

REQ	SPARE	TOTAL	PART NUMBER	DESCRIPTION	MATERIAL	ITEM NO.
56	12	68	1185-2EN328	#8-32 X .328" HELICOIL (8)	NITRONIC 60	4
64	14	78	90585A358	CHCS, 1/4-20 X 5/8" LONG (McMASTER-CARR)	316 SSSL	3
8	-	8	D0900309	CORNER BRACE, OMC STRUCTURAL WELDMENT	6061-T6 AL	2
1	-	1	D0900308	OMC STRUCTURAL WELDMENT	6061-T6 AL	1

**NOTES: (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 GINCHINATI MILACRON'S CUTECH 410 (S21)
- MATCH DRILL CORNER BRACE (D0900309) WELDED STRUCTURE (D0900308). DRILL AND TAP WELDED STRUCTURE FOR 1/4-20 UNC x .500. OVERSIZE TAP THRU WALL  $\sqrt{2} \times .265 \times 82^\circ$ . DRILL AND COUNTERDRILL CORNER BRACE AS INDICATED.
- AFTER MATCH DRILLING BRACES AND STRUCTURE, MECHANICALLY STAMP OR SCRIBE EACH BRACE AND THE MATCHING CORNER OF THE STRUCTURE WITH MATCHING NUMBERS STARTING AT 1 AND CONTINUING CONSECUTIVELY AROUND THE STRUCTURE. CHARACTERS SHOULD BE AT LEAST 0.12" HIGH. SEE DRAWING FOR EXAMPLES.
- ESTIMATED WEIGHT FROM CAD MODEL: 46.3 LB (21.3 kg)
- HELICOILS, ITEM NO. 4, TO BE INSTALLED INTO WELDMENT, ITEM NO. 1, BY USDO PERSONNEL AFTER ALL PARTS ARE CLEANED AND BAKED.

DIMENSIONS ARE IN INCHES

TOLERANCES:  
XXX ± .01  
XXX ± .005  
ANGULAR ± 0.5°

MATERIAL: N/A

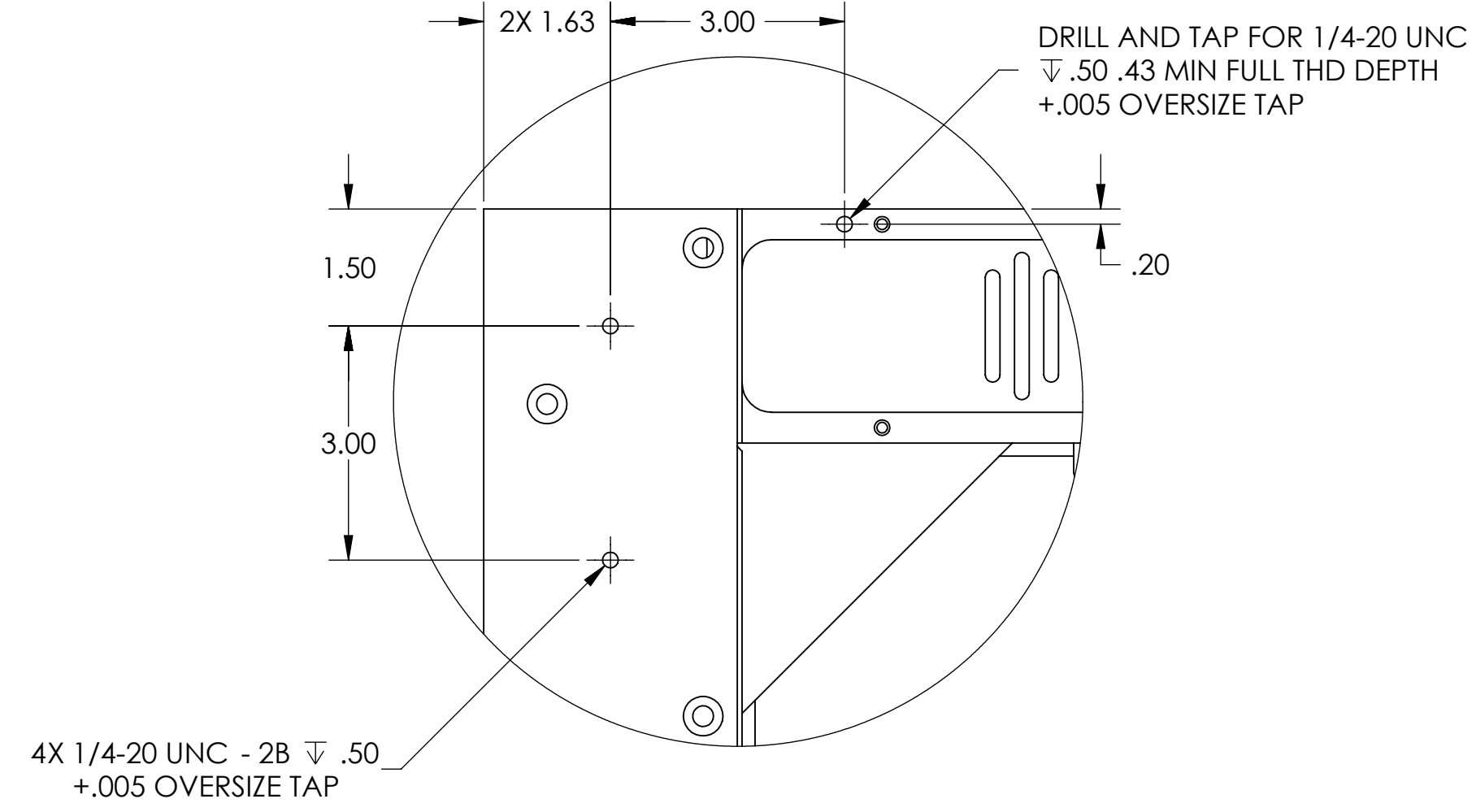
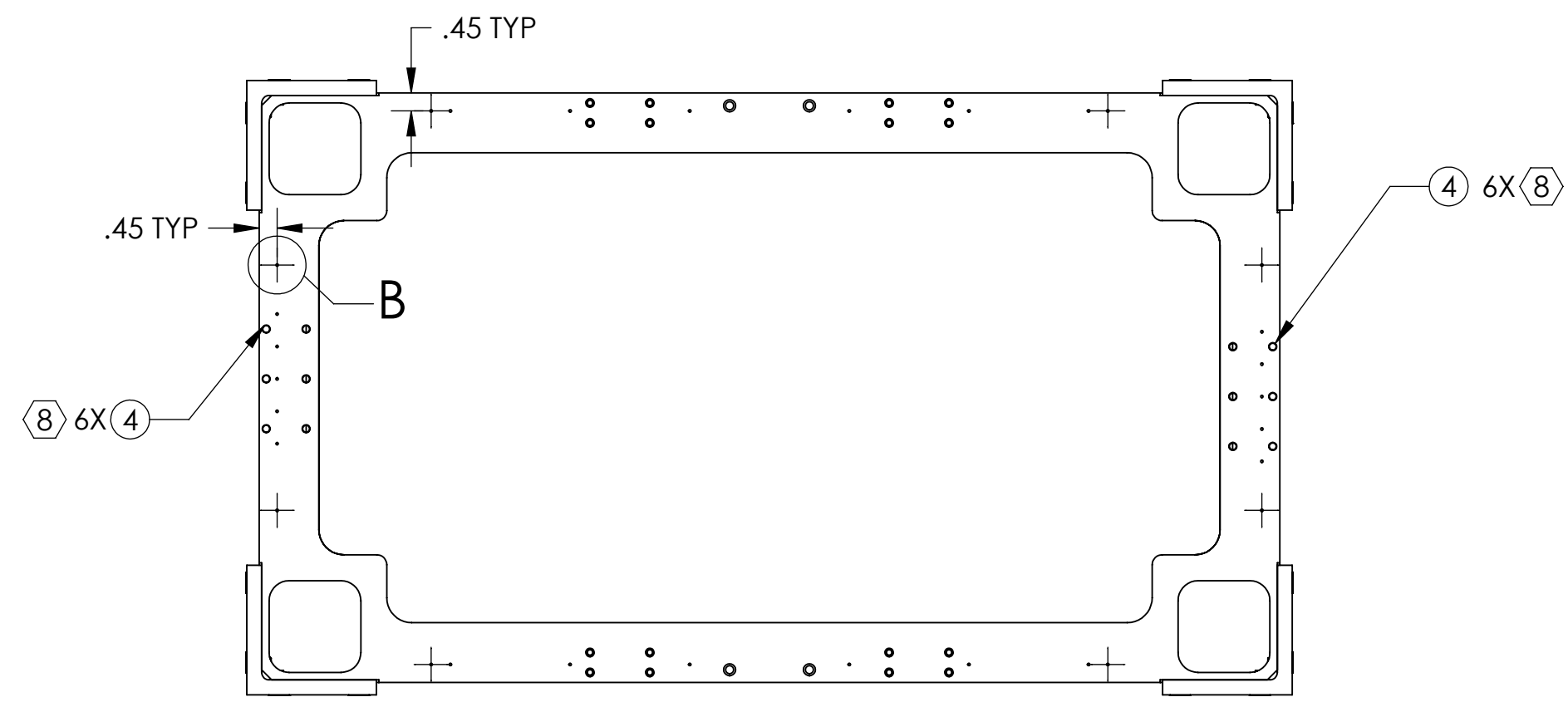
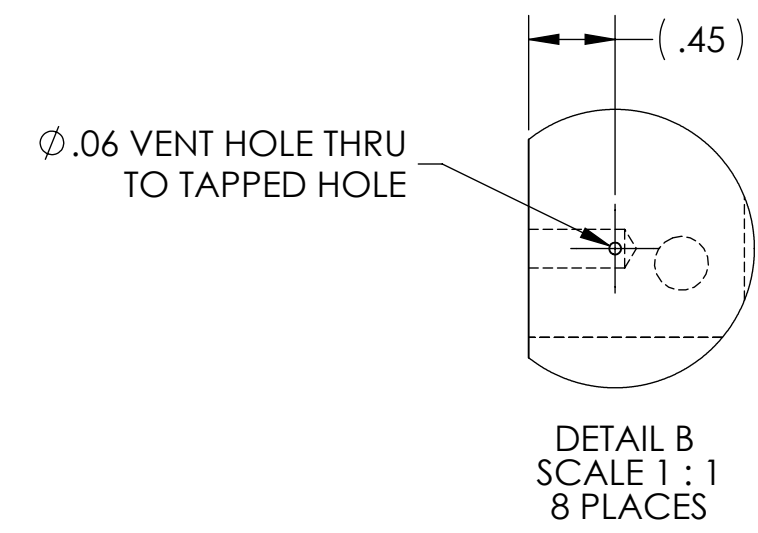
FINISH: N/A

DESIGNER: C. ECHOLS 17 DEC 2006  
DRAWN: B. MICHELE 14 APR 2009  
CHECKED: M. METZLER 17 APR 2009

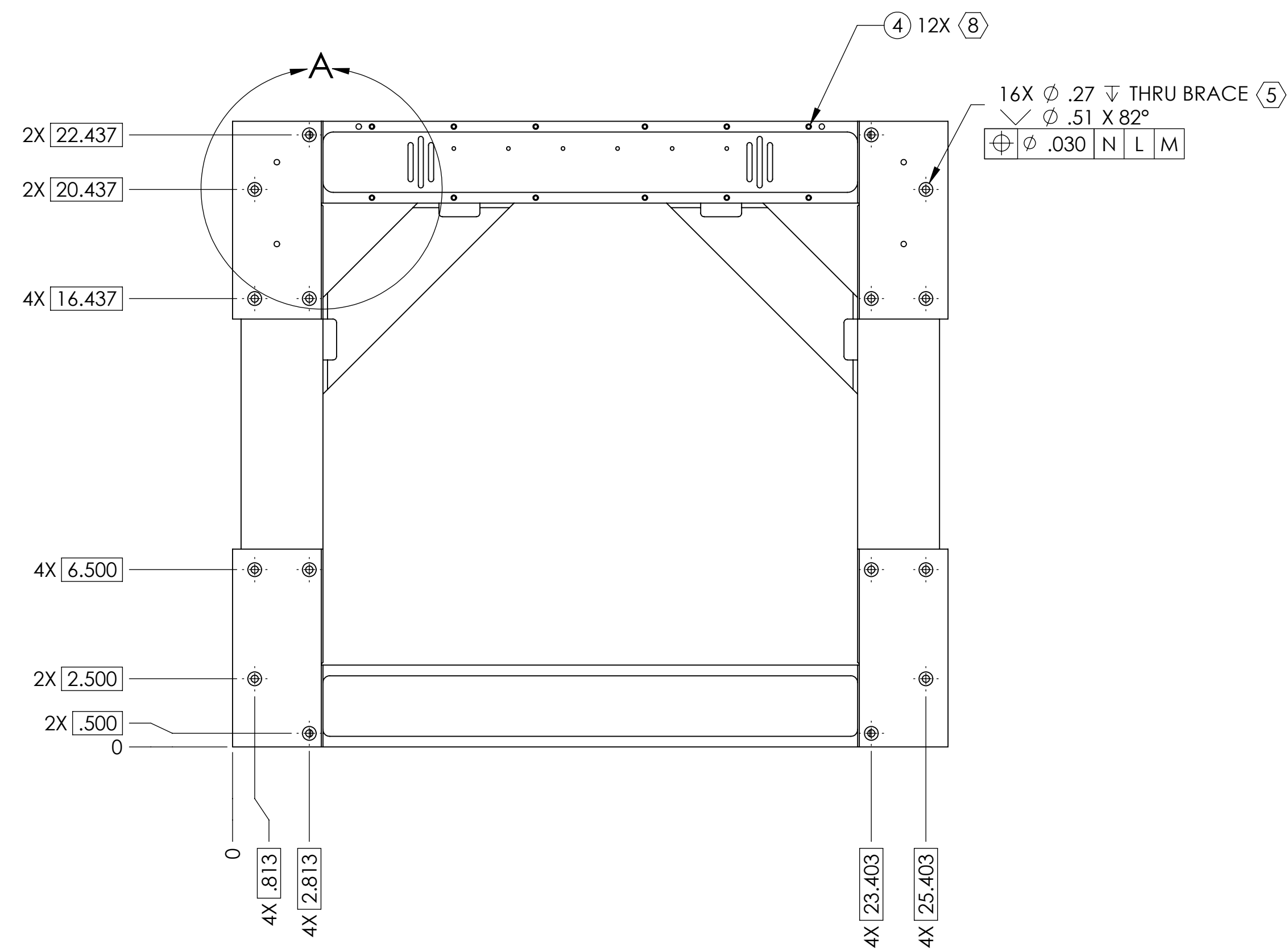
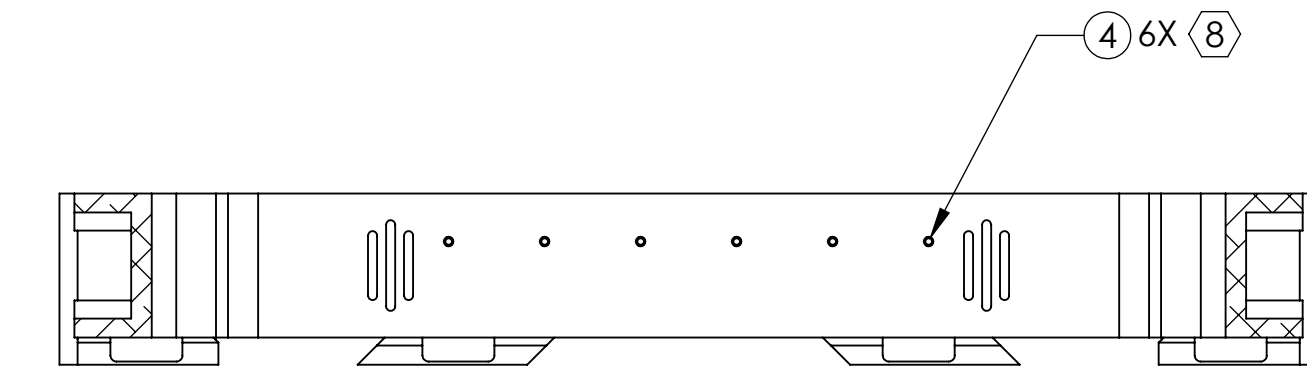
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SYSTEM: ADVANCED LIGO  
SUB-SYSTEM: SUS  
NEXT ASSY: D0900295  
PART NAME: STRUCTURAL WELDMENT ASSY, OMC  
SIZE DWG. NO.: D0900655  
SCALE: 1:4  
PROJECTION: SHEET 1 OF 2

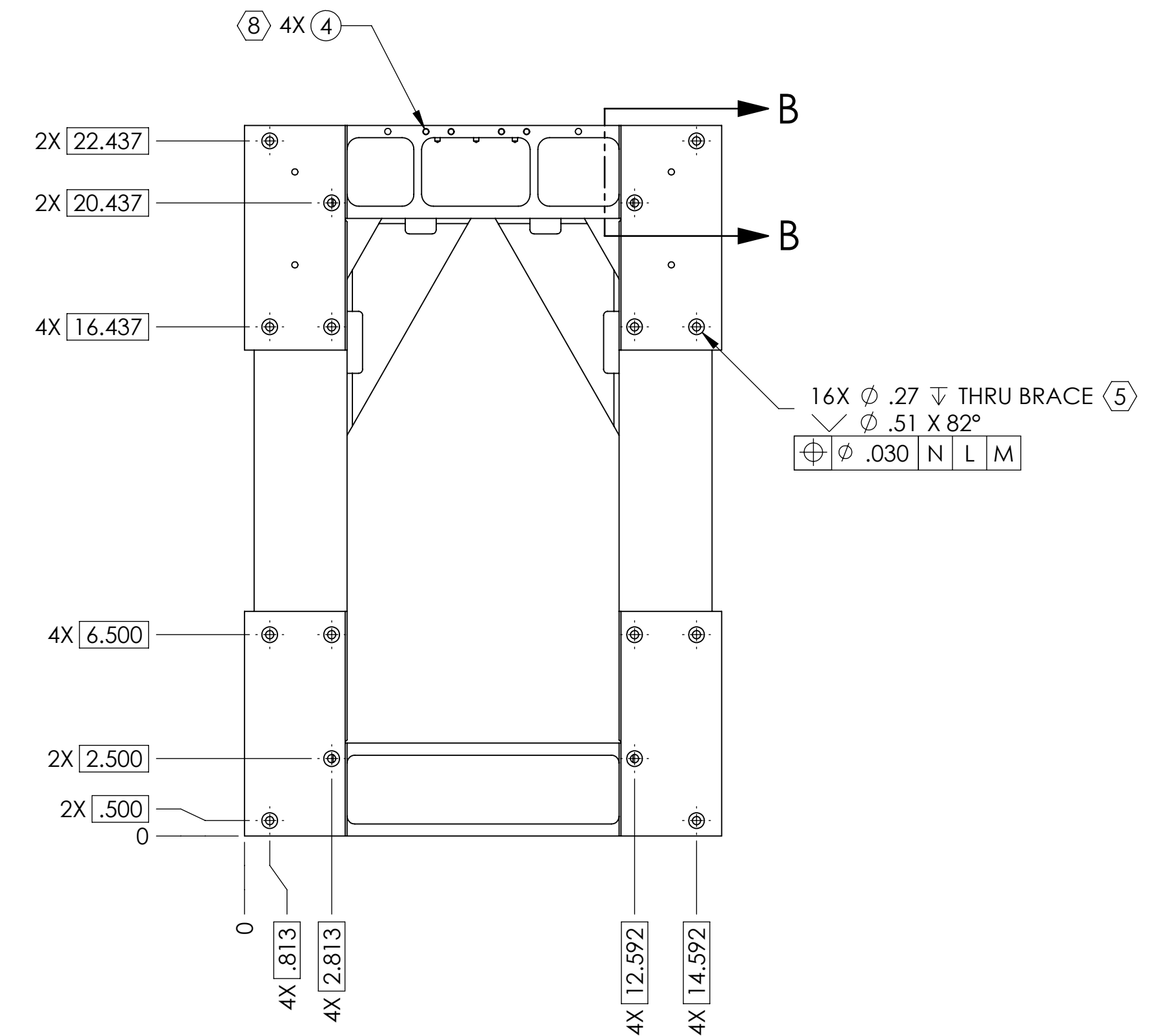
D0900655\_AsdLIGO\_OMC\_Structural Weldment Assembly - PART PDM REV: X-005. DRAWING PDM REV: X-007



DETAIL A  
SCALE 1 : 2  
4 PLACES  
OPPOSITE ON RIGHT SIDE



FRONT AND BACK VIEW



LEFT AND RIGHT SIDE VIEW