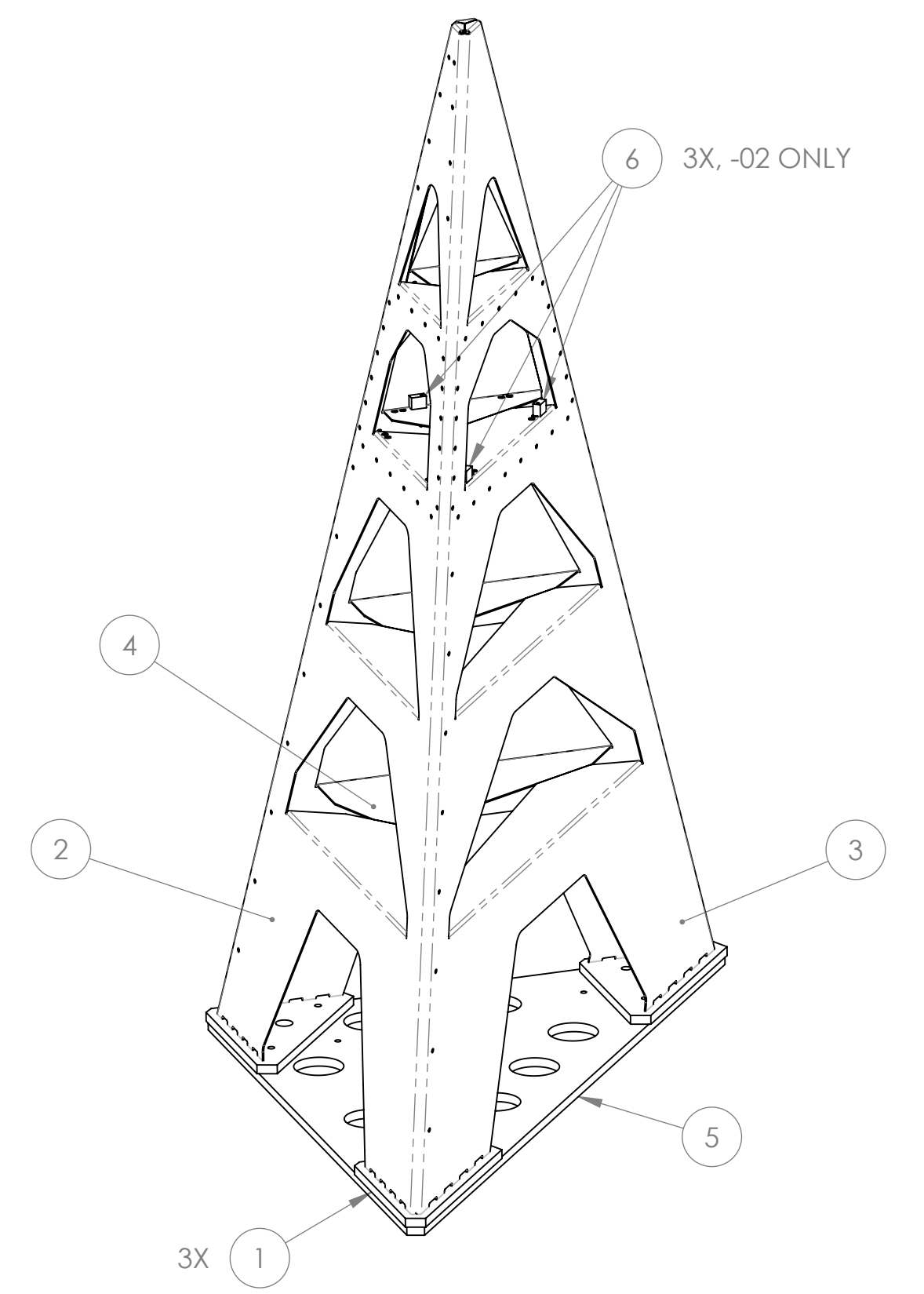
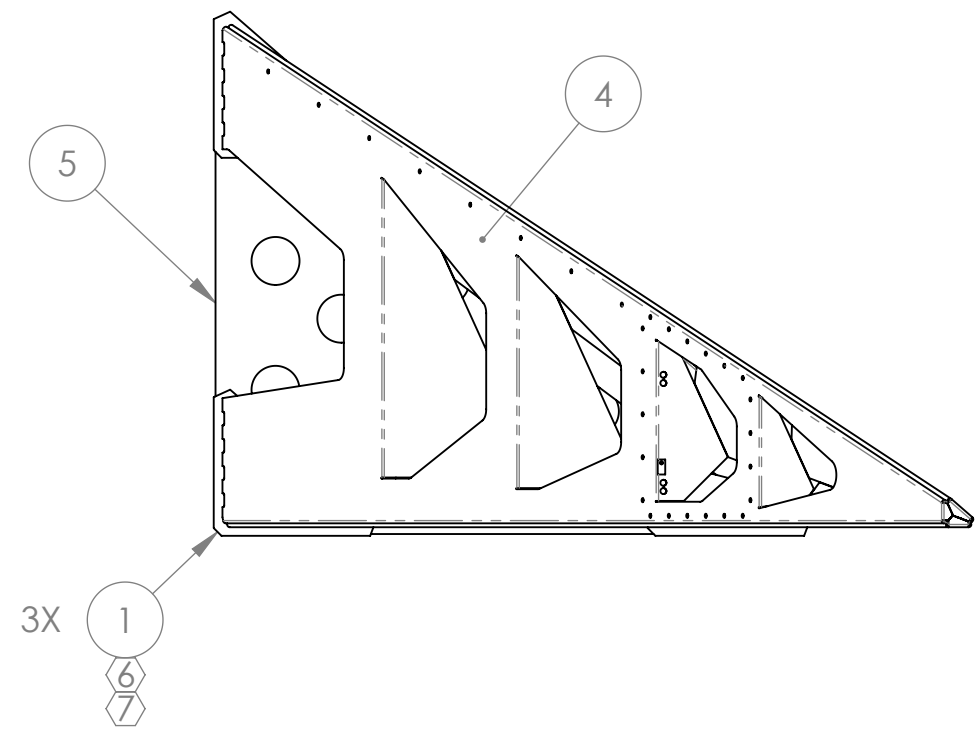
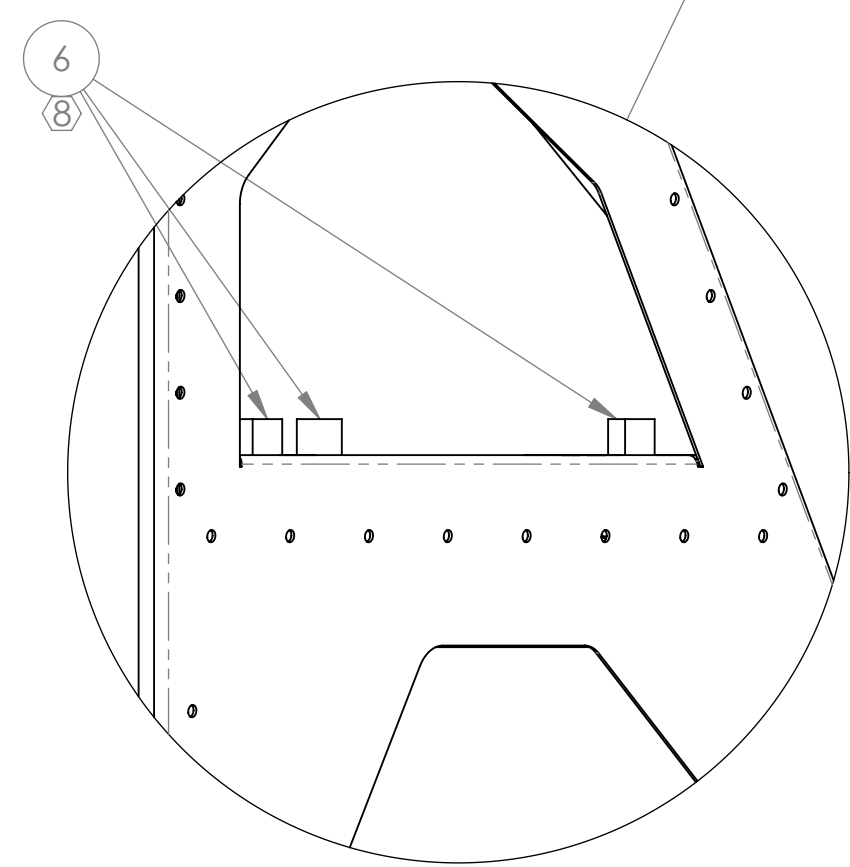
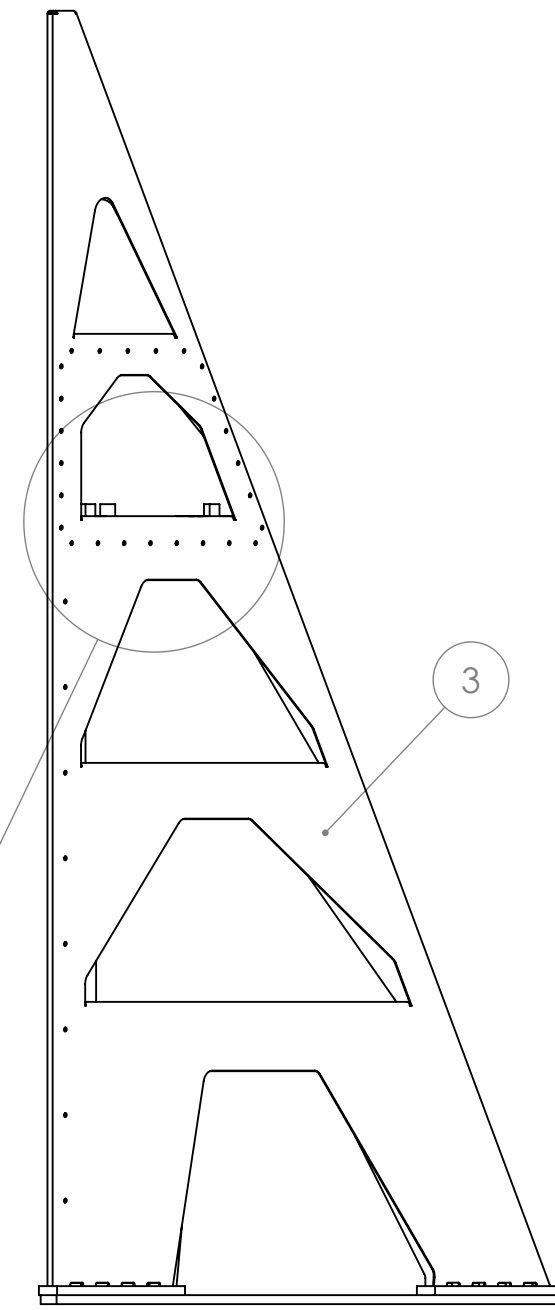
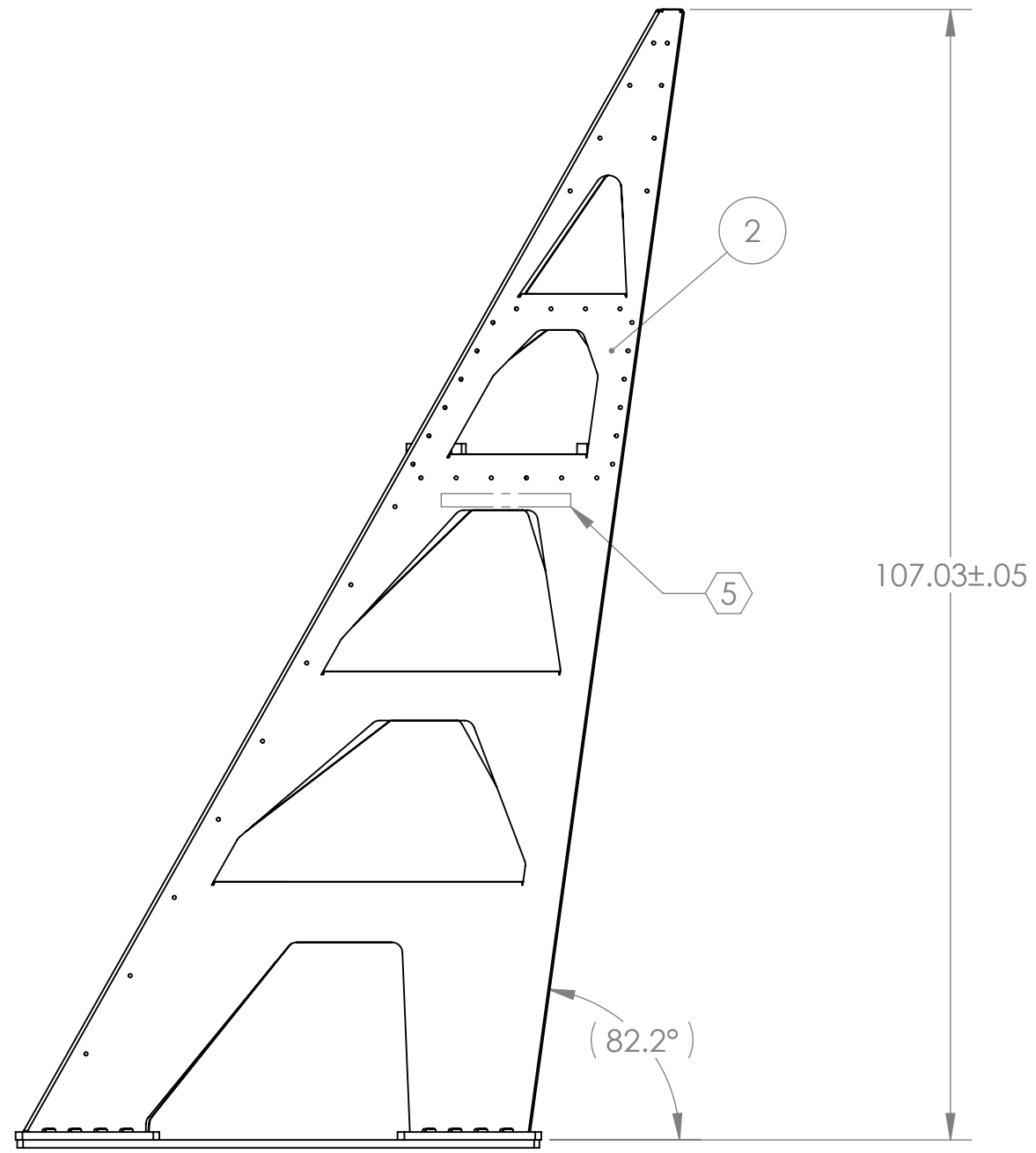
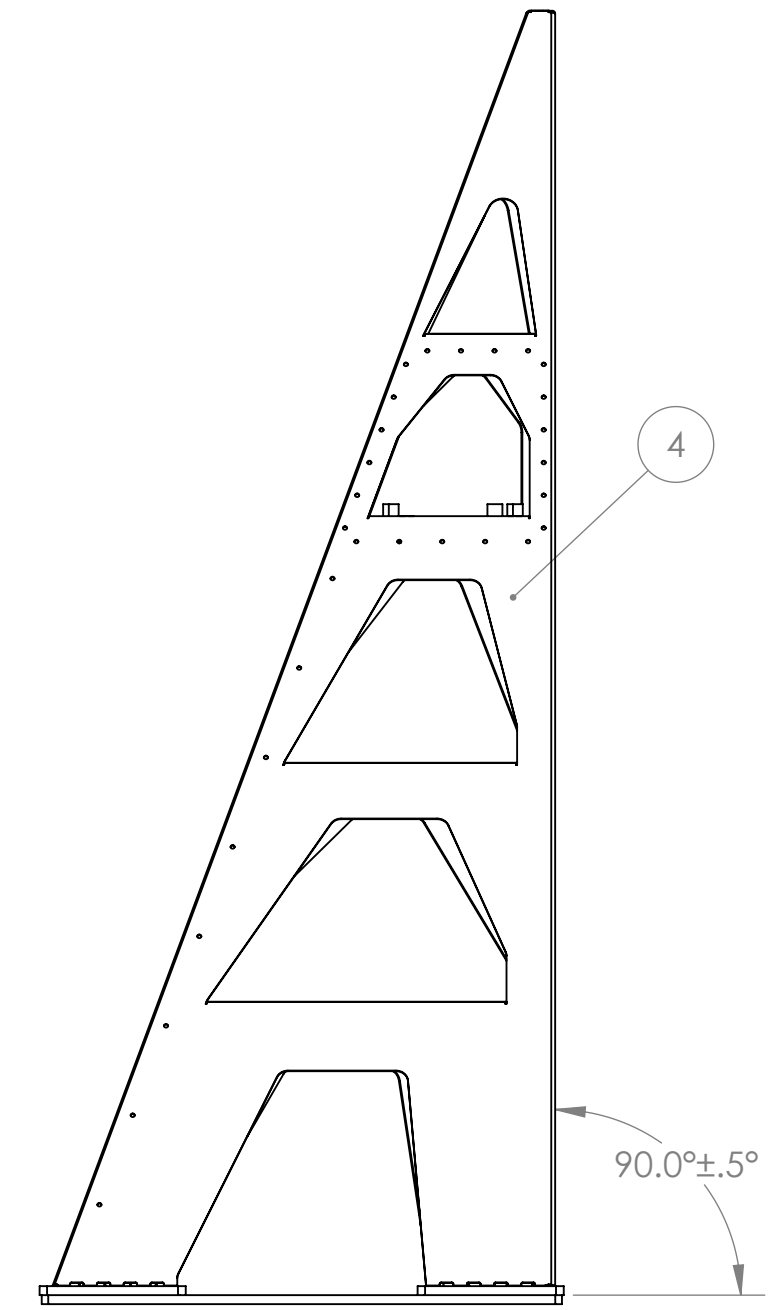
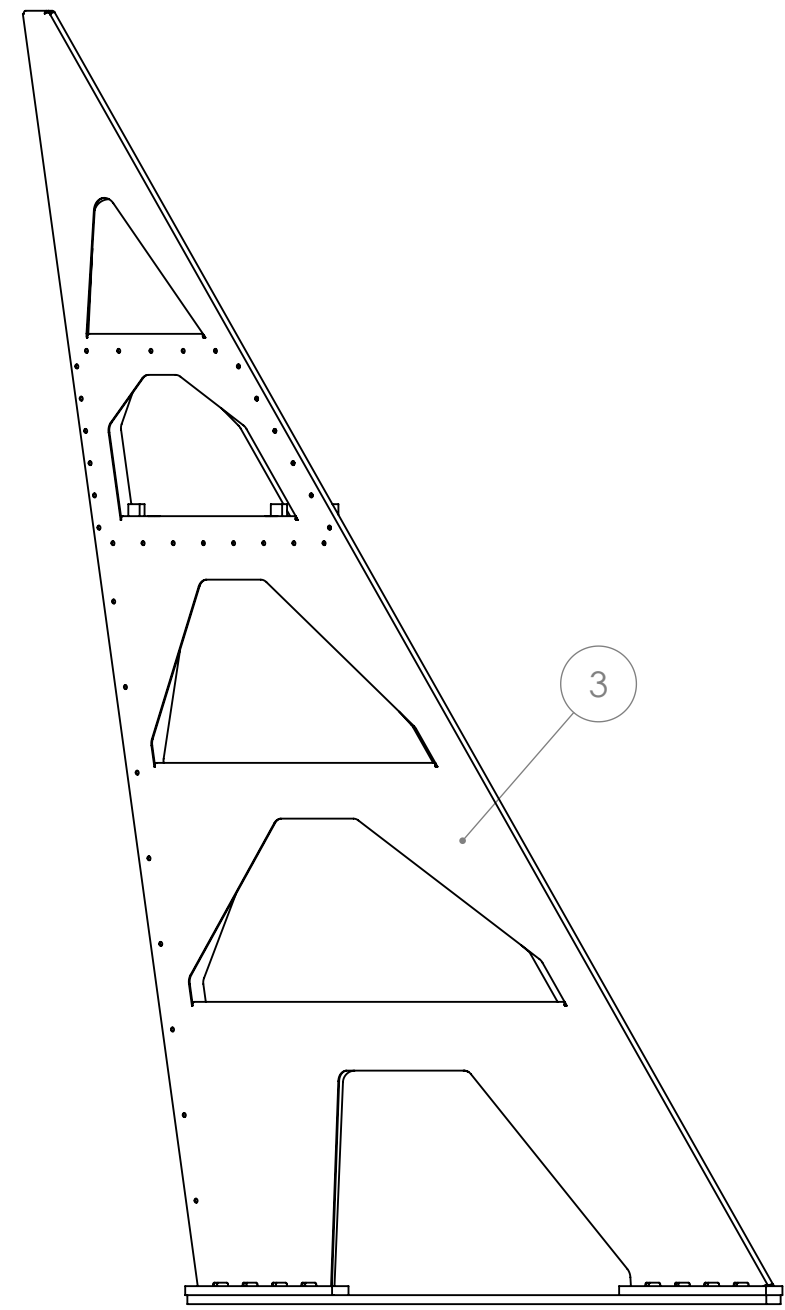


- NOTES (CONTINUED):**
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION, AND TYPE (DASH) NUMBER ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. EXAMPLE: D1001297-V2, TYPE-01, S/N 001
 - ⑥ FASTEN ITEMS ① TO ITEM ⑤ BEFORE APPLYING NOTED WELDS, TO ENSURE ALIGNMENT. FOR EACH ITEM ①, USE THREE 1/2-20 UNF SCREWS TO TAPPED HOLES IN ITEM ⑤. ITEM ⑤ MUST BE REMOVEABLE & RE-ATTACHABLE POST-WELD, WITH NO BINDING OF SCREWS. TO BE DELIVERED WITH ITEM ⑤ ATTACHED.
 - ⑦ WARPAGE OF ITEM ① & ITEM ⑤ TO BE MINIMIZED USING PREFERRED METHODS, IE. HEAT SINKING.
 - ⑧ APPLY ITEMS ⑥ TO -02 WELDMENTS ONLY, USING TOOLING FIXTURE D1300525-v1 PER PROCEDURE E1300593-v2.
 - 9. 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	-
v2	08 OCT 2013	E1300649	-
-	-	-	-



ISO VIEW



-02 SHOWN, ALL VIEWS

ITEM NO.	PART NO.	DESCRIPTION	REV.	MATERIAL	-01 (ITMY) /QTY.	-02 (ETMX) /QTY.
6	D1300499	ALIGO PCAL RECEIVER MOUNTING BLOCK	V2	304 SSSL	-	3
5	D1000836	ALIGO AOS PIER FOOTING 4	V3	302 SSSL	1	1
4	D1000596-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL3 (LLO)	V1	304 SSSL	1	1
3	D1000595-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL2 (LLO)	V2	304 SSSL	1	1
2	D1000594-2	ALIGO AOS OPLEV & PHOTCAL RX PIER SIDE PANEL1 (LLO)	V2	304 SSSL	1	1
1	D1000835	ALIGO AOS PIER BASE 4	V1	304 SSSL	3	3

DIMENSIONS ARE IN		TOLERANCES:		ANGULAR ± N/A °	
.XX	± N/A	.XXX	± N/A		
MATERIAL		FINISH		NEXT ASSY	
N/A		N/A μinch		D1001330	

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.

LOGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LOGO** SUB-SYSTEM: **AOS**

PART NAME		DESIGNER		DATE		SIZE		DWG. NO.		REV.	
ALIGO AOS OPLEV & PCAL RX PIER WELDMENT RH		C. CONLEY		17 AUG 2010		D		D1001297		v2	
CHECKER		N. KILPATRICK		17 AUG 2010		SCALE: NONE		PROJECTION:		SHEET 1 OF 1	

D1001297.dwg: AOS Oplev & Pcal Rx Pier Weldment RH, PART PDM REV: X-092, DRAWING PDM REV: X-016