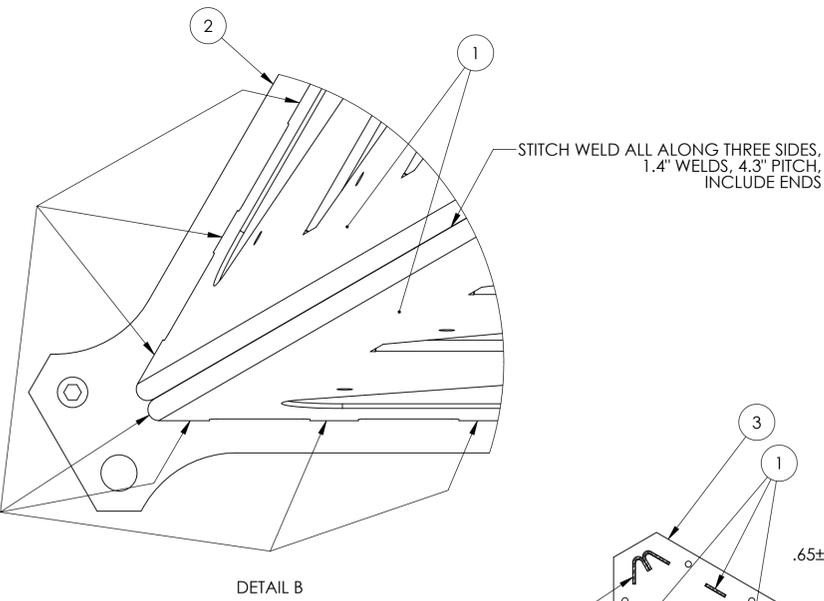
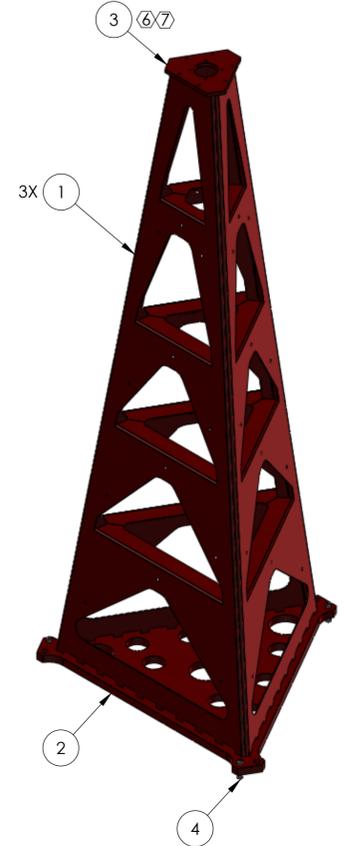
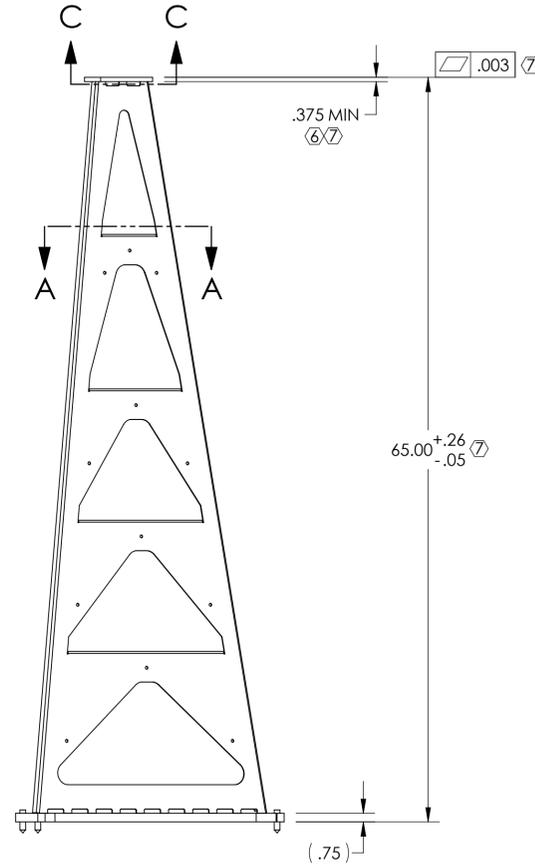
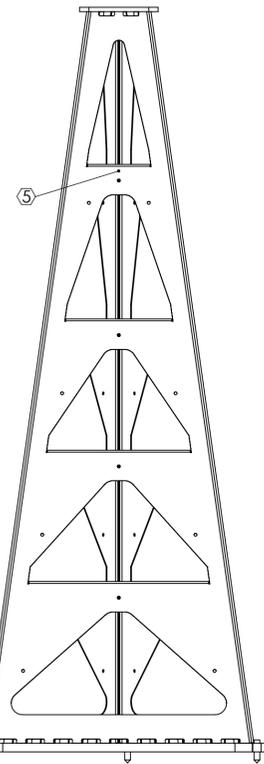
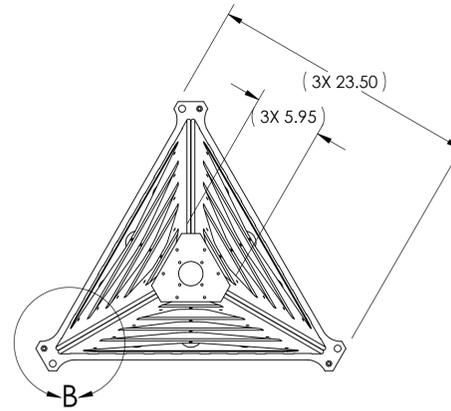
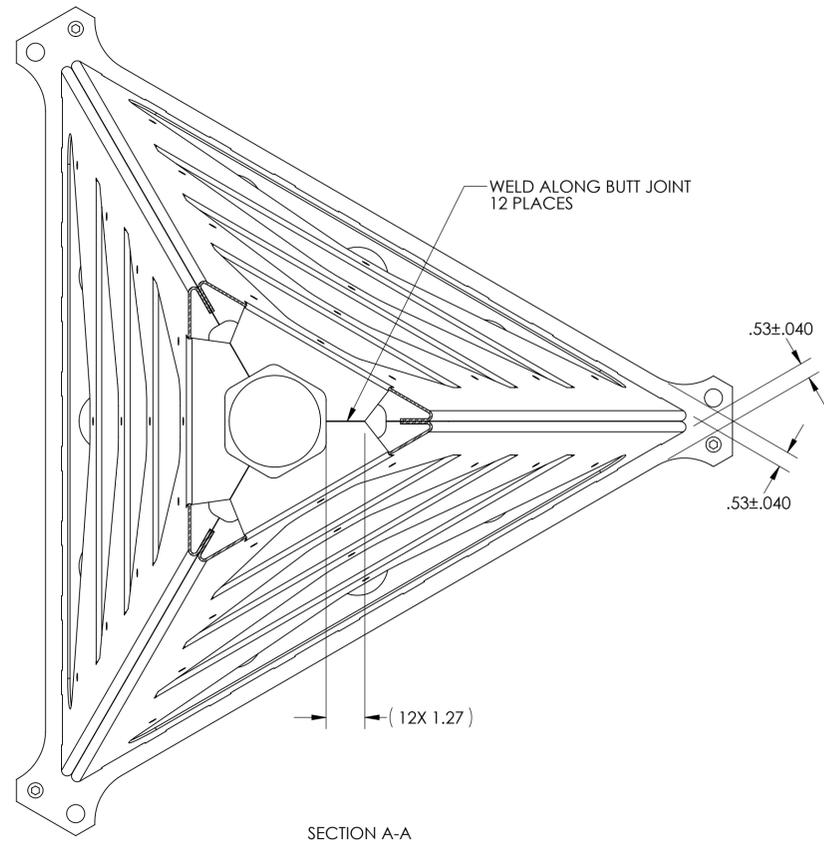


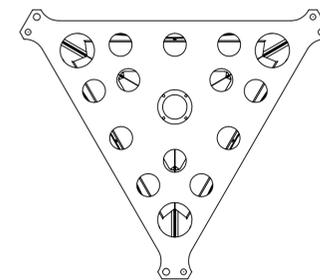
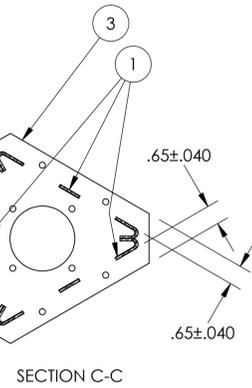
- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: 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
-	-	-	-



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

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



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	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	SIZE DWG. NO.
DRAFTER	C. CONLEY	16 JUNE 2009	D
CHECKER			D0900657
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