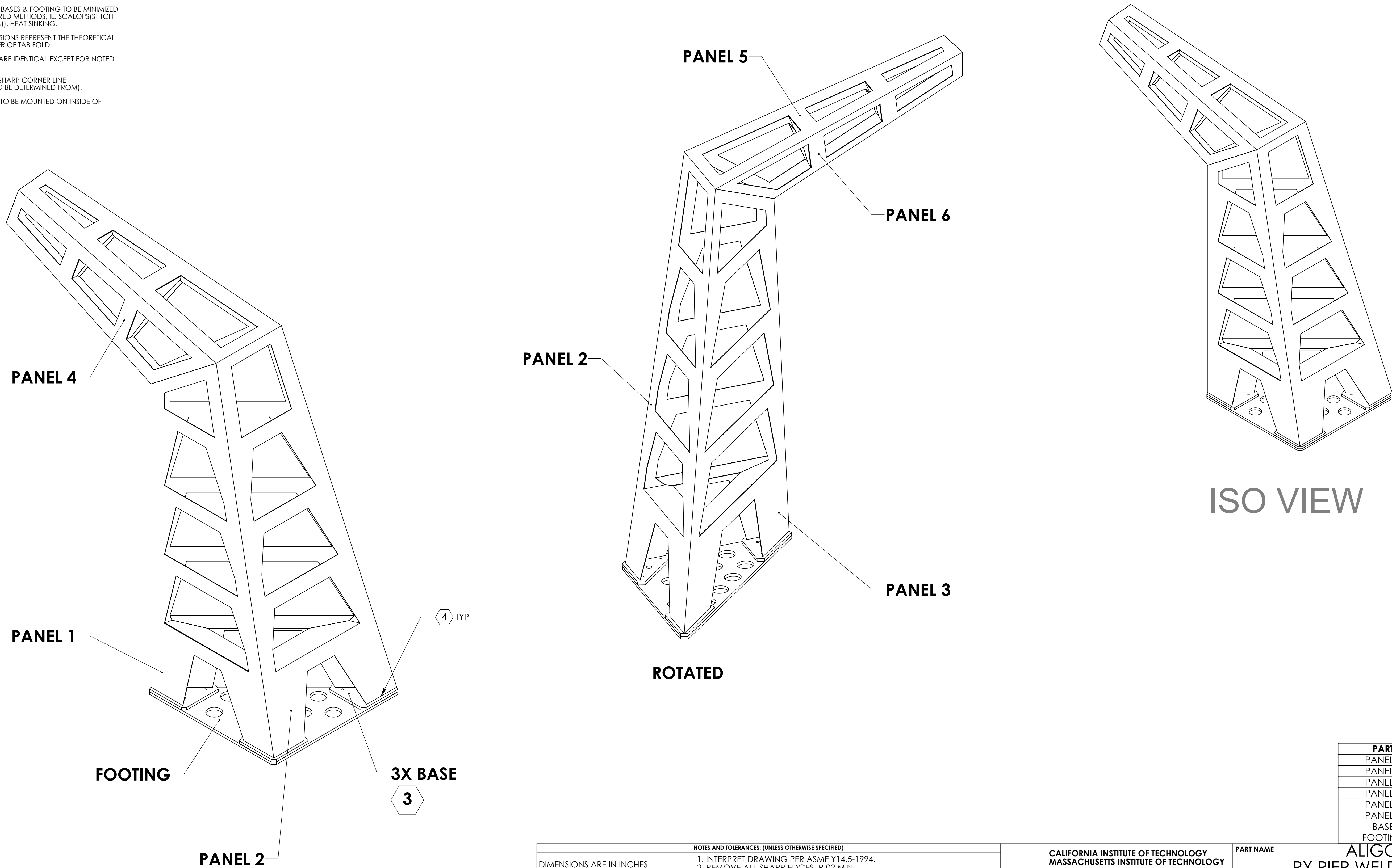


**NOTES CONTINUED:**

1. STRUCTURE SHOWN & DIMENSIONED WITH SHARP ADJOINING PANEL CORNERS. ACTUAL PANELS TO BE BENT SIMILARLY TO D1001292 PANELS AT ADJOINING CORNERS. DIMENSIONS TO SAID SHARP CORNERS ARE FOR ESTABLISHING STRUCTURAL SIZE & SHAPE ONLY.
2. ALL BEND RADII .125.
- ③ BASES TO BE FASTENED TO FOOTING DURING WELDING OF BASES TO PANELS. FASTEN EACH BASE USING THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN FOOTING. FOOTING MUST BE REMOVABLE & RE-ATTACHABLE. POST-WELD, WITH NO BINDING OF SCREWS. WELDMENT TO BE DELIVERED WITH FOOTING ATTACHED.
- ④ WARPAGE OF BASES & FOOTING TO BE MINIMIZED USING PREFERRED METHODS, IE. SCALOPS(STITCH WELDING (50%)), HEAT SINKING.
- ⑤ NOTED DIMENSIONS REPRESENT THE THEORETICAL SHARP CORNER OF TAB FOLD.
- ⑥ FOLDED TABS ARE IDENTICAL EXCEPT FOR NOTED DIMENSIONS.
- ⑦ THEORETICAL SHARP CORNER LINE (BEND LINES TO BE DETERMINED FROM).
- ⑧ ALL PEM NUTS TO BE MOUNTED ON INSIDE OF WELDMENT.

REV.	DATE	DCN #	DRAWING TREE #
v1	18 AUG 2010	E1000182-v1	-
-	-	-	-
-	-	-	-



ISO VIEW

ROTATED

PART	MATERIAL	FINISH
PANEL 1	304 SST SHEET, 12 GAUGE	STOCK FINISH/AS RECEIVED
PANEL 2		
PANEL 3		
PANEL 4		
PANEL 5		
PANEL 6		
BASE	304 SSTL	63 micro inch
FOOTING	302 SSTL	

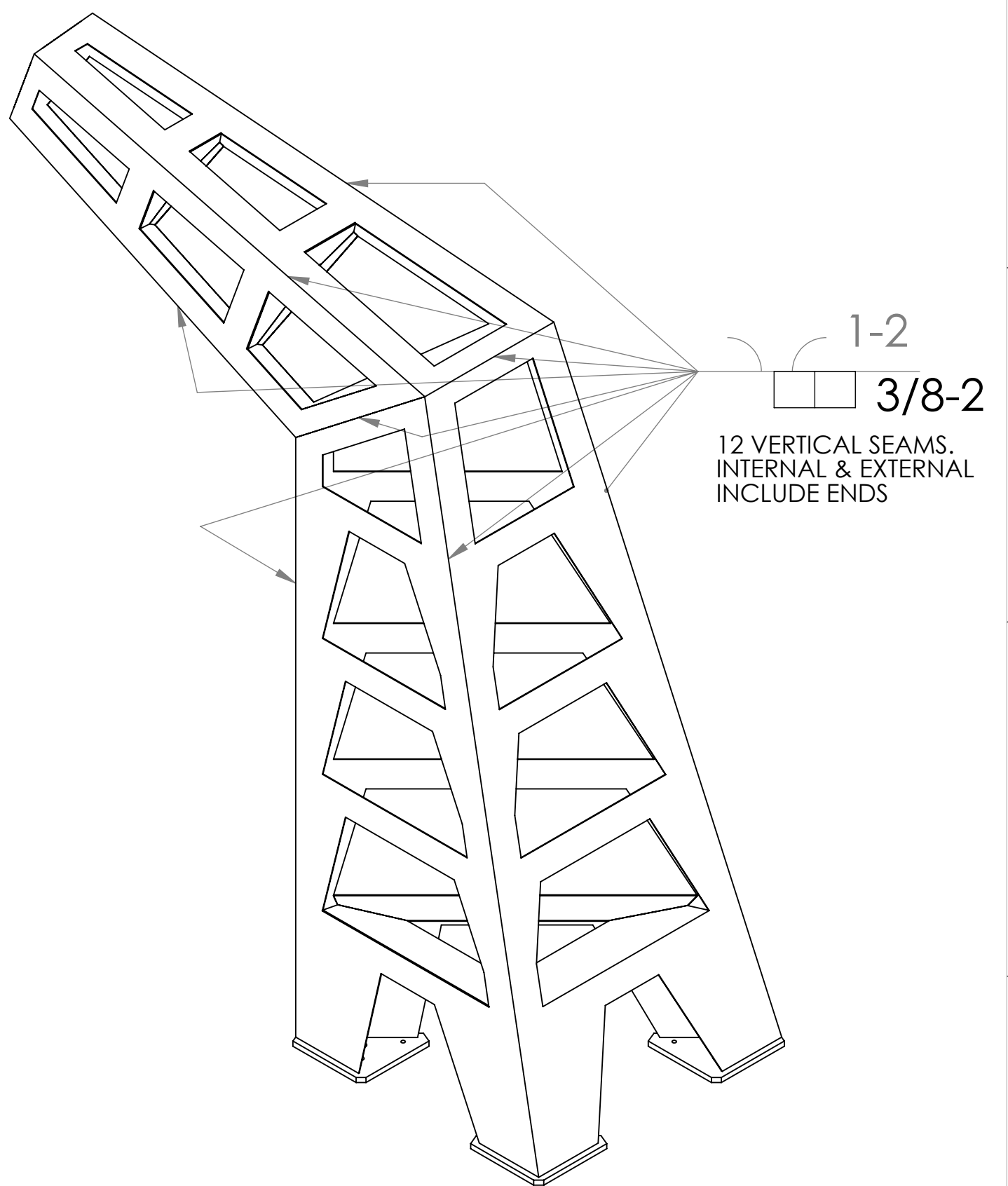
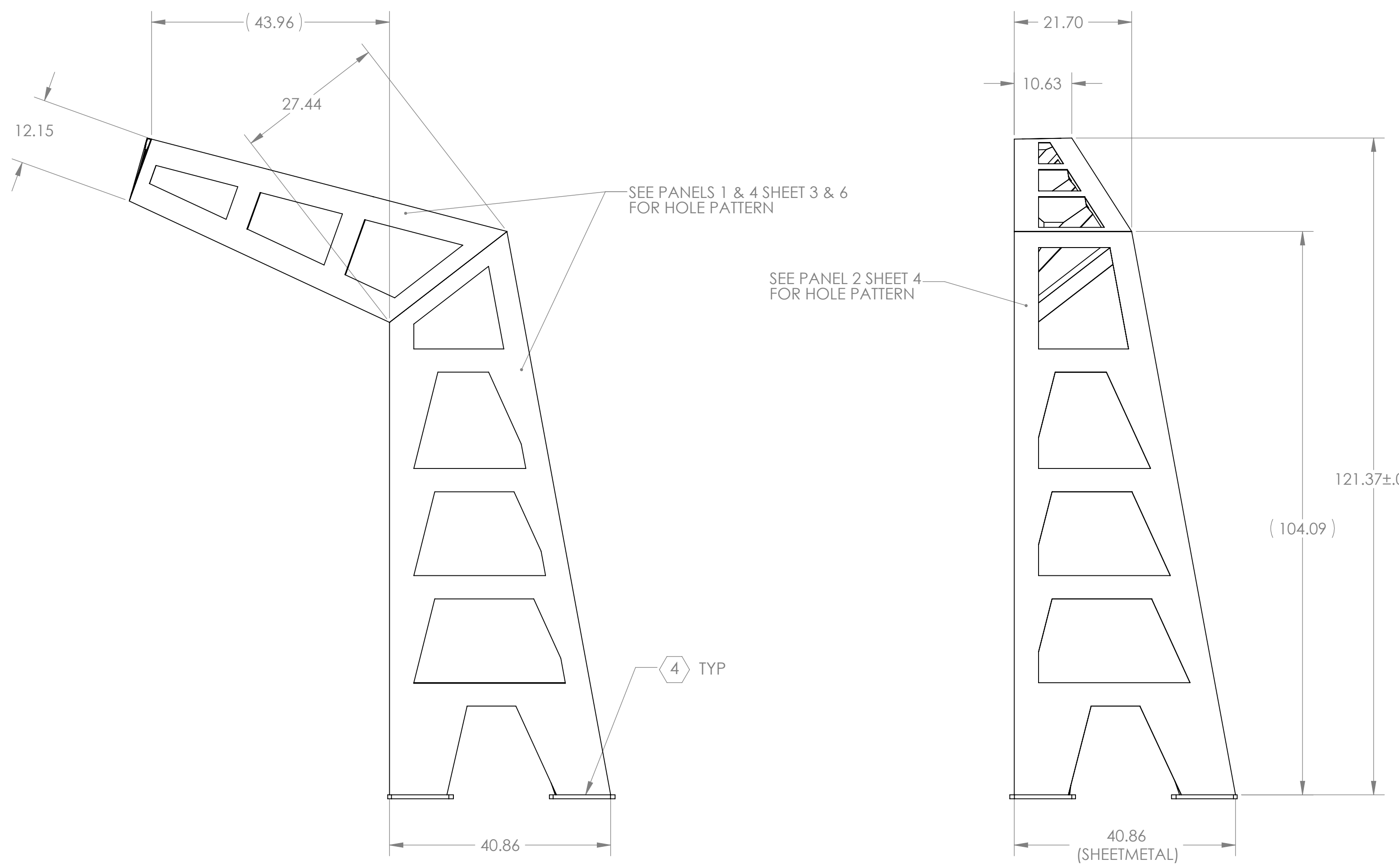
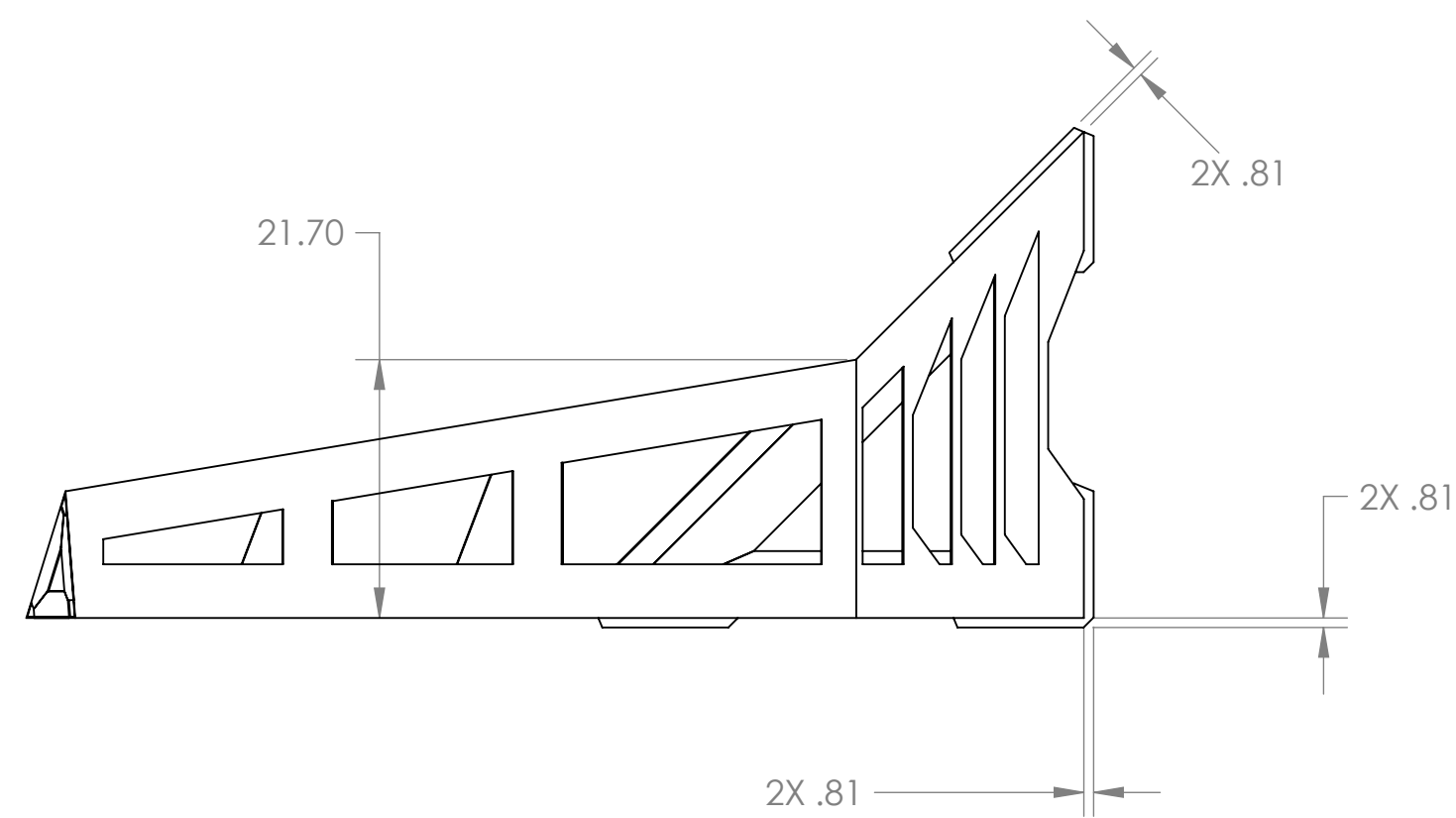
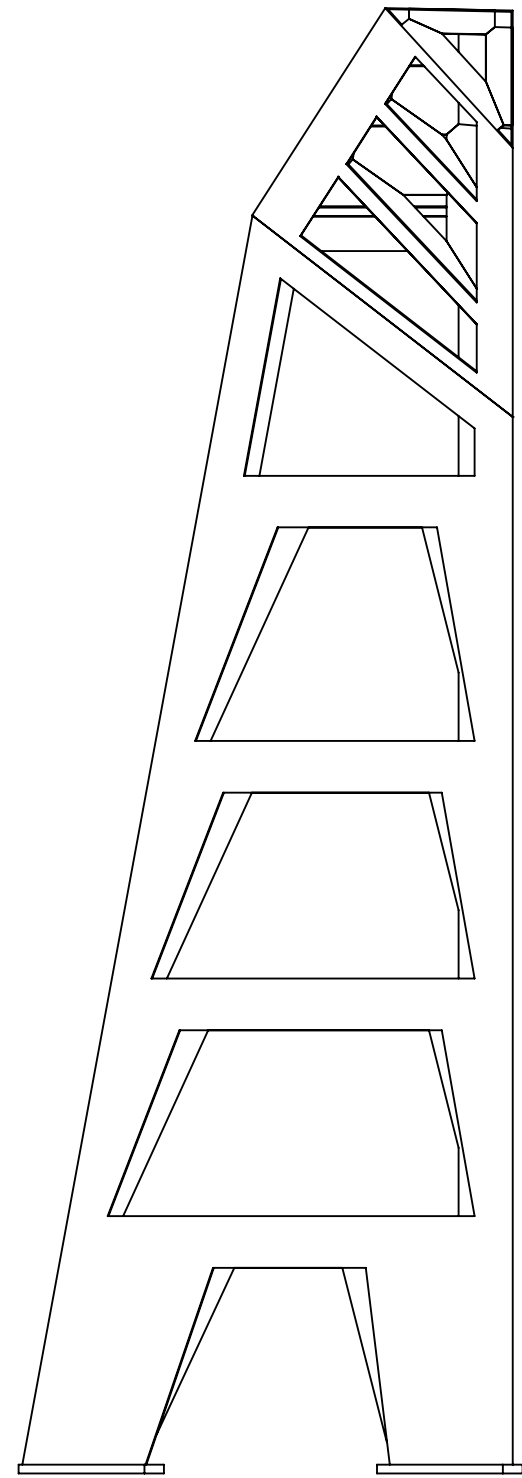
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± N/A °				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		ALIGO AOS OPLEV RX PIER WELDMENT LH (PR3, SR3)					
						SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER C CONLEY	DATE 29 APR 2010	SIZE D	DWG. NO. D1002207
MATERIAL REFER TO TABLE		FINISH REFER TO TABLE		NEXT ASSY		SCALE: 1:12		PROJECTION:		SHEET 1 OF 10	

D:\002207\aligo\_aos\_oplev\Rx\_Pier\_Weldment\_LH (PR3, SR3).PART.PDM.REV.X-051.DRAWING.PDM.REV.X-035

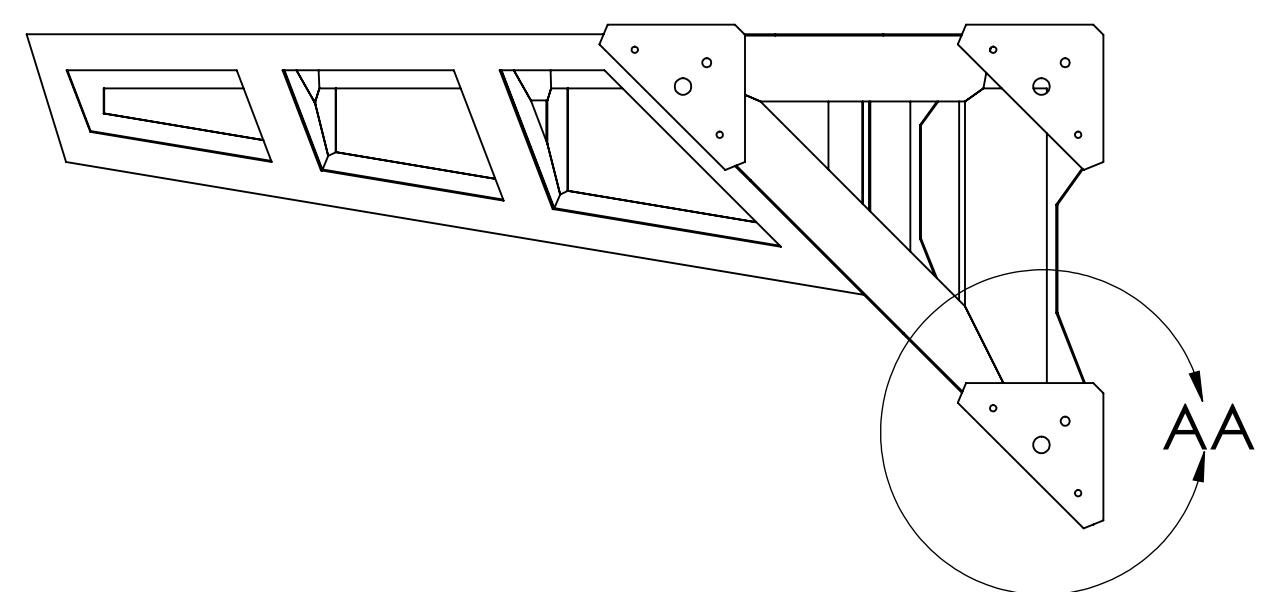
8 7 6 5 4 3 2 1

H  
G  
F  
E  
D  
C  
B  
A

H  
G  
F  
E  
D  
C  
B  
A



**WELDMENT**

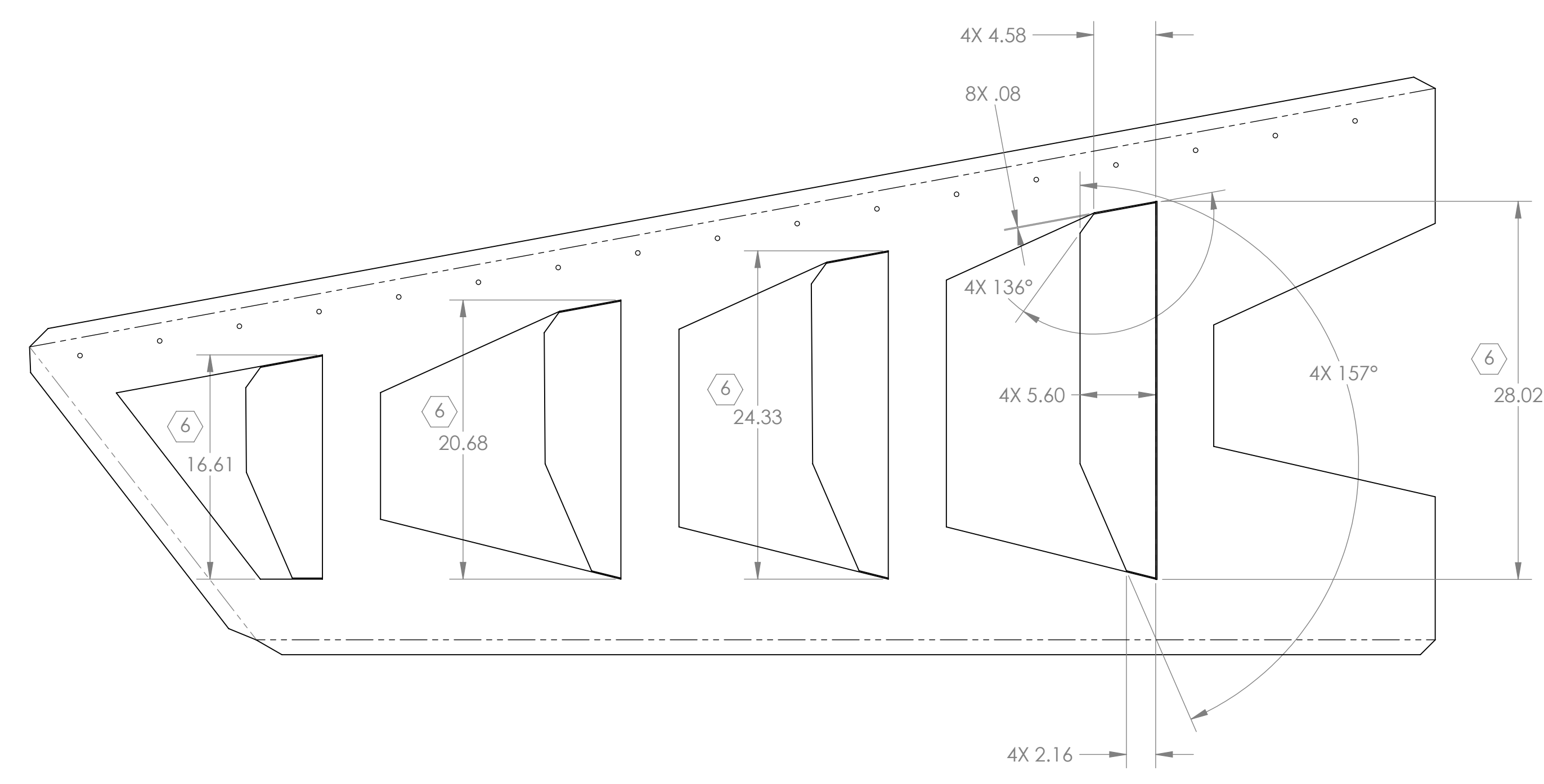
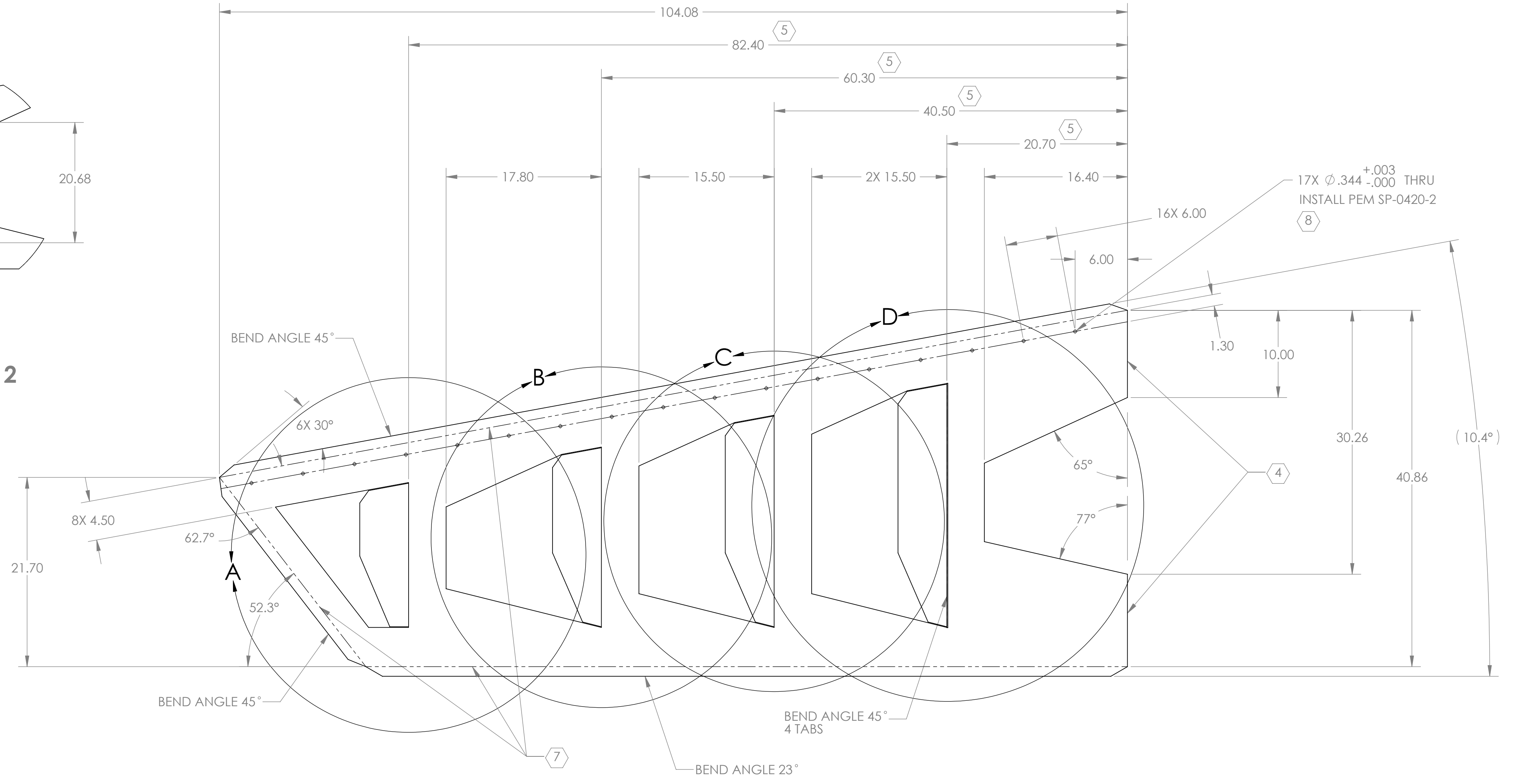
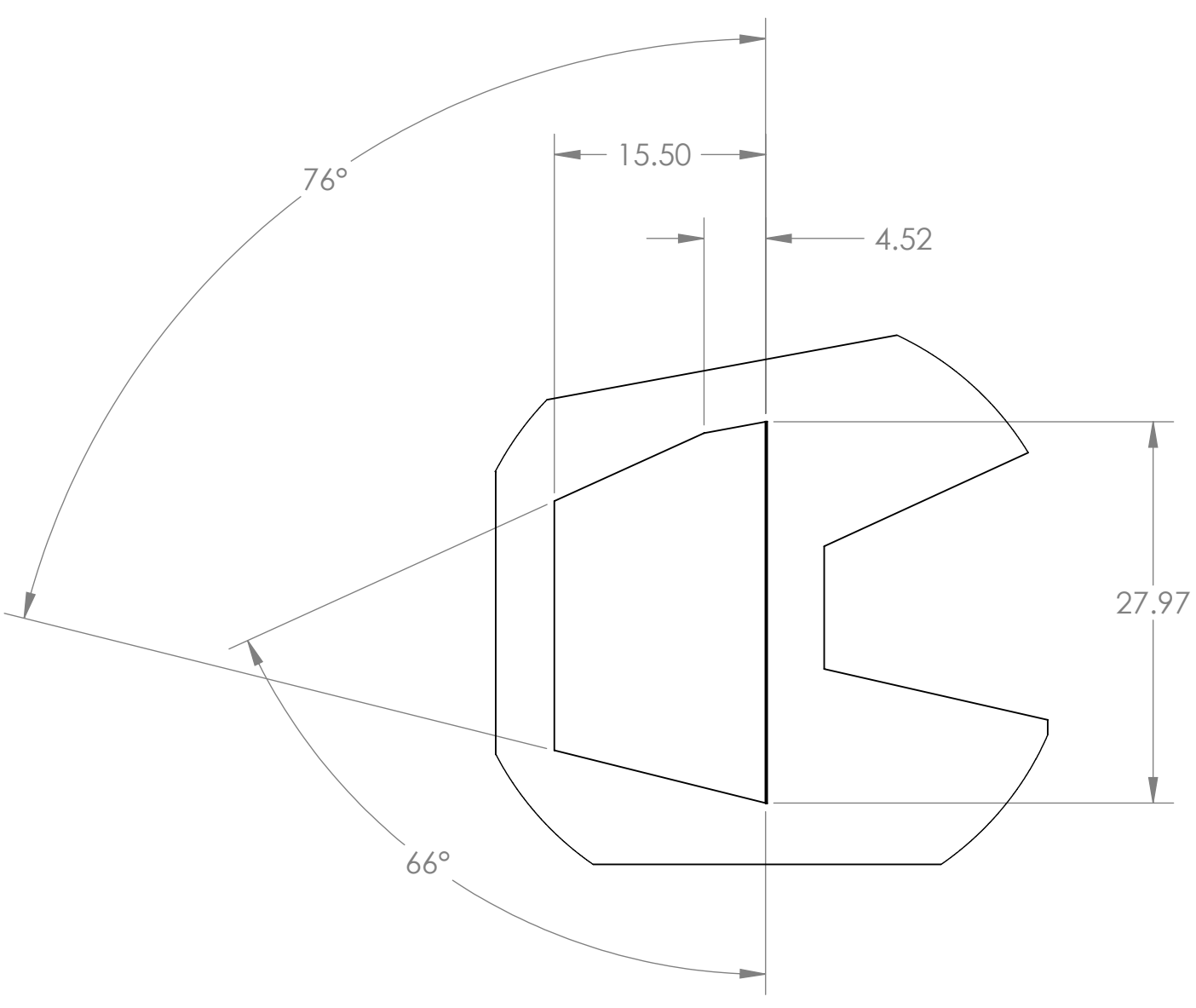
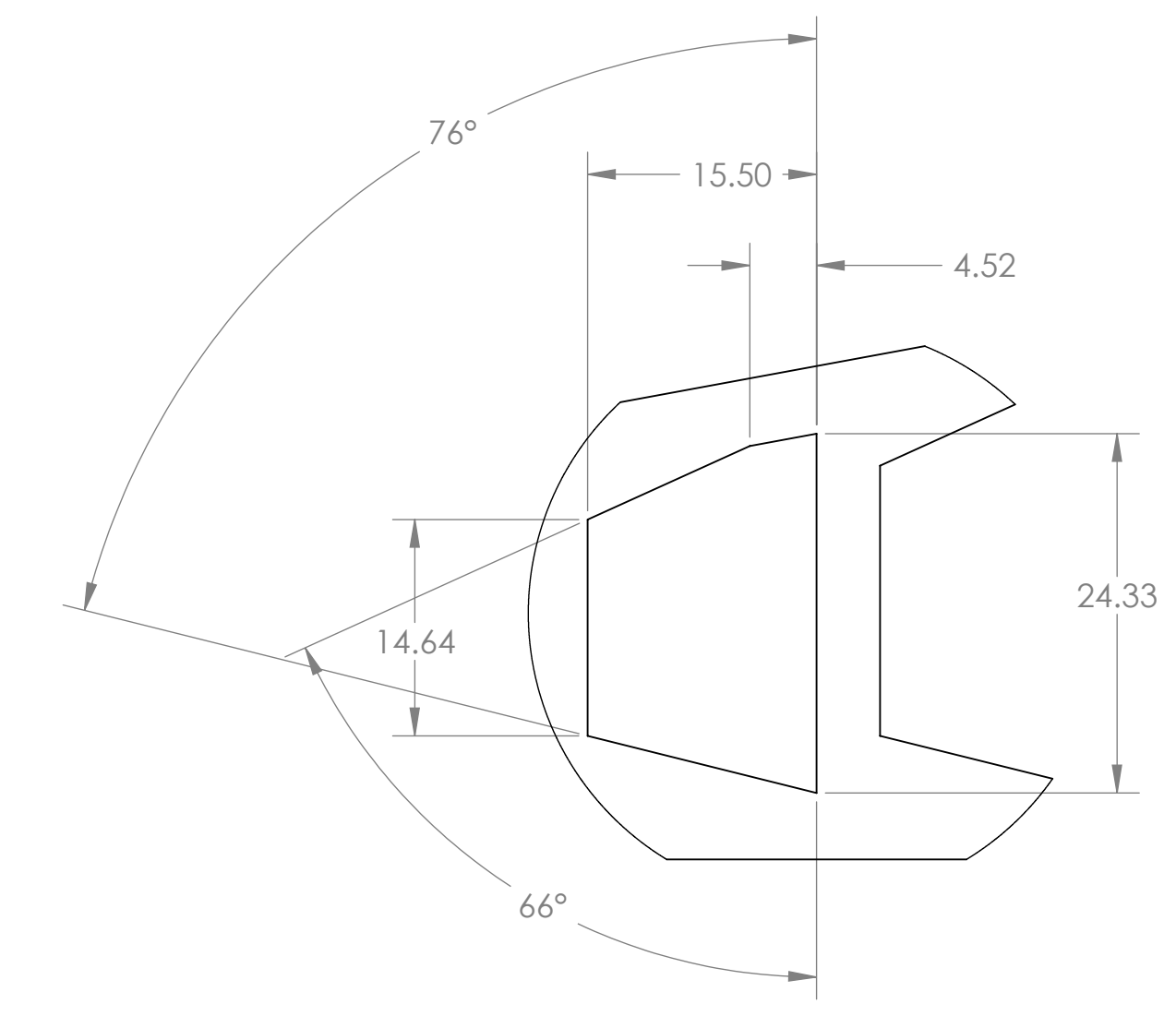
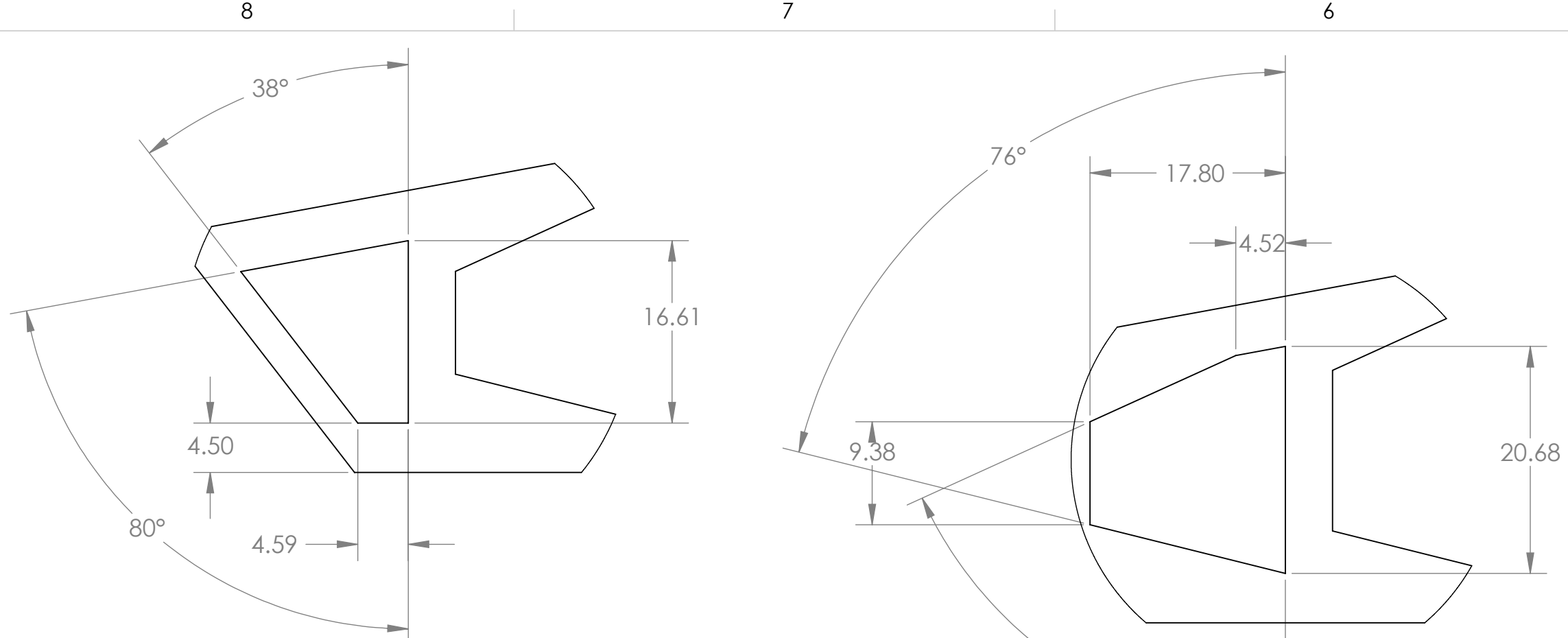


REMOVE FOOTING VIEW FOR CLARITY

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
<b>D</b> <b>D1002207</b>	<b>v1</b>
SCALE: 1:16	PROJECTION:  SHEET 2 OF 10

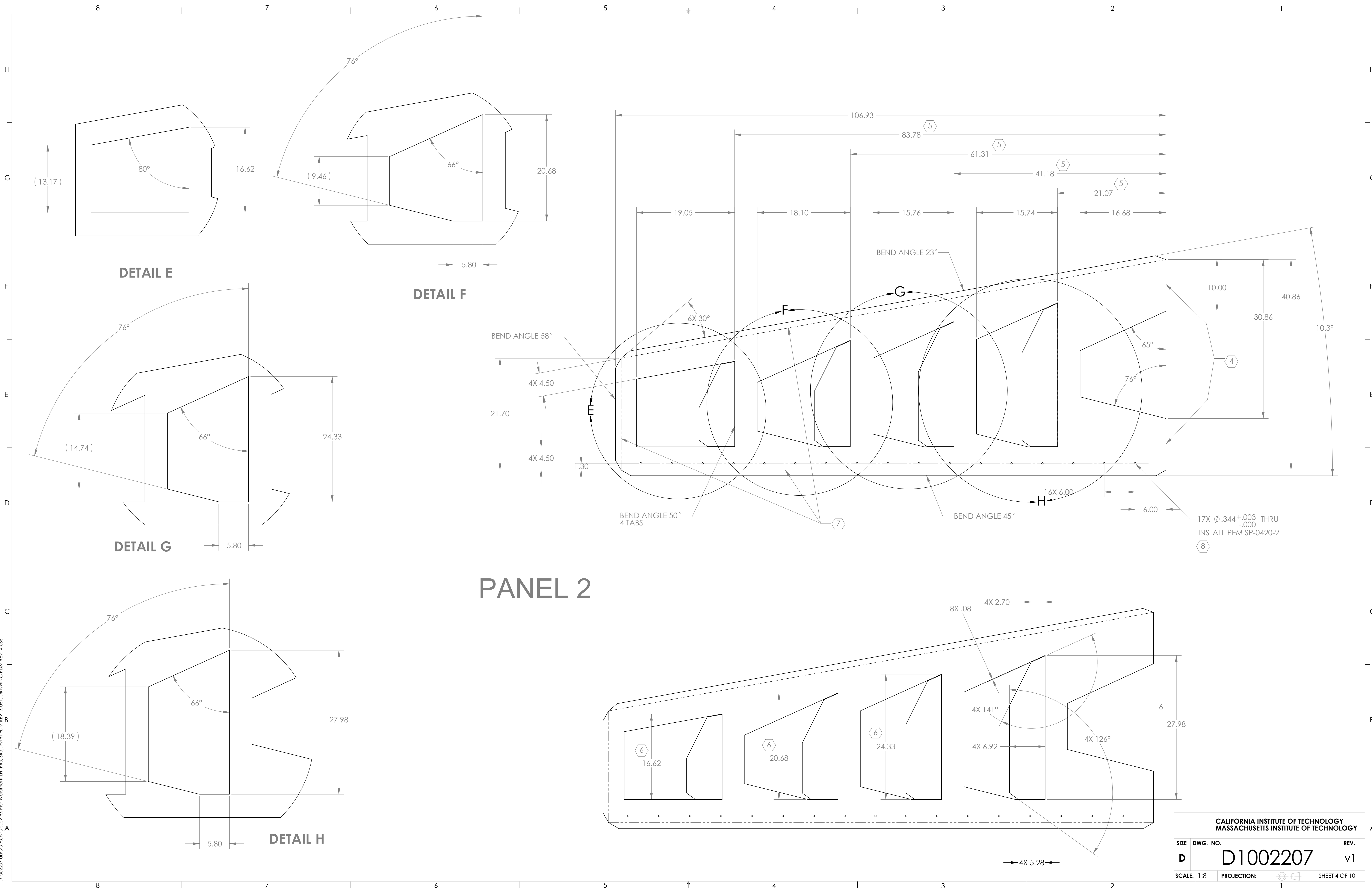
D:\002207\dligo\ACS\Ocl\ev-RX\Pier Weldment LH (PES, SB3).PART PDM\_REV-X.051.DRAWING PDM\_REV-X.055

8 7 6 5 4 3 2 1



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE DWG. NO.	D	D1002207
REV.		v1
SCALE: 1:8	PROJECTION:	SHEET 3 OF 10

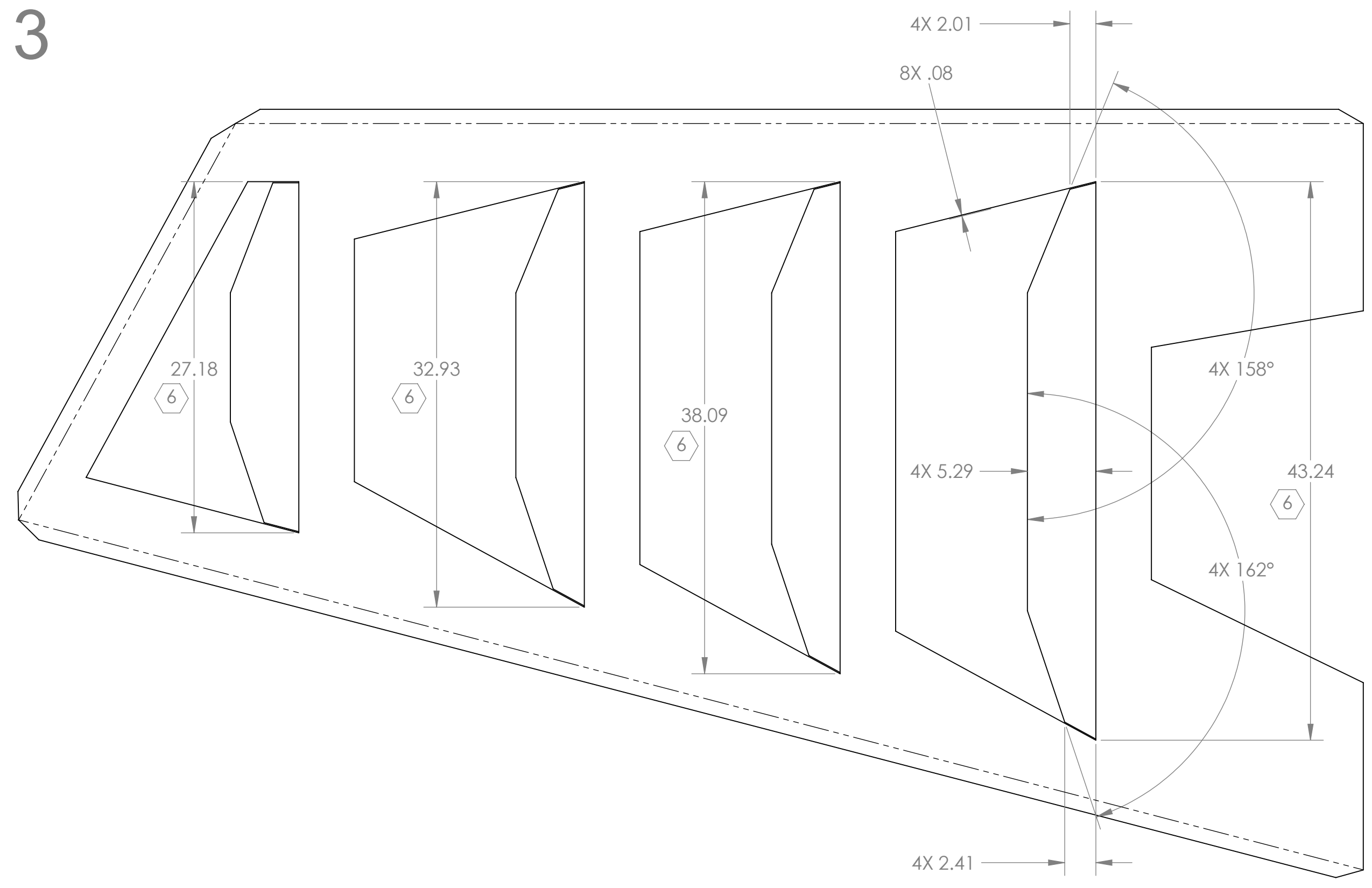
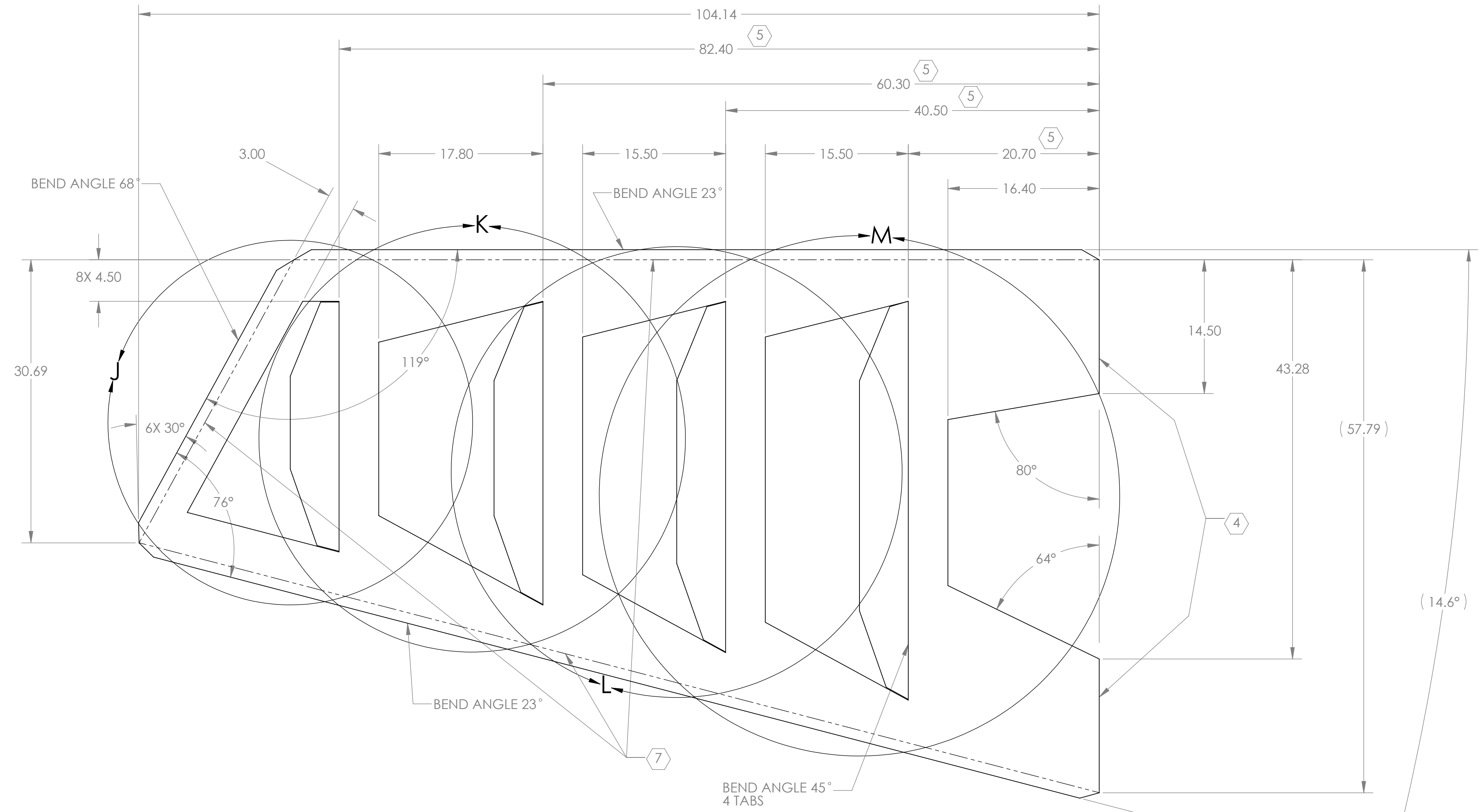
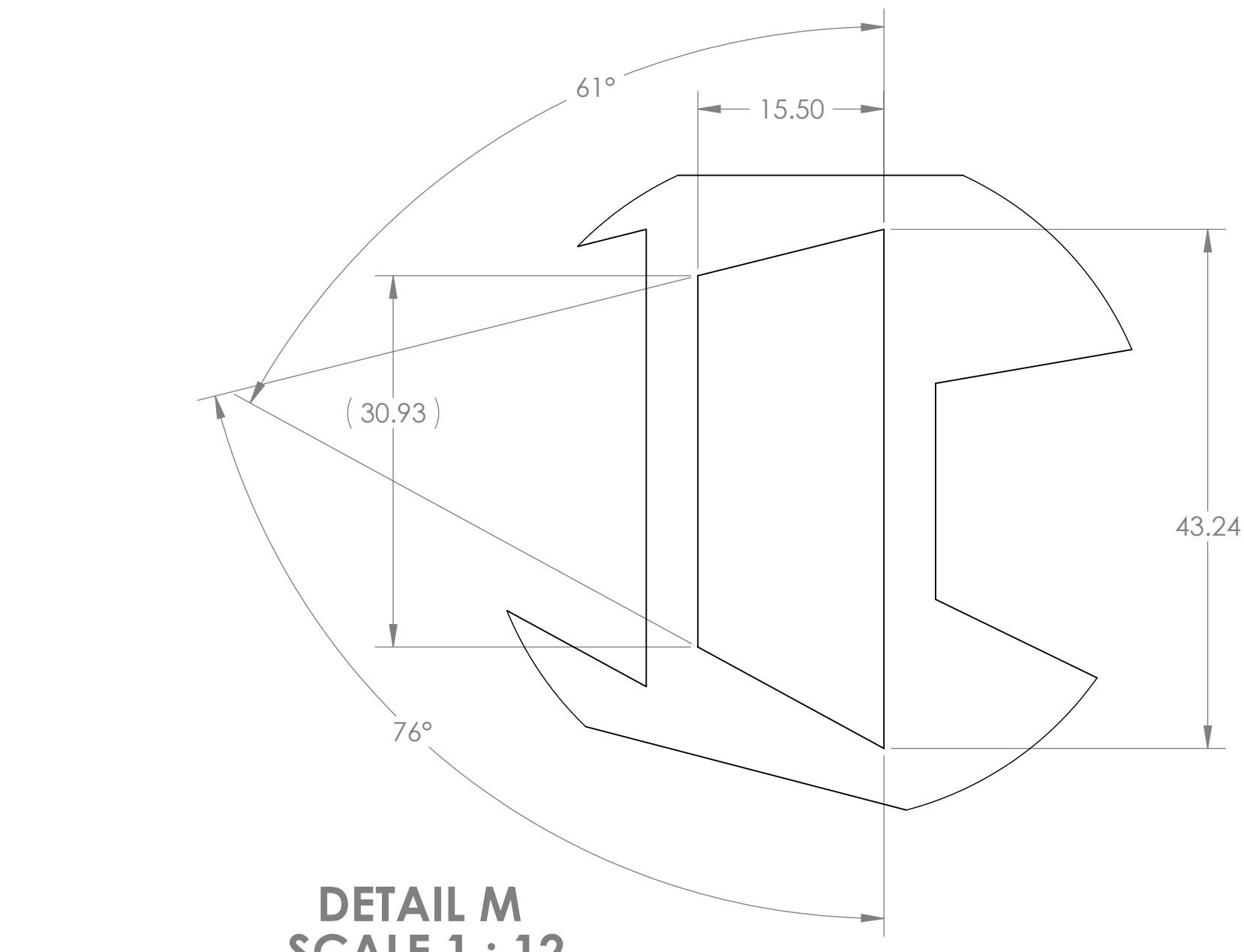
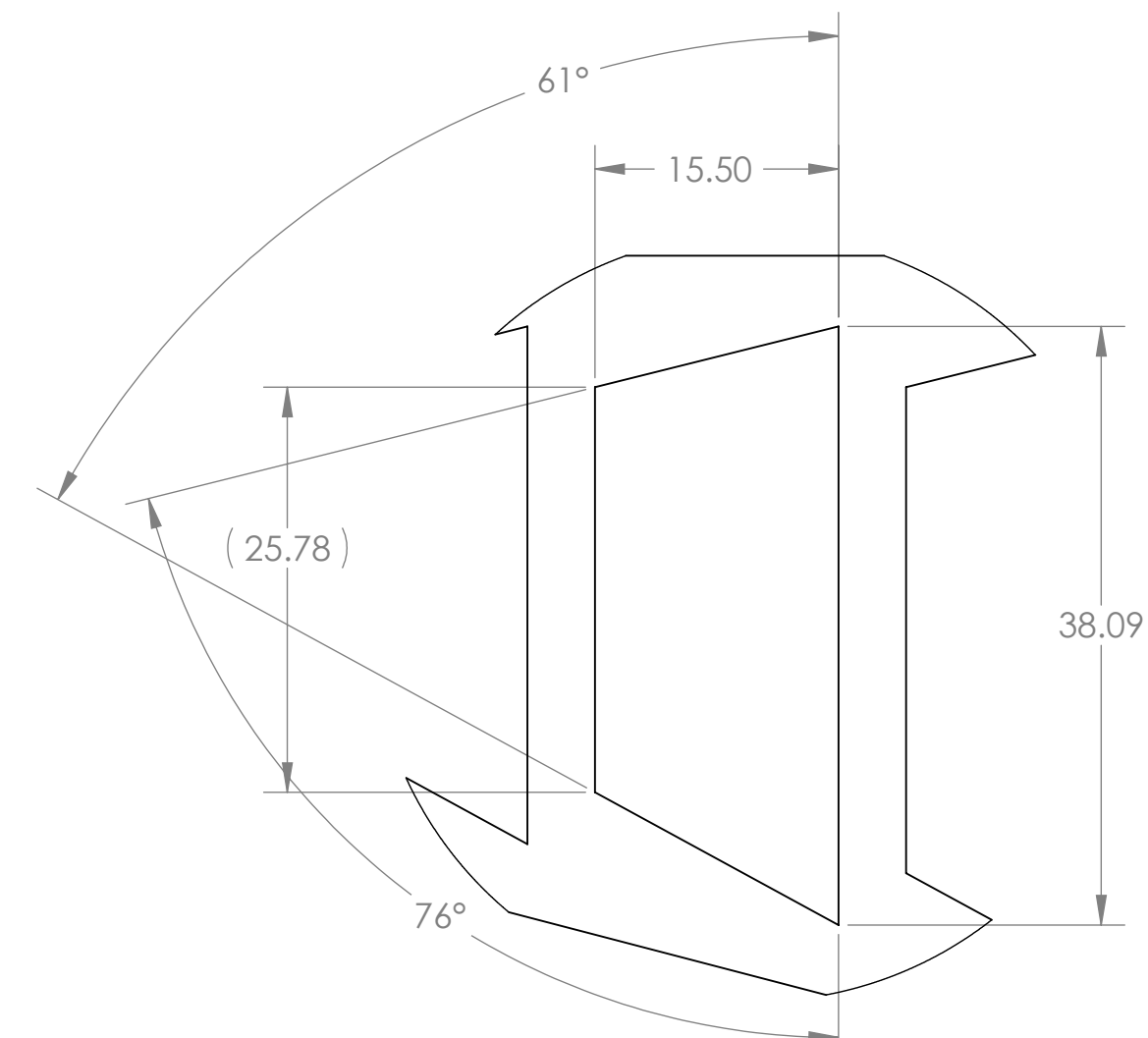
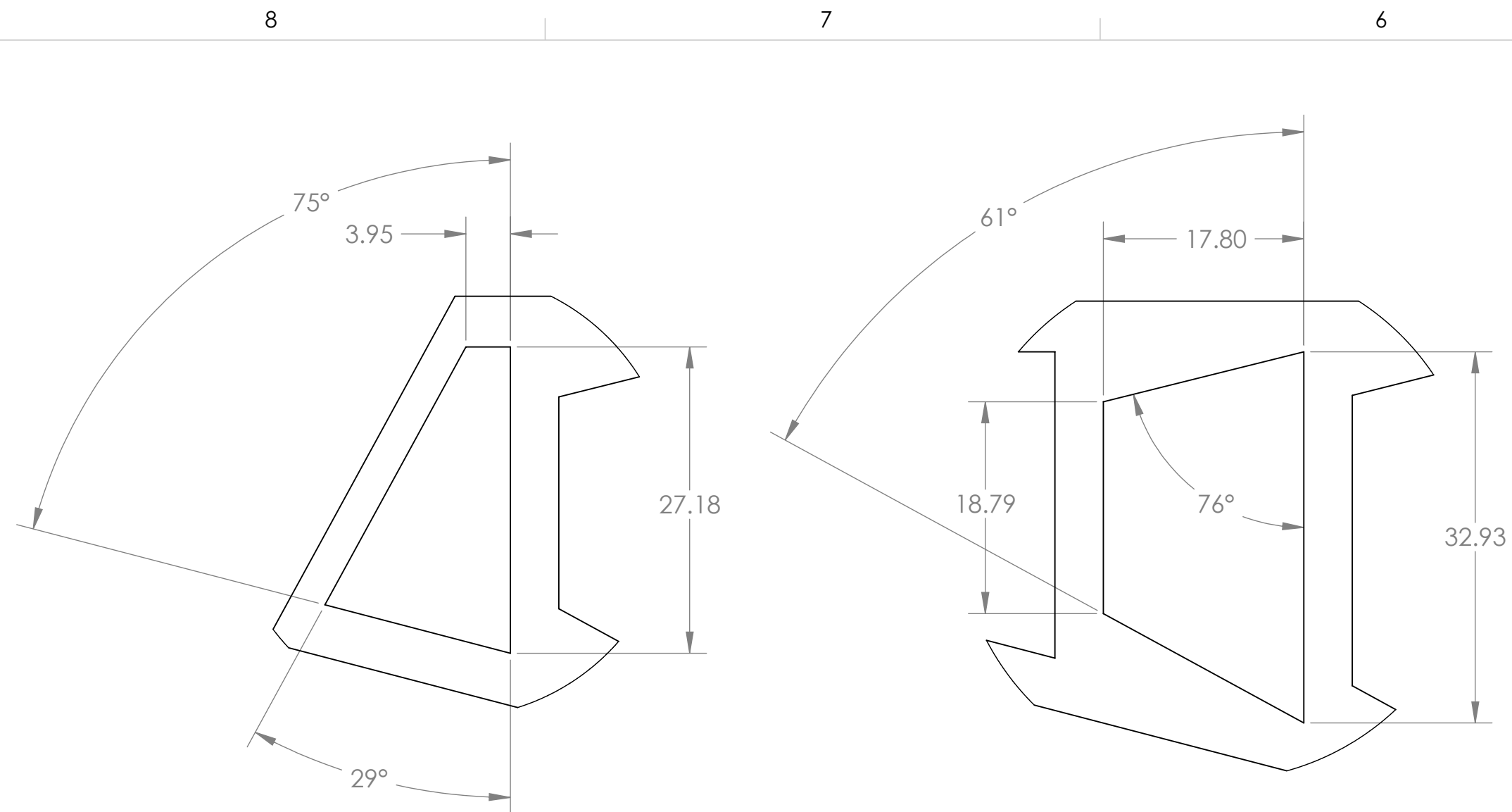
D1002207.dwg: ACS Octave: RX Pipe Weldment LH (PRL, S3), PART PDM REV: X051, DRAWING PDM REV: X055



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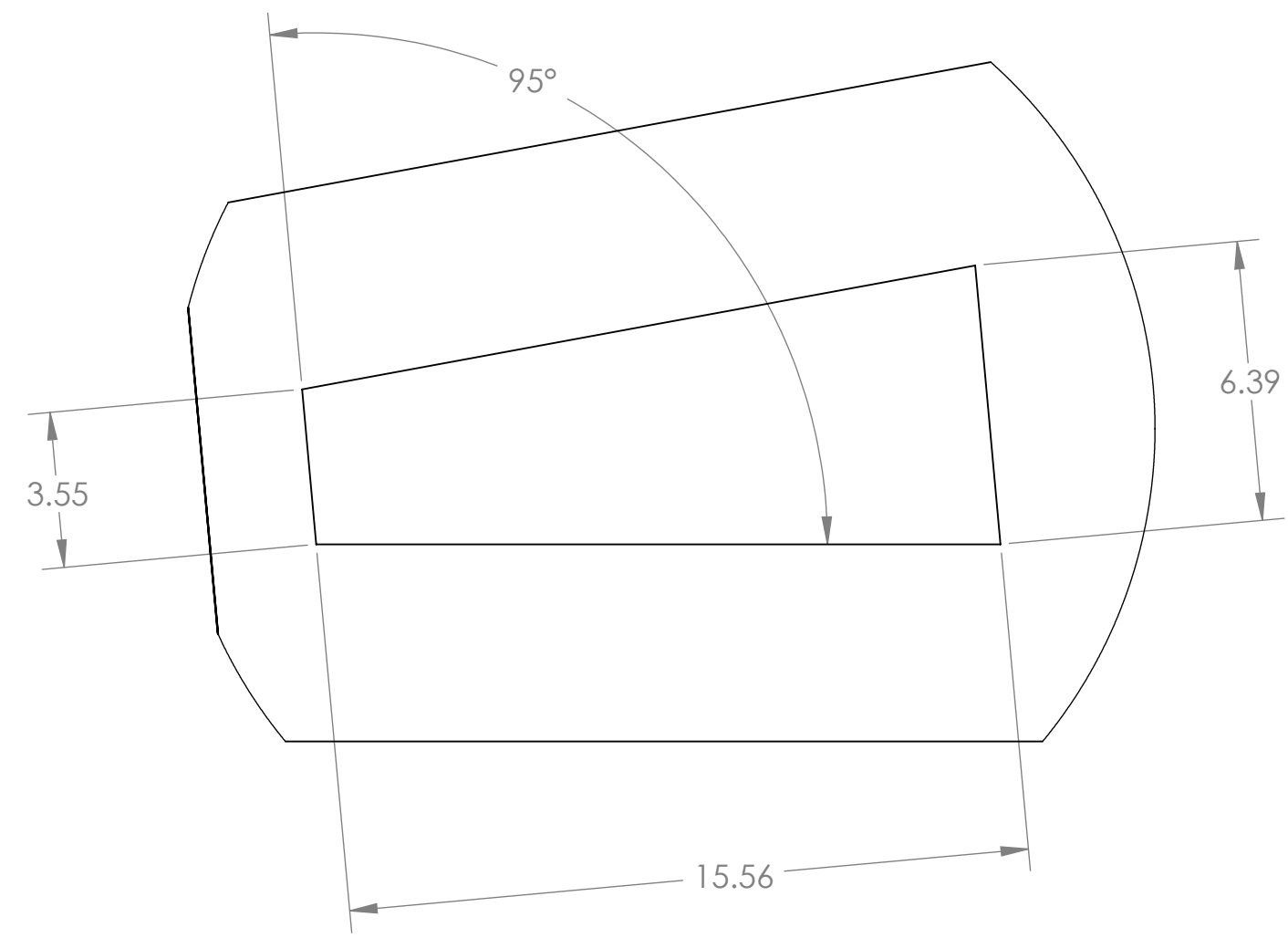
SIZE	DWG. NO.	REV.
D	D1002207	v1
SCALE: 1:8	PROJECTION:	SHEET 4 OF 10

D:\002207.dwg ACS Octave RP Fiber Weldment LH (PES, S3), PART PDM REV: X.051, DRAWING PDM REV: X.035

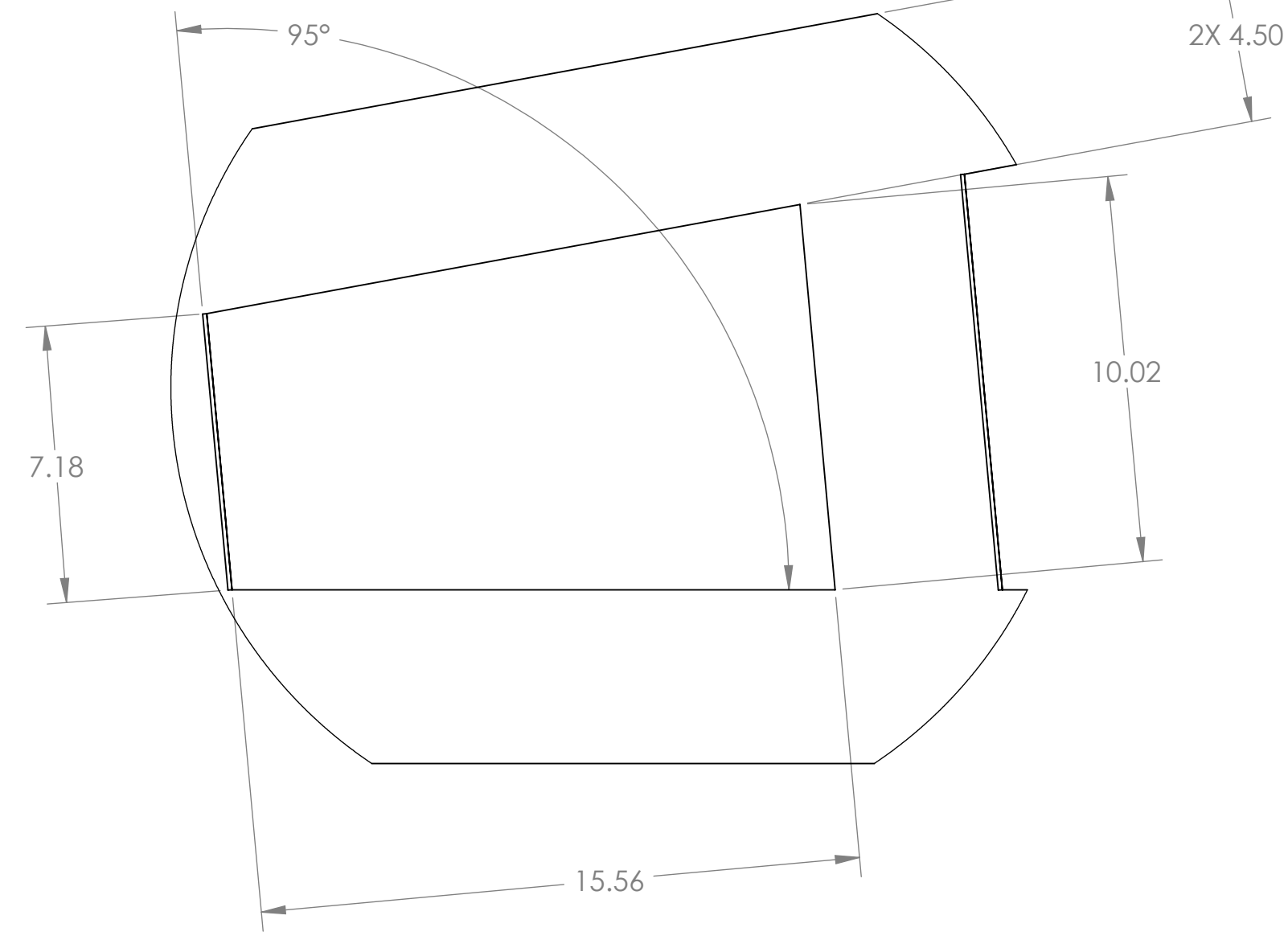


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE DWG. NO.	D	D1002207
REV.		v1
SCALE: 1:8	PROJECTION:	SHEET 5 OF 10

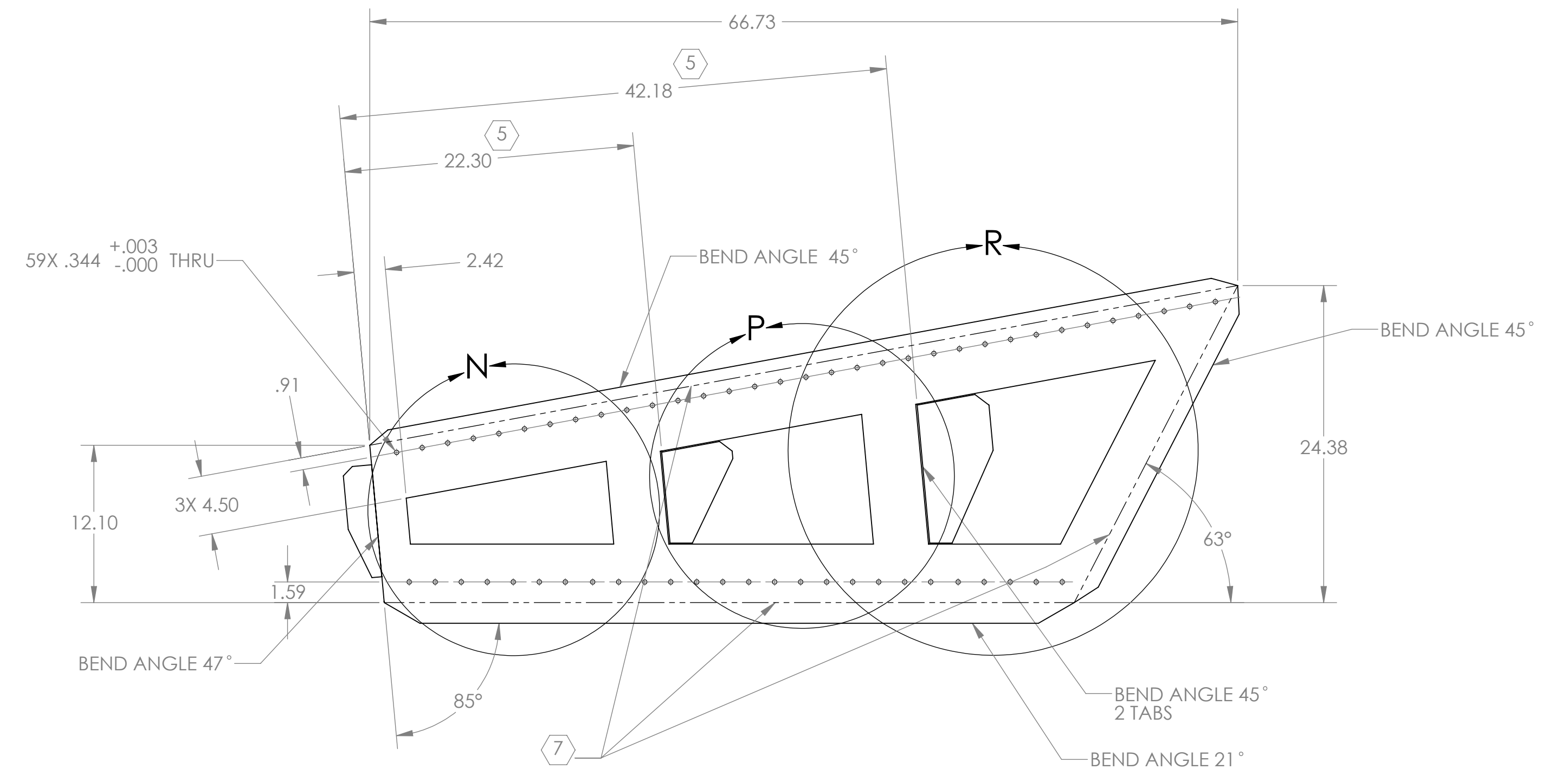
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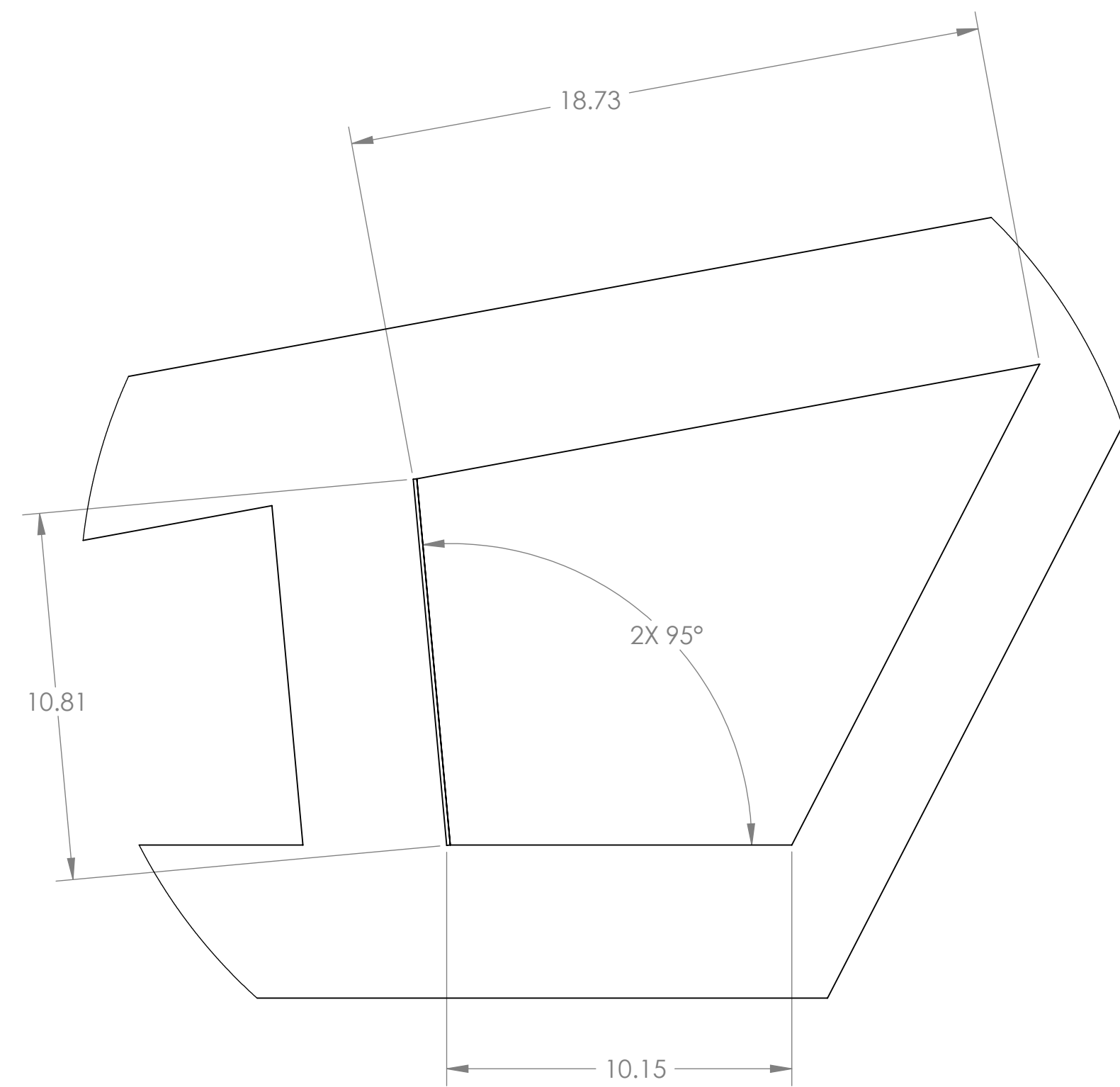
**DETAIL N  
SCALE 1 : 4**



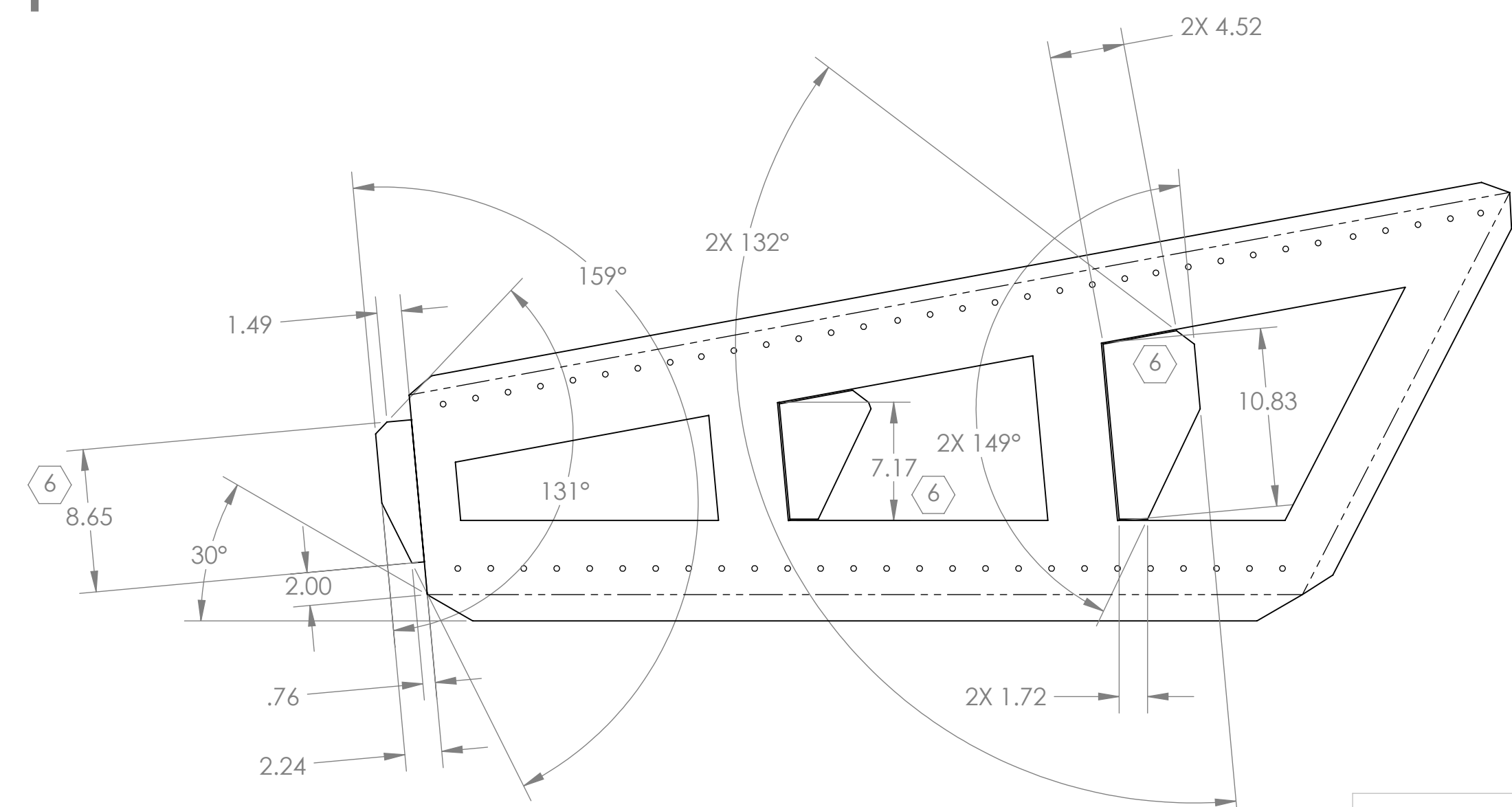
**DETAIL P  
SCALE 1 : 4**



**PANEL 4**



**DETAIL R  
SCALE 1 : 4**

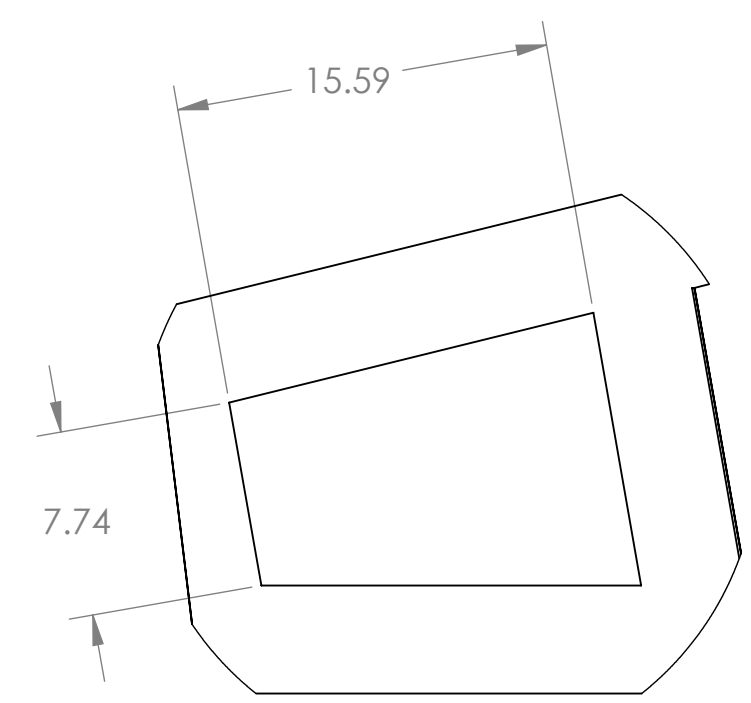


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002207	v1
SCALE: 1:8	PROJECTION:	SHEET 6 OF 10

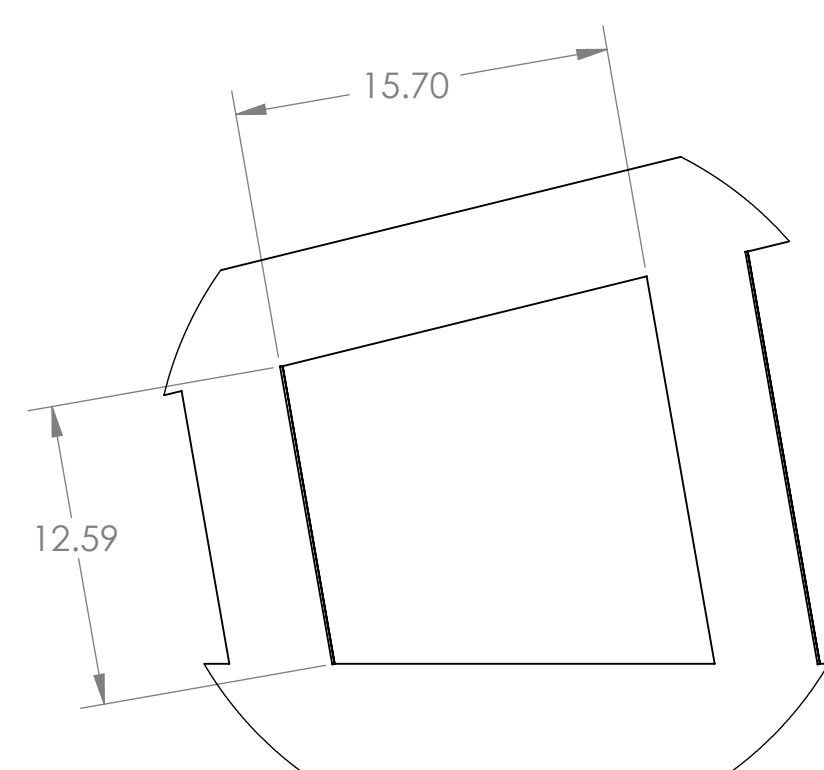
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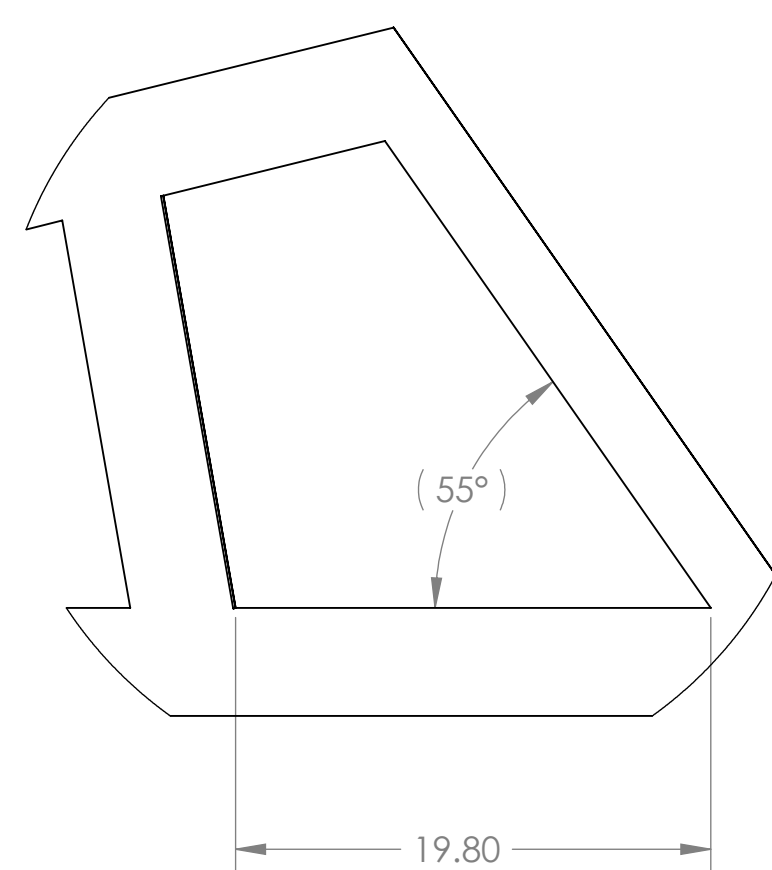




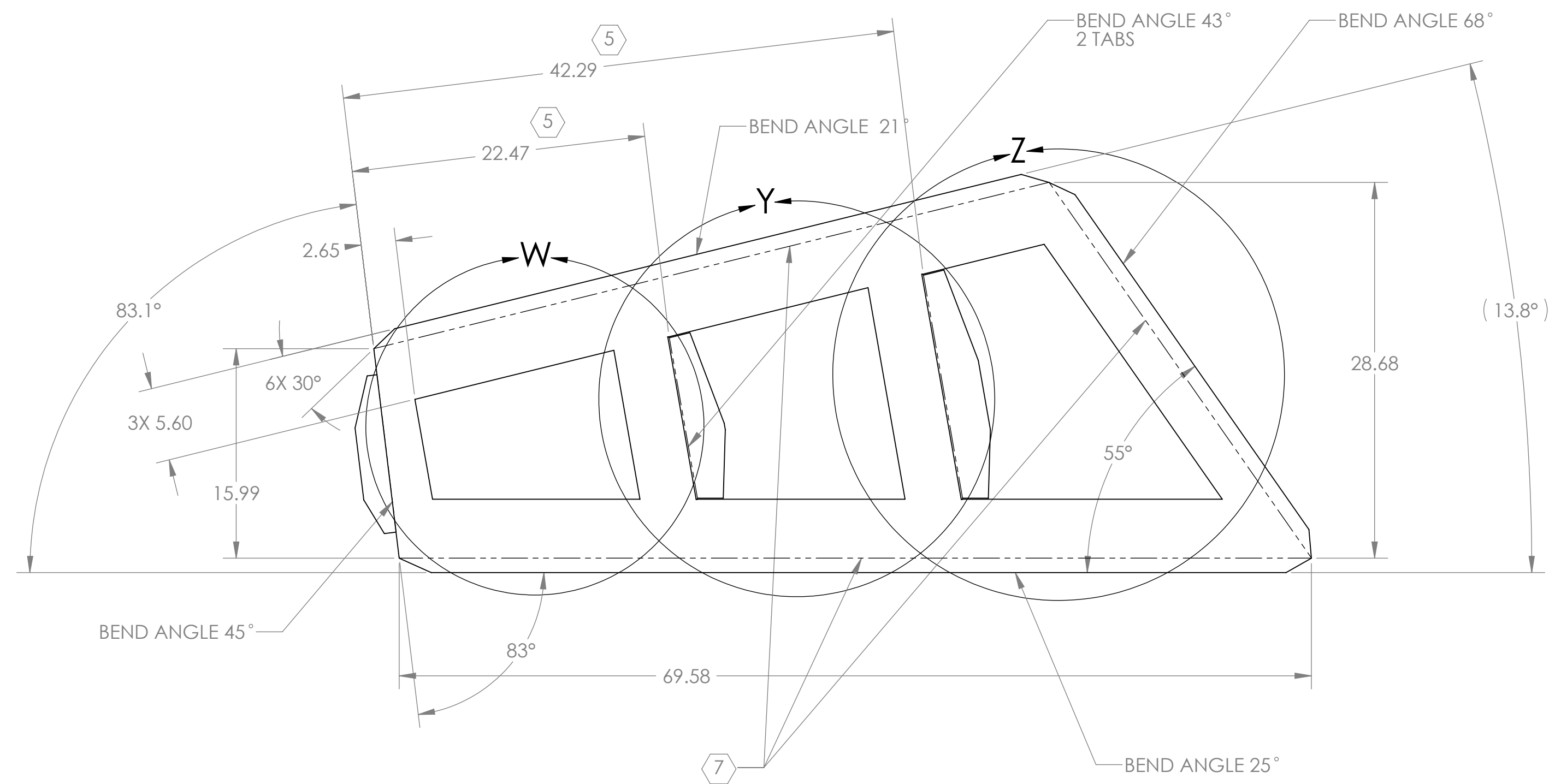
DETAIL W



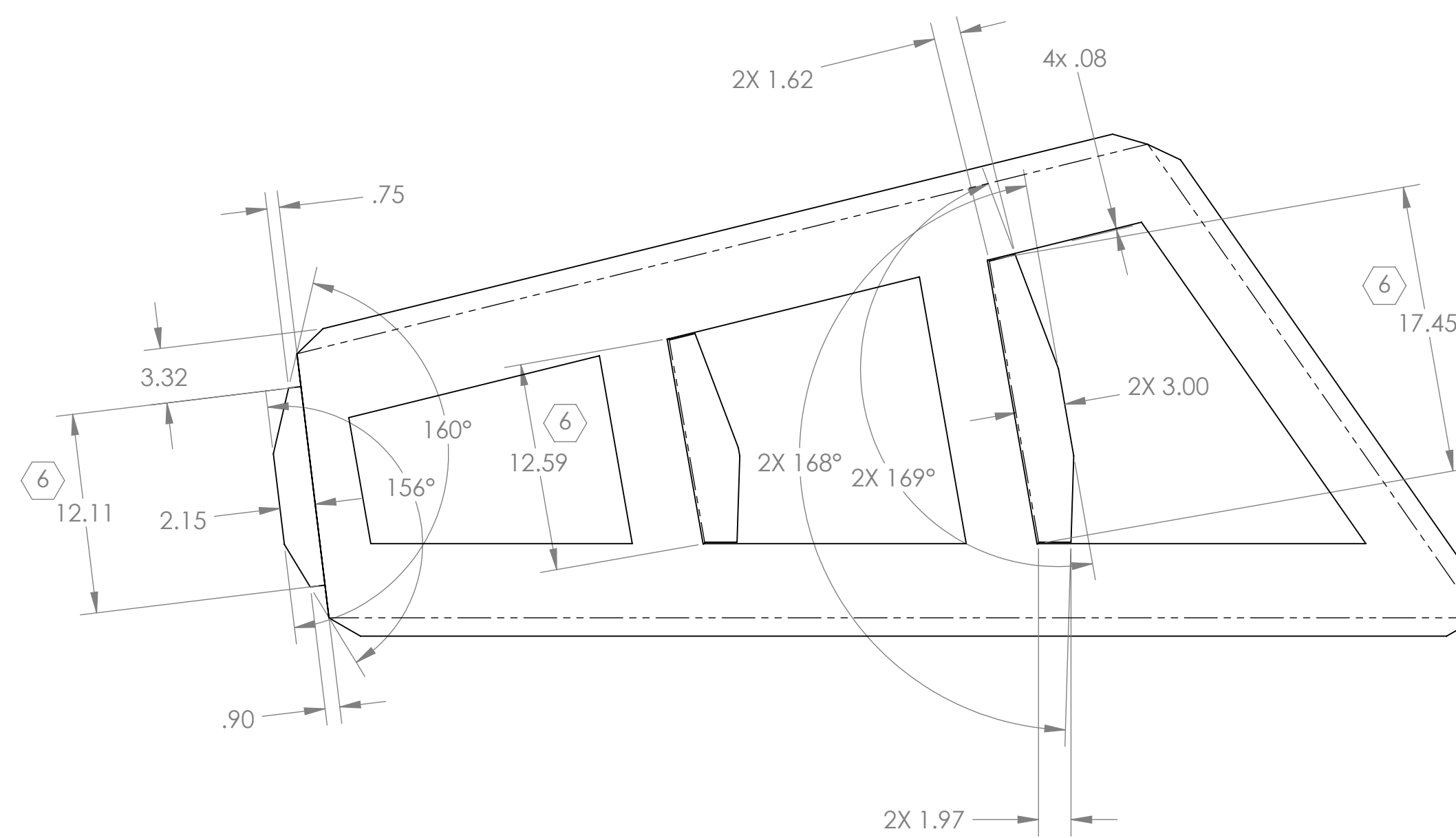
DETAIL Y



DETAIL Z



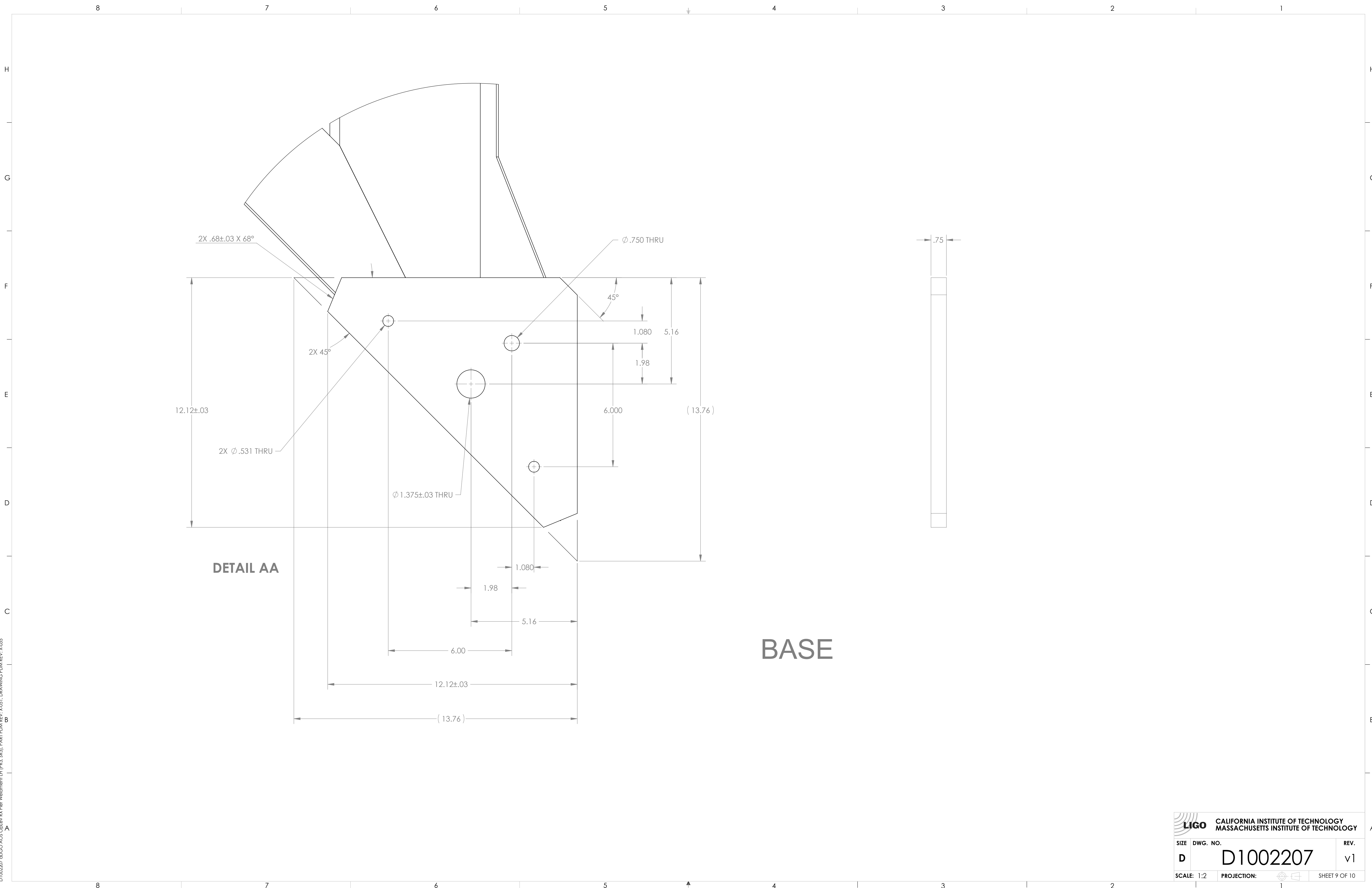
PANEL 6



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002207	v1
SCALE: 1:8	PROJECTION:	SHEET 8 OF 10

D:\002207.dwg ACS C:\lev\RX Plier Weldment LH (PES, SBJ) PART PDM REV: X.051 DRAWING PDM REV: X.055





BASE

DETAIL AA

		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE	DWG. NO.	REV.	
D	D1002207	v1	
SCALE: 1:2	PROJECTION:		
		SHEET 9 OF 10	

D:\002207.dwg ACS Oct 14 10:45 AM P:\Pier Weldment LH (PES, SB3) PART PDM REV: X.051 DRAWING PDM REV: X.035

