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.

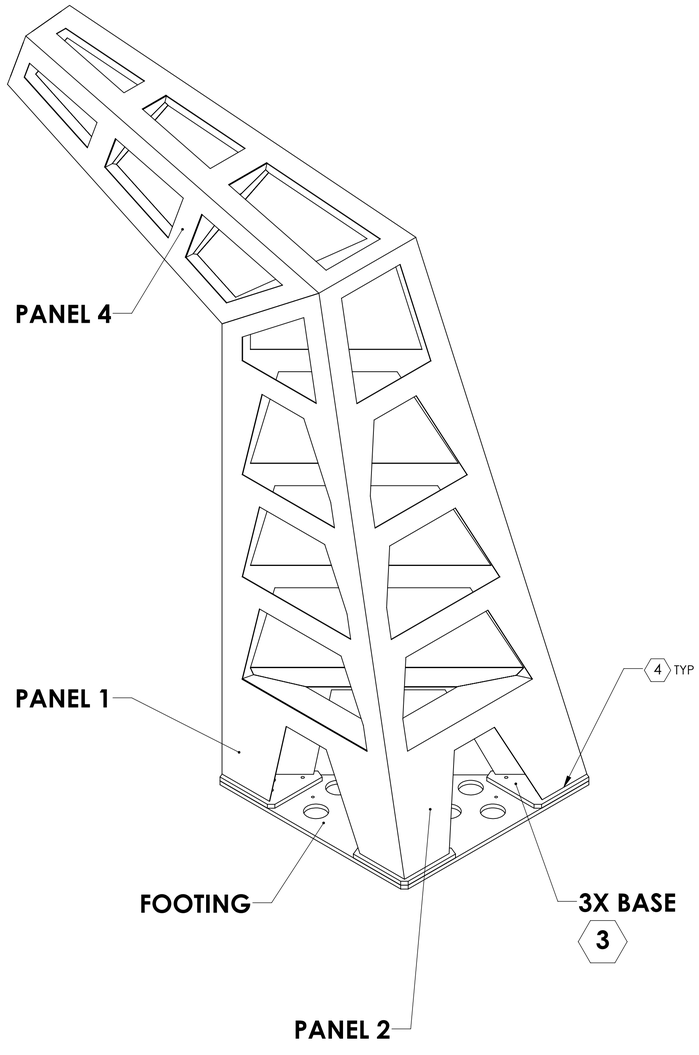
⑤ NOTED DIMENSIONS REPRESENT THE THEORETICAL SHARP CORNER OF TAB FOLD.

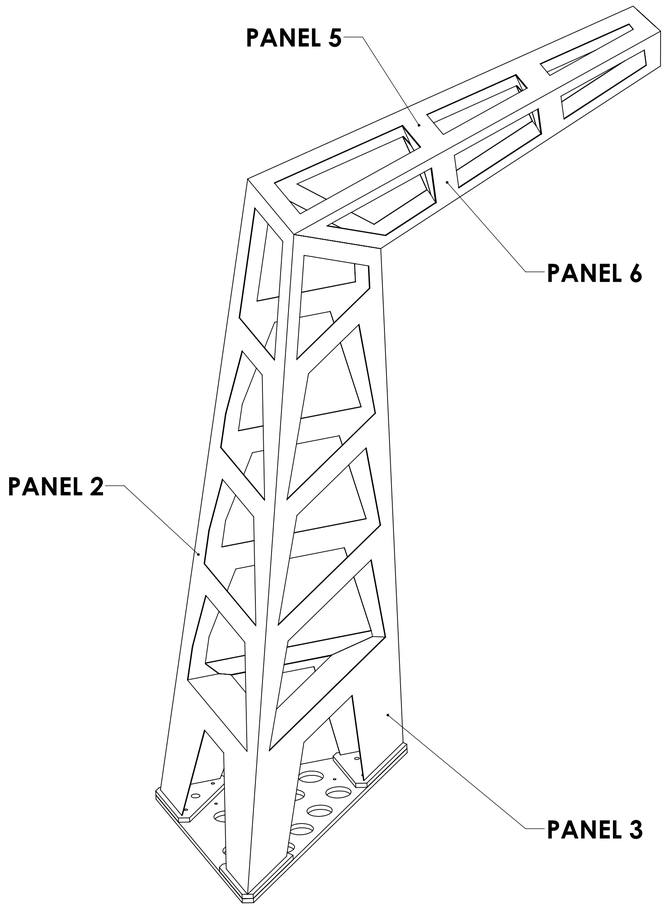
⑥ FOLDED TABS ARE IDENTICAL EXCEPT FOR NOTED DIMENSIONS.

⑦ THEORETICAL SHARP CORNER LINE (BEND LINES TO BE DETERMINED FROM).

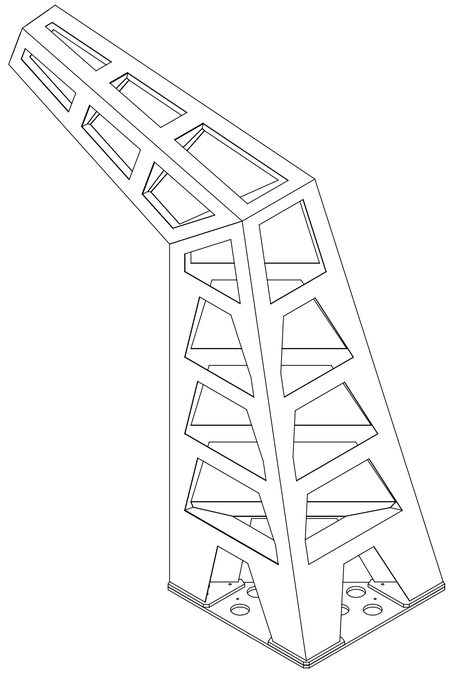
⑧ ALL PEM NUTS TO BE MOUNTED ON INSIDE OF WELDMENT.

REV.	DATE	DCN #	DRAWING TREE #
v1	18 AUG 2010	E1000182-v1	-
v2	2 DEC 2010	E1000182-v2	-
-	-	-	-





ROTATED



ISO VIEW

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	

304 SS OK everywhere

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

MATERIAL: REFER TO TABLE
FINISH: REFER TO TABLE

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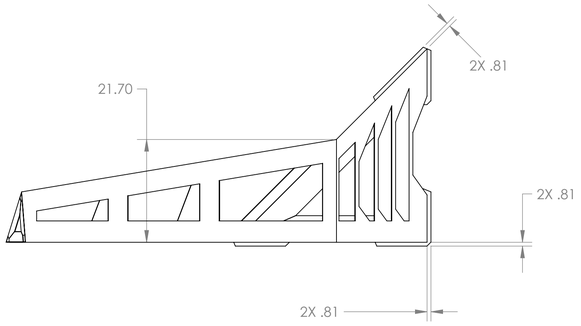
SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY:

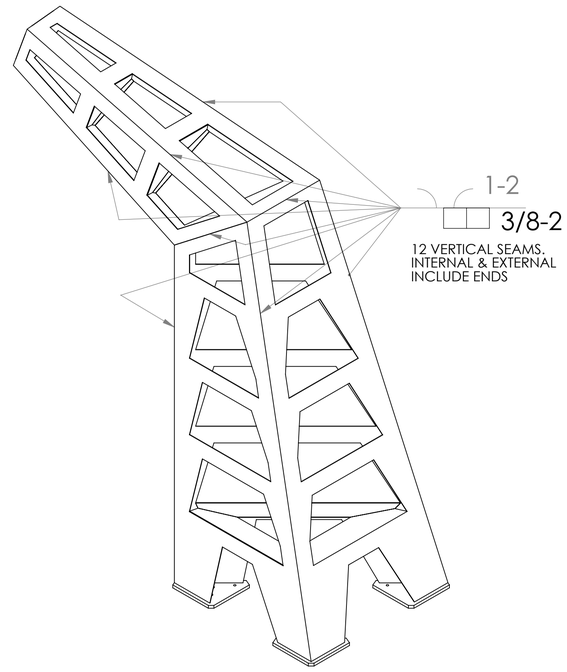
PART NAME: ALIGO AOS OPLEV
RX PIER WELDMENT LH (PR3, SR3)

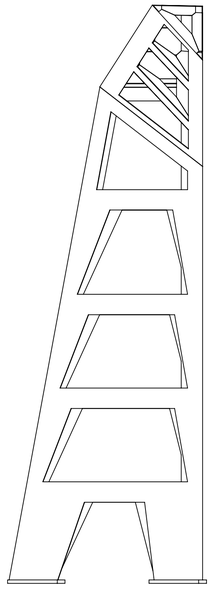
DESIGNER	C CONLEY	29 APR 2010	
DRAFTER	N. KILPATRICK	18 AUG 2010	
CHECKER			
APPROVAL			

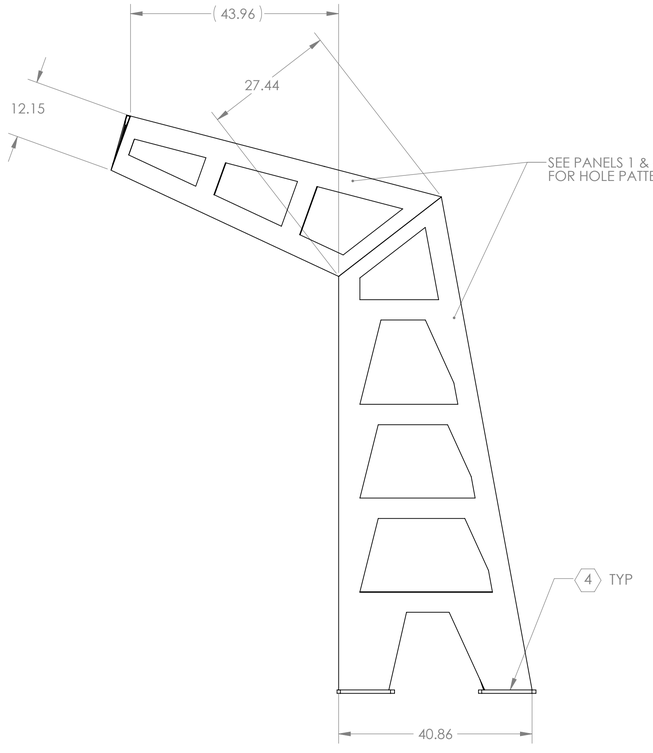
SIZE: D
DWG. NO.: D1002207
REV.: V3
SCALE: 1:12
PROJECTION:
SHEET 1 OF 10

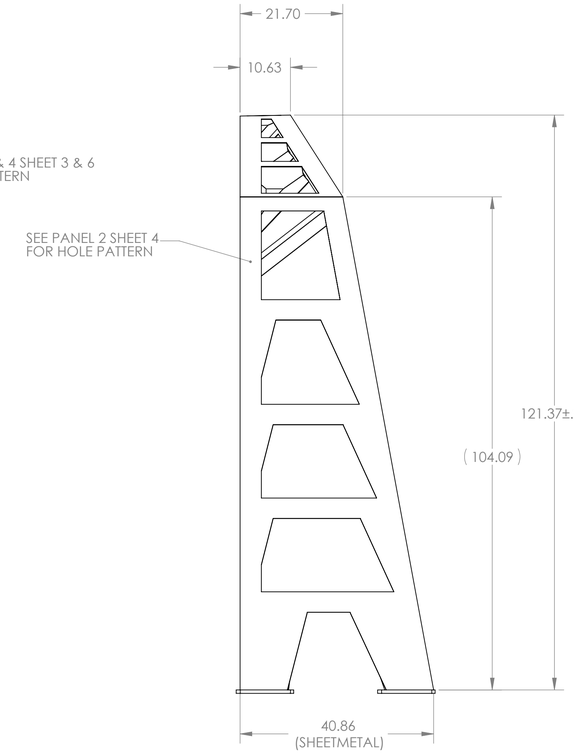
D1002207 aLIGO AOS Oplev RX Pier Weldment LH (PR3, SR3), PART PDM REV: X:052, DRAWING PDM REV: X:035



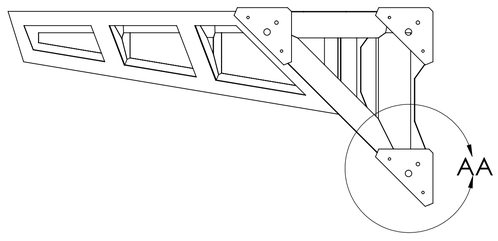








WELDMENT

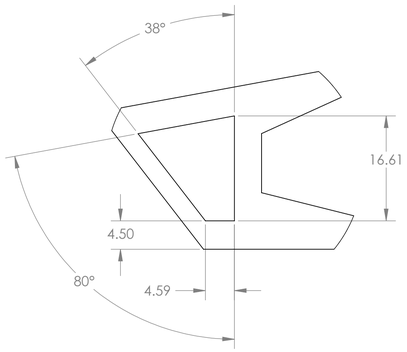


REMOVE FOOTING VIEW
FOR CLARITY

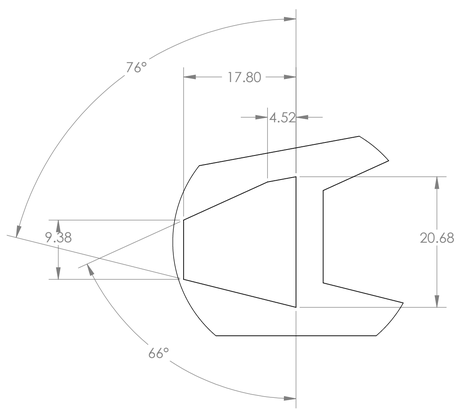
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D1002207	v2

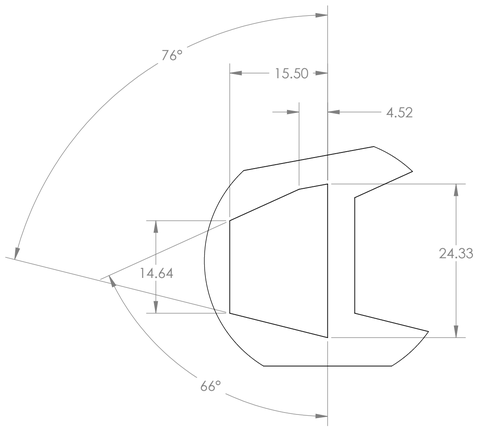
SCALE: 1:16 | PROJECTION: | SHEET 2 OF 10



DETAIL A
SCALE 1 : 12

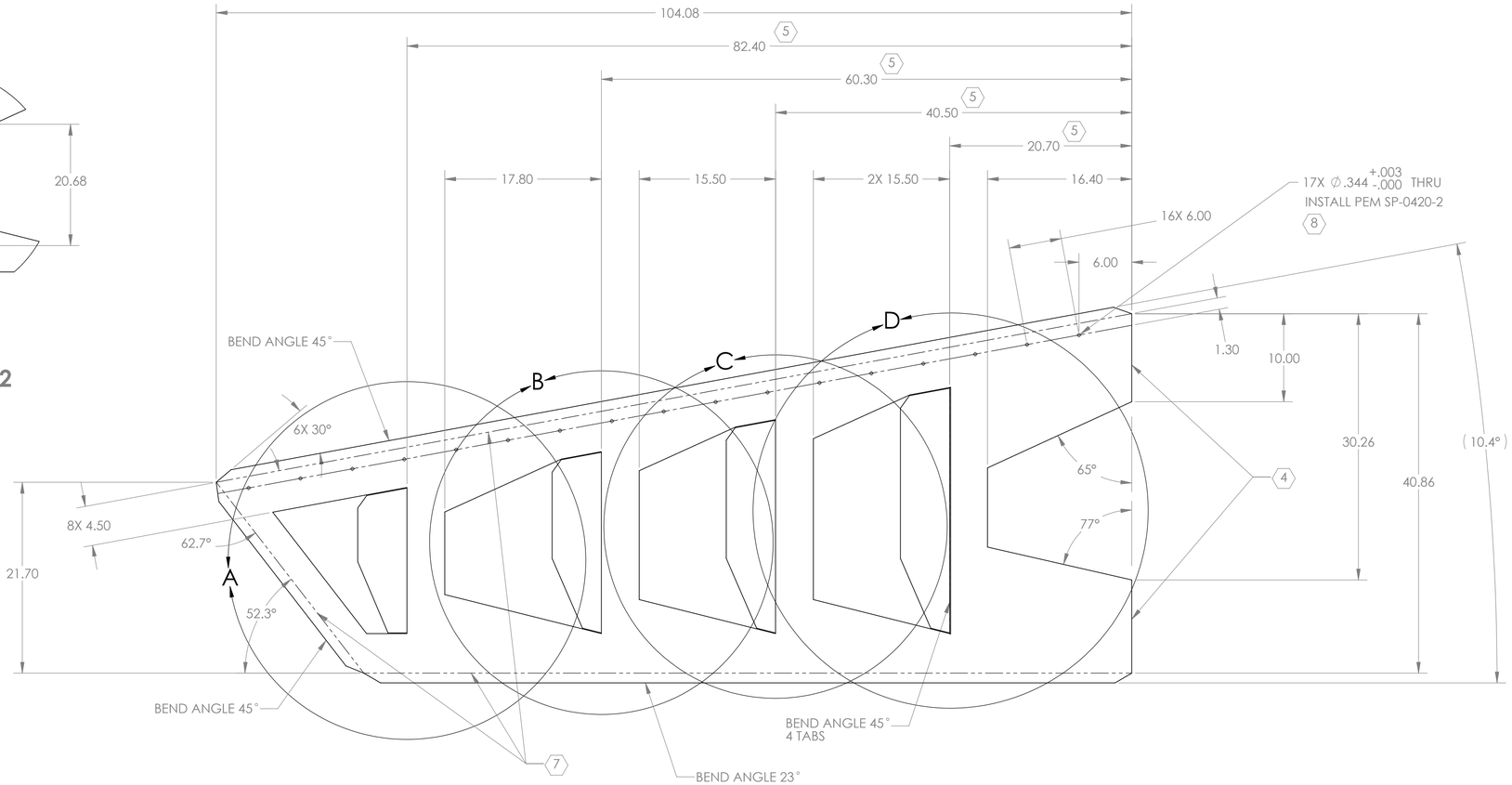


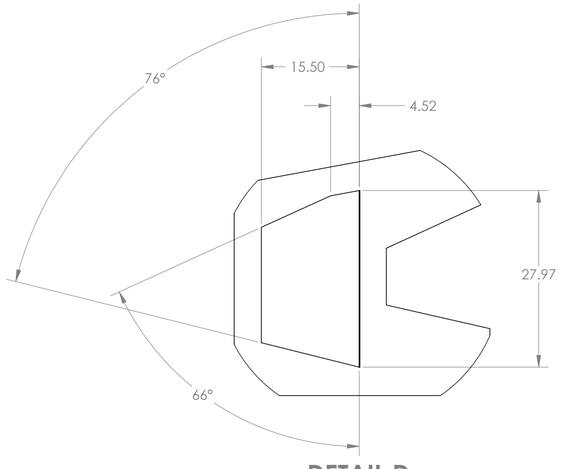
DETAIL B
SCALE 1 : 12



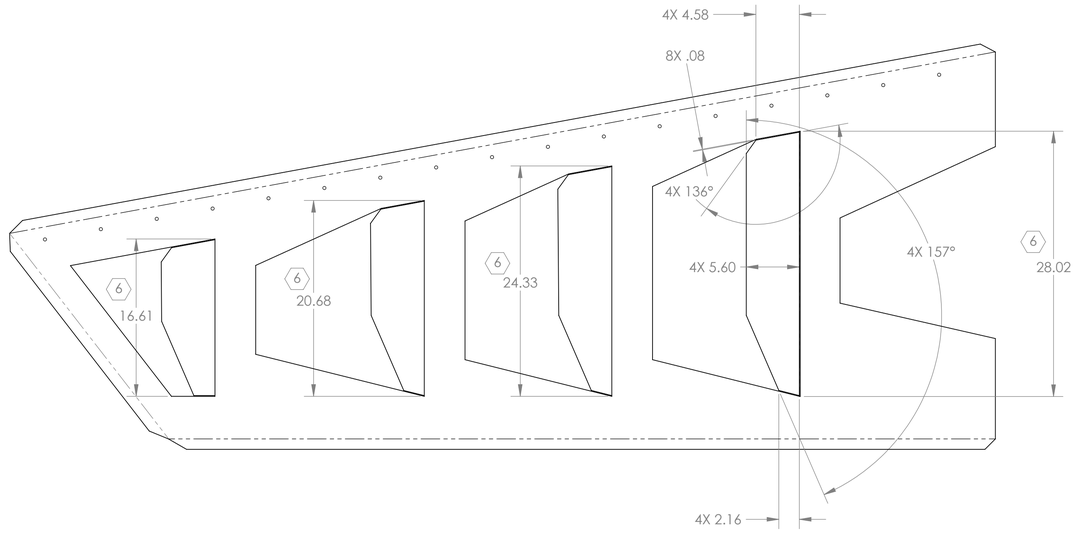
DETAIL C
SCALE 1 : 12

PANEL 1





DETAIL D
SCALE 1 : 12



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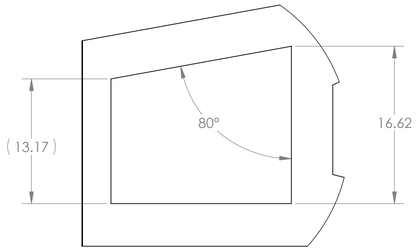
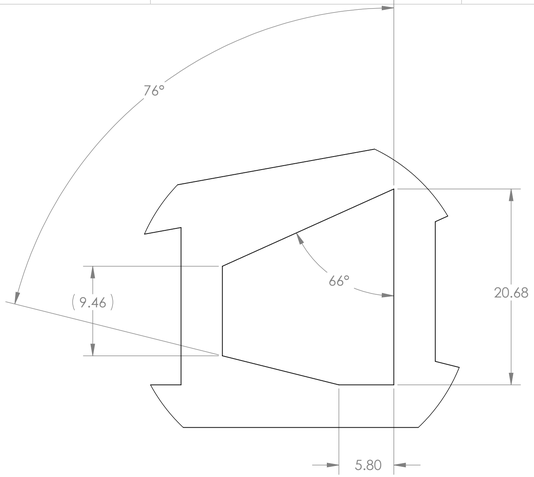
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D1002207	v2

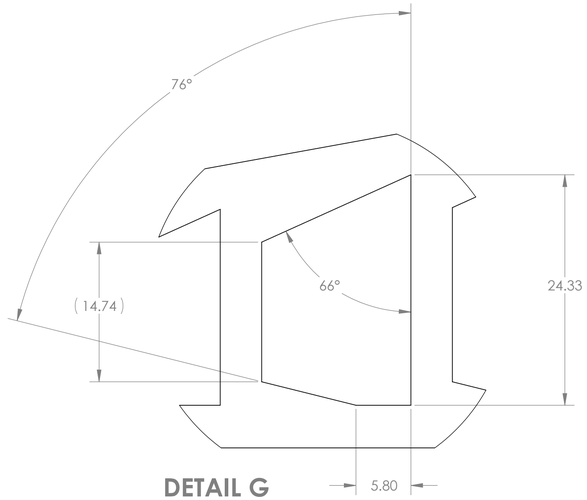
SCALE: 1:8 | PROJECTION: | SHEET 3 OF 10



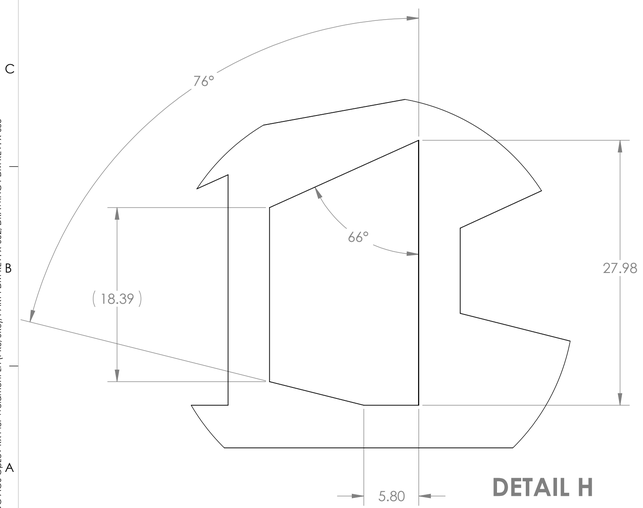
DETAIL E



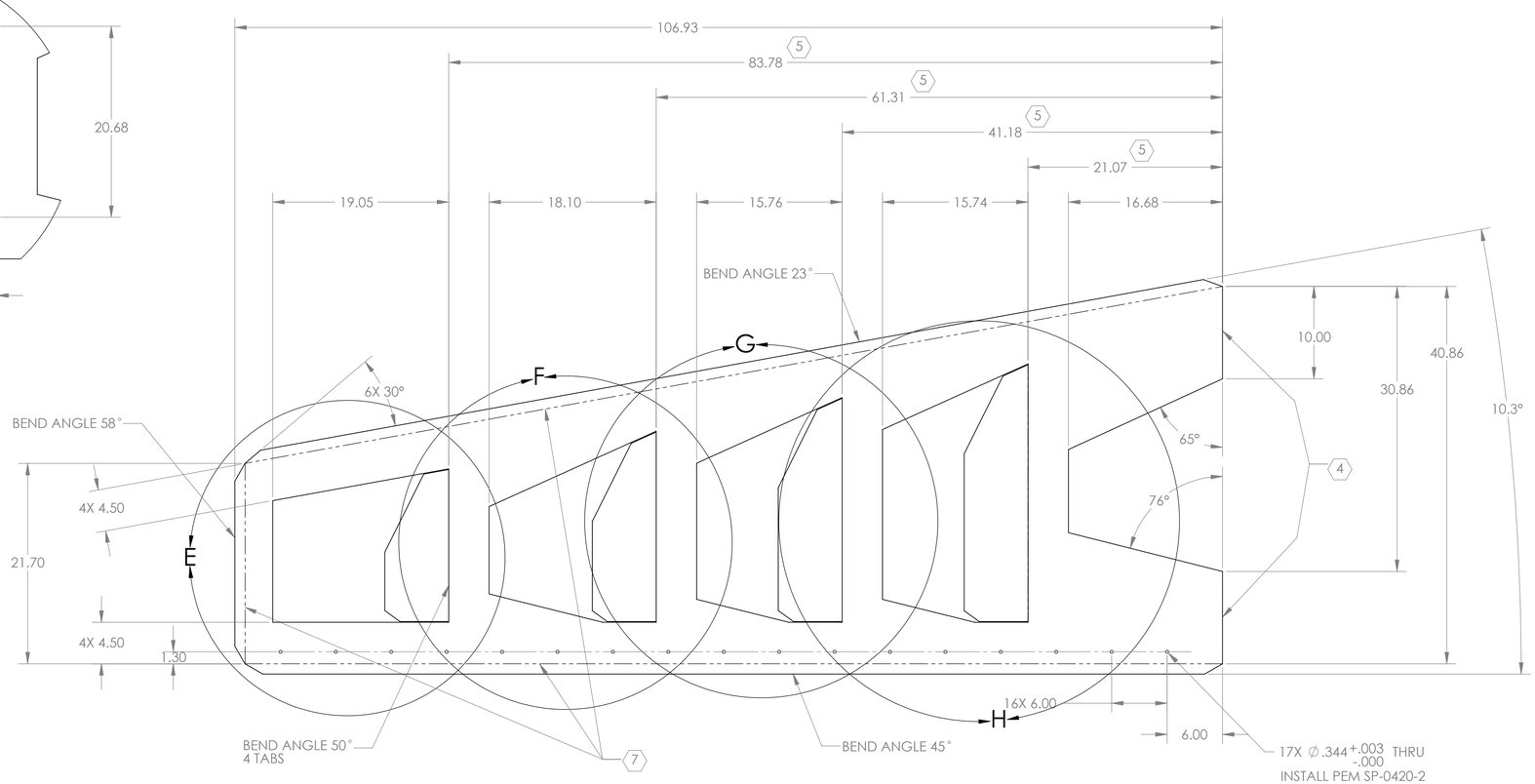
DETAIL F



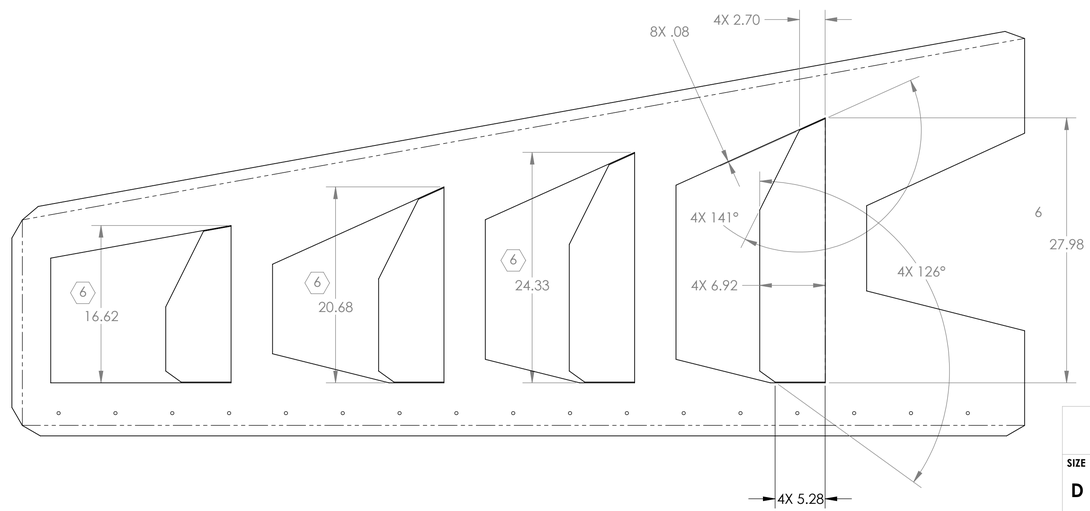
DETAIL G



DETAIL H

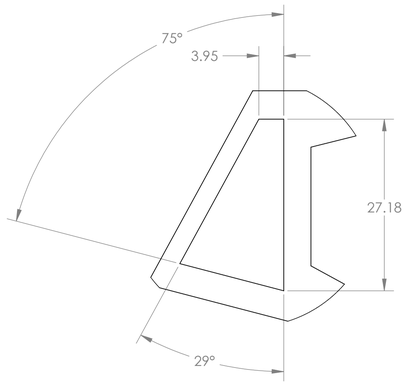


PANEL 2

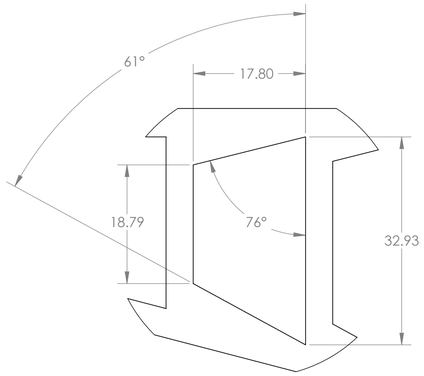


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE D	DWG. NO. D1002207	REV. v2
SCALE: 1:8	PROJECTION:	SHEET 4 OF 10

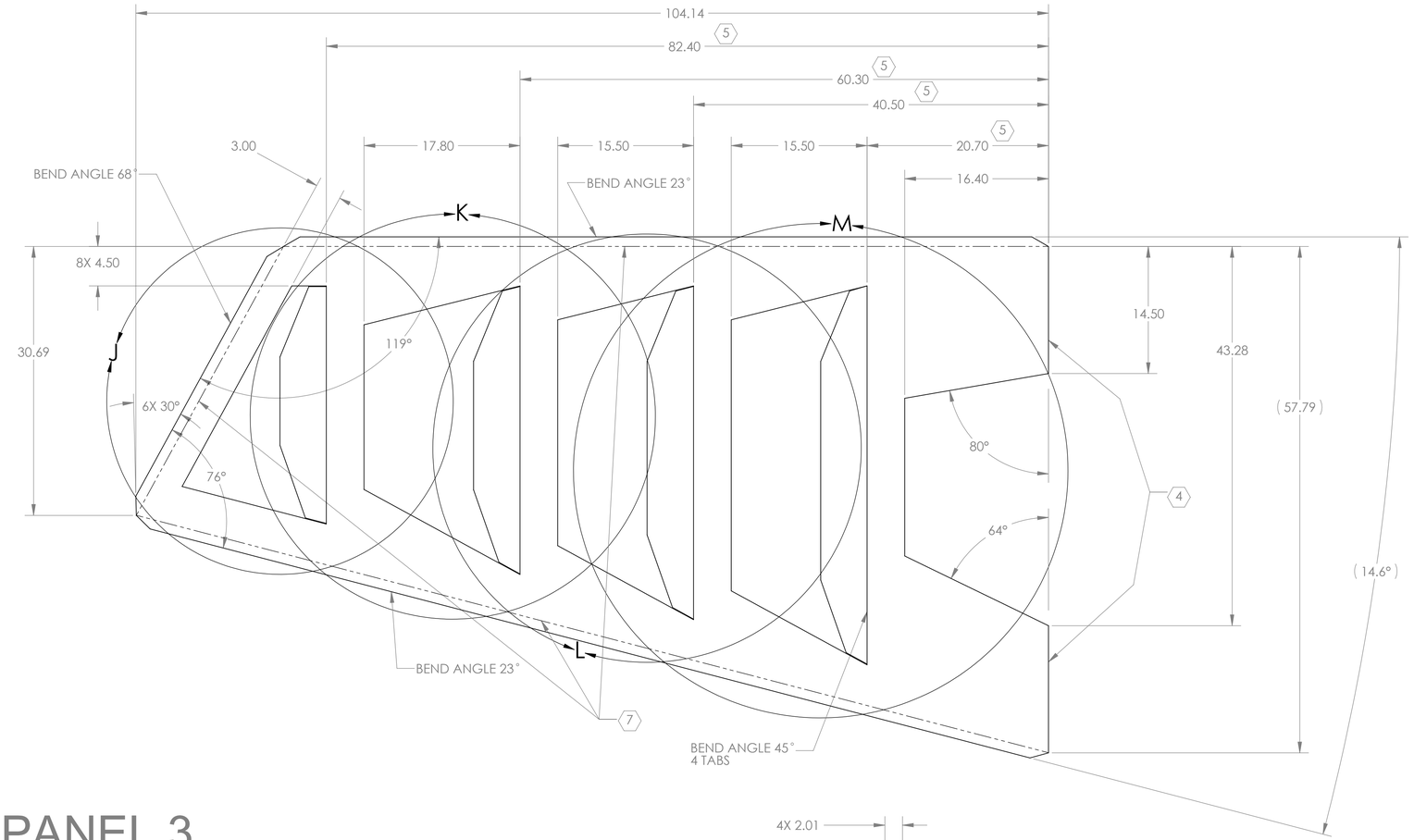
PANEL 3

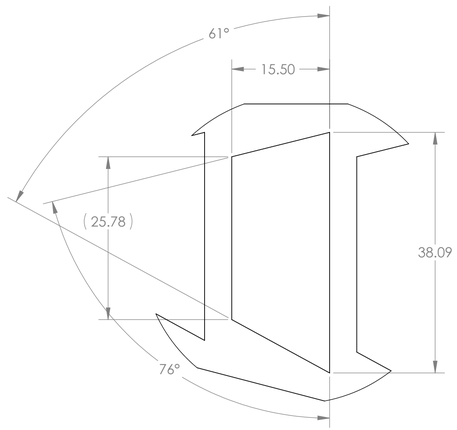


DETAIL J
SCALE 1 : 12

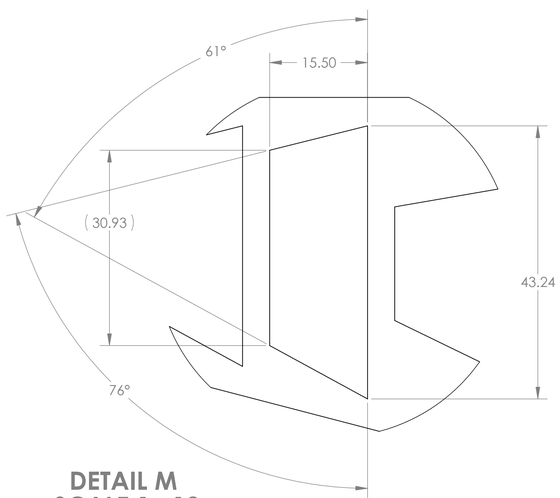


DETAIL K
SCALE 1 : 12

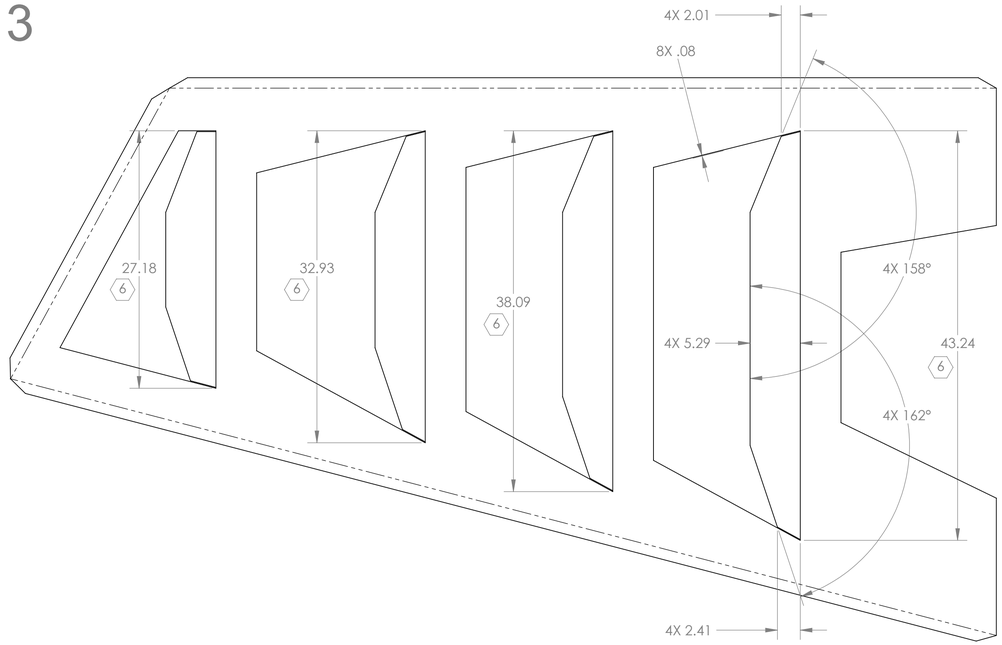




DETAIL L
SCALE 1 : 12

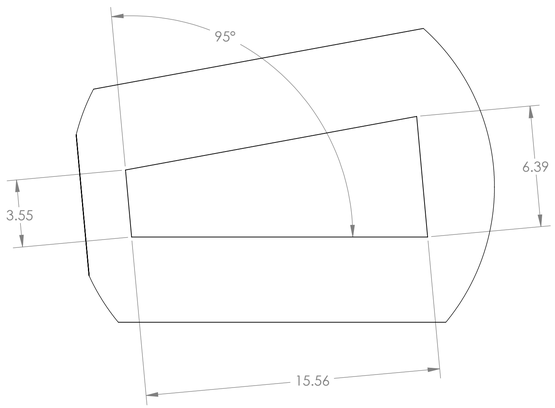


DETAIL M
SCALE 1 : 12

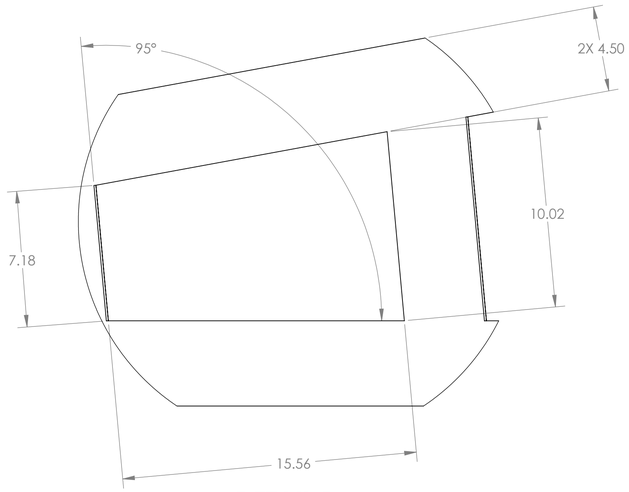


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE: D	DWG. NO.: D1002207	REV.: v2
SCALE: 1:8	PROJECTION:	SHEET 5 OF 10

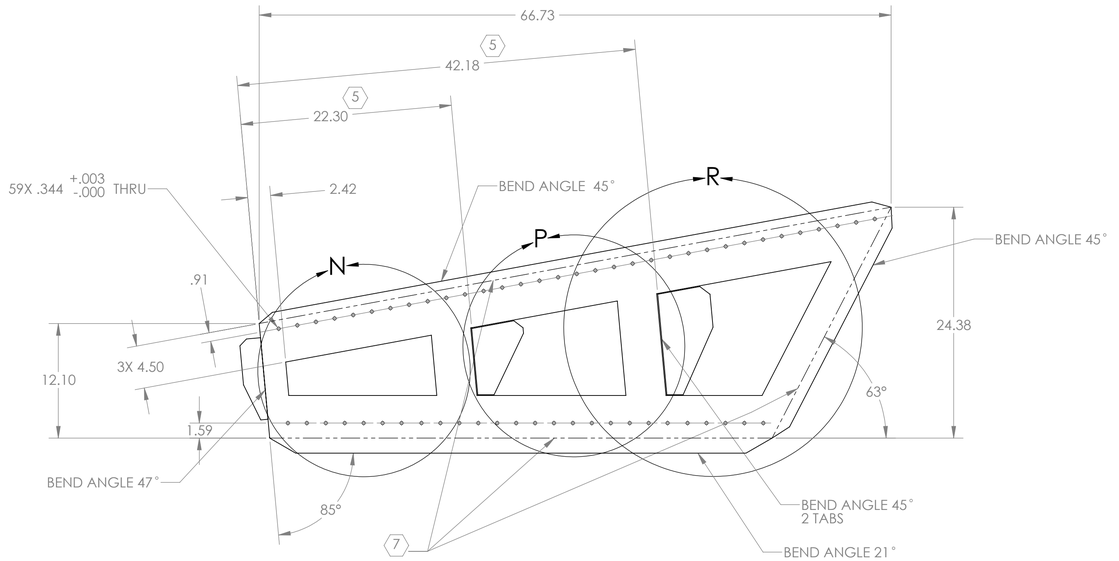
PANEL 4

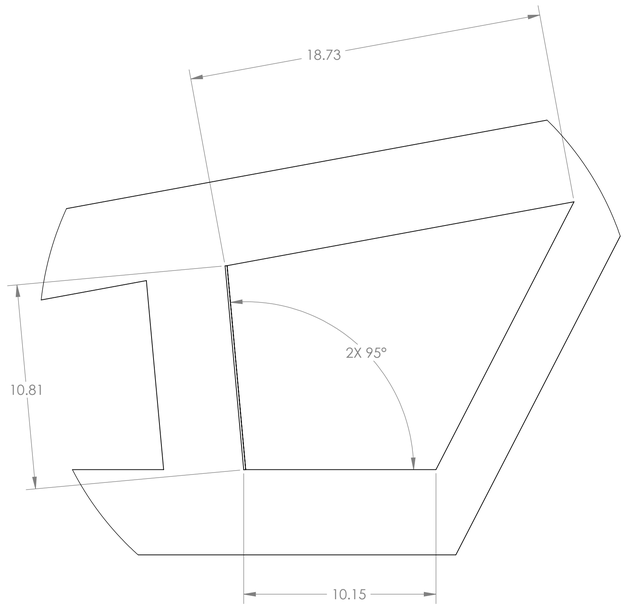


DETAIL N
SCALE 1 : 4

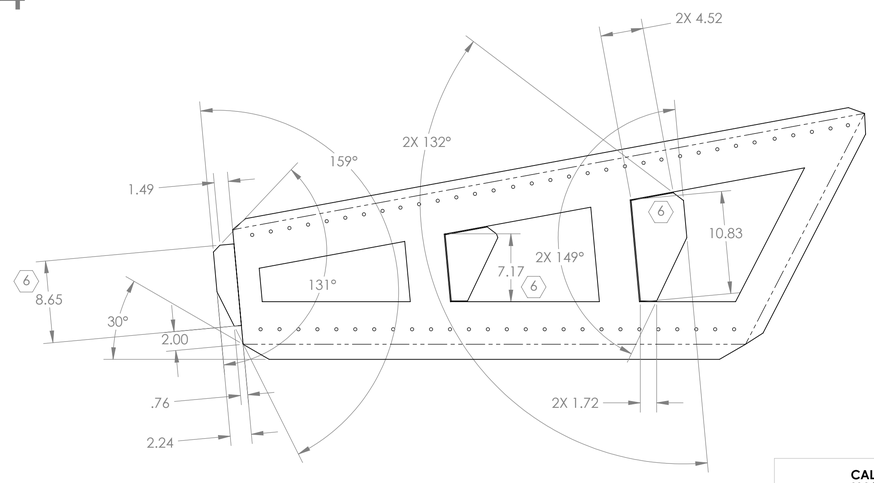


DETAIL P
SCALE 1 : 4





DETAIL R
SCALE 1 : 4

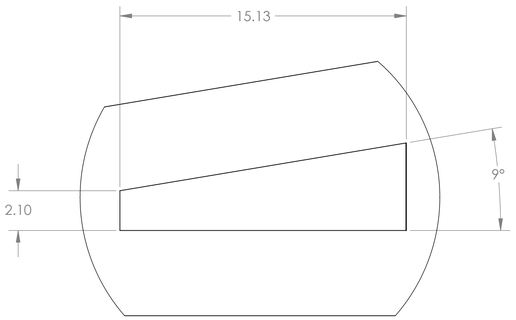


CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

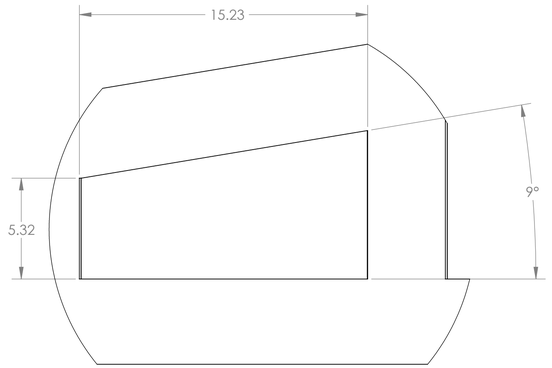
SIZE	DWG. NO.	REV.
D	D1002207	v2

SCALE: 1:8 | PROJECTION: | SHEET 6 OF 10

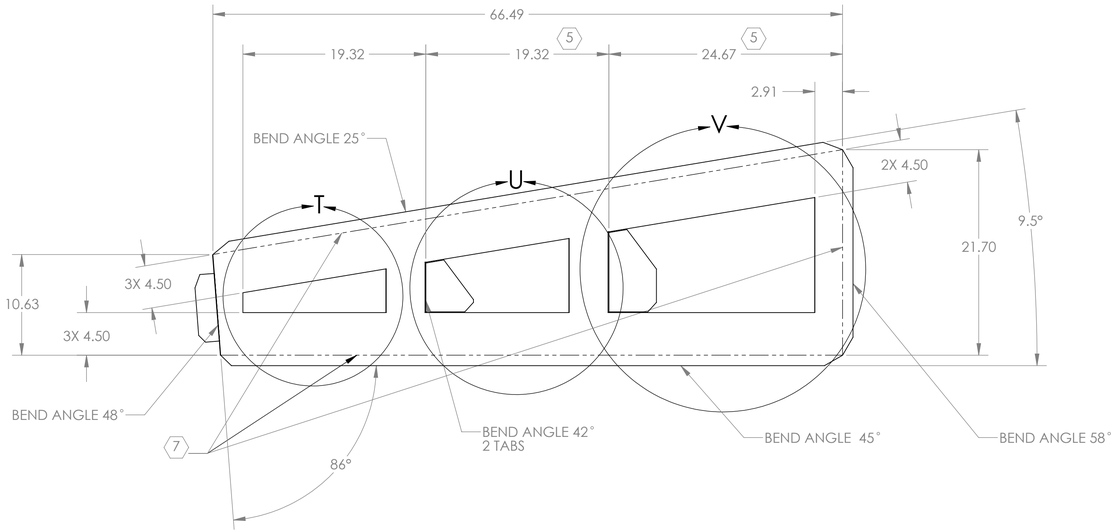
PANEL 5

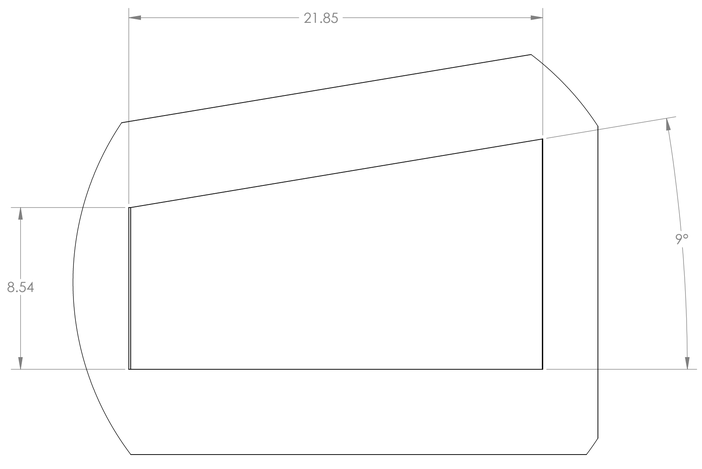


DETAIL T
SCALE 1 : 4

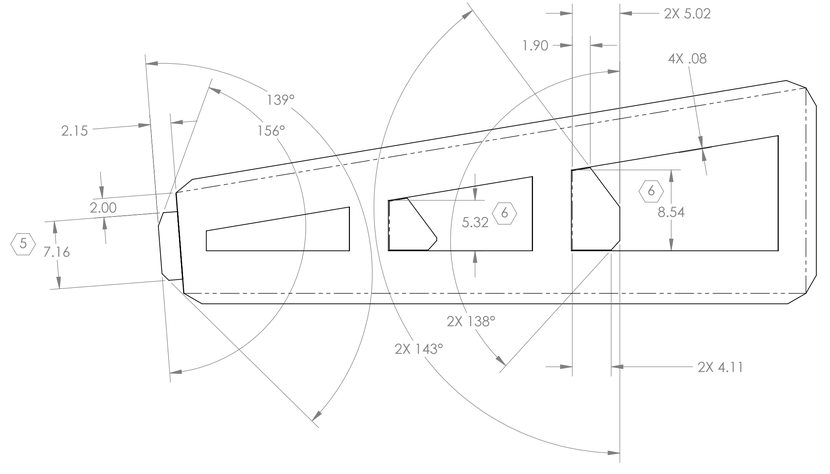


DETAIL U
SCALE 1 : 4



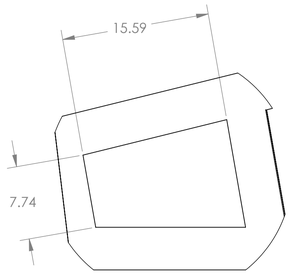


DETAIL V
SCALE 1 : 4

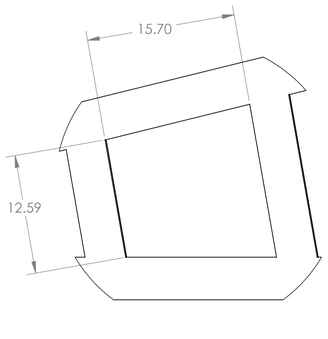


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE D	DWG. NO. D1002207	REV. v2
SCALE: 1:8	PROJECTION:	SHEET 7 OF 10

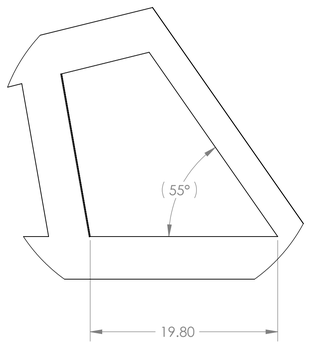
PANEL 6



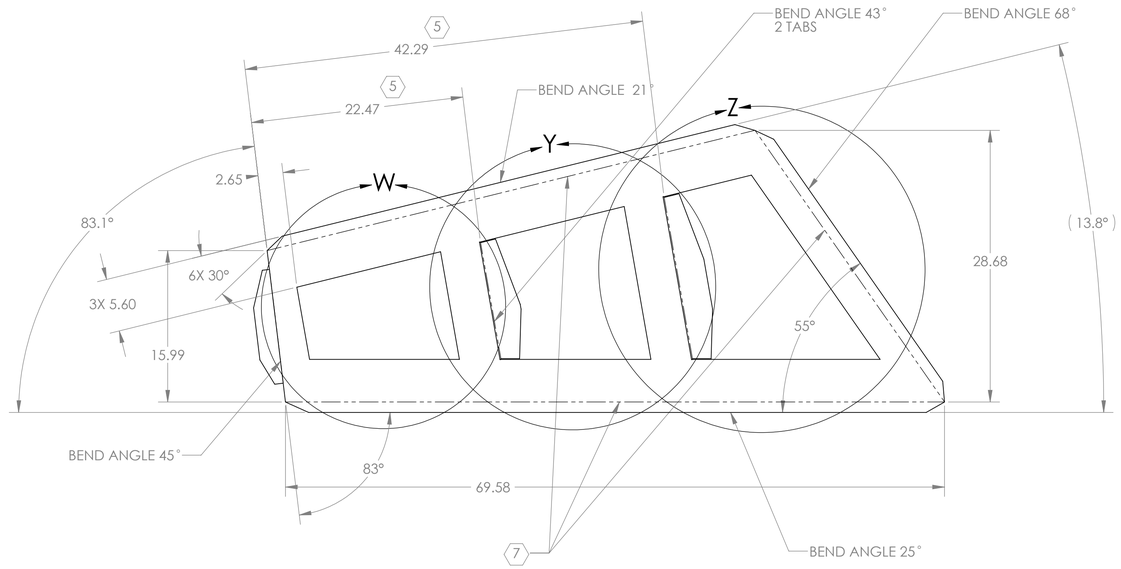
DETAIL W

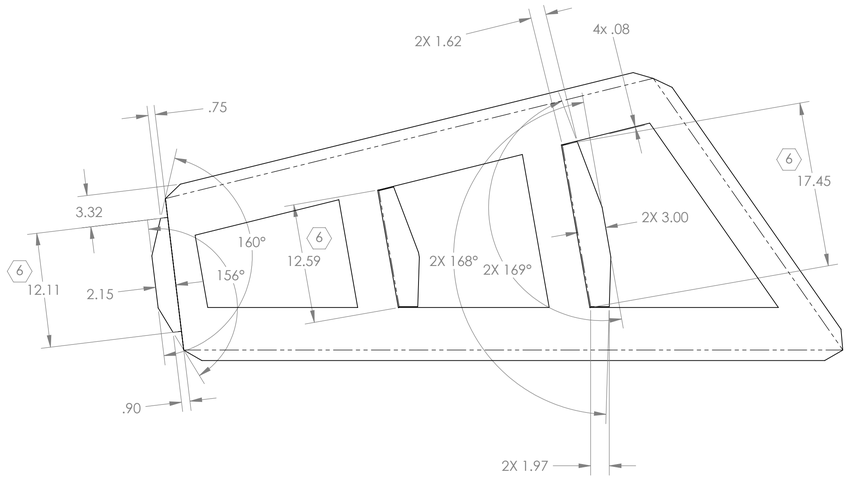


DETAIL Y

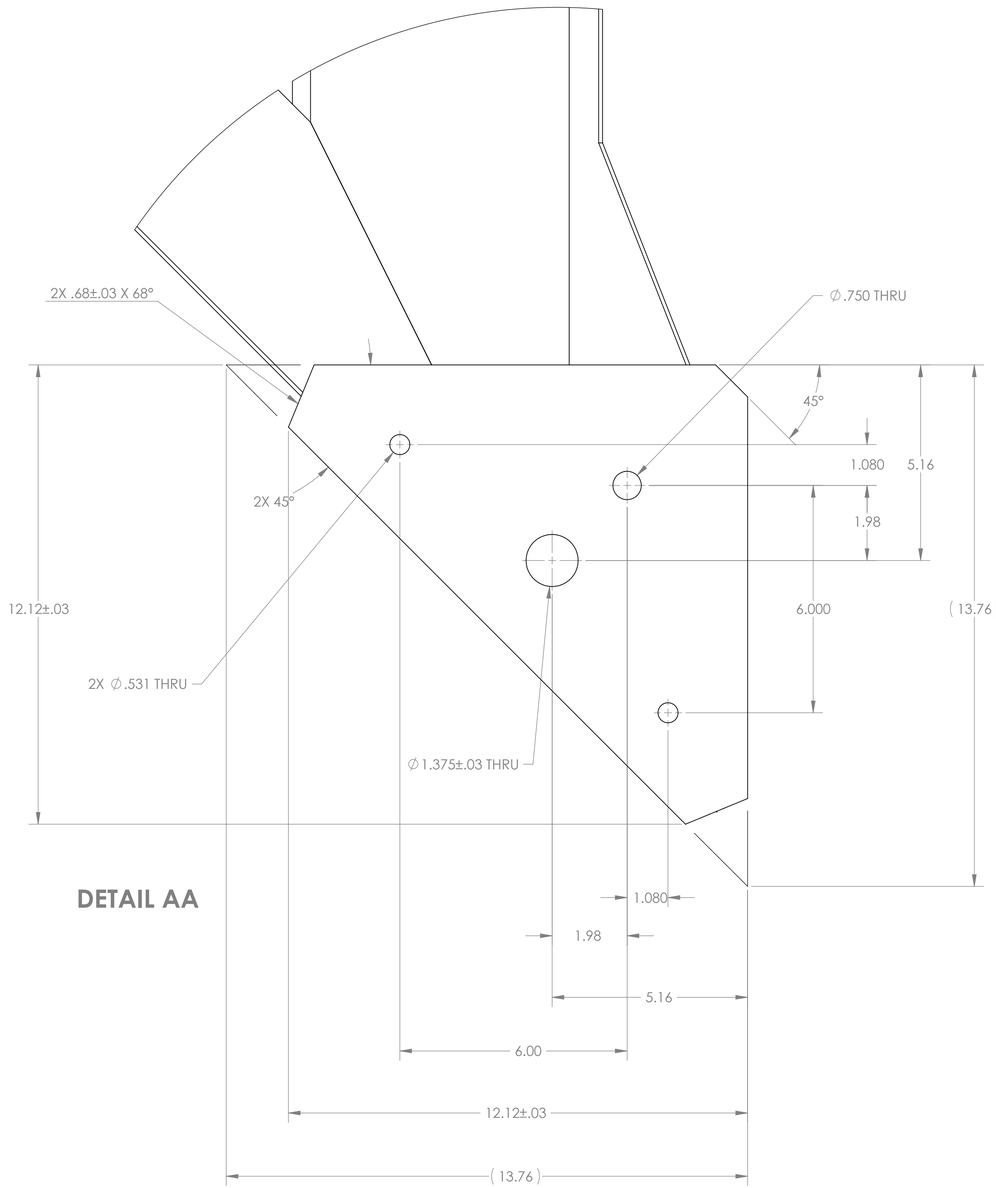


DETAIL Z

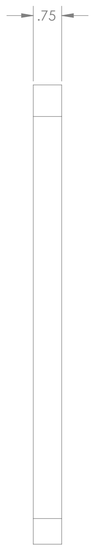




CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE D	DWG. NO. D1002207	REV. v2
SCALE: 1:8	PROJECTION:	SHEET 8 OF 10

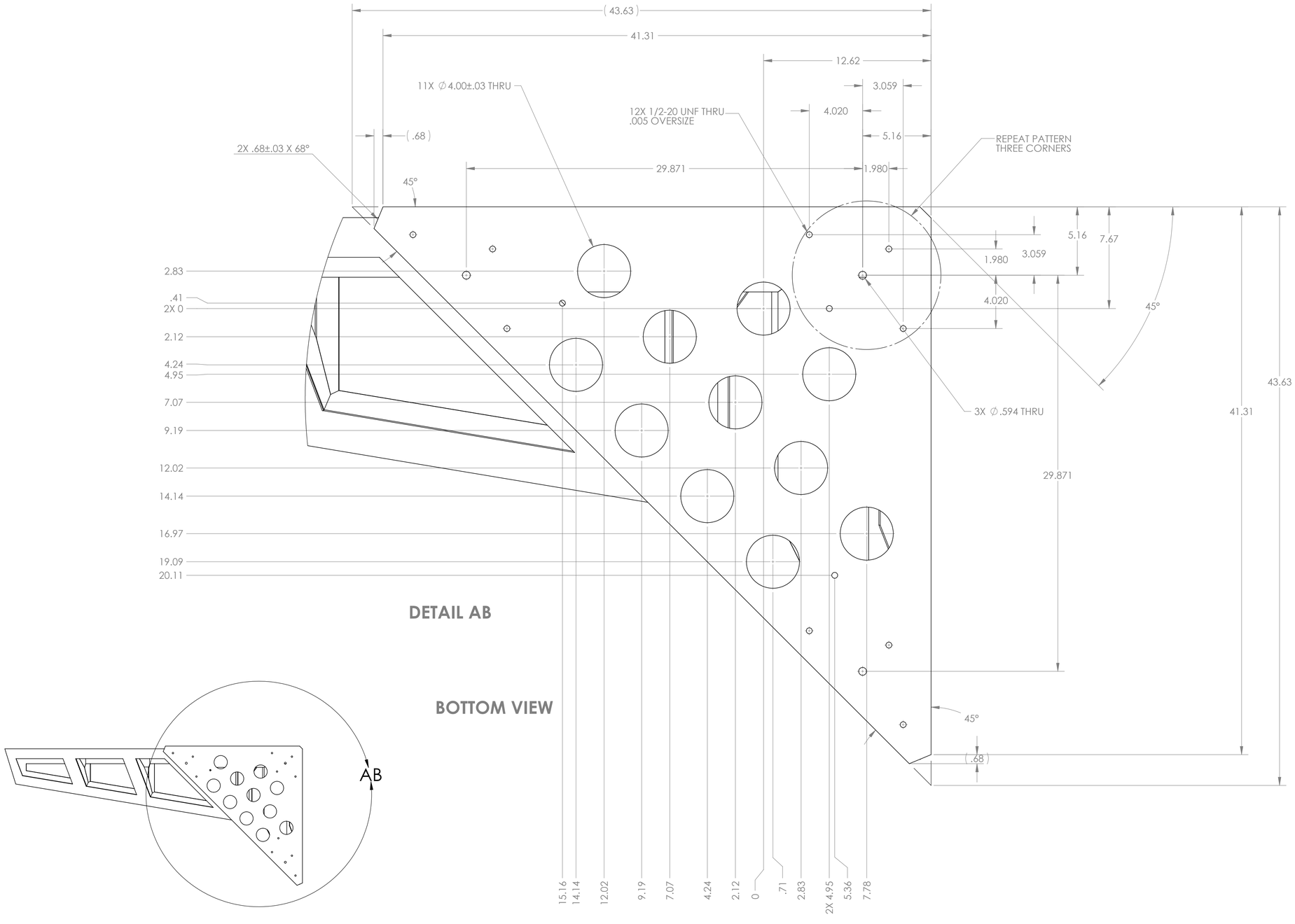


DETAIL AA



BASE

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE: D	DWG. NO.: D1002207	REV.: v2
SCALE: 1:2	PROJECTION:	SHEET 9 OF 10



DETAIL AB

BOTTOM VIEW

FOOTING

D1002207 aLIGO AOS Cryo+ RX Pier Weldment LH (PR3, SR3), PART PDM REV: X-052, DRAWING PDM REV: X-035

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE: D	DWG. NO.: D1002207	REV.: v2
SCALE: 1:4	PROJECTION:	SHEET 10 OF 10