

D1002862 aLIGO OPLEV PIER ADAPTER STRUCTURE, WELDMENT, PART PDM REV: X-017, DRAWING PDM REV: X-006

REV.	DATE	DCN #	DRAWING TREE #
v1	15 FEB 2011	E1100106-v1	-
v2	09 SEPT 2011	E1100106-v1	-
-	-	-	-

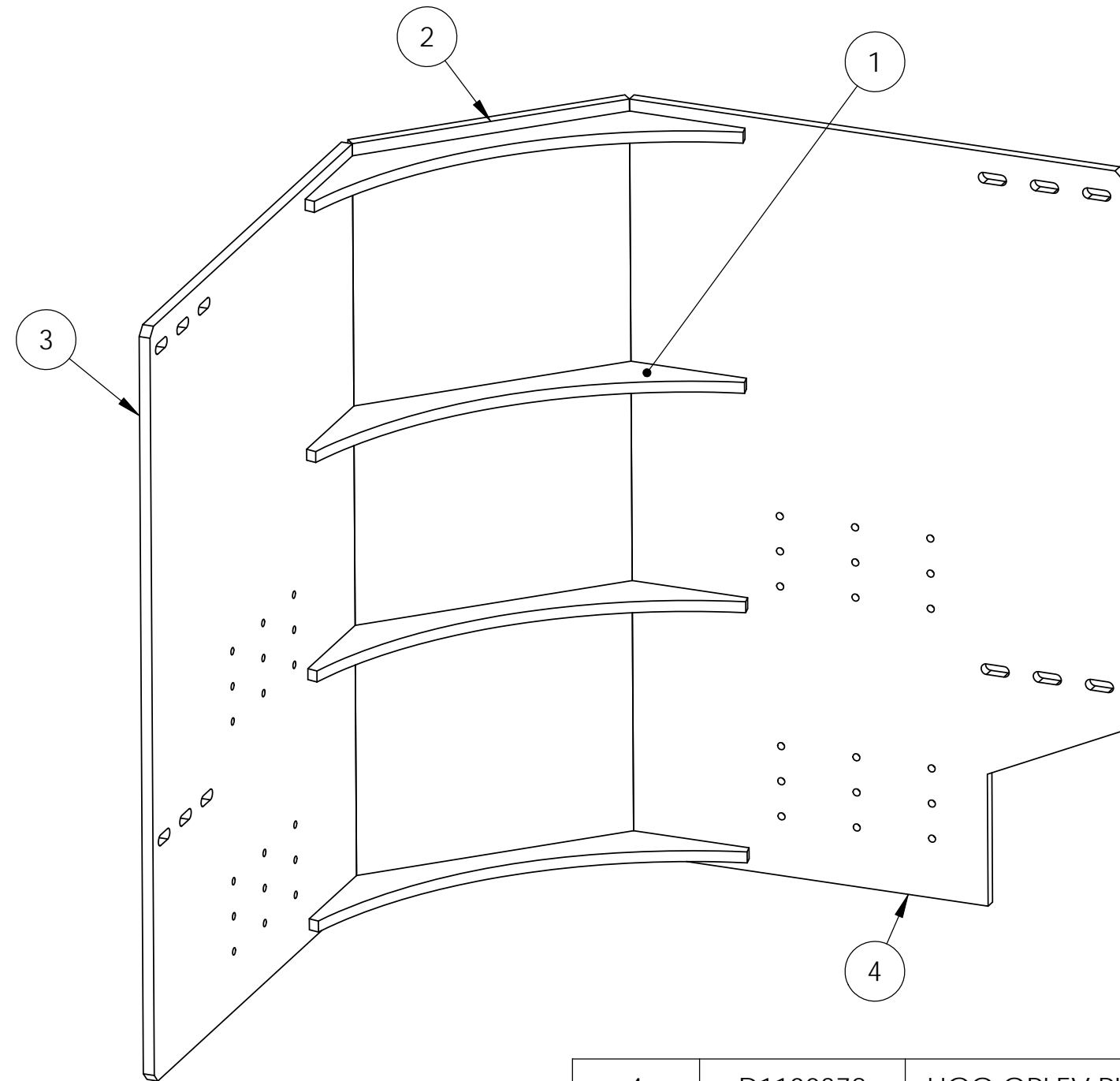
NOTES CONTINUED:

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 = 66.83 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.

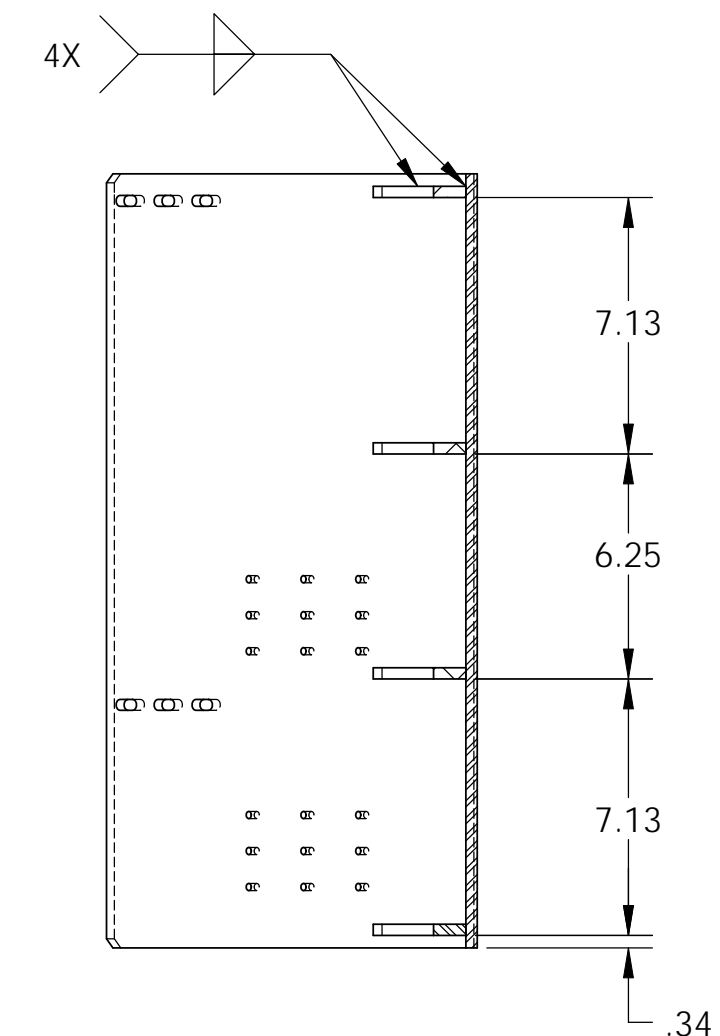
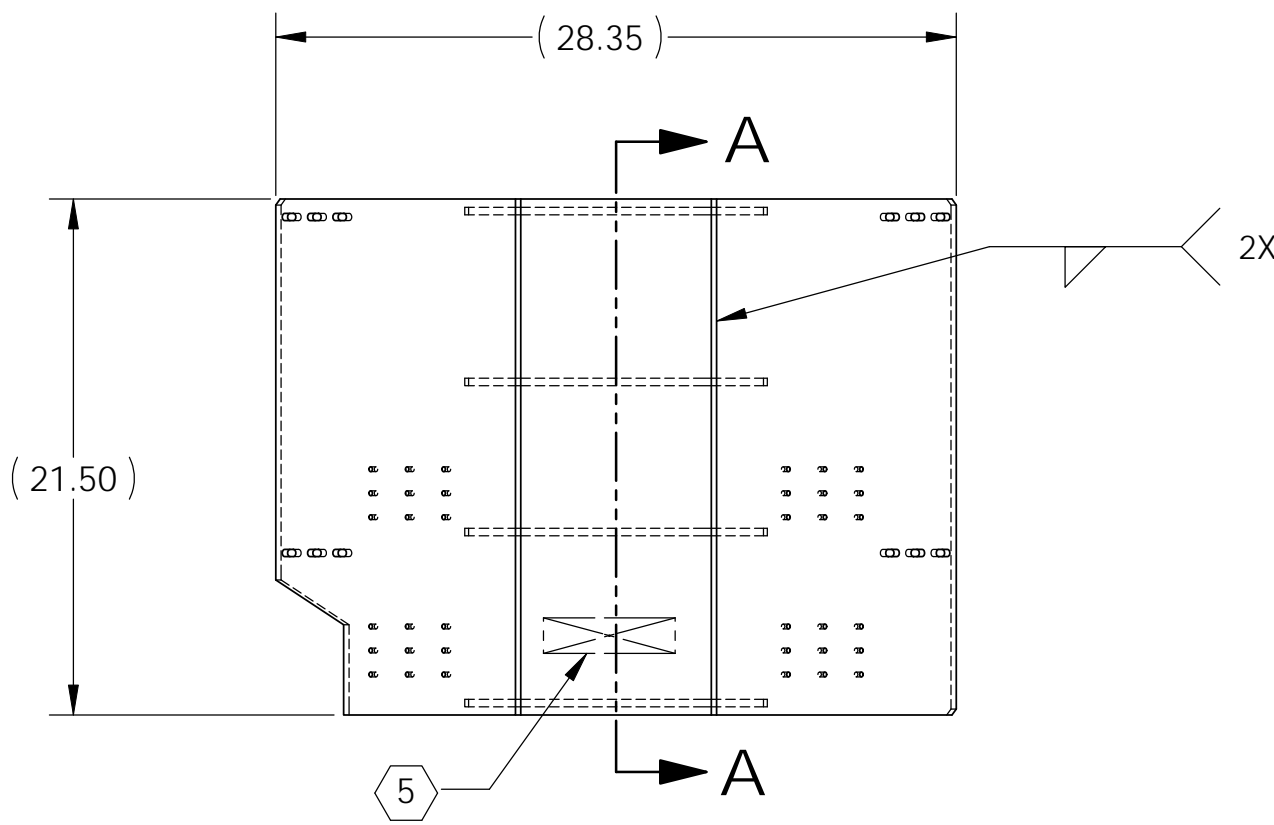
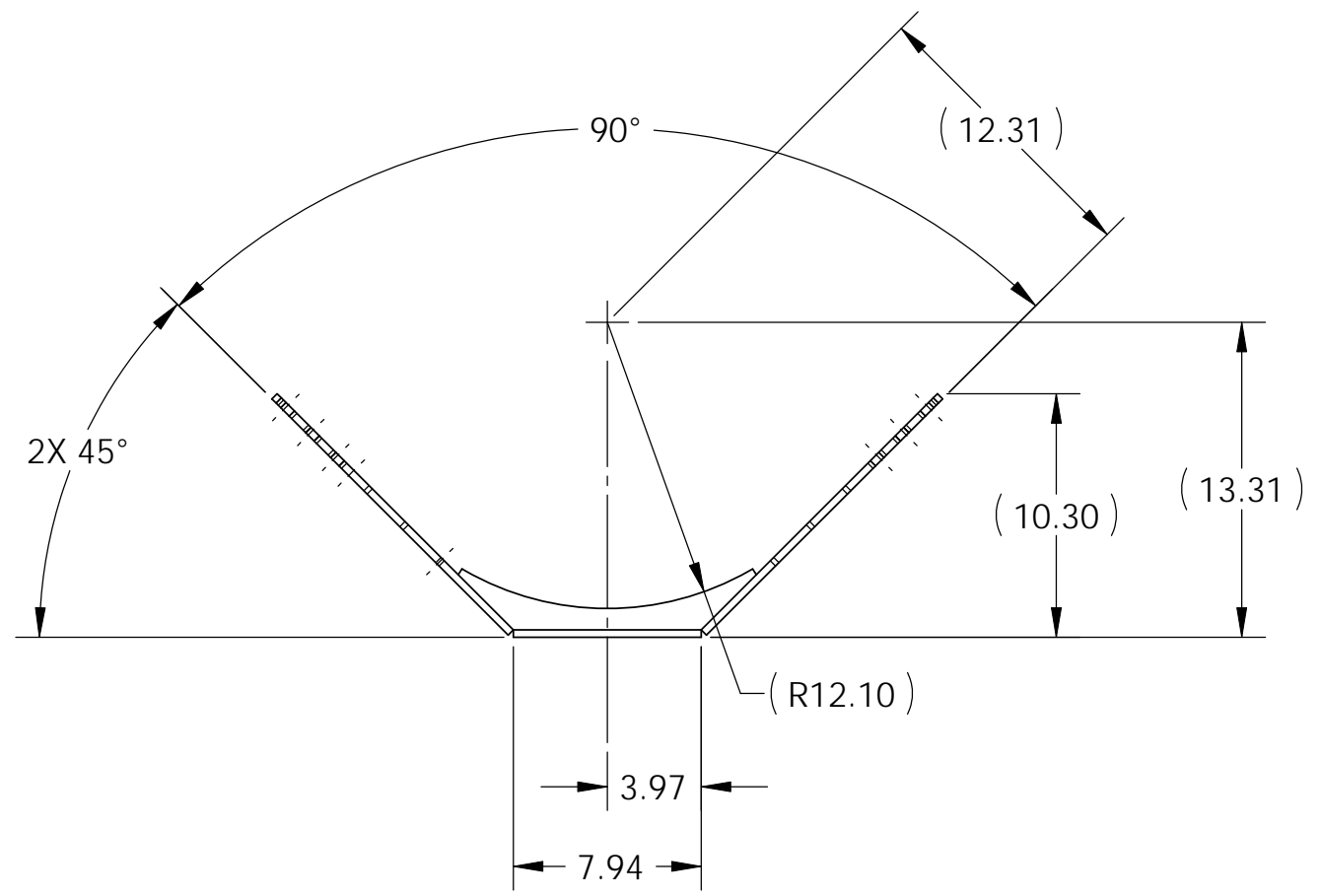


ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	D1100378	aLIGO OPLEV PIER PLATE, LARGE	304 SSSL	1		1
3	D1002859	aLIGO OPLEV PIER PLATE, LARGE, FULL	304 SSSL	1		1
2	D1002860	aLIGO PIER PLATE, SMALL	304 SSSL	1		1
1	D1002861	aLIGO OPLEV PIER, RIB	304 SSSL	4		4



PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
DIMENSIONS ARE IN INCHES		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.		ADVANCED LIGO		aLIGO OPLEV PIER ADAPTER STRUCTURE, WELDMENT		REV. v2	
TOLERANCES: .XX ± .02 .XXX ± .010		MATERIAL N/A		SUB-SYSTEM AOS		SIZE DWG. NO. B D1002862		DRAWN J. TERRAZAS 14 FEB 2011	
ANGULAR ± 1.0°		FINISH N/A μinch		NEXT ASSY D1100302		SCALE: 1:8		PROJECTION:	

D1002862 aLIGO OPLEV PIER ADAPTER STRUCTURE, WELDMENT, PART PDM REV: X-017, DRAWING PDM REV: X-006



SECTION A-A
SCALE 3 : 16

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D1002862
SCALE: 1:8	PROJECTION:  SHEET 2 OF 2
REV. v2	