

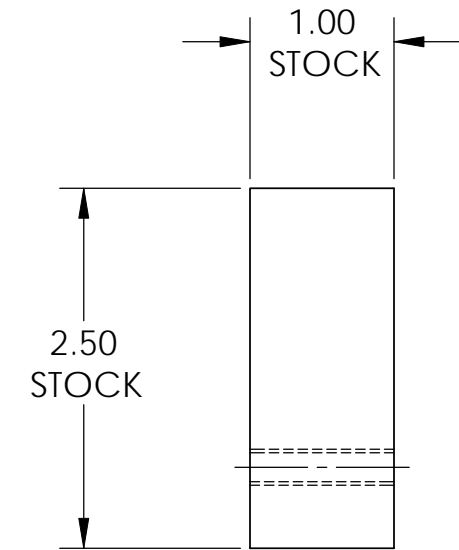
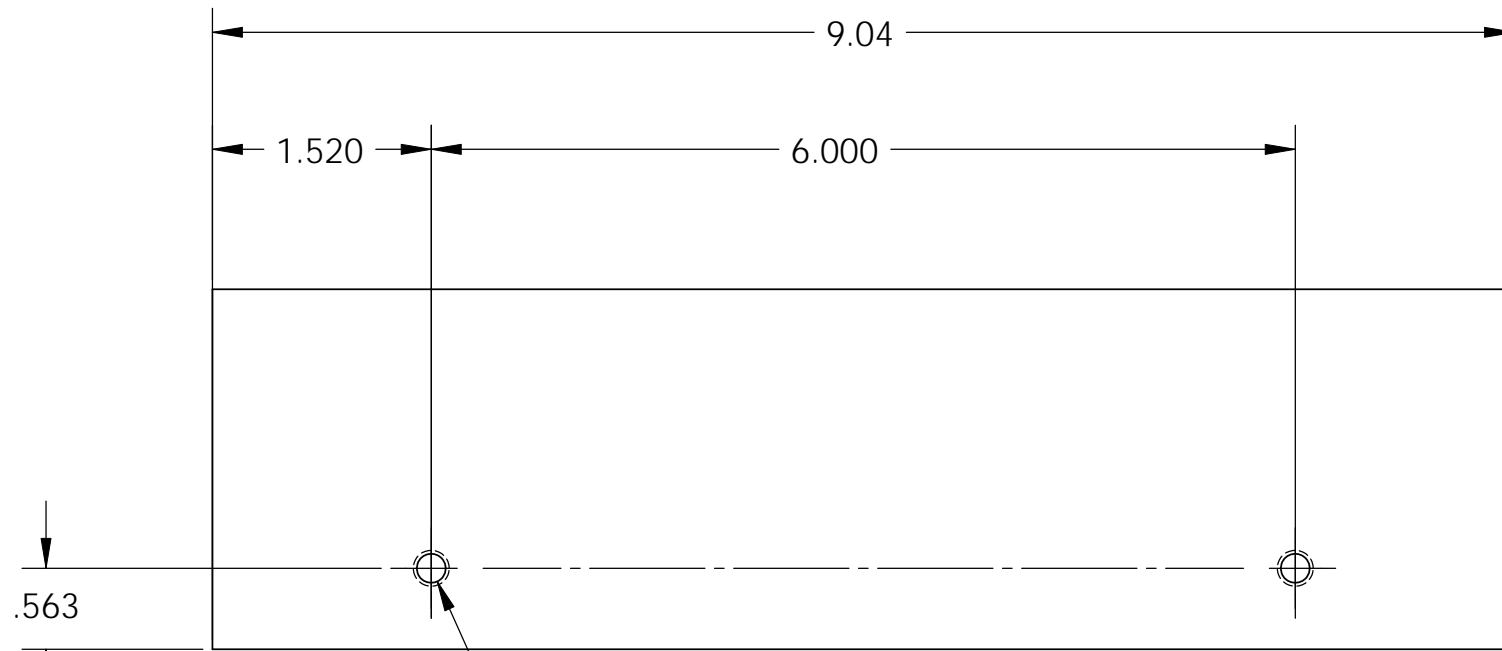
D1002499 aLIGO OPLEV STIFFENER WELDMENT BAR, PART PDM REV: X-016, DRAWING PDM REV: X-005

8 7 6 5 4 3 2 1

NOTES CONTINUED:

- 5. APPROXIMATE WEIGHT = 2.18 LBS.
- 6. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 FEB 2011	E1100106-v1	-
v2	12 SEPT 2011	E1100106-v1	-
-	-	-	-



2X  $\phi$  .20 THRU ALL  
 1/4-20 UNC - 2B THRU ALL  
 (.005 OVERSIZE, DRILL & TAP)

D C B A

D C B A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		ADVANCED LIGO		SUB-SYSTEM AOS		aLIGO OPLEV STIFFENER WELDMENT BAR			
TOLERANCES: .XX ± .03 .XXX ± .005		MATERIAL 304 SSSL		FINISH $\mu$ inch		NEXT ASSY D1002493		DESIGNER	SIZE	DWG. NO.	REV.
ANGULAR ± 0.5°								DRAFTER J. TERRAZAS 17 FEB 2011	B	D1002499	v2
								CHECKER	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
								APPROVAL			

8 7 6 5 4 3 2 1