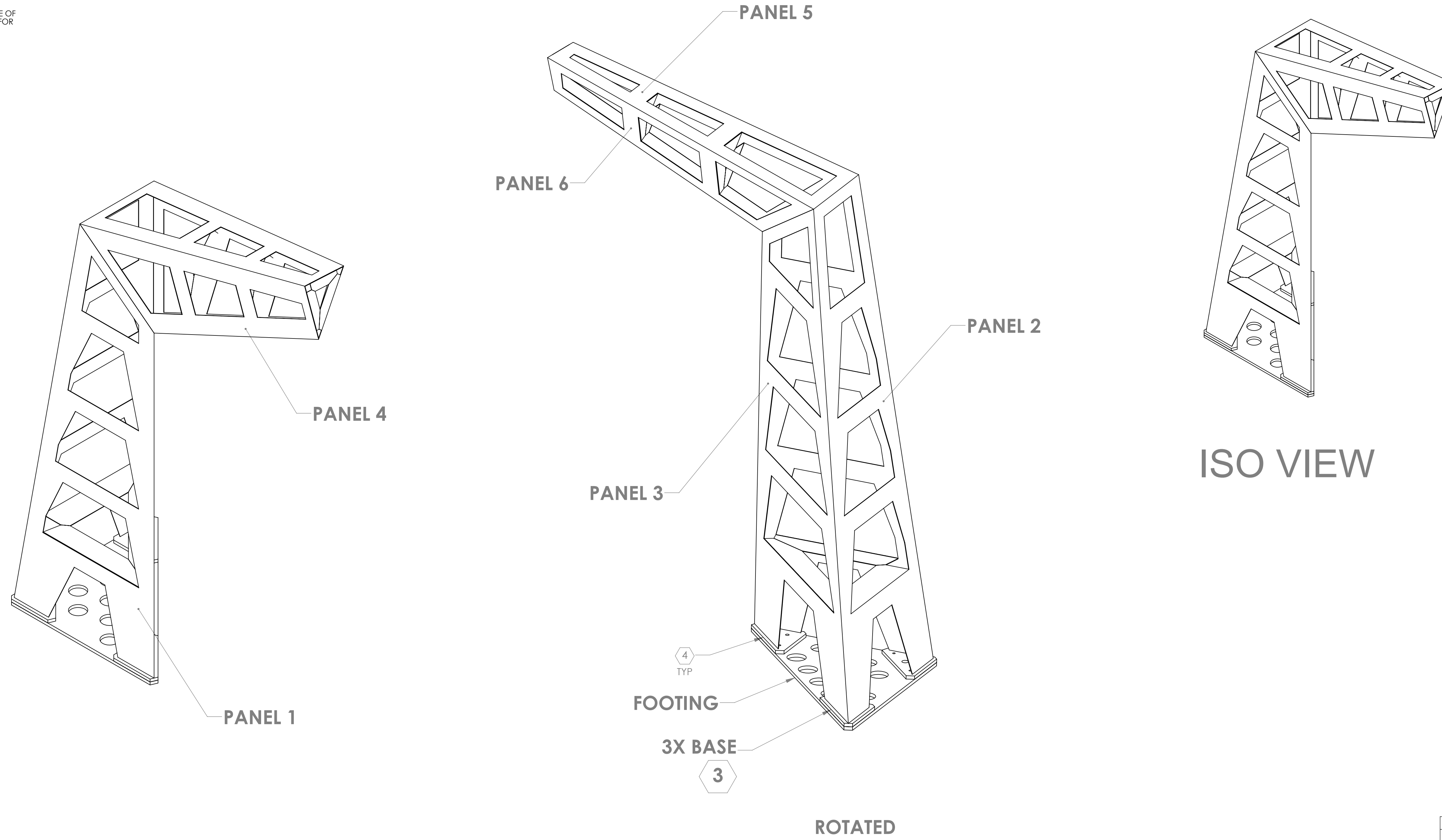


**NOTES CONTINUED:**

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. THIS UNIT IS MIRROR IMAGE OPPOSITE OF D1002207. SEE DRAWING D1002207 FOR COMPLETE CONSTRUCTION DETAILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 AUG 2010	E1000182-v1	-
-	-	-	-
-	-	-	-



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	

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .02 .XXX ± .005		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.		SYSTEM		ALIGO AOS OPLEV RX PIER WELDMENT RH (SR3)	
ANGULAR ± N/A °		MATERIAL REFER TO TABLE		SUB-SYSTEM ADVANCED LIGO		DWG. NO. D1002208	
		FINISH REFER TO TABLE		NEXT ASSY		REV. v1	
						SCALE: 1:12	
						PROJECTION:	
						SHEET 1 OF 1	

D1002208.dwg: AOS Oplev: RX Pier Weldment RH (SR3) - H1, L1, PART PDM REV: X-003, DRAWING PDM REV: X-005