

D1002493 aLIGO OPLEV PERISCOPE MOUNTING AND INSTALL SHELF WELDMENT, PART PDM REV: X-015, DRAWING PDM REV: X-005

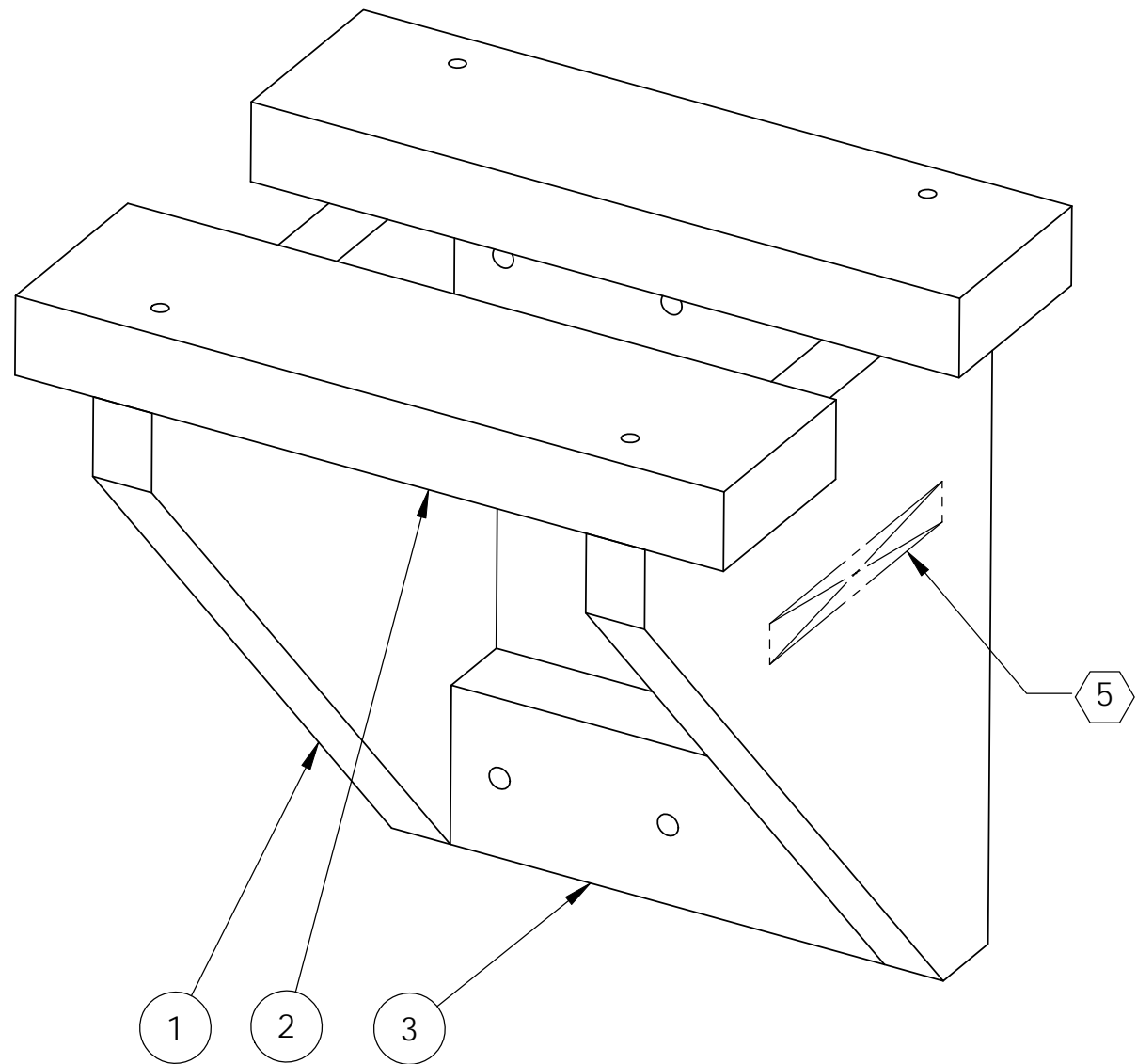
8 7 6 5 4 3 2 1

REV.	DATE	DCN #	DRAWING TREE #
v1	18 FEB 2011	E1100106-v1	-
v2	12 SEPT 2011	E1100106-v1	-
-	-	-	-

**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 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- 6. APPROXIMATE WEIGHT = 19.39 LBS.
- 7. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 8. WELDING:  
ALL DIMENSIONS APPLY AFTER WELDING.  
ALL WELDS MUST MEET MIL-STD-2219, CLASS C.



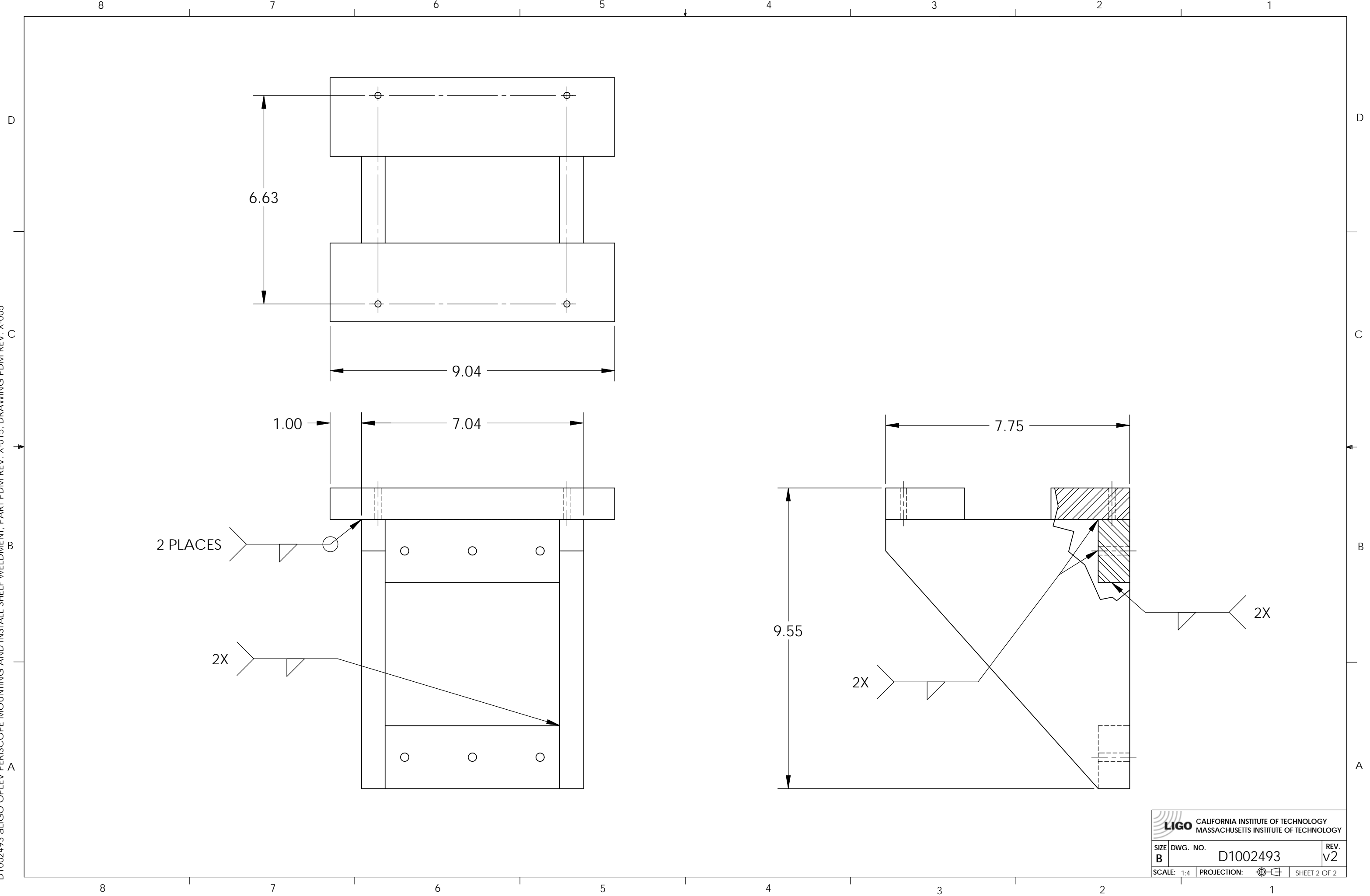
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	SPARE	REQ	TOTAL
3	D1100329	aLIGO OPLEV STIFFENER WELDMENT BACKING SUPPORT	304 SSTL		2	2
2	D1002499	aLIGO OPLEV STIFFENER WELDMENT BAR	304 SSTL		2	2
1	D1002492	aLIGO OPLEV PERISCOPE MOUNTING AND INSTALL GUSSET	304 SSTL		2	2

**PARTS LIST**

<p><b>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</b></p> <p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES: .XX ± .06 .XXX ± .010</p> <p>ANGULAR ± 1.0°</p>		<p>1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWINGS. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.</p>		<p><b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME aLIGO OPLEV PERISCOPE MOUNTING, AND INSTALL SHELF WELDMENT</p>	
<p>MATERIAL N/A</p>		<p>FINISH N/A μinch</p>		<p>SYSTEM ADVANCED LIGO</p>		<p>DESIGNER J. TERRAZAS</p>	
<p>DATE 17 FEB 2011</p>		<p>SCALE: 1:4</p>		<p>PROJECTION: </p>		<p>SIZE DWG. NO. B D1002493</p>	
<p>APPROVAL</p>		<p>REVISION v2</p>		<p>PROJECT: </p>		<p>SHEET 1 OF 2</p>	

8 7 6 5 4 3 2 1

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**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE <b>B</b>	DWG. NO. D1002493	REV. v2
SCALE: 1:4		PROJECTION:  SHEET 2 OF 2