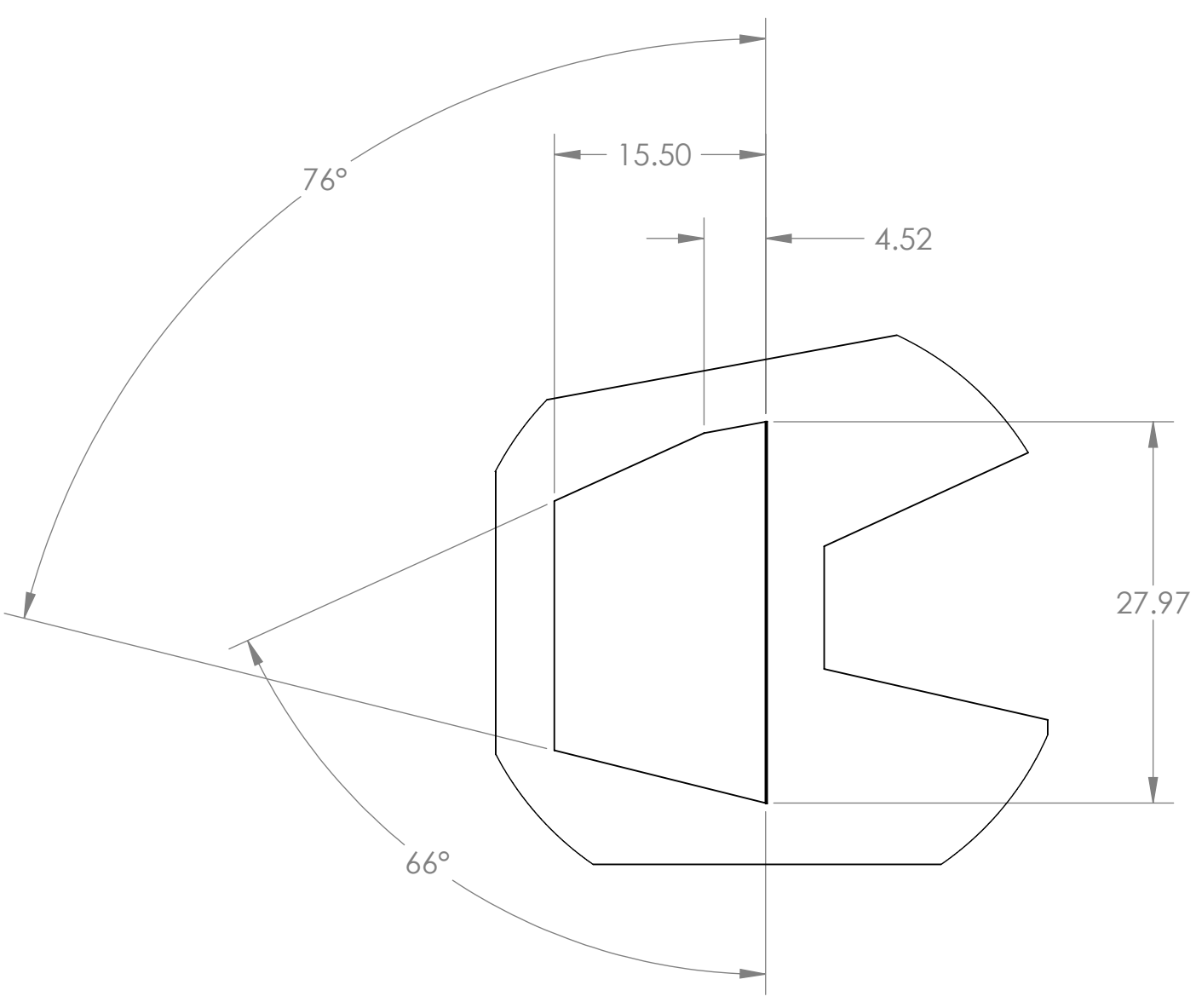
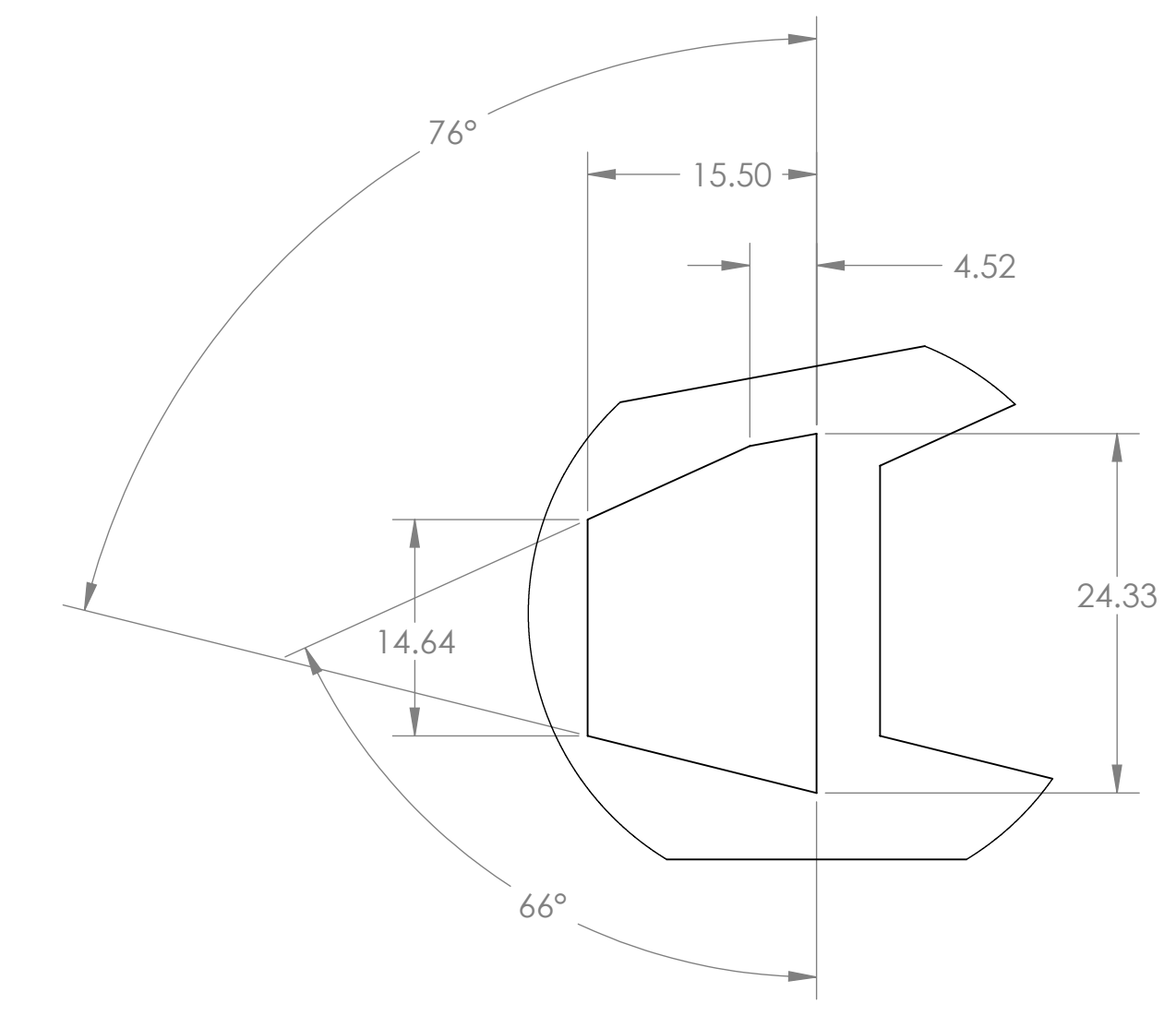
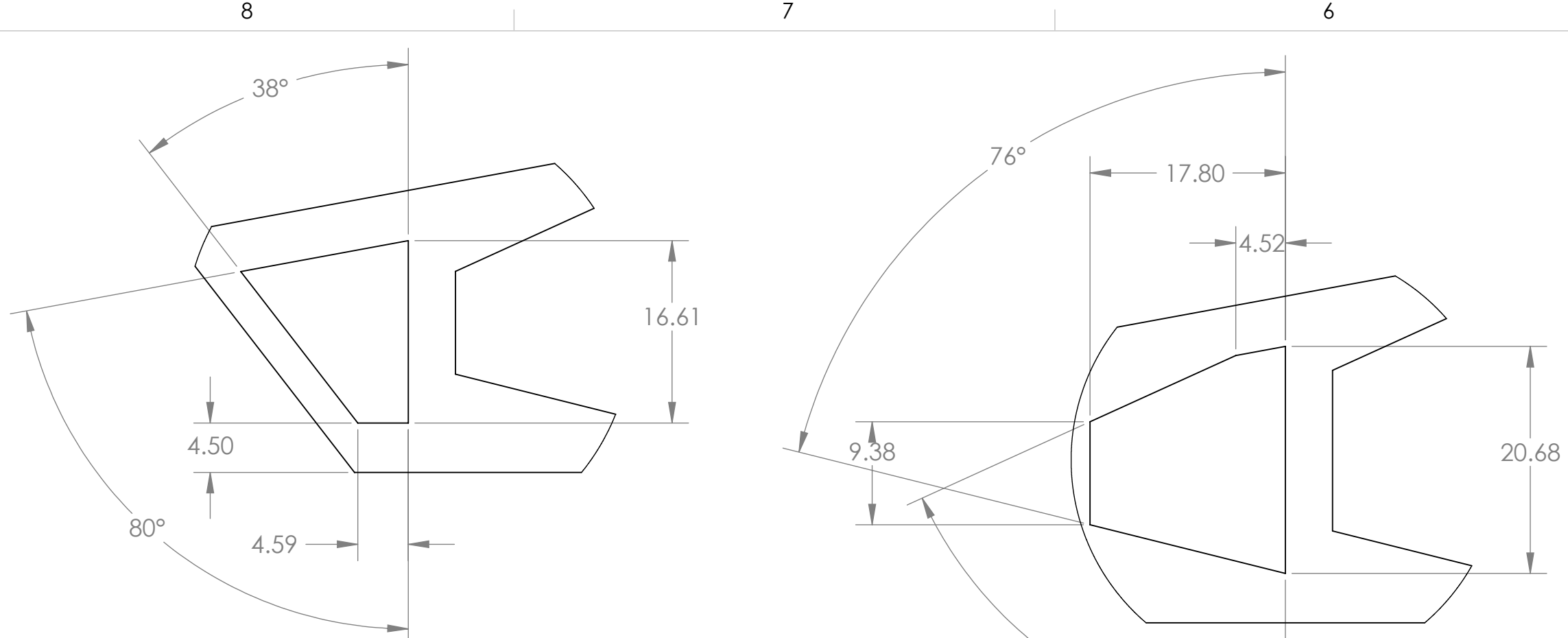
WELDMENT



REMOVE FOOTING VIEW FOR CLARITY

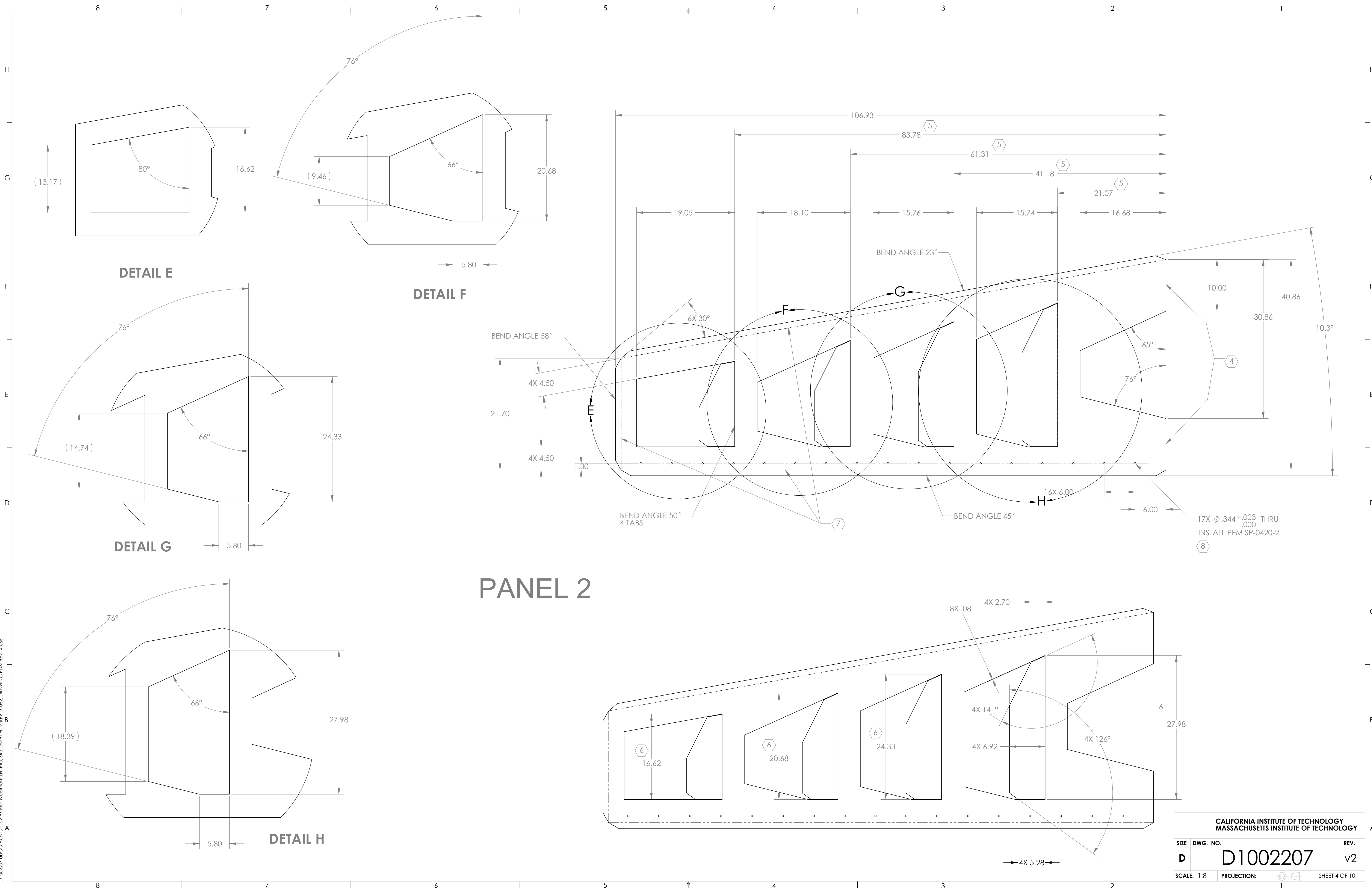
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1002207	v2
SCALE: 1:16	PROJECTION: SHEET 2 OF 10

D:\002207.dwg ACS Oct 16 10:45:10 AM P:\PDM\REV-X\022.DRAWING.PDM REV: X-035



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE DWG. NO.	D	D1002207
REV.		v2
SCALE: 1:8	PROJECTION:	SHEET 3 OF 10

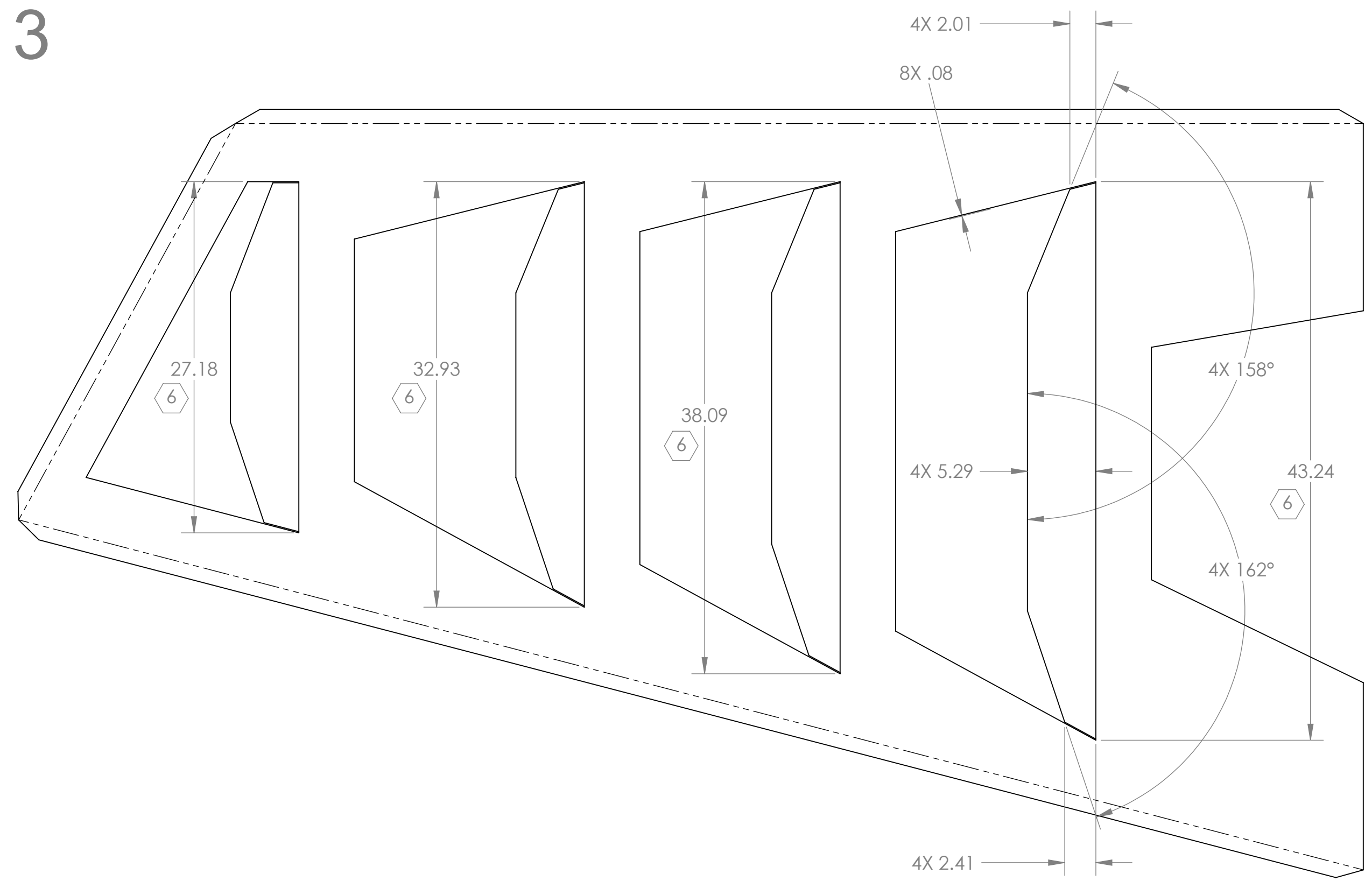
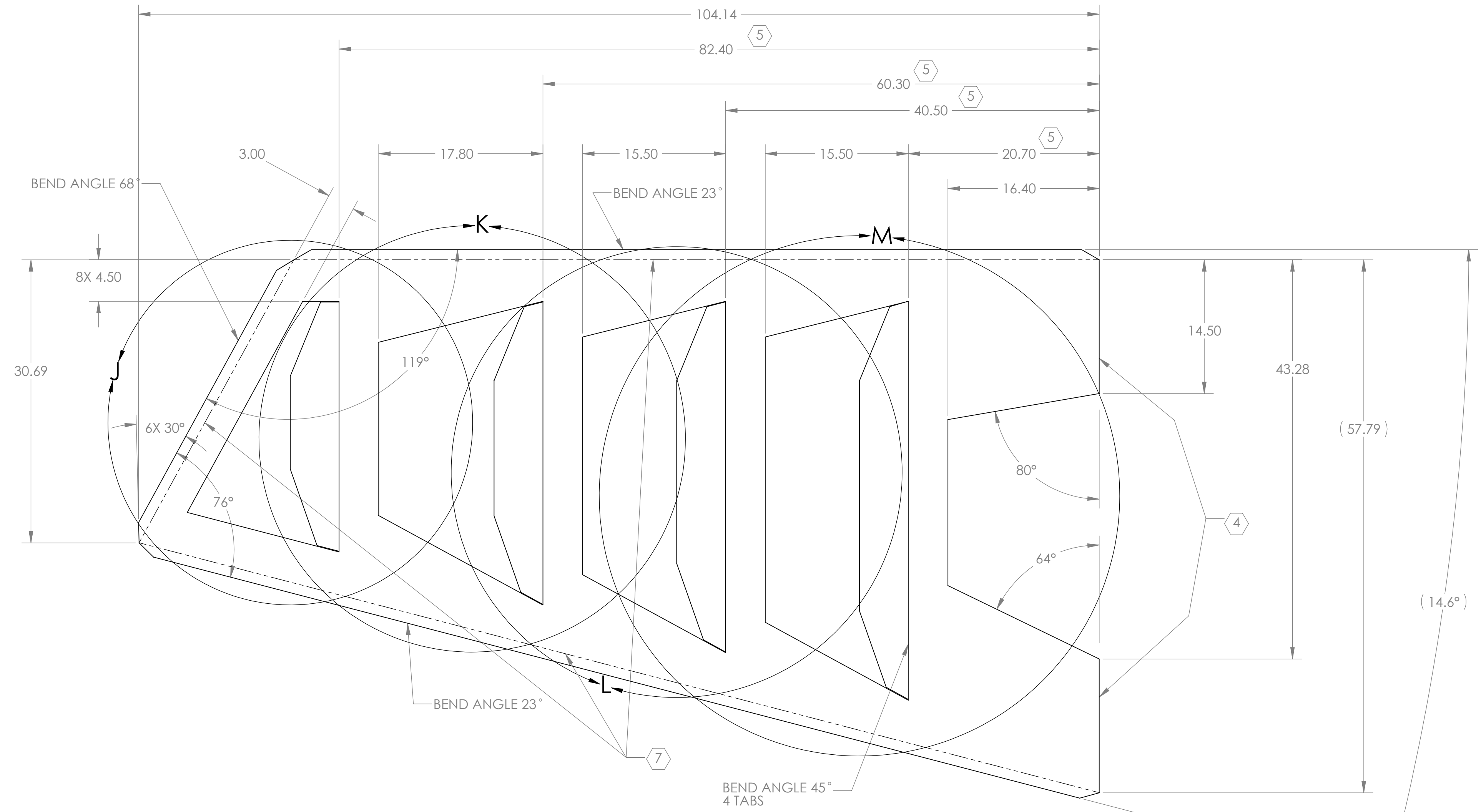
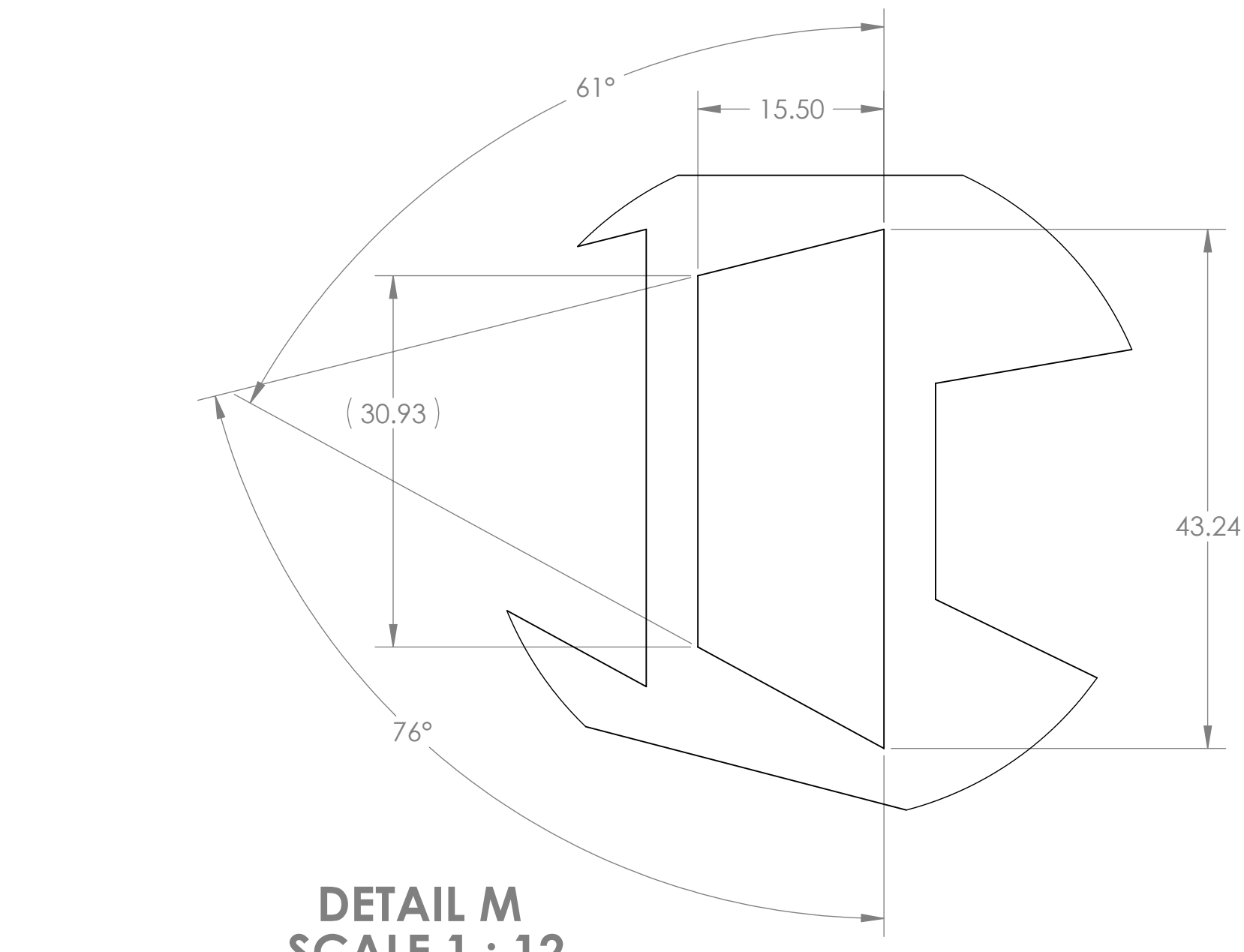
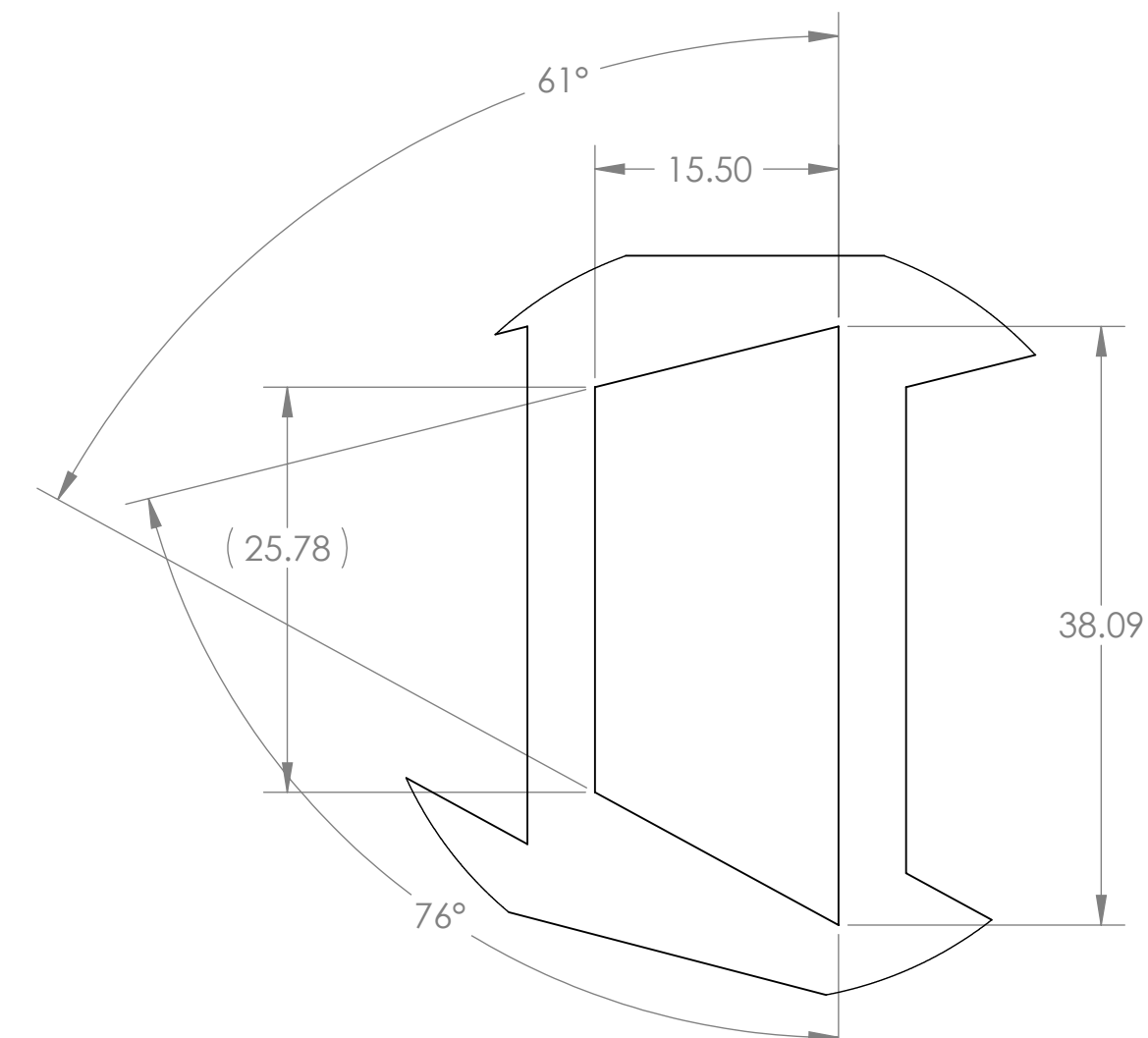
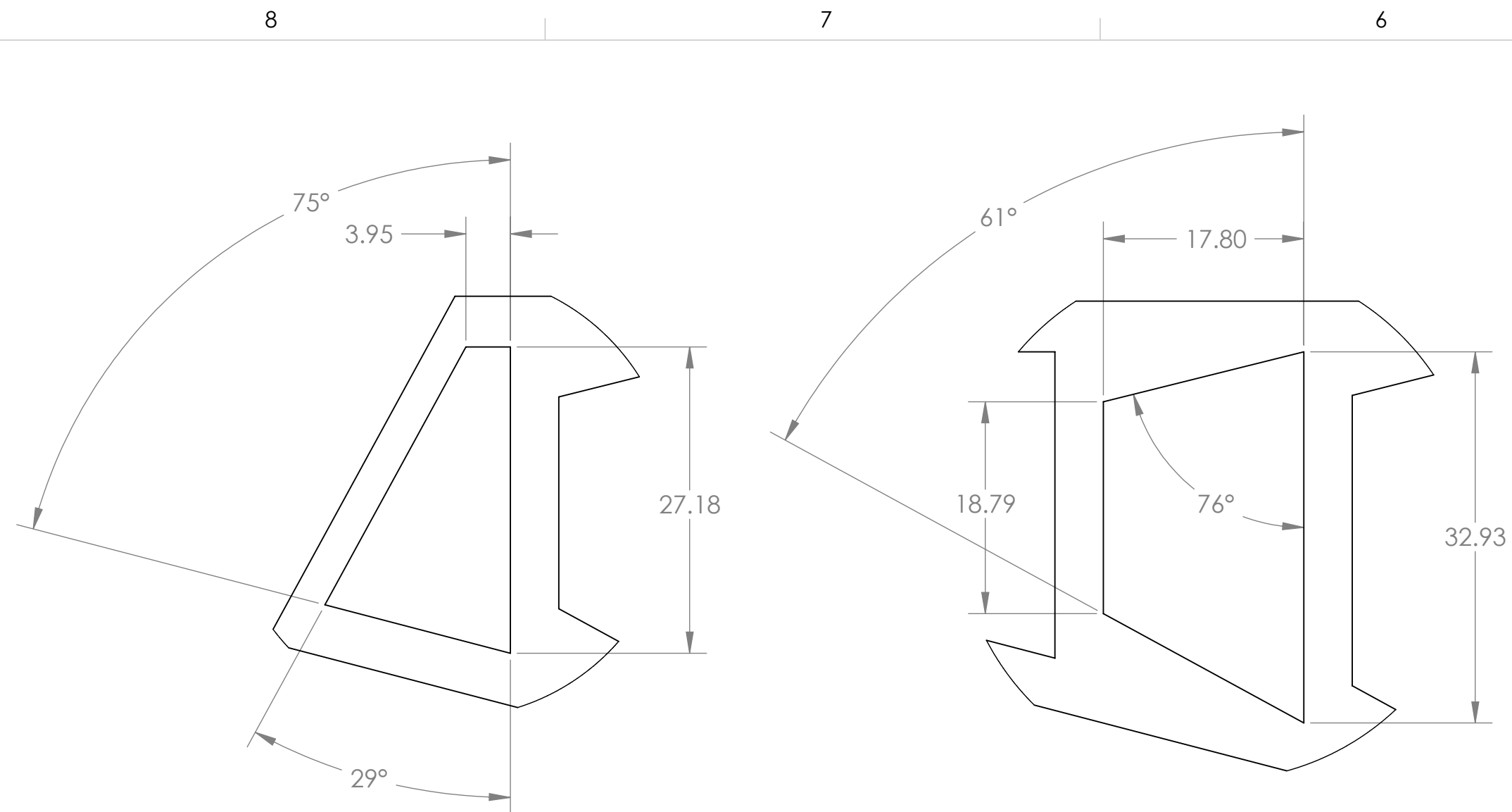
D1002207.dwg: ACS Octave: RX Pipe Weldment LH (PRL, S3), PART PDM_REV: X:02, DRAWING PDM_REV: X:03



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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

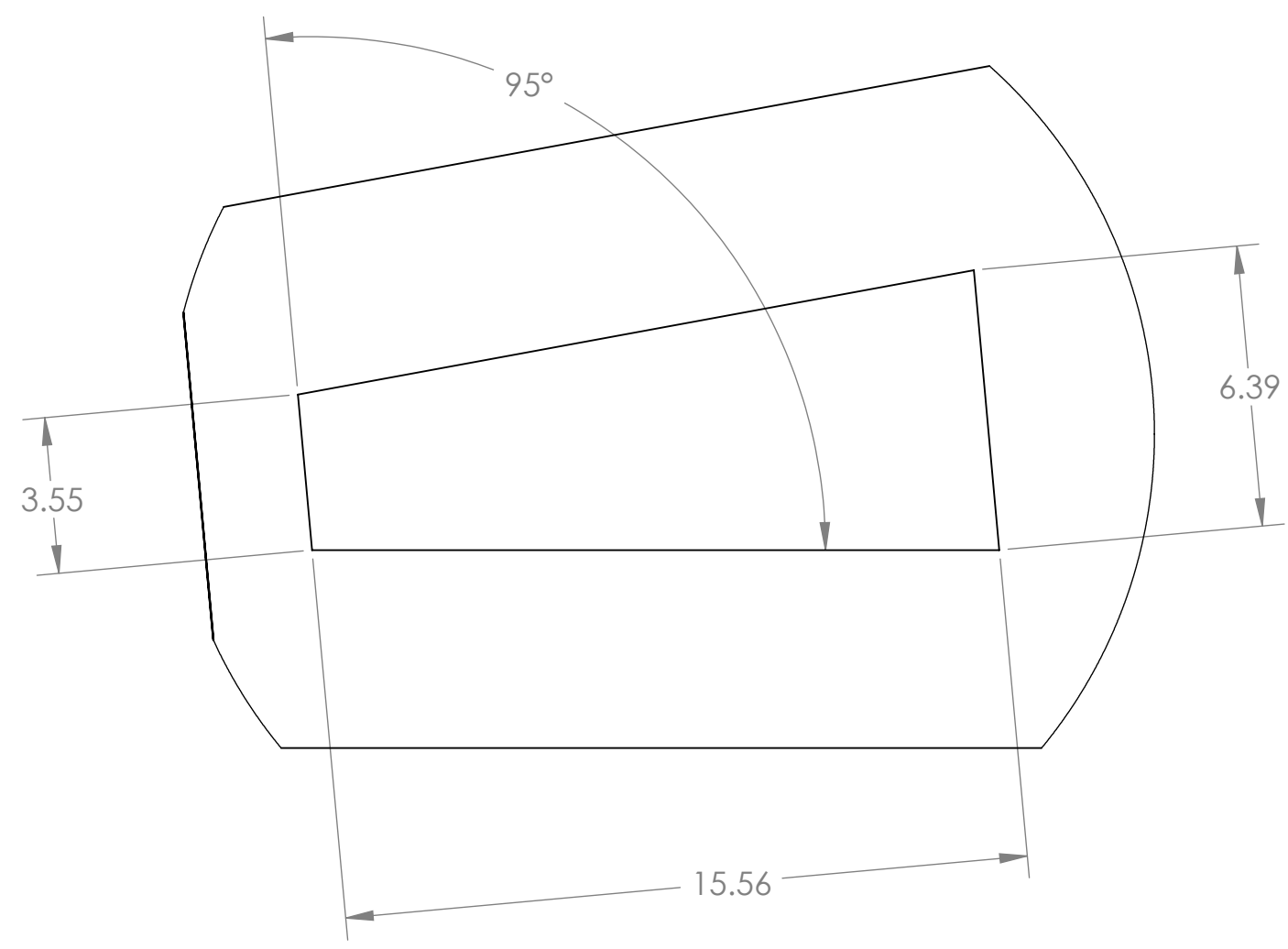
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D	D1002207	v2
SCALE: 1:8	PROJECTION:	SHEET 4 OF 10

D:\002207.dwg ACS Octave RP Pier Weldment LH (PES_5B3)_PART PDM_REV-X.032_DRAWING-PDM_REV-X.035

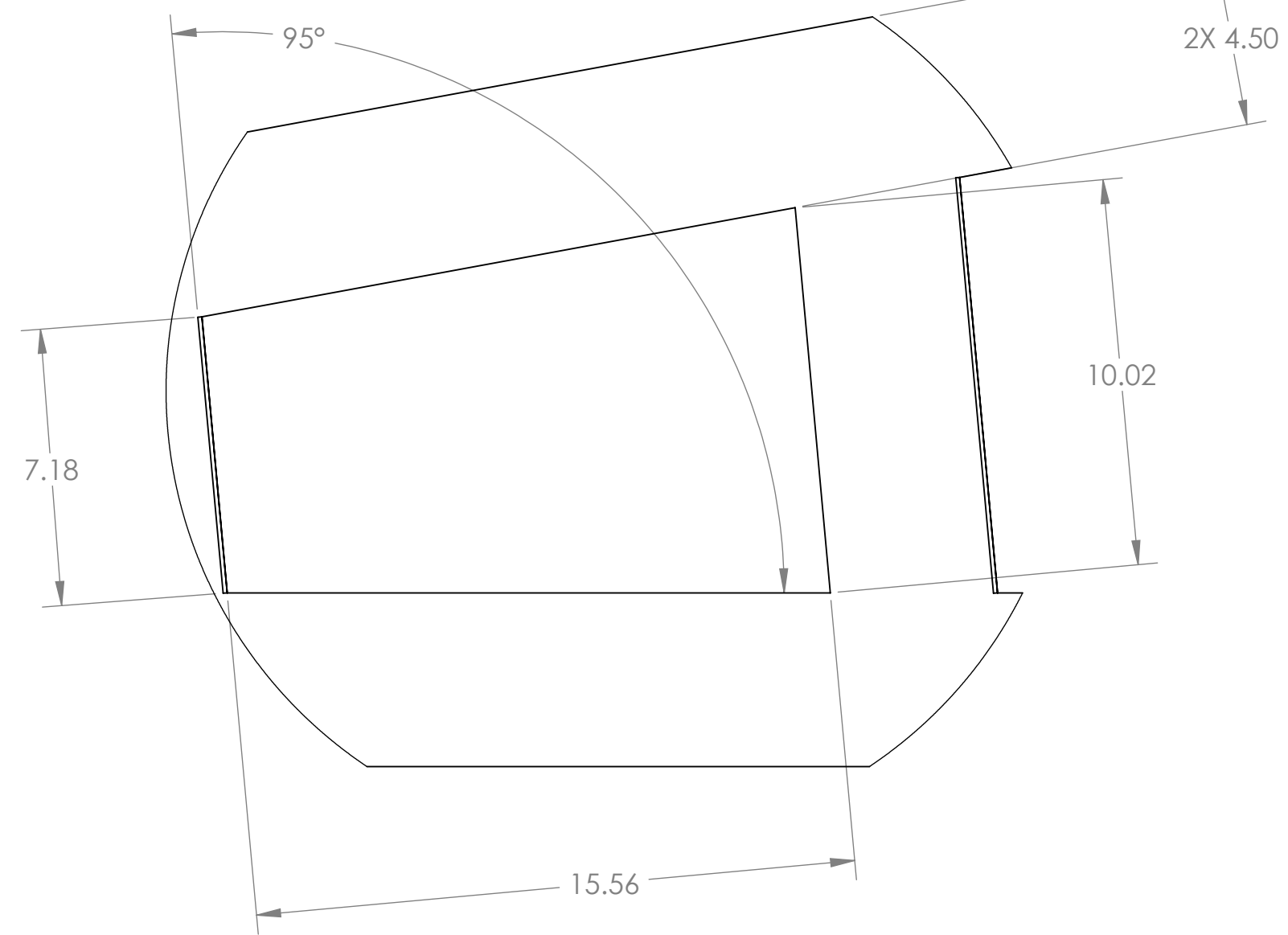


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002207	v2
SCALE: 1:8	PROJECTION:	SHEET 5 OF 10

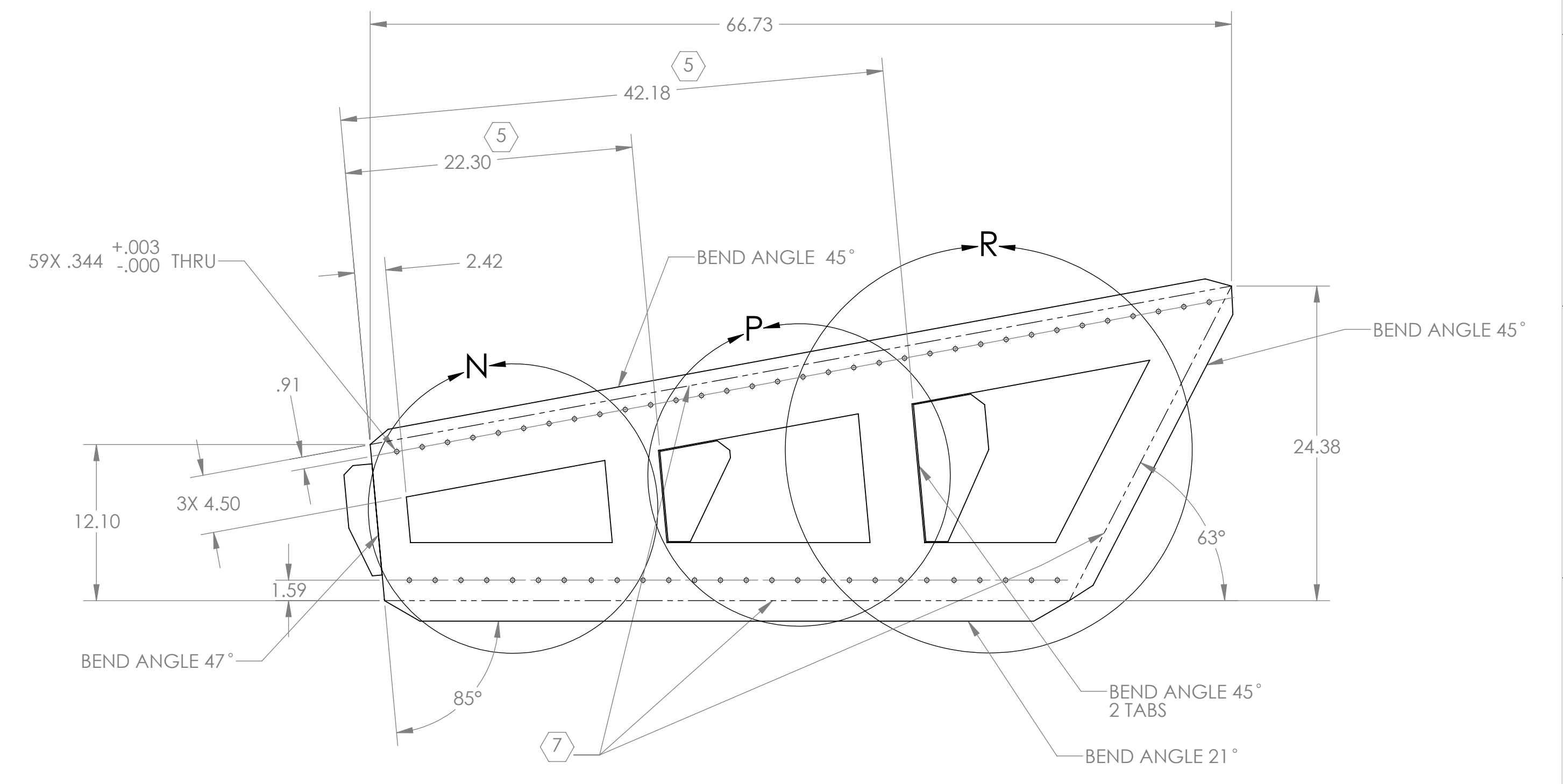
D:\002207.dwg ACS Octlev-RX Pipe Weldment LH (PRL, S33), PART PDM_REV-X.032, DRAWING PDM_REV-X.035



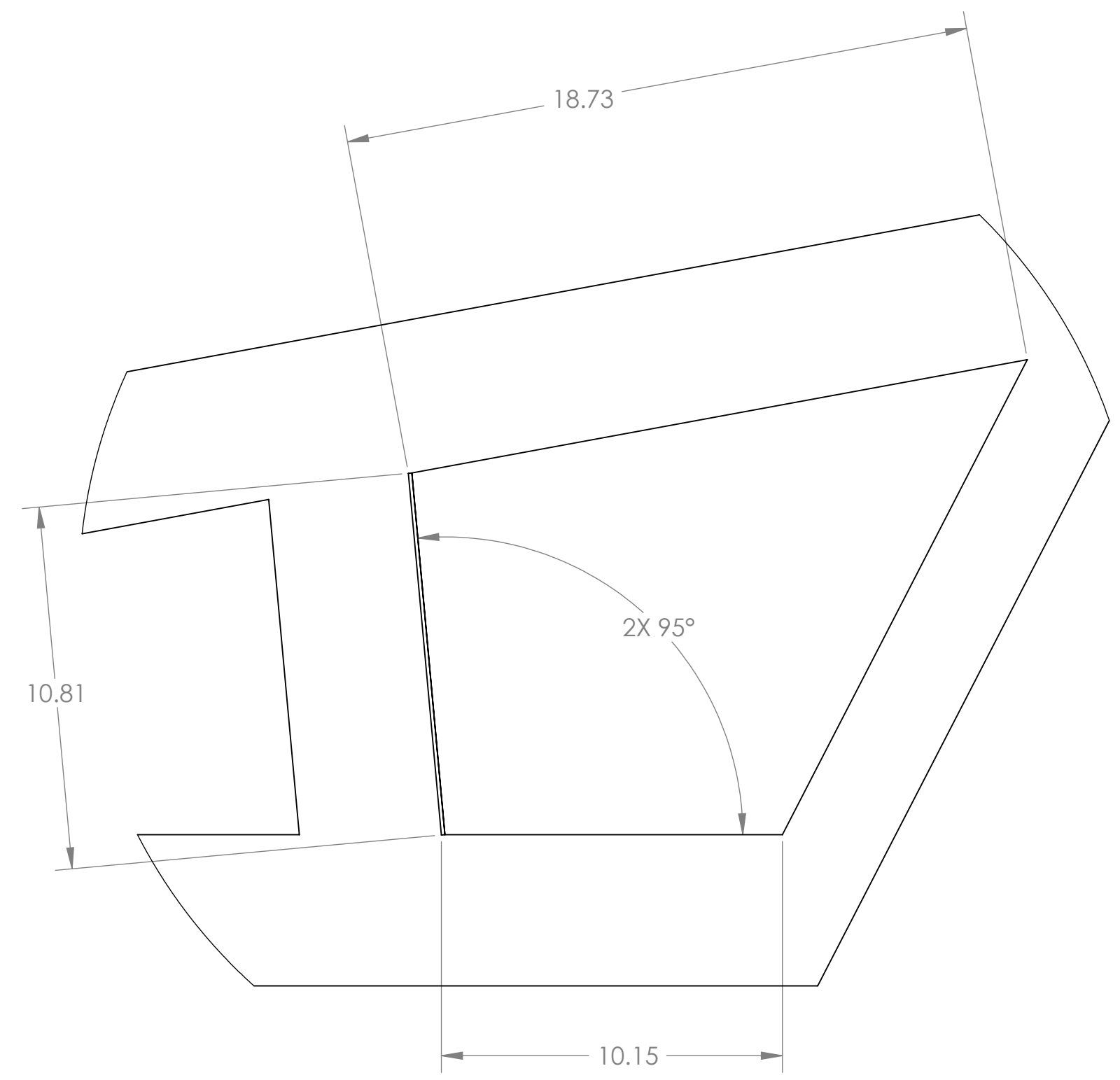
DETAIL N
SCALE 1 : 4



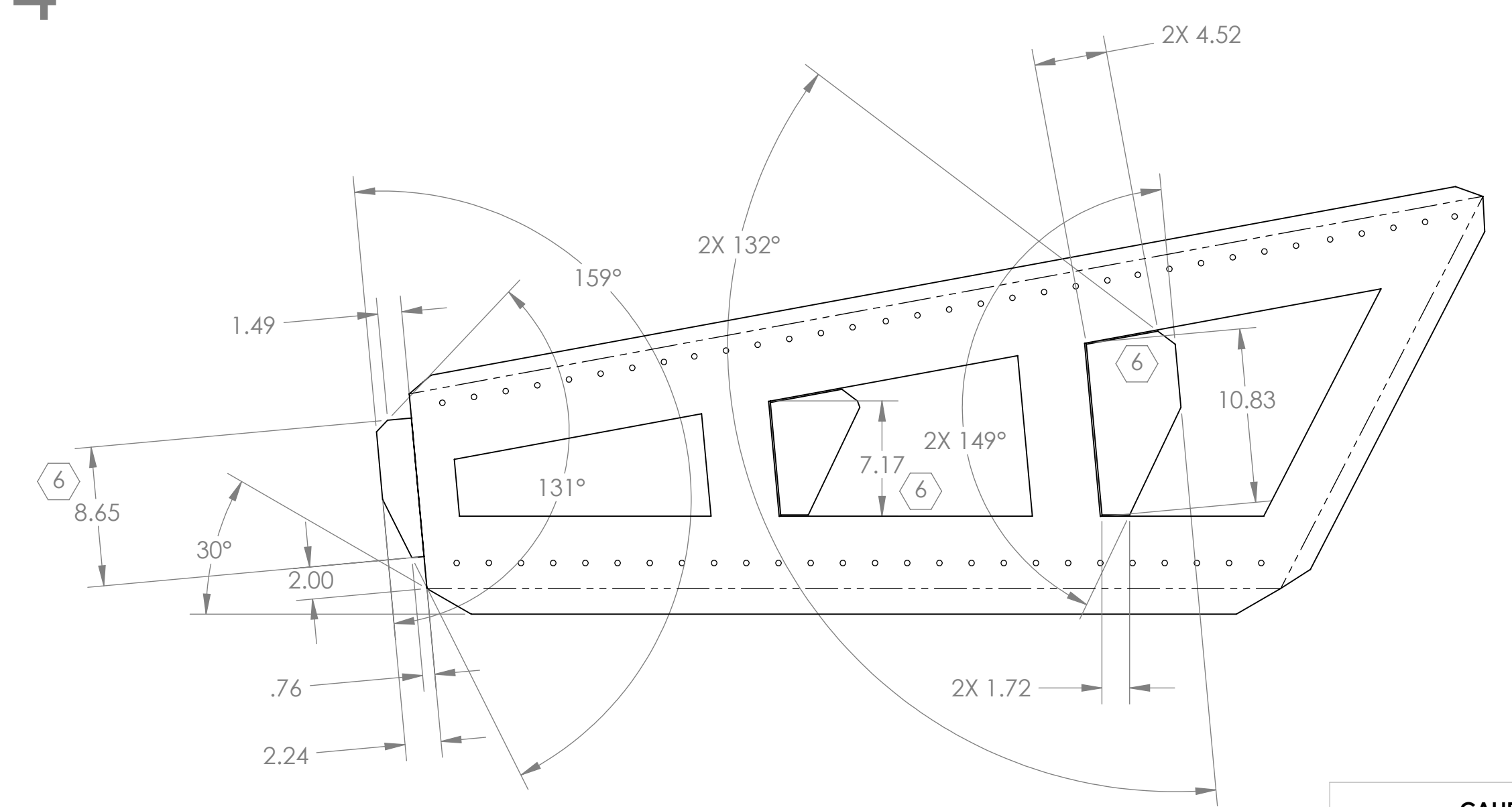
DETAIL P
SCALE 1 : 4



PANEL 4

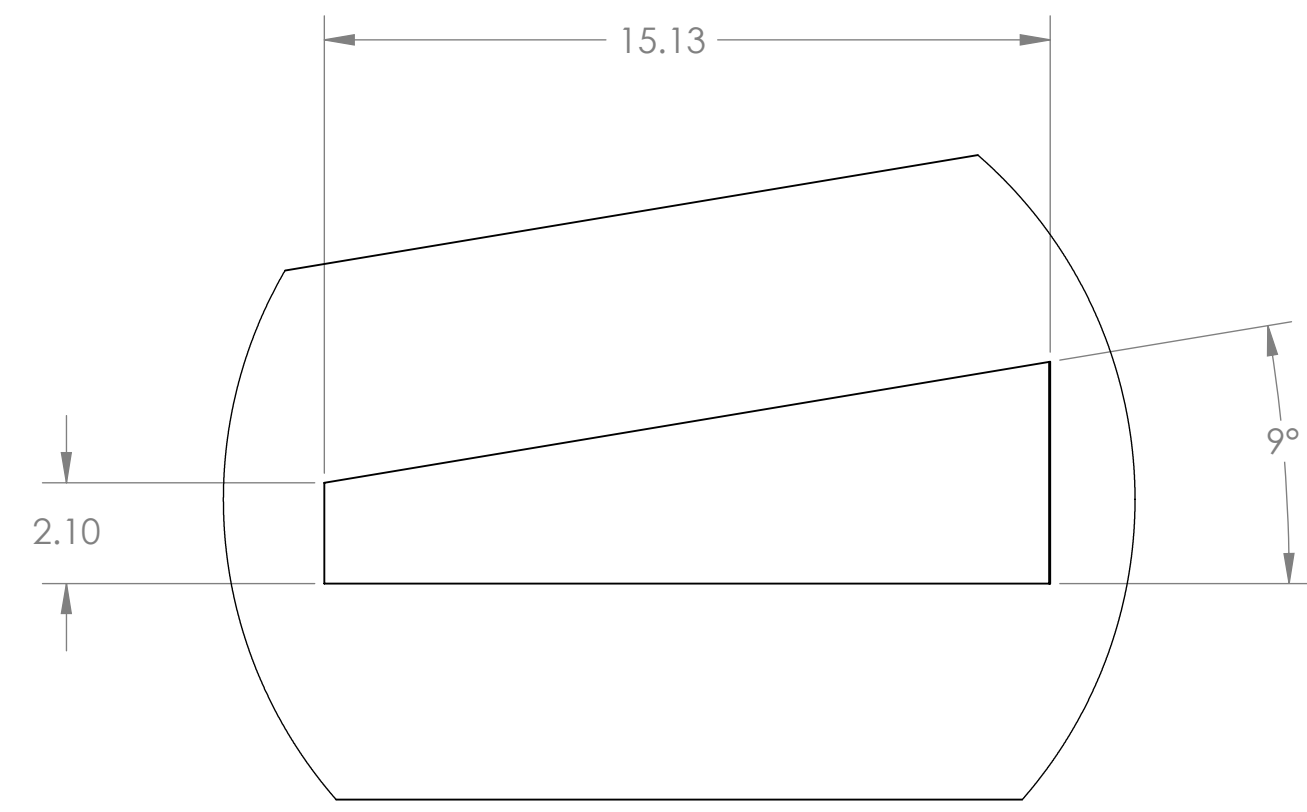


DETAIL R
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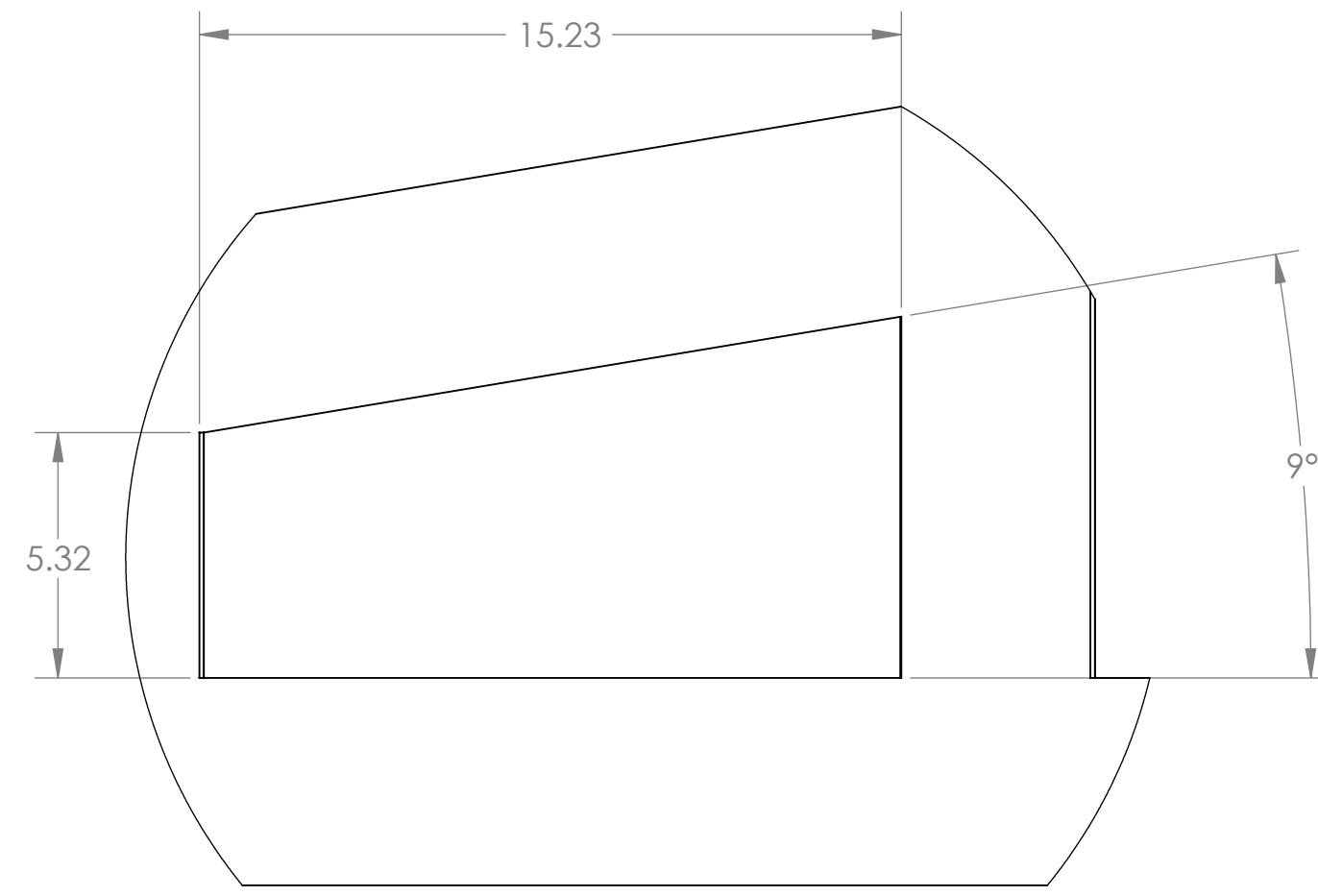


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002207	v2
SCALE: 1:8	PROJECTION:	SHEET 6 OF 10

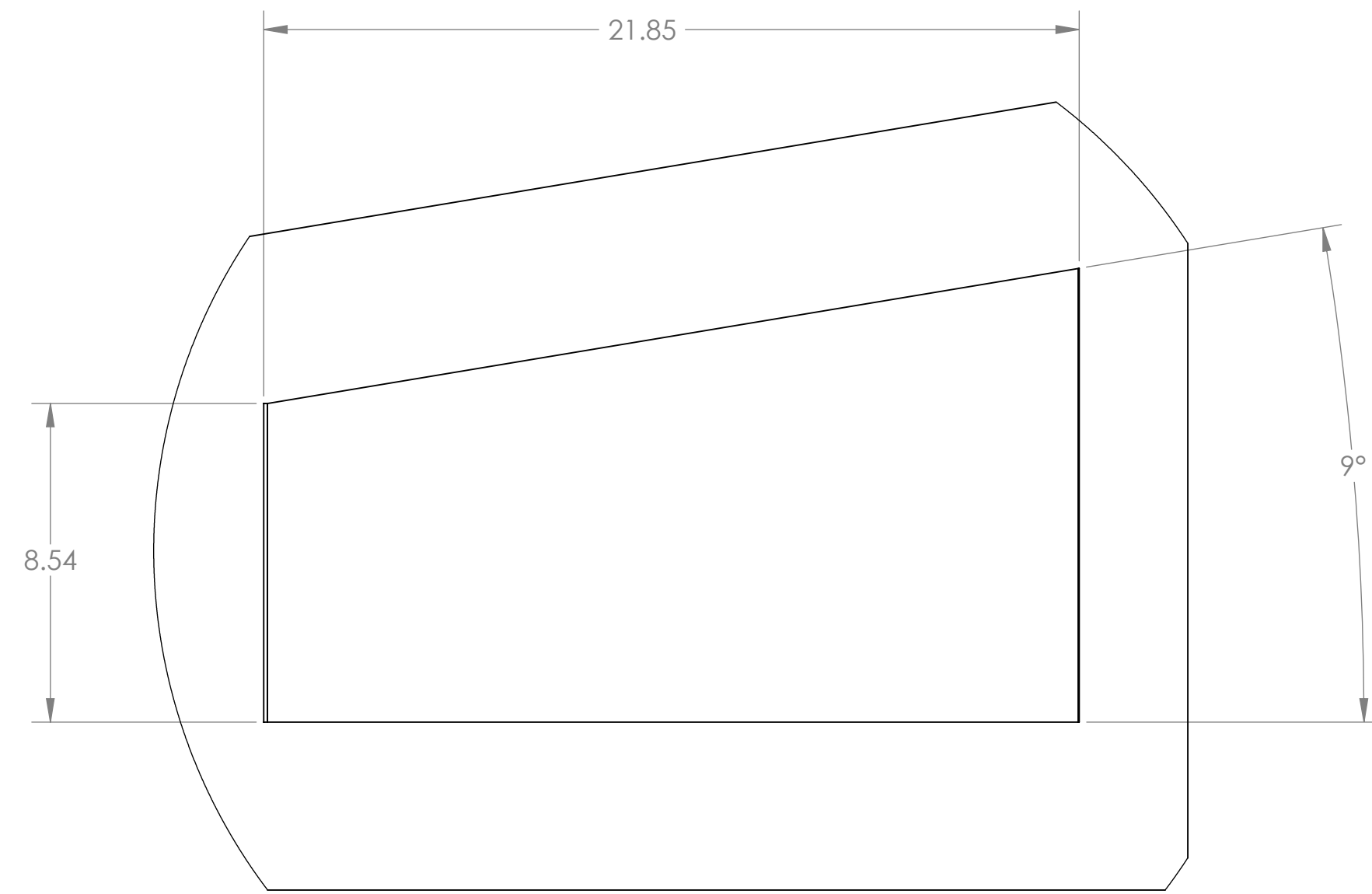
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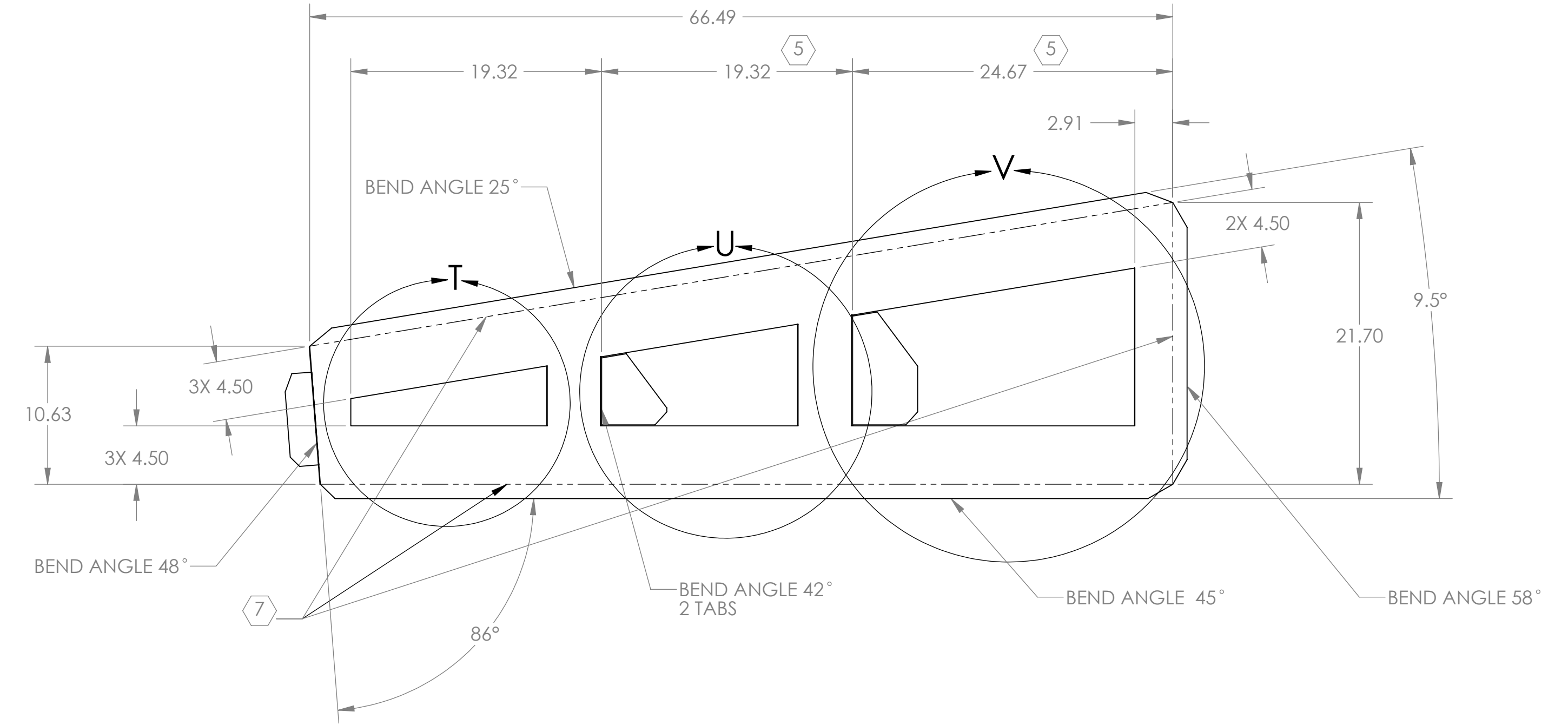
DETAIL T
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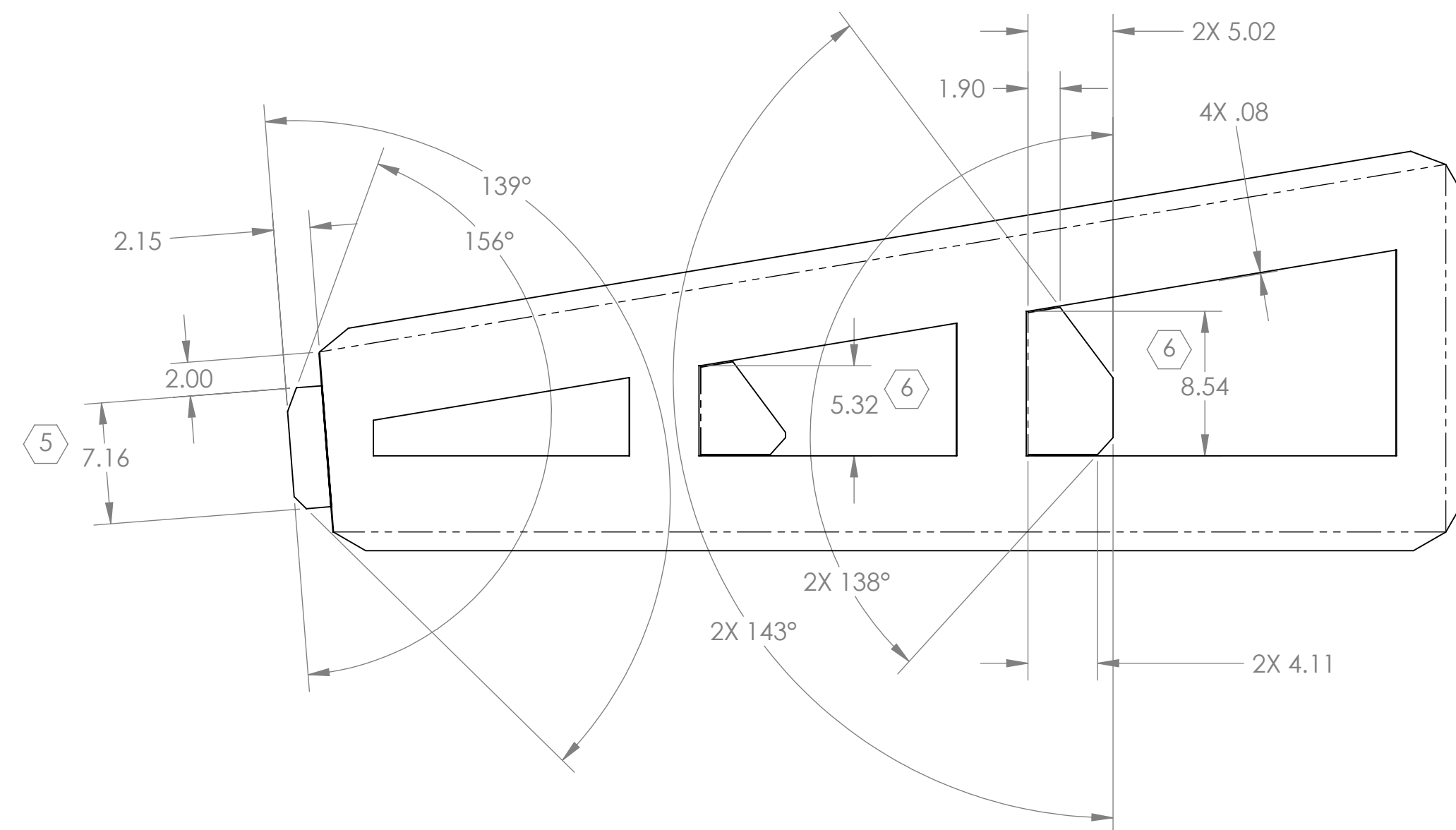
DETAIL U
SCALE 1 : 4



DETAIL V
SCALE 1 : 4

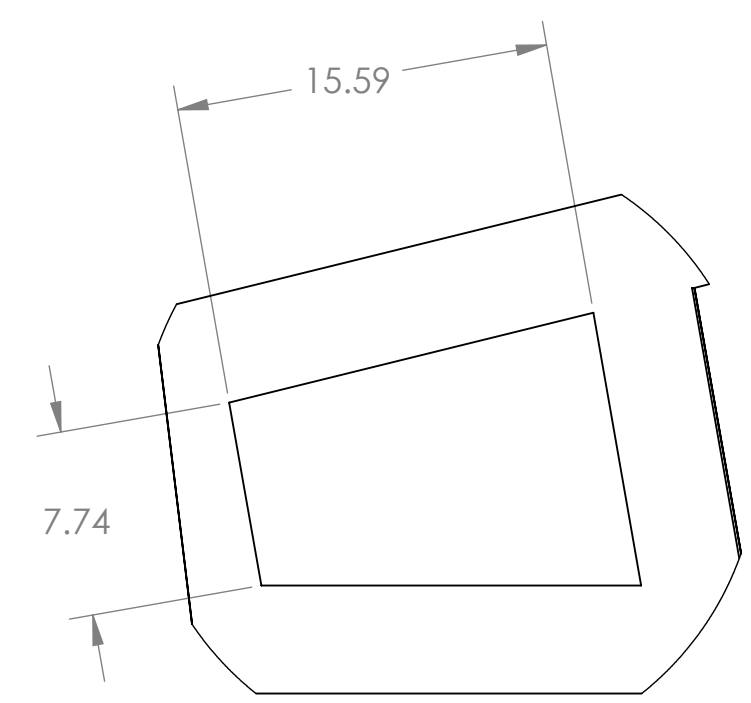


PANEL 5

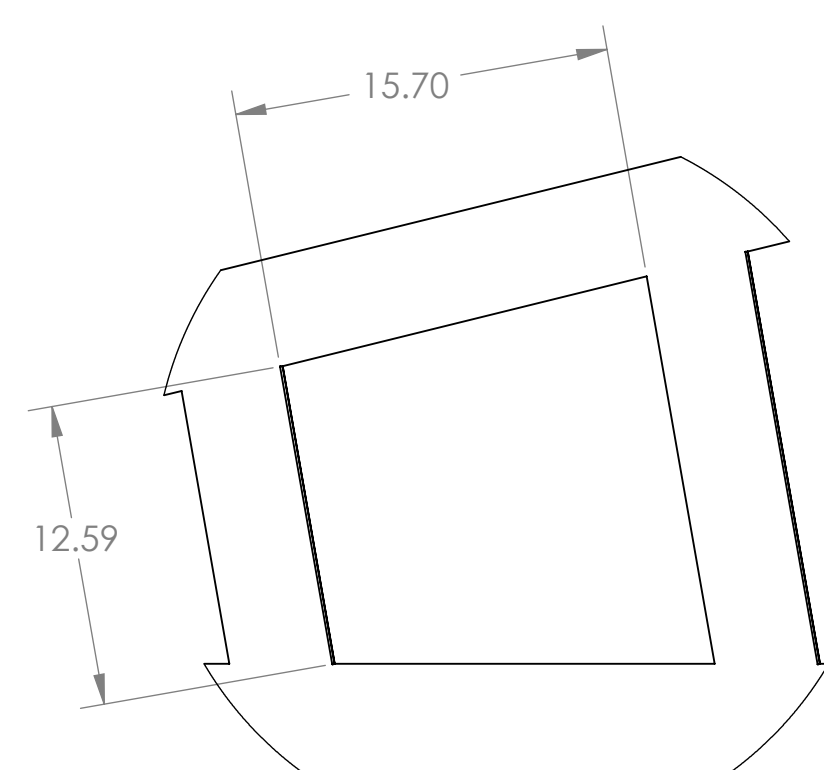


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
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SCALE: 1:8	PROJECTION:	SHEET 7 OF 10

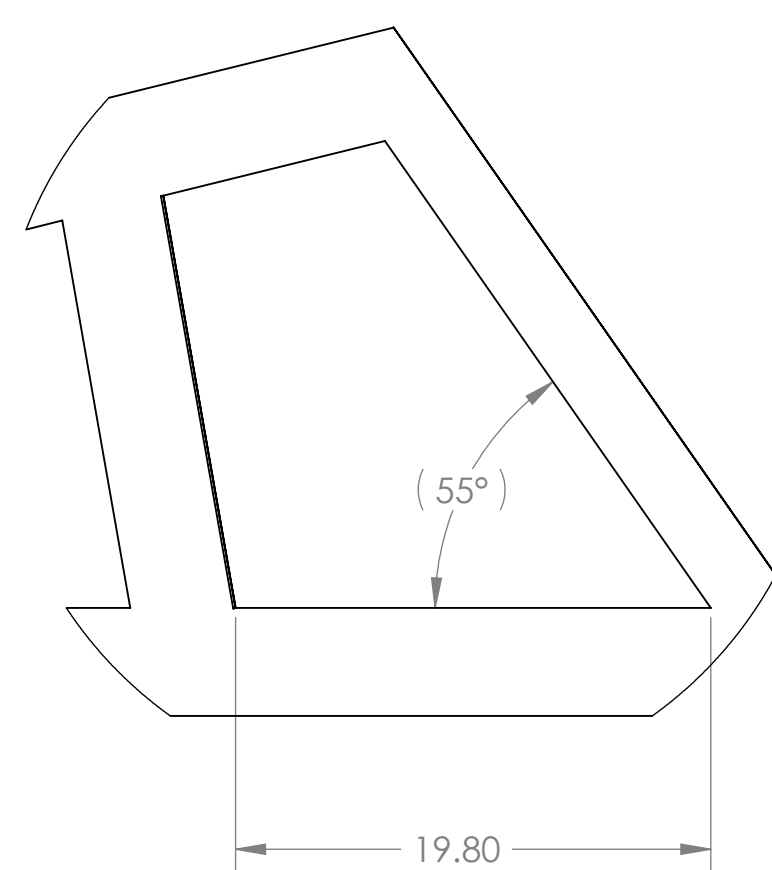
D:\002207\duco\ACS\Oclew\RX\Plan\Weldment LH (PES, SBJ)_PART PDM_REV-X.032.DRAWING PDM_REV-X.035



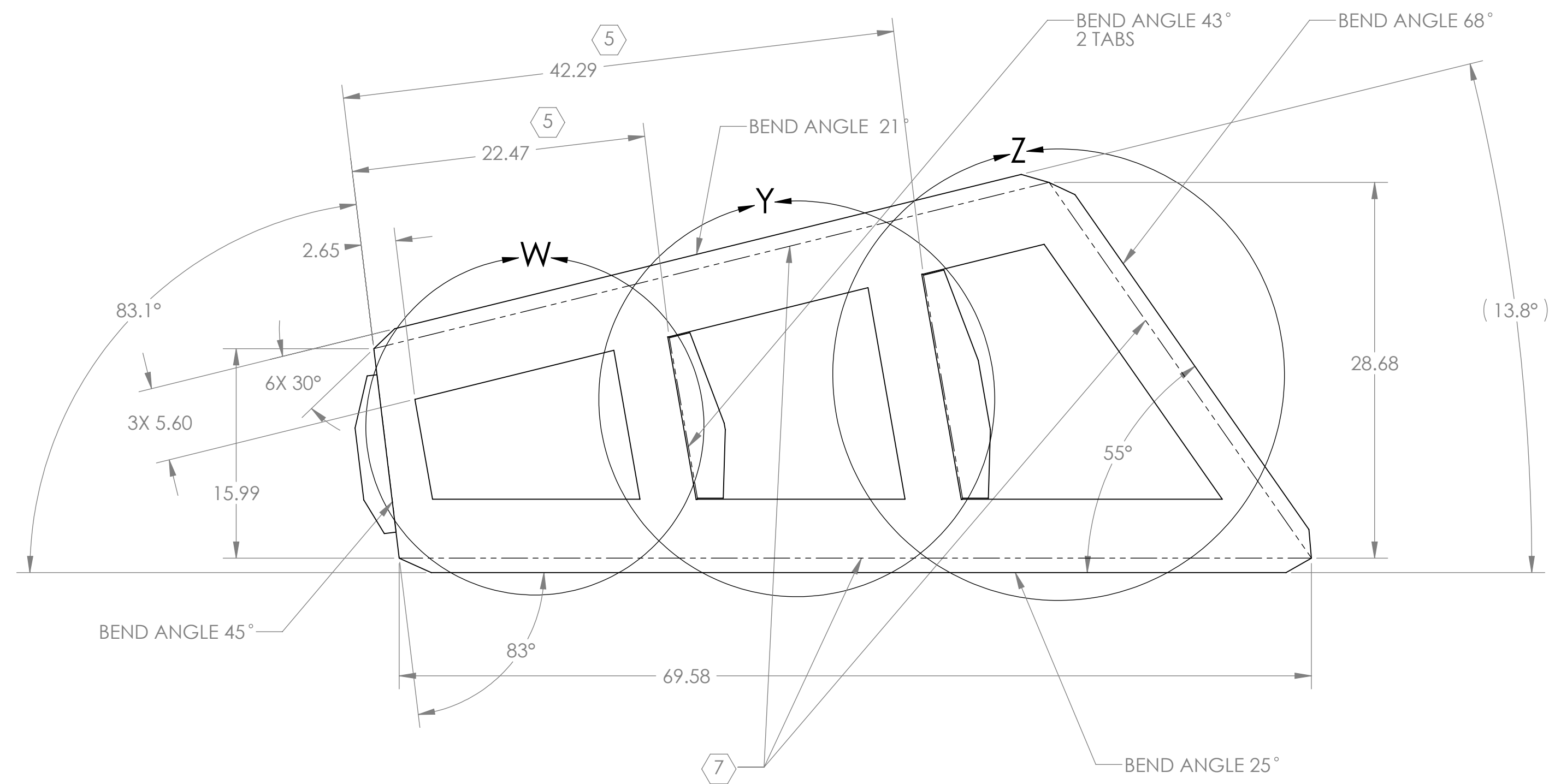
DETAIL W



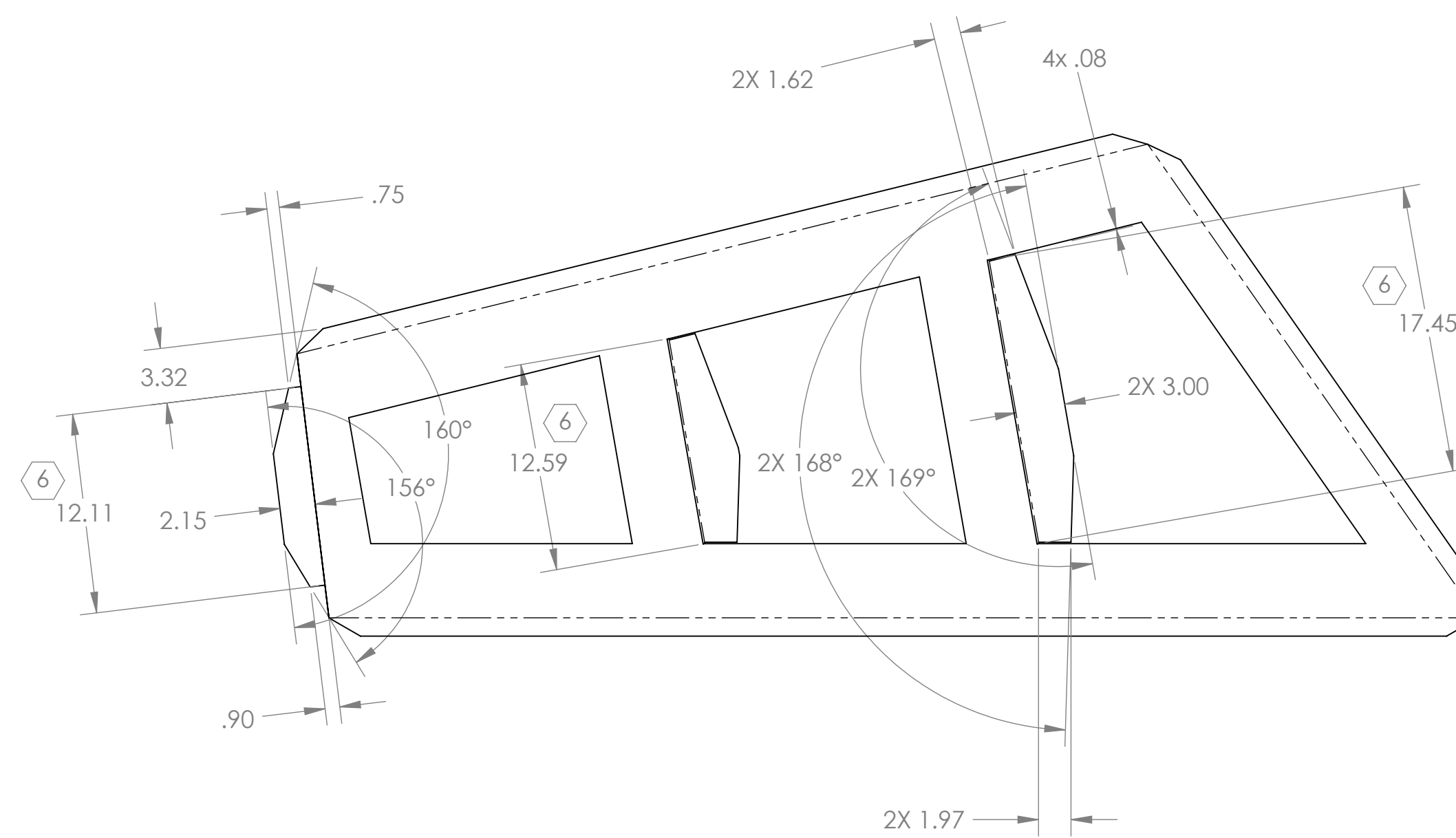
DETAIL Y



DETAIL Z

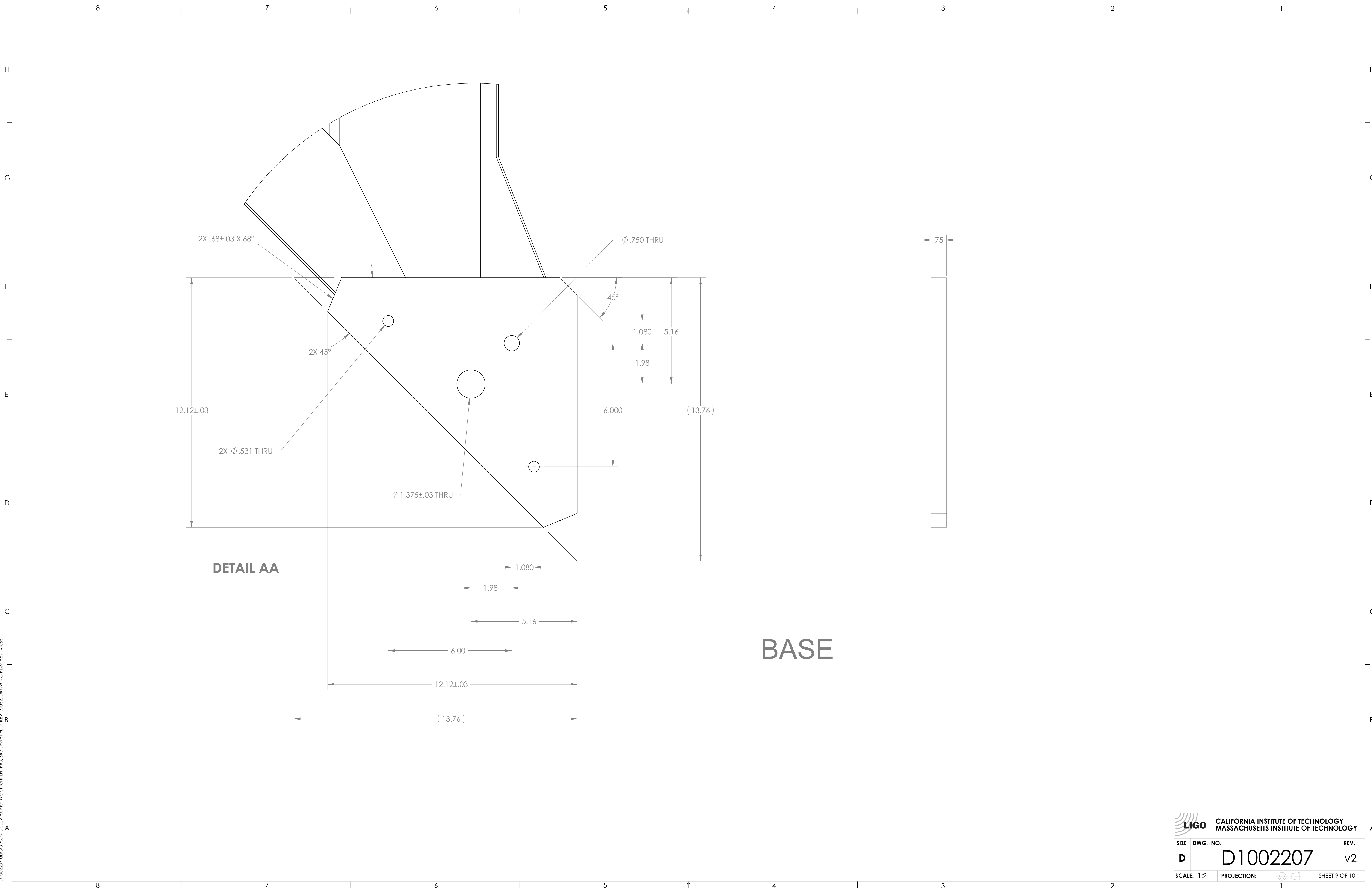


PANEL 6



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
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D	D1002207	v2
SCALE: 1:8	PROJECTION:	SHEET 8 OF 10

D:\002207.dwg ACS Oct 14 10:58 AM P:\PDM\REV-X\032.DRAWING.PDM REV: X-035

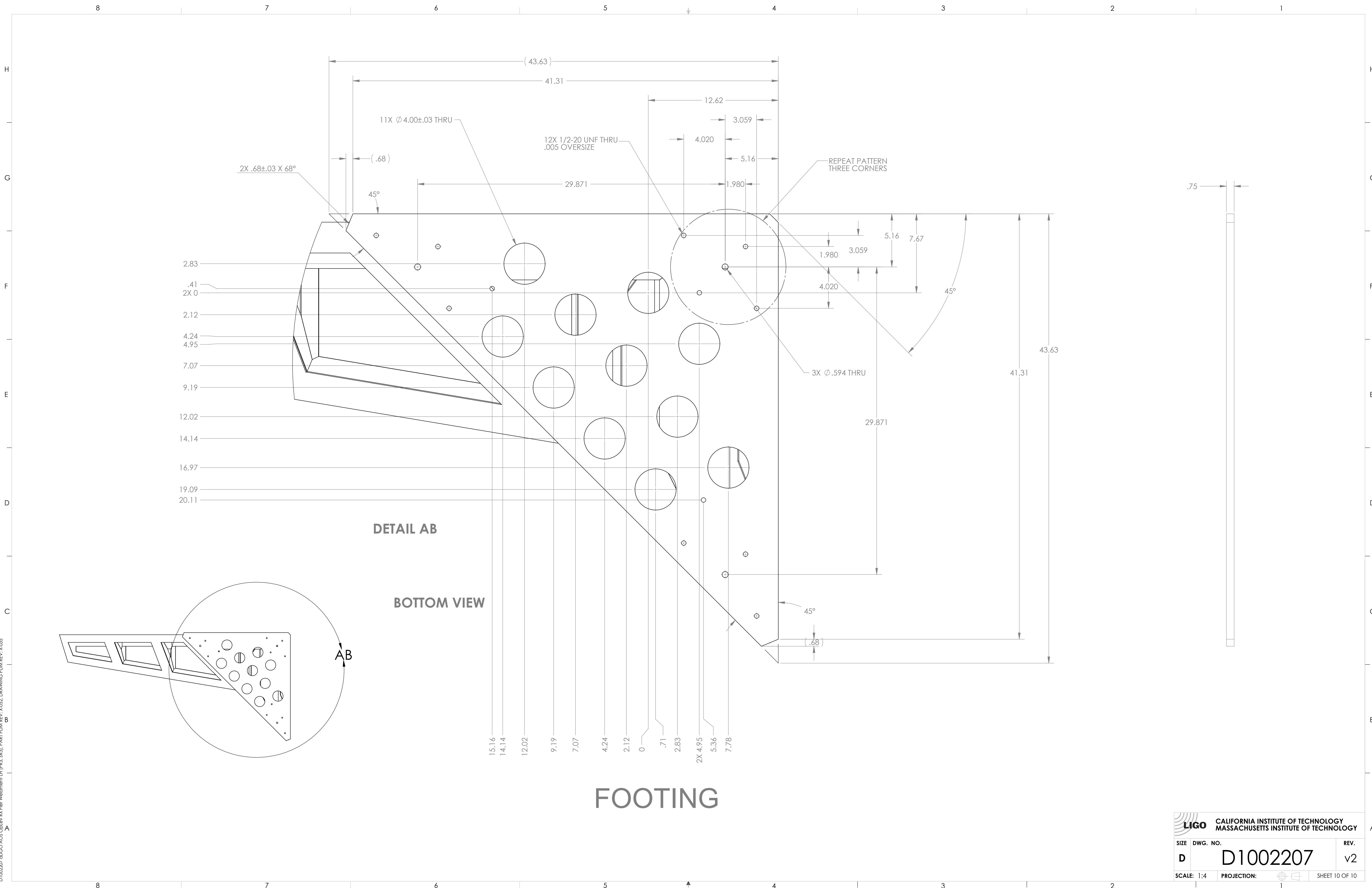


BASE

DETAIL AA

		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE	DWG. NO.	REV.	
D	D1002207	v2	
SCALE: 1:2	PROJECTION:	SHEET 9 OF 10	

D:\002207.dwg ACS Oct 16 11:11 AM [PES, S33] PART PDM REV: X.032 DRAWING PDM REV: X.035



D:\002207.dwg ACS Octave RK Pier Weldment LH (PES, SB3) PART PDM REV-X.052 DRAWING PDM REV-X.055

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1002207	v2
SCALE: 1:4	PROJECTION:	SHEET 10 OF 10