

8 7 6 5 4 3 2 1

NOTES CONTINUED:

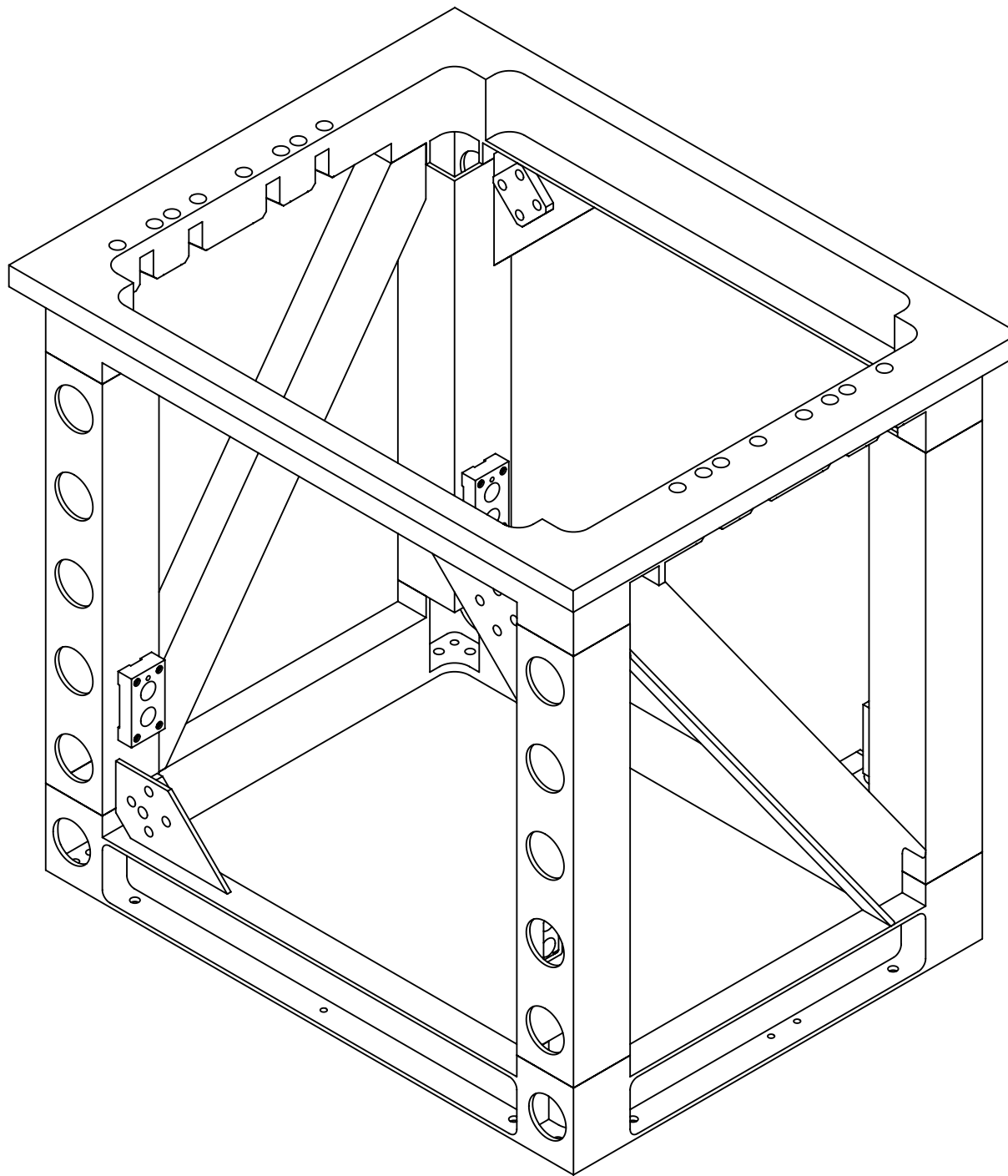
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXXX-VY, TYPE-XX, S/N XXX

6. MASS: 30.180 KG [66.535 LB].

⑦ MAKE FROM LIGO-D060492-v3. DRILL ONE ϕ .484 HOLE AS NOTED.

⑧ 63 μ inch Ra FINISH APPLIES ONLY TO THE MODIFICATION SURFACE.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 APR 2012	E1101214	
-	-	-	
-	-	-	

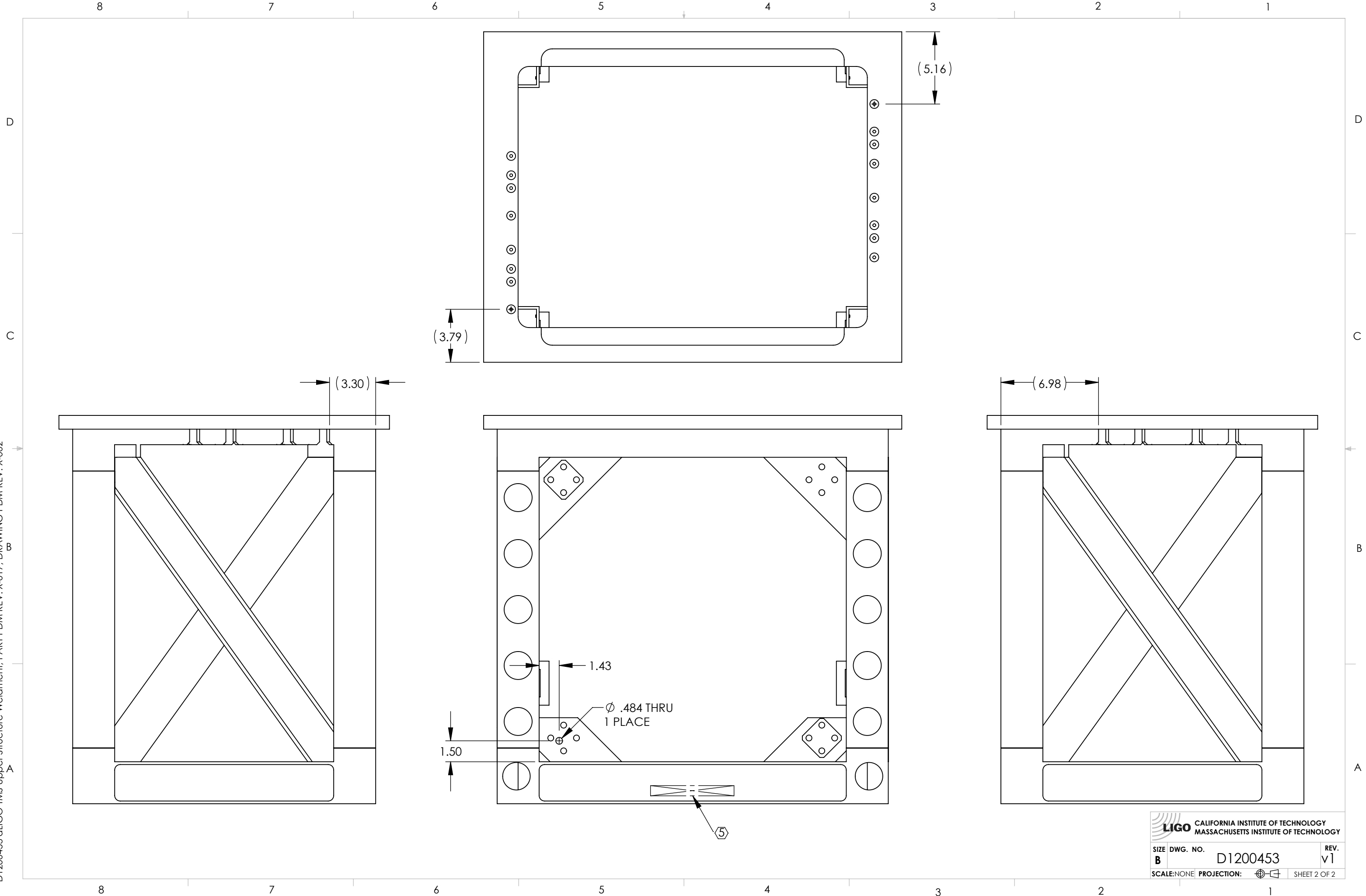


D1200453 aLIGO TMS Upper Structure Weldment, PART PDM REV: X-017, DRAWING PDM REV: X-002

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. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		aLIGO TMS UPPER STRUCTURE WELDMENT	
TOLERANCES: .XX \pm .01 .XXX \pm		MATERIAL		NEXT ASSY D1000549		DESIGNER C. CONLEY 13 MAR 2012		SIZE DWG. NO. B D1200453	
ANGULAR \pm °		FINISH 63 μ inch Ra ⑧		APPROVAL SEE DCN		CHECKER SEE DCN		REV. v1	
						SCALE: NONE		PROJECTION:	
								SHEET 1 OF 2	

8 7 6 5 4 3 2 1

D1200453 aLIGO TMS Upper Structure Weldment, PART PDM REV: X-017, DRAWING PDM REV: X-002



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SIZE	DWG. NO.	REV.
B	D1200453	v1
SCALE: NONE		PROJECTION:
		SHEET 2 OF 2