

**NOTES CONTINUED:**

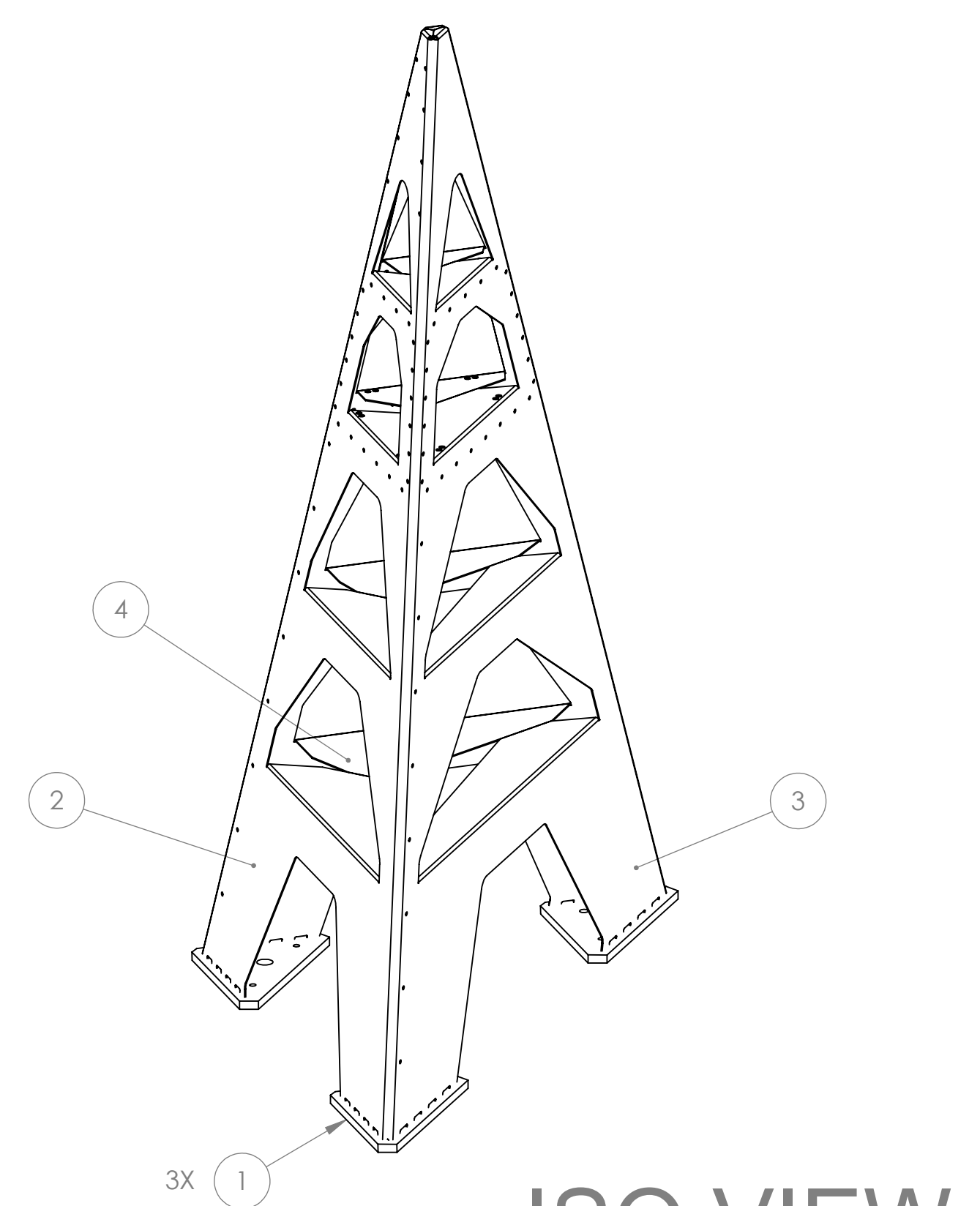
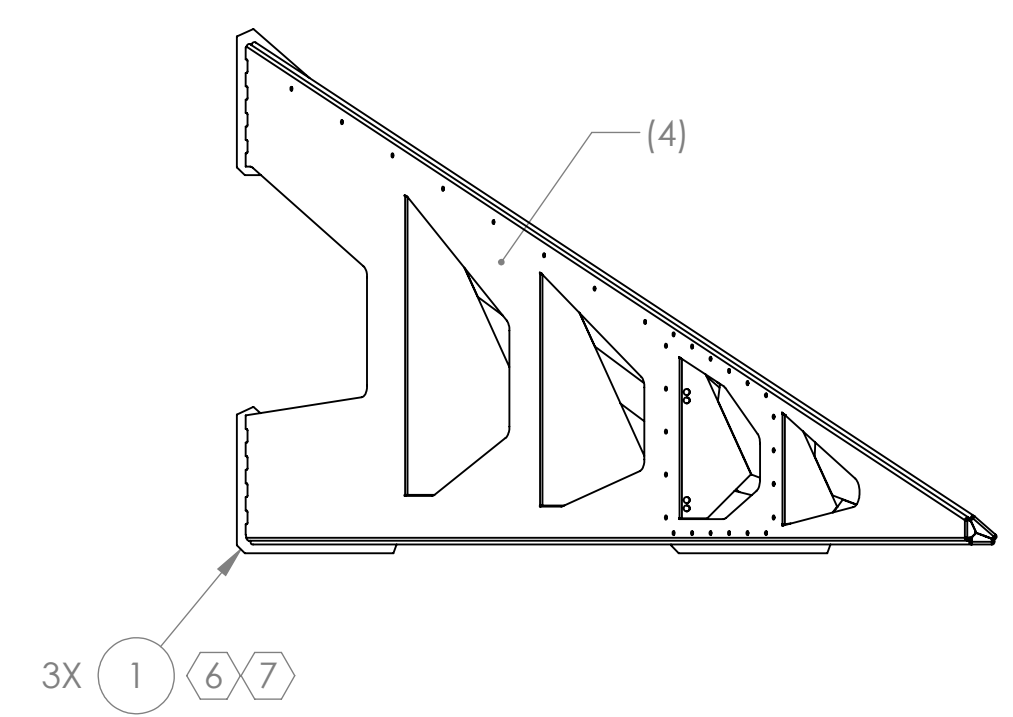
⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12"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

⑥ FASTEN ITEMS 1 TO D1000836 FOOTING BEFORE APPLYING NOTED WELDS, TO ENSURE ALIGNMENT. FOR EACH ITEM 1, USE THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN FOOTING. FOOTING MUST BE REMOVABLE & RE-ATTACHABLE POST-WELD, WITH NO BINDING OF SCREWS. TO BE DELIVERED WITH FOOTING ATTACHED.

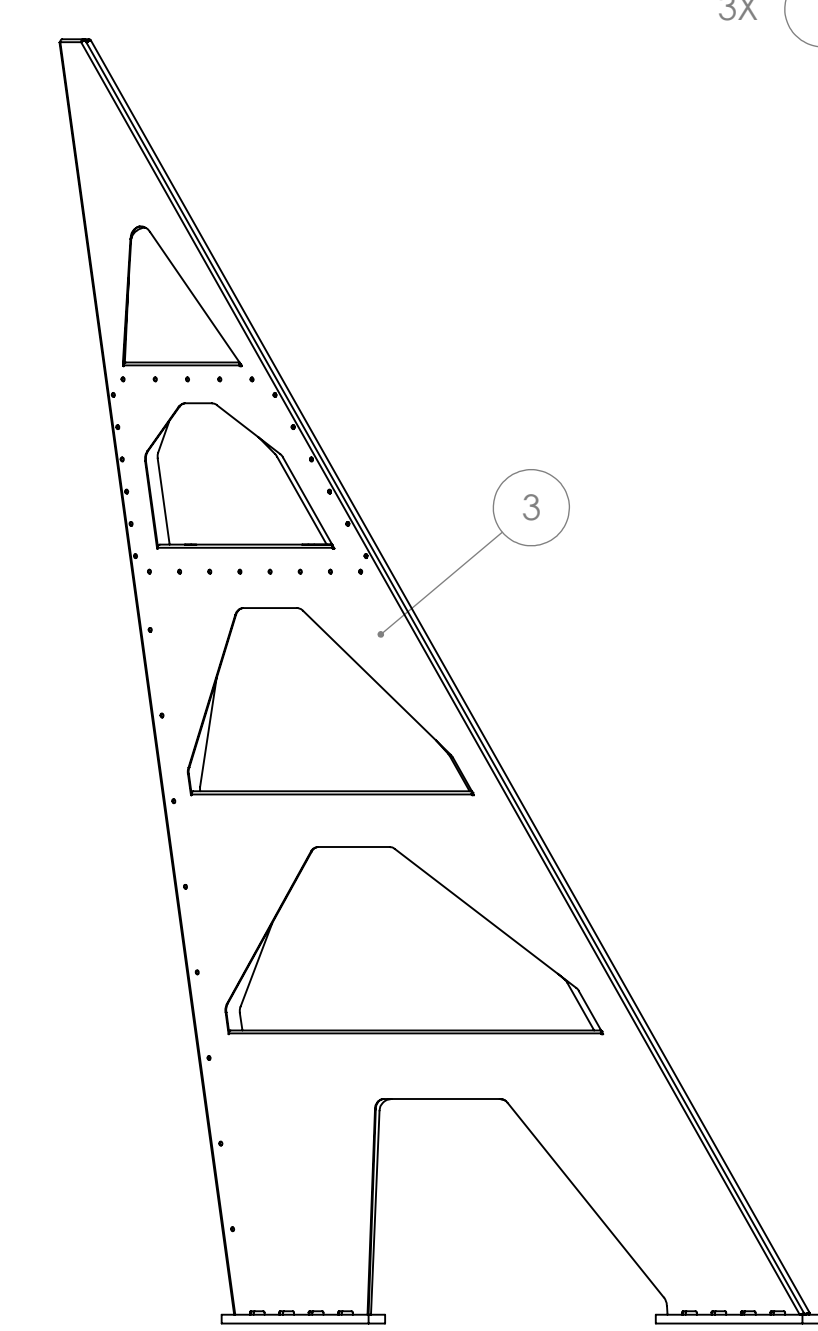
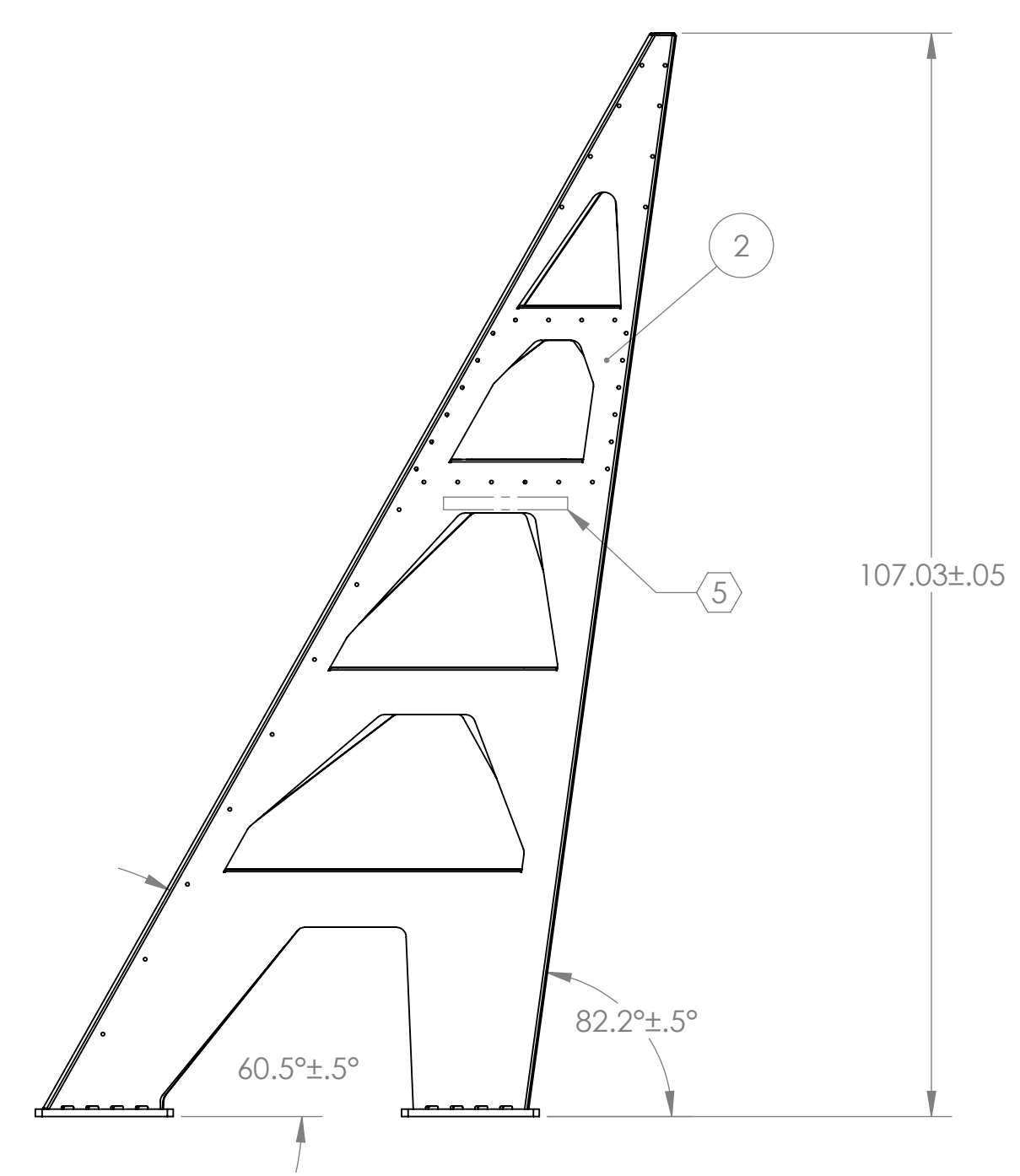
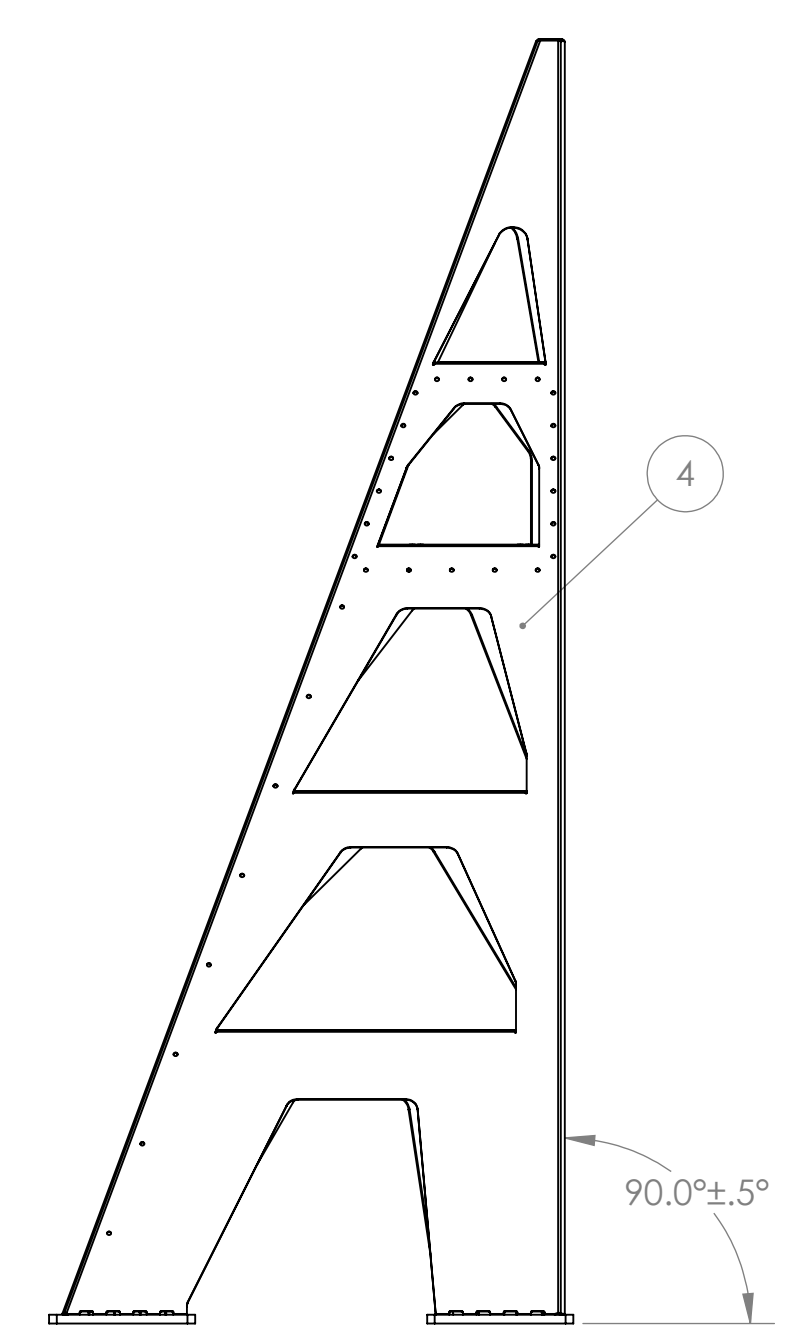
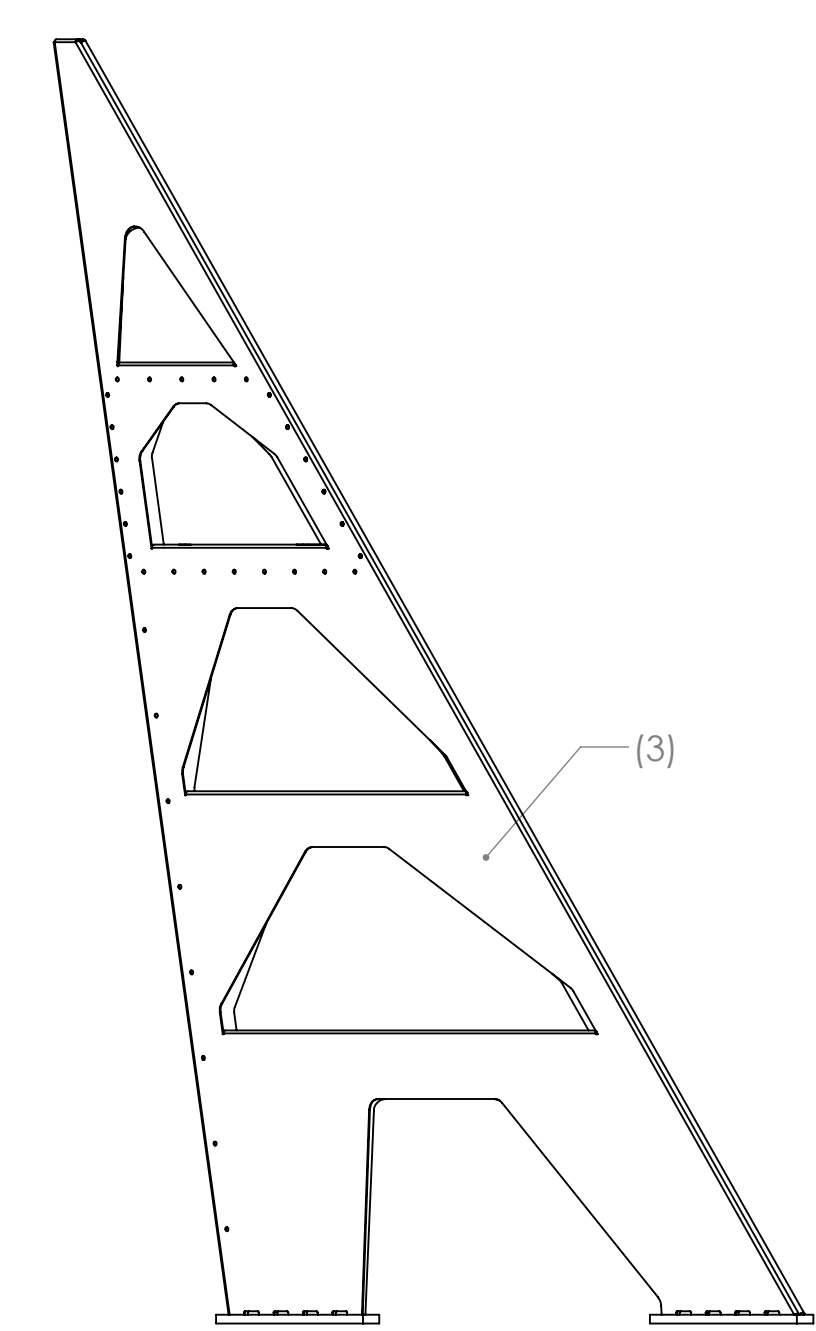
⑦ WARPAGE OF ITEM 1 & FOOTING TO BE MINIMIZED USING PREFERRED METHODS, I.E. HEAT SINKING.

8. THIS UNIT IS MIRROR IMAGE OPPOSITE OF D1001292. SEE DRAWING D1001292 FOR COMPLETE CONSTRUCTION DETAILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 AUGUST 2010	E1000182-v1	-
-	-	-	-
-	-	-	-



ISO VIEW



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	D1000596-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL3 (LLO)	304 SSSL	1		1
3	D1000595-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL2 (LLO)	304 SSSL	1		1
2	D1000594-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL1 (LLO)	304 SSSL	1		1
1	D1000835	ALIGO AOS PIER BASE 4	304 SSSL	3		3

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	
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 SUB-SYSTEM

NEXT ASSY D1001330

PART NAME ALIGO AOS OPLEV AND PHOTCAL RX PIER WELDMENT RH

DESIGNER	C. CONLEY	17 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	N. KILPATRICK	17 AUG 2010	D	D1001297	v1
CHECKER					
APPROVAL			SCALE: 1:16	PROJECTION:	SHEET 1 OF 1

D1001297.dwg: AOS Oplev & Photcal RX Pier Weldment RH (LLO). PAB.PDM.REV.X-019. DRAWING.PDM.REV.X-013