

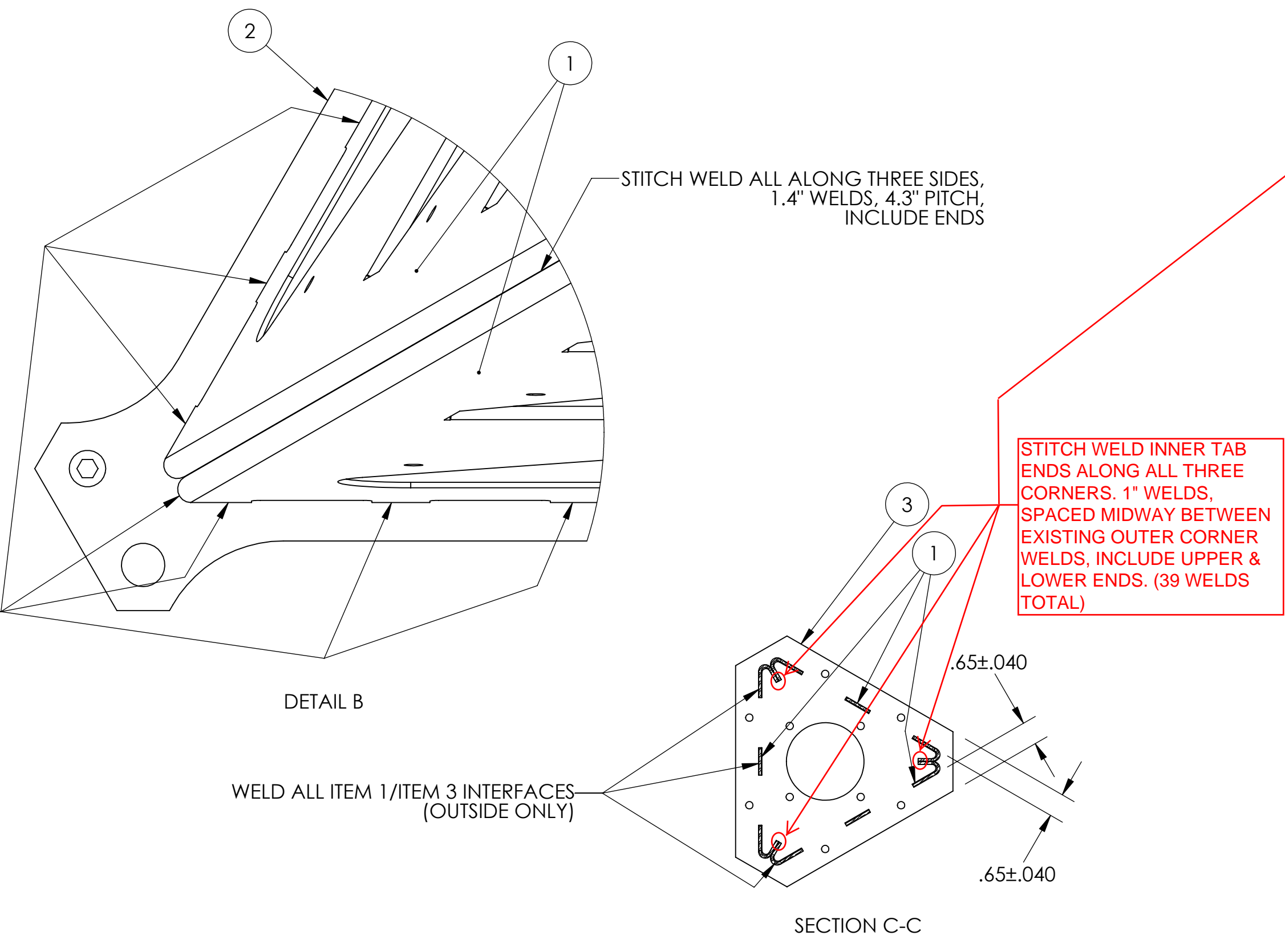
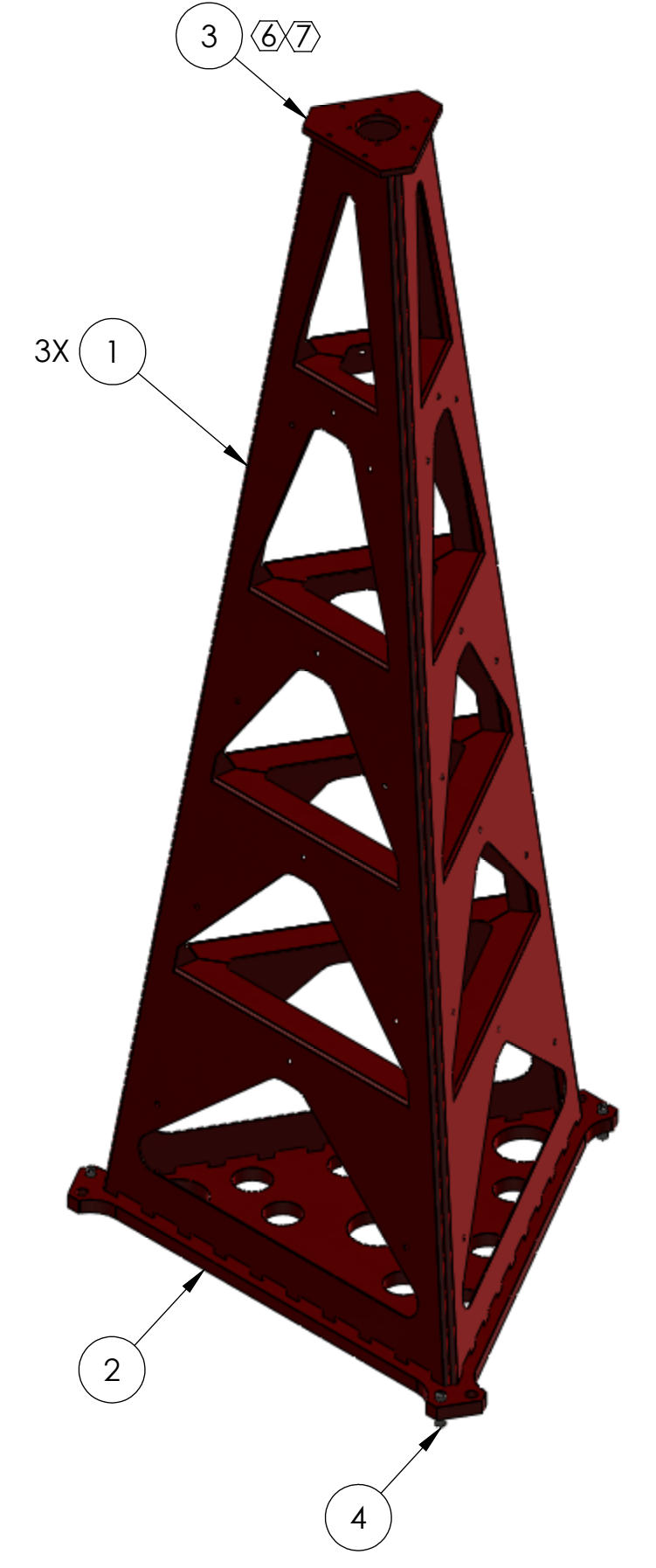
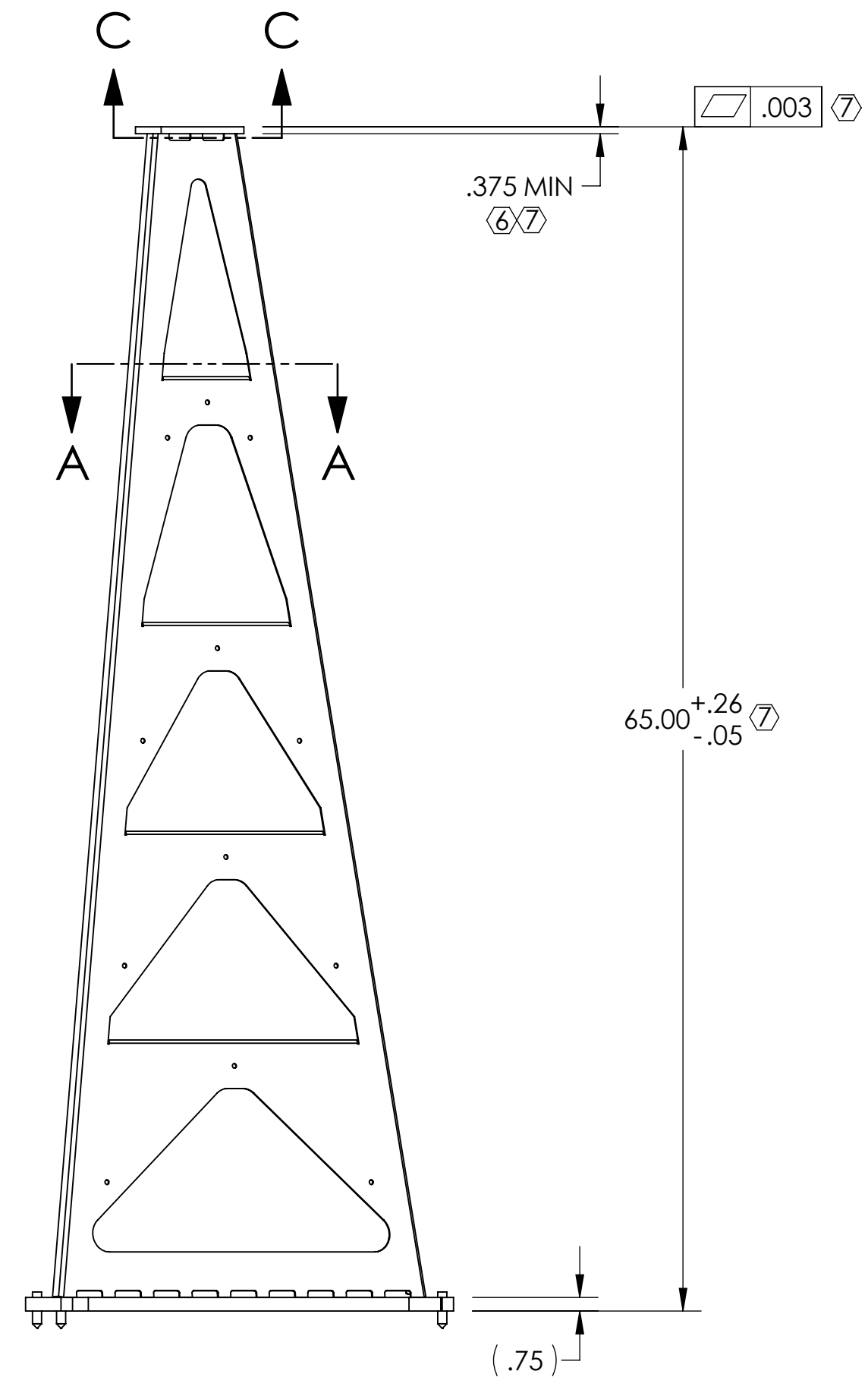
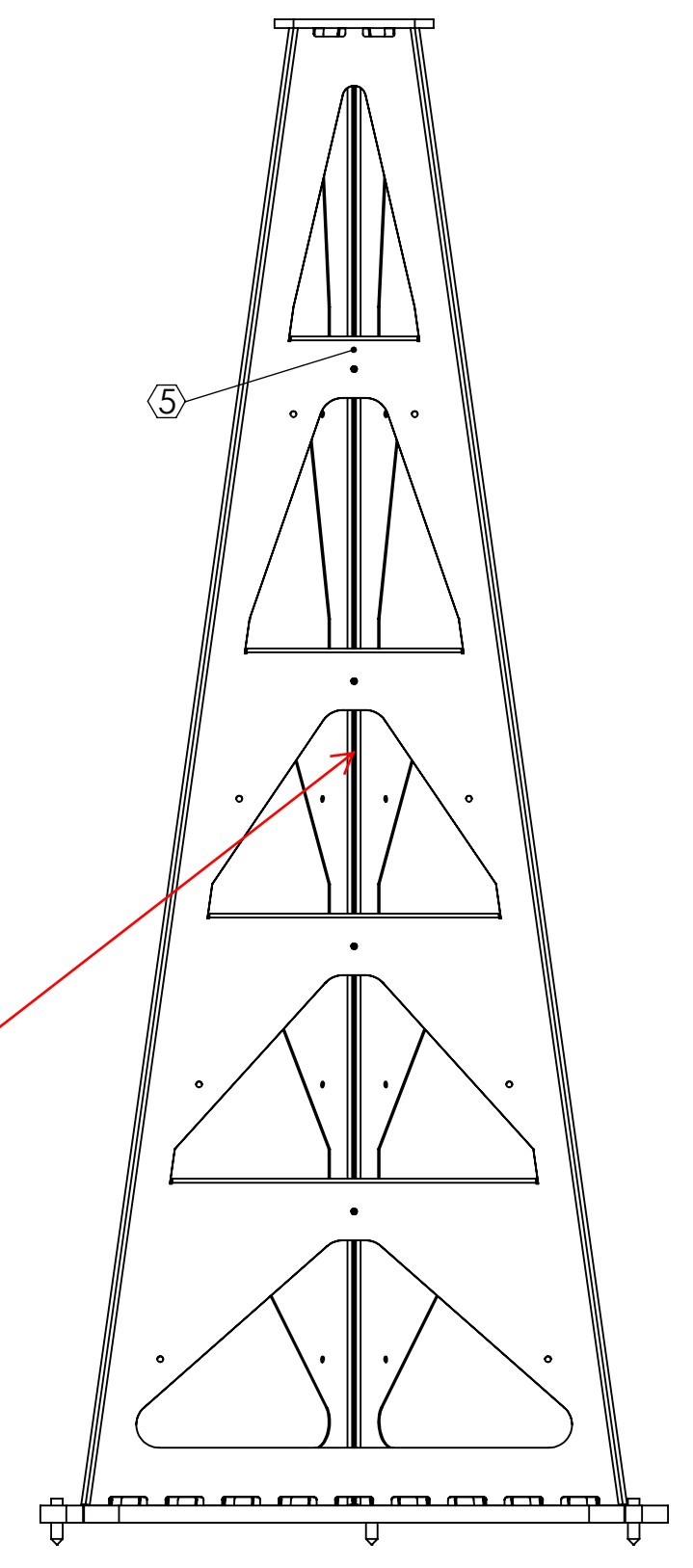
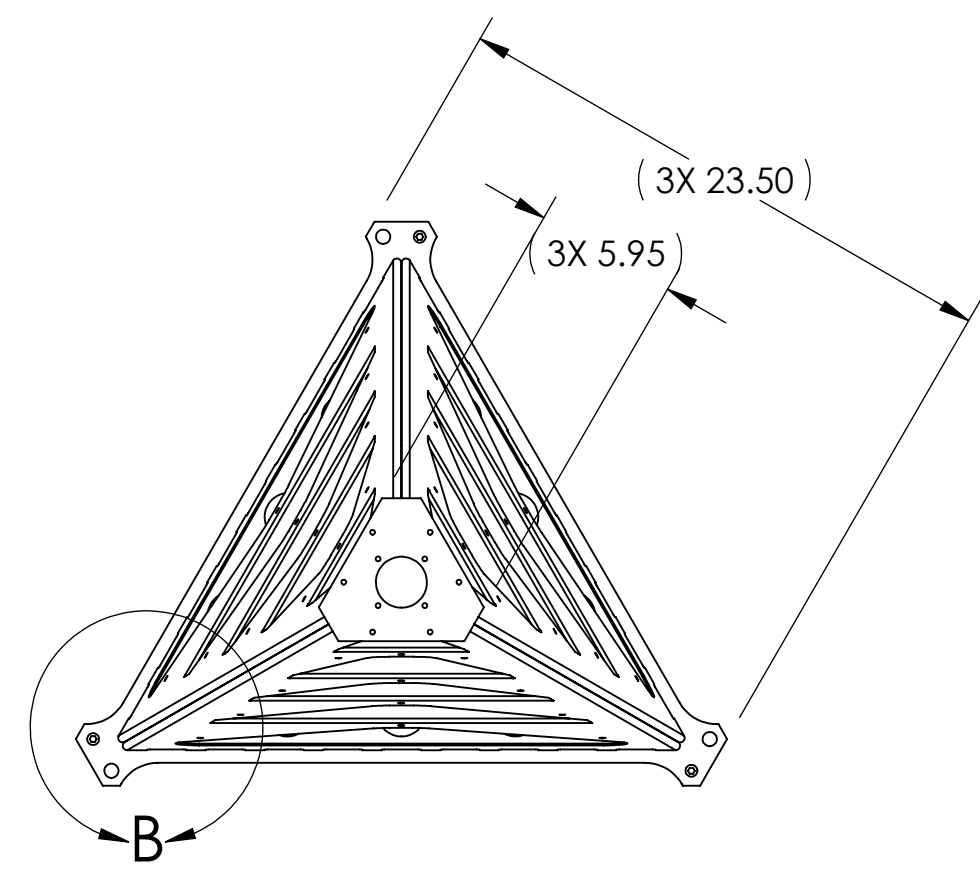
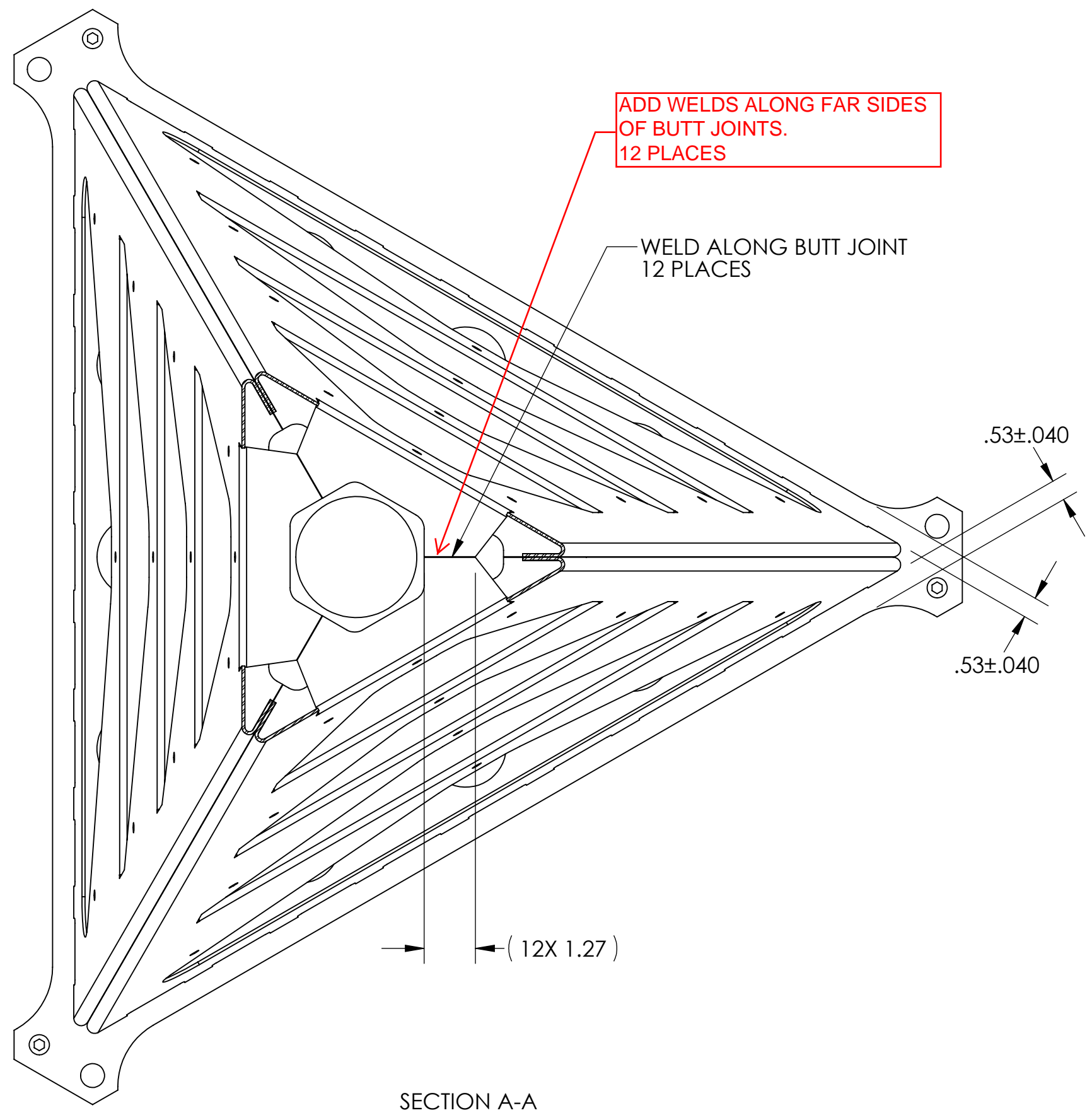
NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

⑥ WELD ITEM 3 TO ITEMS 1 WITH FLATTEST SIDE OF ITEM 3 FACING UPWARD IN VIEW.

⑦ 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	16 JUNE 2009	E0900144	E0900145
v2	23 JUNE 2009	E0900174	E0900145
v3	28 AUGUST 2009	REDLINES PER DCN E0900263	E0900145



ADD WELDS ALONG FAR SIDES OF BUTT JOINTS. 12 PLACES

WELD ALONG BUTT JOINT 12 PLACES

STITCH WELD ALL ALONG THREE SIDES. 1.4" WELDS, 4.3" PITCH, INCLUDE ENDS

STITCH WELD INNER TAB ENDS ALONG ALL THREE CORNERS. 1" WELDS, SPACED MIDWAY BETWEEN EXISTING OUTER CORNER WELDS, INCLUDE UPPER & LOWER ENDS. (39 WELDS TOTAL)

WELD ALL ITEM 1/ITEM 2 INTERFACES (OUTSIDE ONLY)

WELD ALL ITEM 1/ITEM 3 INTERFACES (OUTSIDE ONLY)

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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± N/A
 .XXX ± N/A

ANGULAR ± N/A °

MATERIAL: N/A

FINISH: N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: AOS

NEXT ASSY: D0900912

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	-	SCREW, SOCKET SET, CONE POINT, 1/2-20 UNF-2A X 2 LONG	300 SSSL	3	1	4
3	D0900773	AdvLIGO AOS PIER TABLE	AISI 304	1		1
2	D0900772	PIER BASE	AISI 304	1		1
1	D0900771	PIER SIDE PANEL	AISI 304	3		3

PART NAME: OPTICAL LEVER PIER WELDMENT PROTOTYPE

DESIGNER: C. CONLEY 07 MAY 2009

DRAFTER: C. CONLEY 16 JUNE 2009

CHECKER:

APPROVAL:

SCALE: NONE PROJECTION:

SHEET 1 OF 1

D0900657 AdvLIGO AOS Optical Lever Pier Weldment Prototype PART PDM REV: X-018 DRAWING PDM REV: X-017