

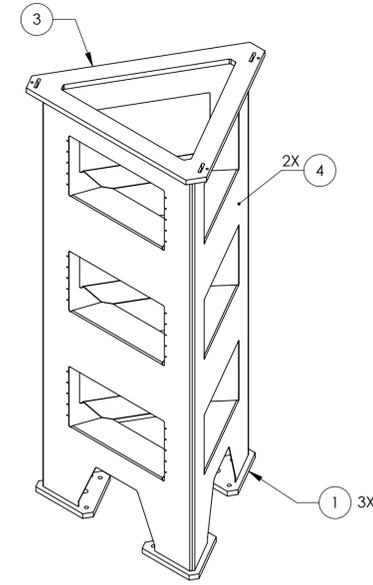
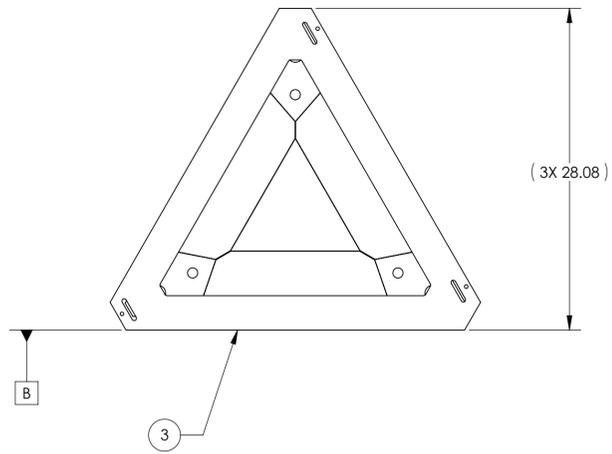
NOTES CONTINUED:

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.

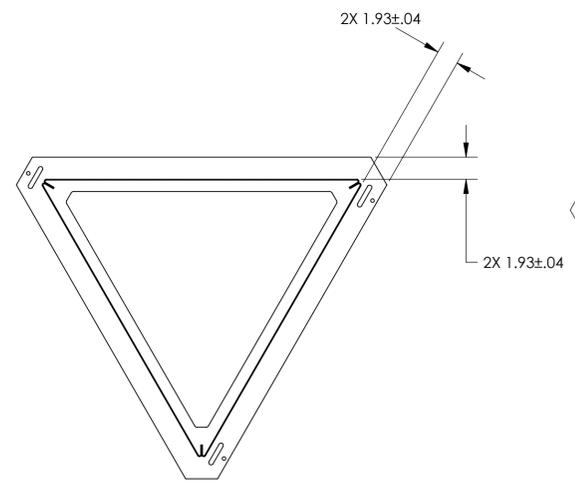
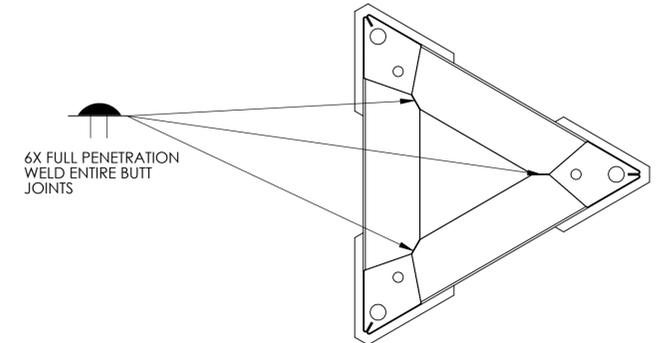
⑥ AFTER COMPLETION OF THE WELDMENT MACHINE AT TOP OF ITEM X TO NOTED SPECIFICATIONS IF NECESSARY, LEVEL THE UPPER FACE OF ITEM X (SQUARE WITH MACHINING HEAD) BEFORE MACHINING.

⑦ FASTEN ITEMS 1 TO D1XXXXXX FOOTING BEFORE APPLYING NOTED WELDS. TO ENSURE ALIGNMENT, FOR EACH ITEM X USE THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN FOOTING MUST BE REMOVABLE & RE-ATTACHABLE POST-WELD WITH NO BINDING OF SCREWS, TO BE DELIVERED WITH FOOTING ATTACHED.

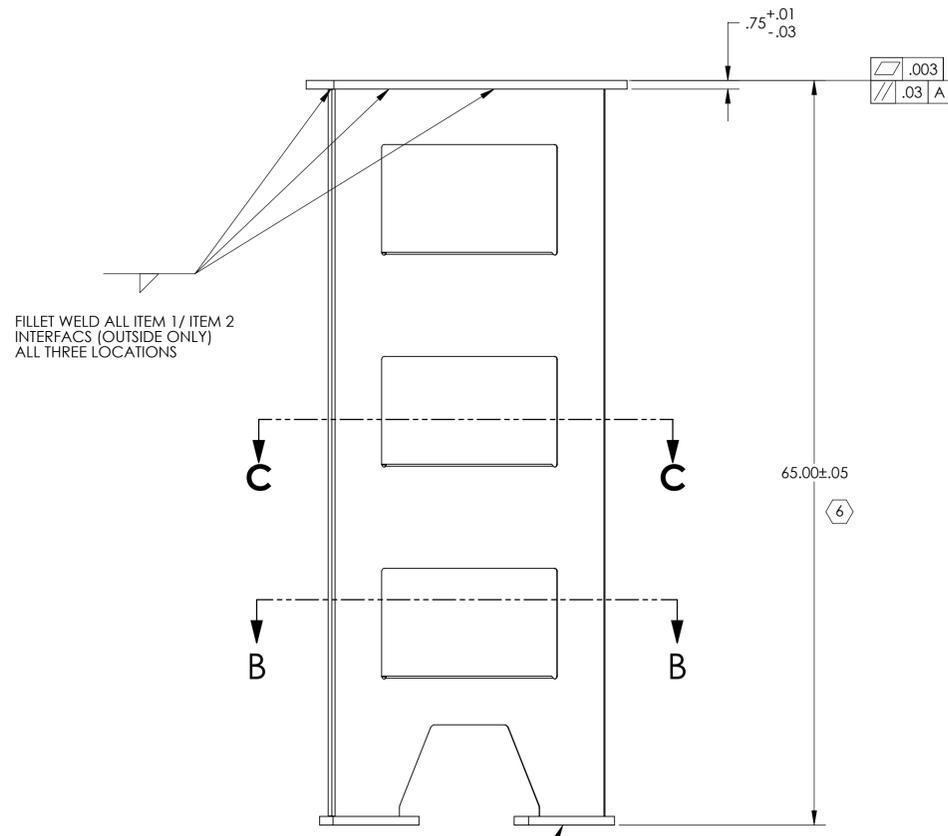
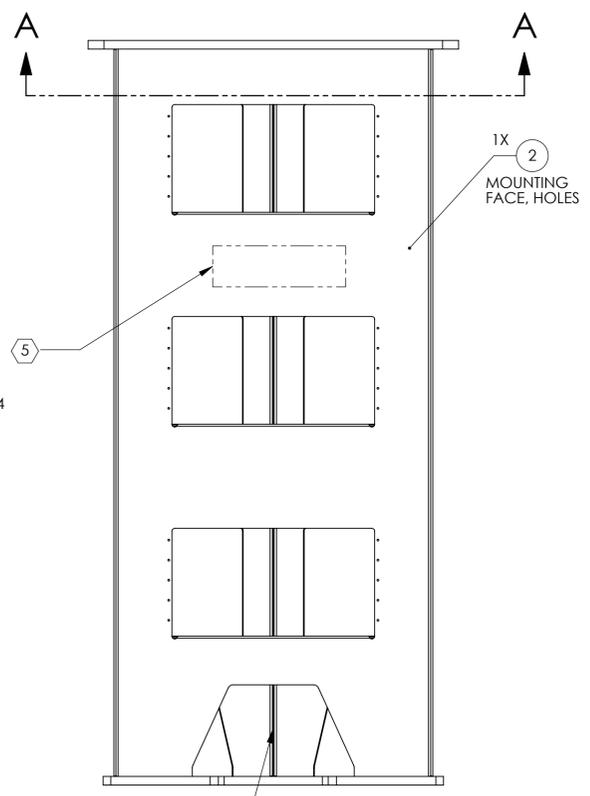
⑧ WARRPAGE OF ITEMS 1, 3, & FOOTING TO BE MINIMIZED USING PREFERRED METHOD, IE, HEAT SINKING.



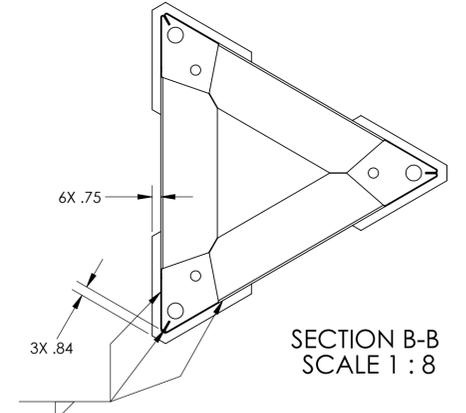
REV.	DATE	DCN #	DRAWING TREE #
v1	11 JUL 2011		
v2	2 FEB 2012		



SECTION A-A
SCALE 1:8



SECTION C-C
SCALE 1:8



SECTION B-B
SCALE 1:8

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	LLO/ QTY.	SPARE	TOTAL
4	D1000672-2	No Mounting Holes	304 SSSL	2		0
3	D1000673	ADLIGO AOS PHOTCAL TX PIER TABLE	304 SSSL	1		0
2	D1000672-1	Side Panel with Holes	304 SSSL	1		0
1	D1000677	ALIGO AOS PIER BASE 3 (LHO)	304 SSSL	3		0

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
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: D1000676

PART NAME: aLIGO AOS PhotCal TX Pier Weldment

DESIGNER: R SAVAGE	2/1/12	SIZE: D	DWG. NO. D1000675	REV. v2
DRAFTER: I ROMERO	2/1/12	SCALE: 1:16	PROJECTION:	SHEET 1 OF 1
CHECKER:				
APPROVAL:				

D1000675 aLIGO AOS PhotCal TX Pier Weldment (LLO) PART PDM REV: X.002 DRAWING PDM REV: X.003