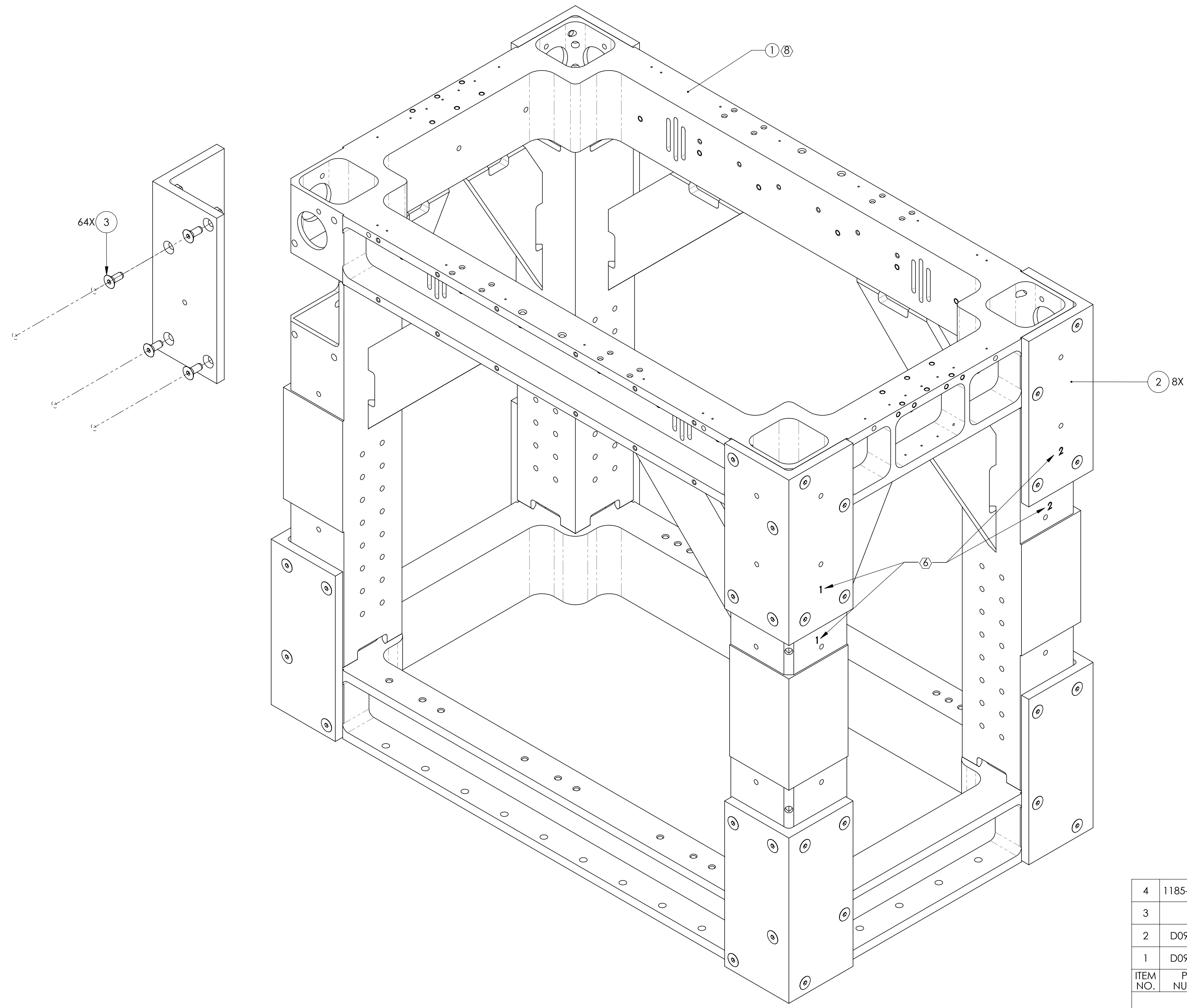


REV.	DATE	DCN #	DRAWING TREE #
v1	16 APR 2009	D0900106	D0900052
v2	-	INTERNAL REVISION	-
v3	28 JAN 2013	E1300085	E09000061



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	1185-2EN328	HELICOIL, #8-32 X 0.328 LONG (8)	NITRONIC 60	56	12	68
3	-	FLAT HEAD CAP SCREW, 1/4-20 X 0.625 LONG	316 SSSL	64	14	74
2	D0900309	CORNER BRACE, STRUCTURAL WELDMENT	6061-T6 Al	8	0	0
1	D0900308	STRUCTURAL WELDMENT, OMCS (8)	6061-T6 Al	1	0	1

PARTS LIST

**NOTES: (UNLESS OTHERWISE SPECIFIED)**

- INTERPRET DRAWING PER ASME Y14.5 1994
- REMOVE ALL SHARP EDGES, R 0.25 MIN.
- DO NOT SCALE FROM DRAWING
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CONCENTRATED MILACRON'S CUTECH 410 (S31)
- MATCH DRILL CORNER BRACE (D0900309) WELDED STRUCTURE (D0900308) DRILL AND TAP WELDED STRUCTURE FOR 1/4-20 UNC x 0.625 OVERSIZE TAP THRU WALL 265 X 82° 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 WELDEDMENT, ITEM NO. 1, BY LIGO PERSONNEL AFTER ALL PARTS ARE CLEANED AND BAKED.

DIMENSIONS ARE IN INCHES

TOLERANCES:  
XXX ± 0.1  
XXX ± 0.05  
ANGULAR ± 0.5°

MATERIAL: N/A

FINISH: N/A

DESIGNER: C. ECHOLS 17 DEC 2008  
DRAWN: B. MOORE 26 FEB 2013  
CHECKED: B. MOORE 24 FEB 2013

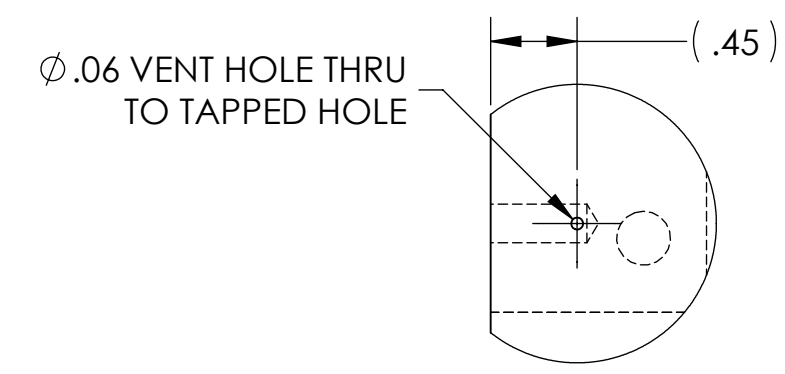
CALIFORNIA INSTITUTE OF TECHNOLOGY  
LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO  
SUB-SYSTEM: SUS  
NEXT ASSY: OMCS OVERALL ASSY

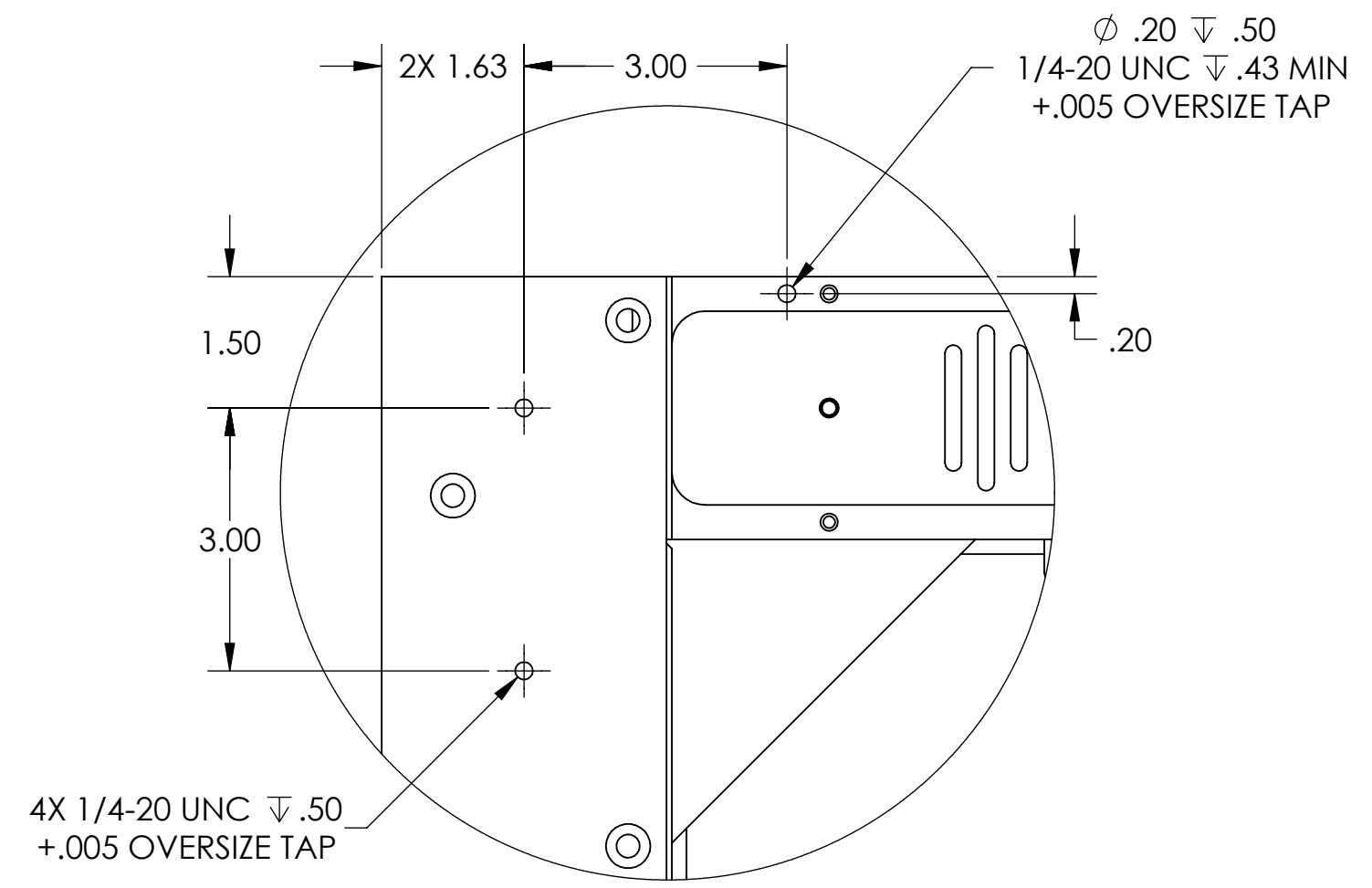
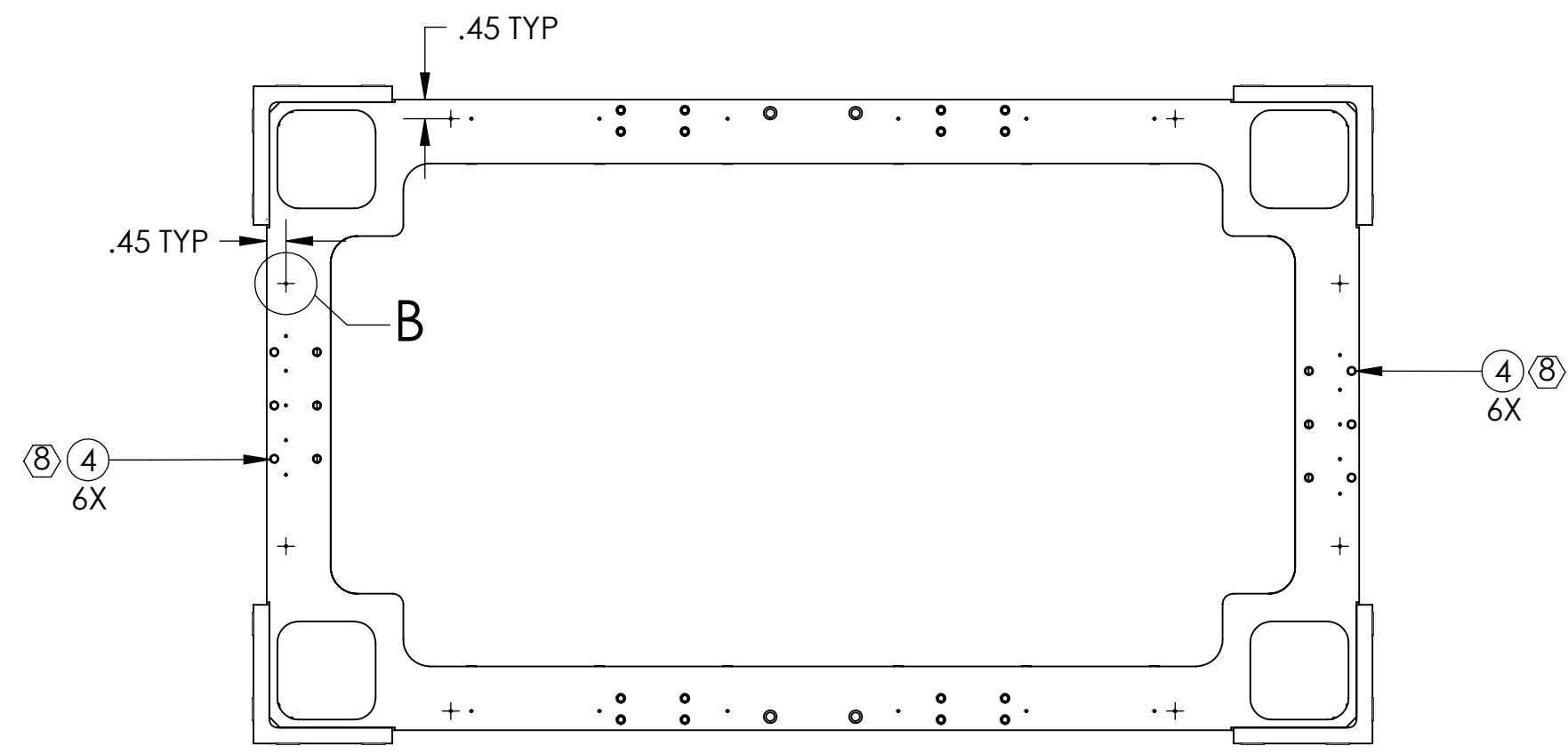
PART NAME: STRUCTURAL WELDMENT ASSY, OMCS

SIZE DWG. NO.: D0900655  
SCALE: 1:1 PROJECTION: SHEET 1 OF 2

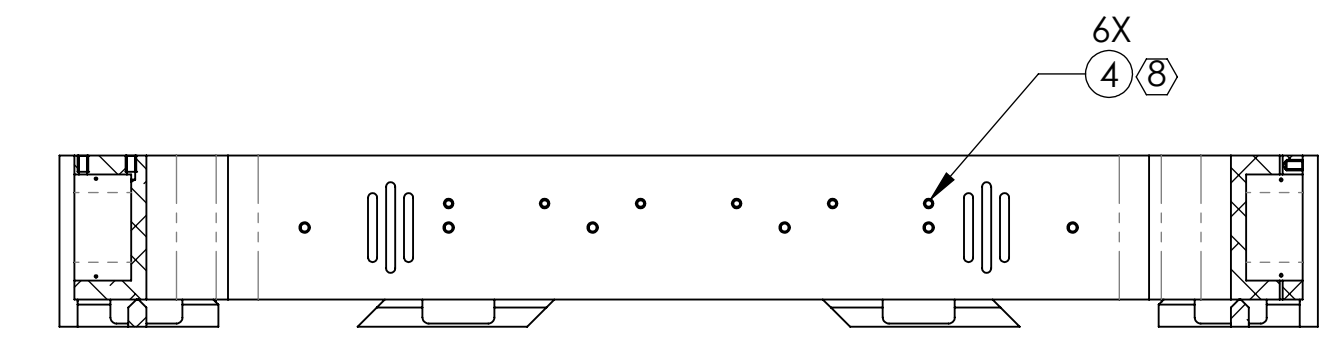
D0900655\_AsdLIGO\_OMCS\_Structural Weldment Assembly - PART PDM REV-V1.006 DRAWING PDM REV-V1



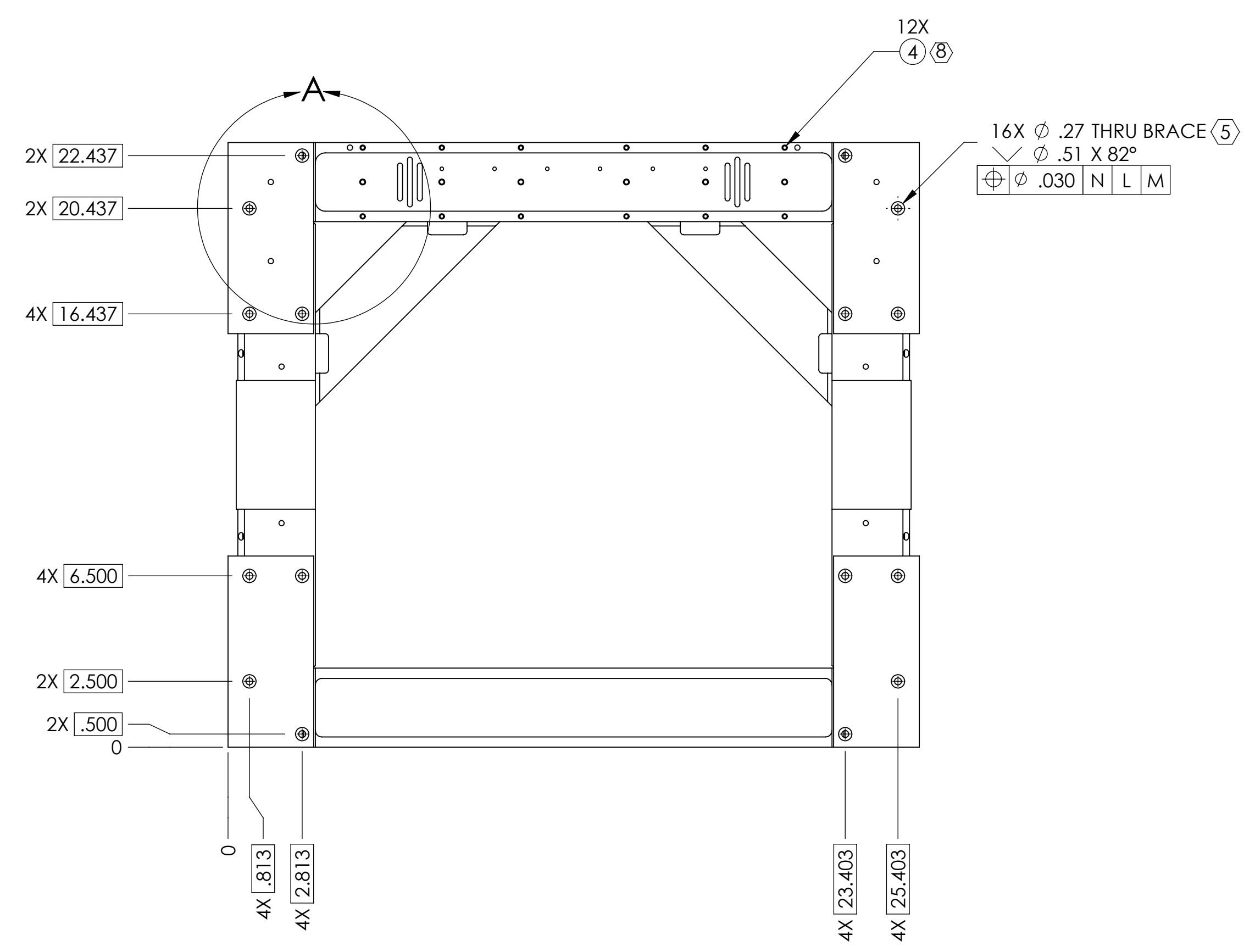
DETAIL B  
SCALE 1 : 1  
8 PLACES



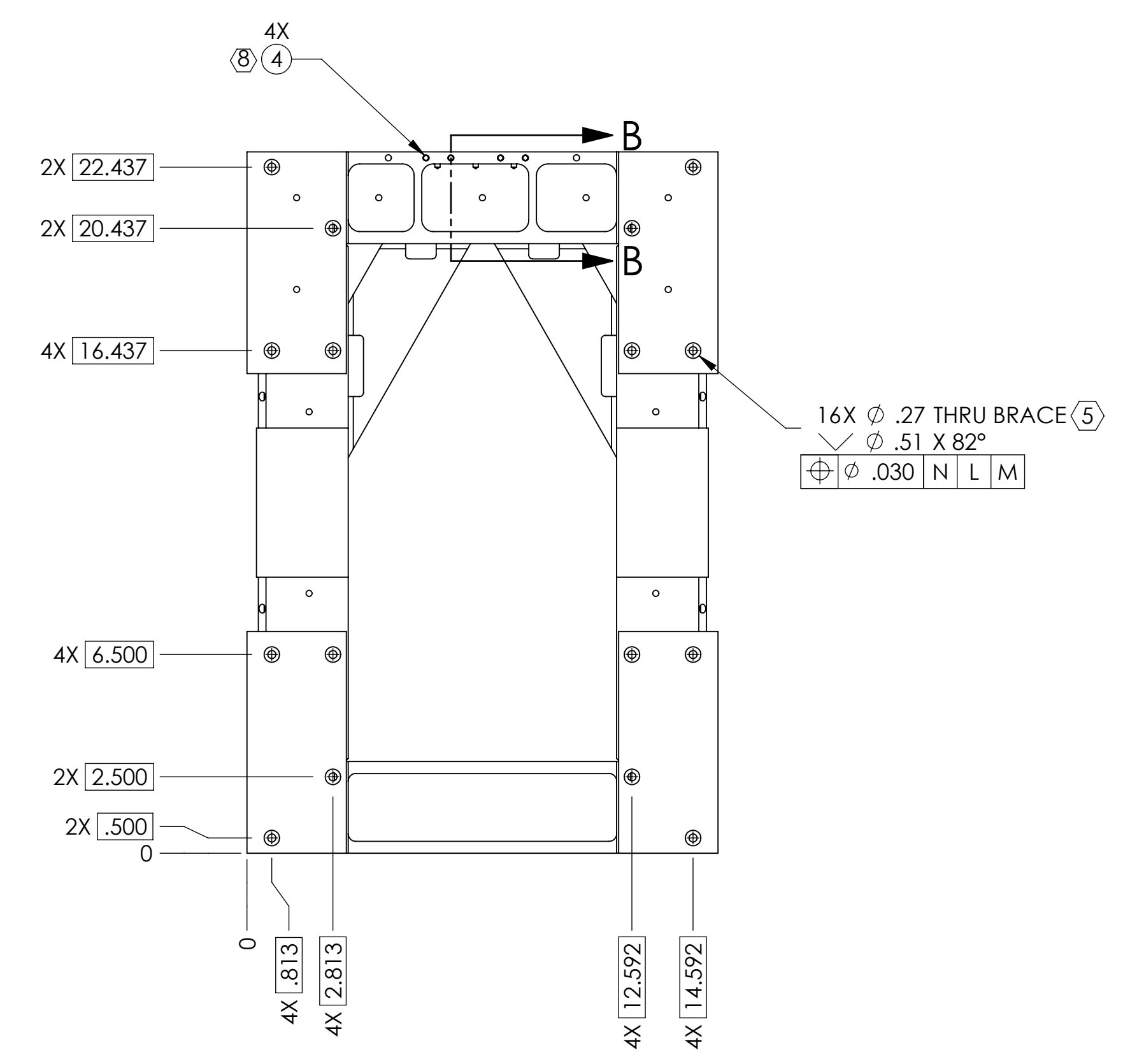
DETAIL A  
SCALE 1 : 2  
4 PLACES  
OPPOSITE ON RIGHT SIDE



SECTION B-B  
LEFT AND RIGHT INSIDE VIEW



FRONT AND BACK VIEW



LEFT AND RIGHT SIDE VIEW