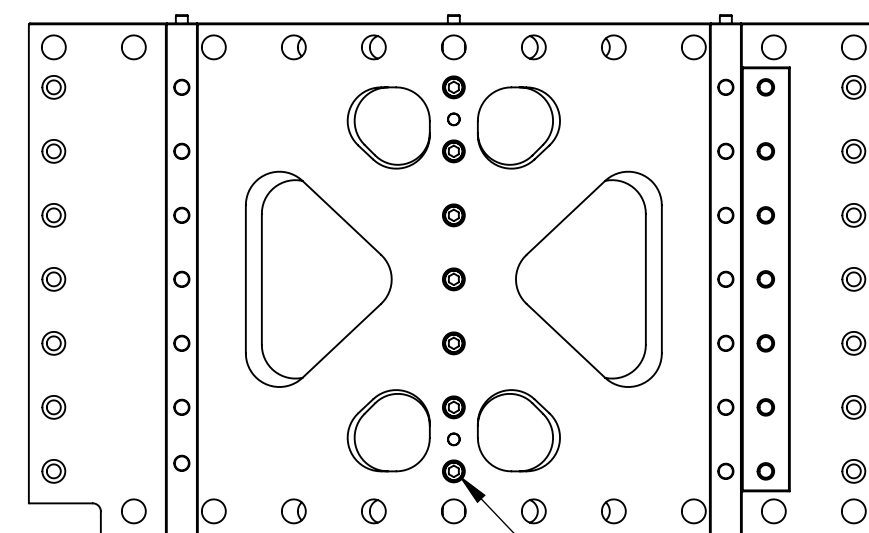


NOTES CONTINUED:

- 5. Refer to LIGO-E0900216 for assembly instructions.
- 6. Orient Barrel Nuts with flats facing away from screws.
- 7. Weight of finished assembly: 96 lbs

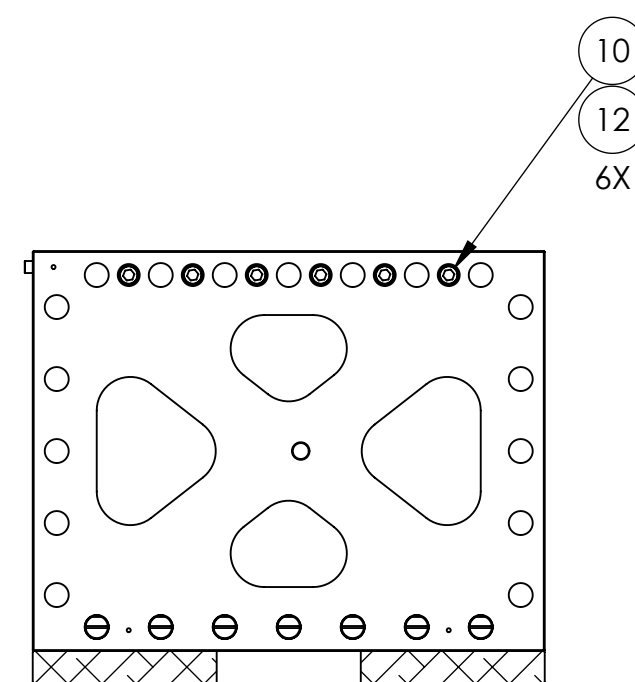
REV.	DATE	DCN #	DRAWING TREE #
v1 / D	08 JAN 2008	N/A	N/A
v2	06 JAN 2010	E1000001	T0900305



11

12

7X

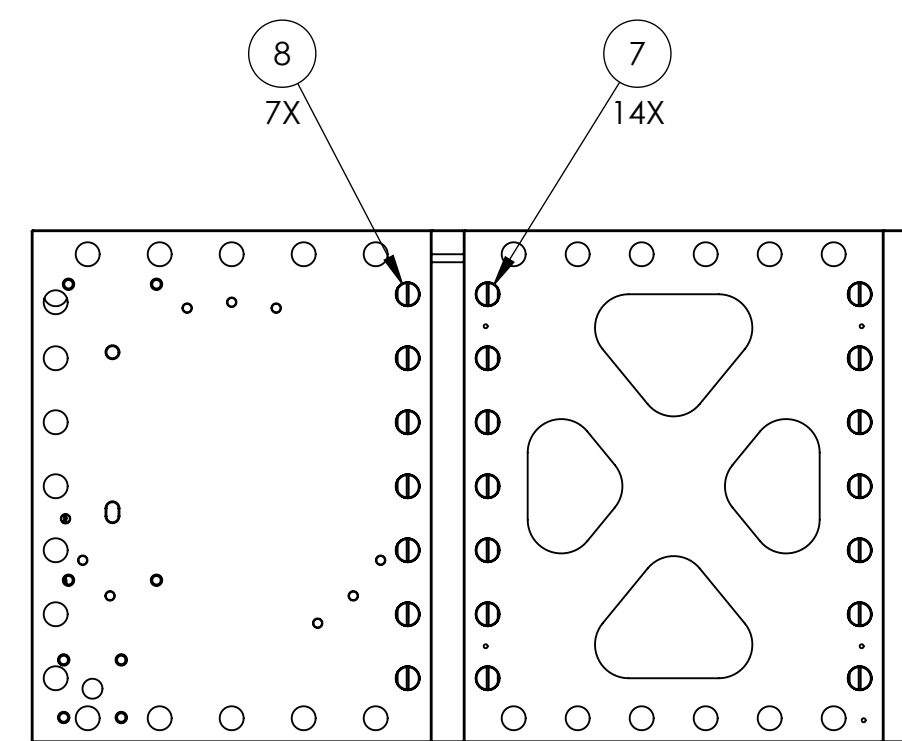
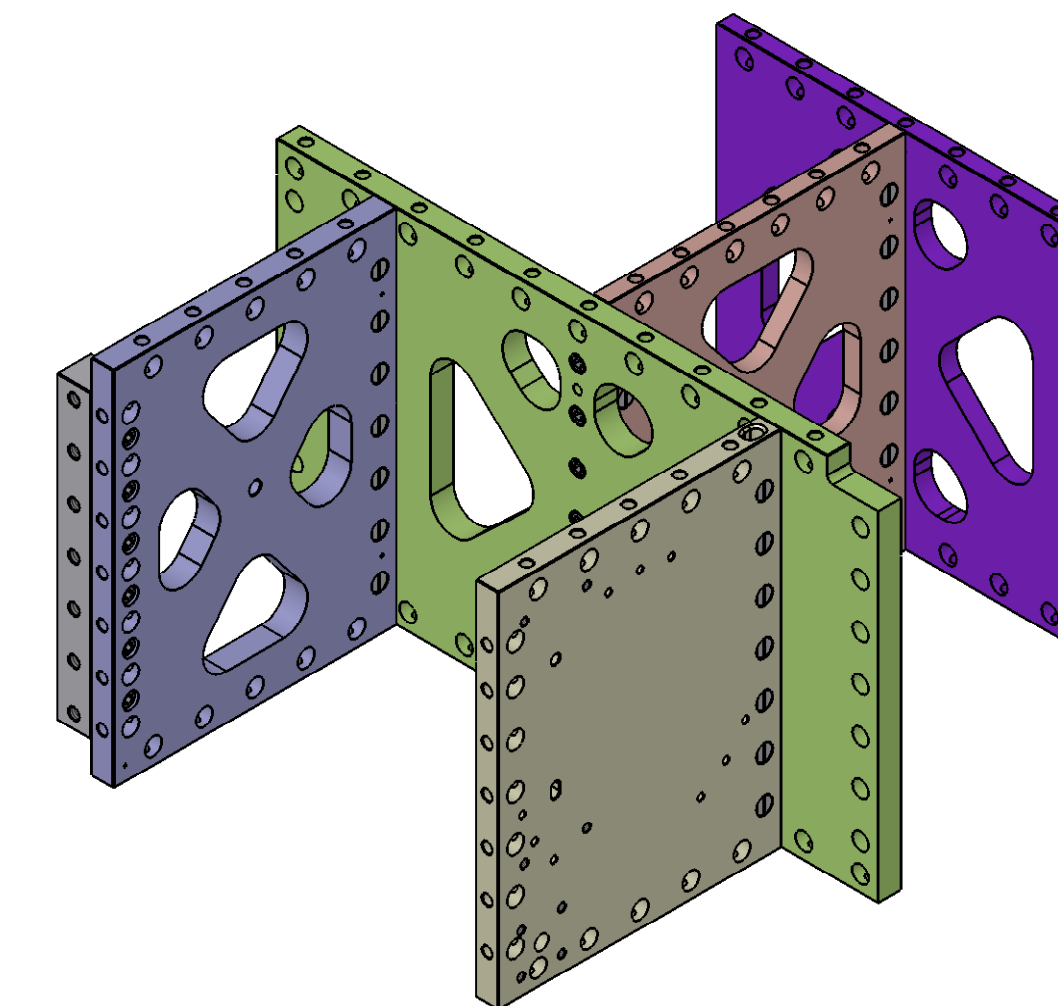
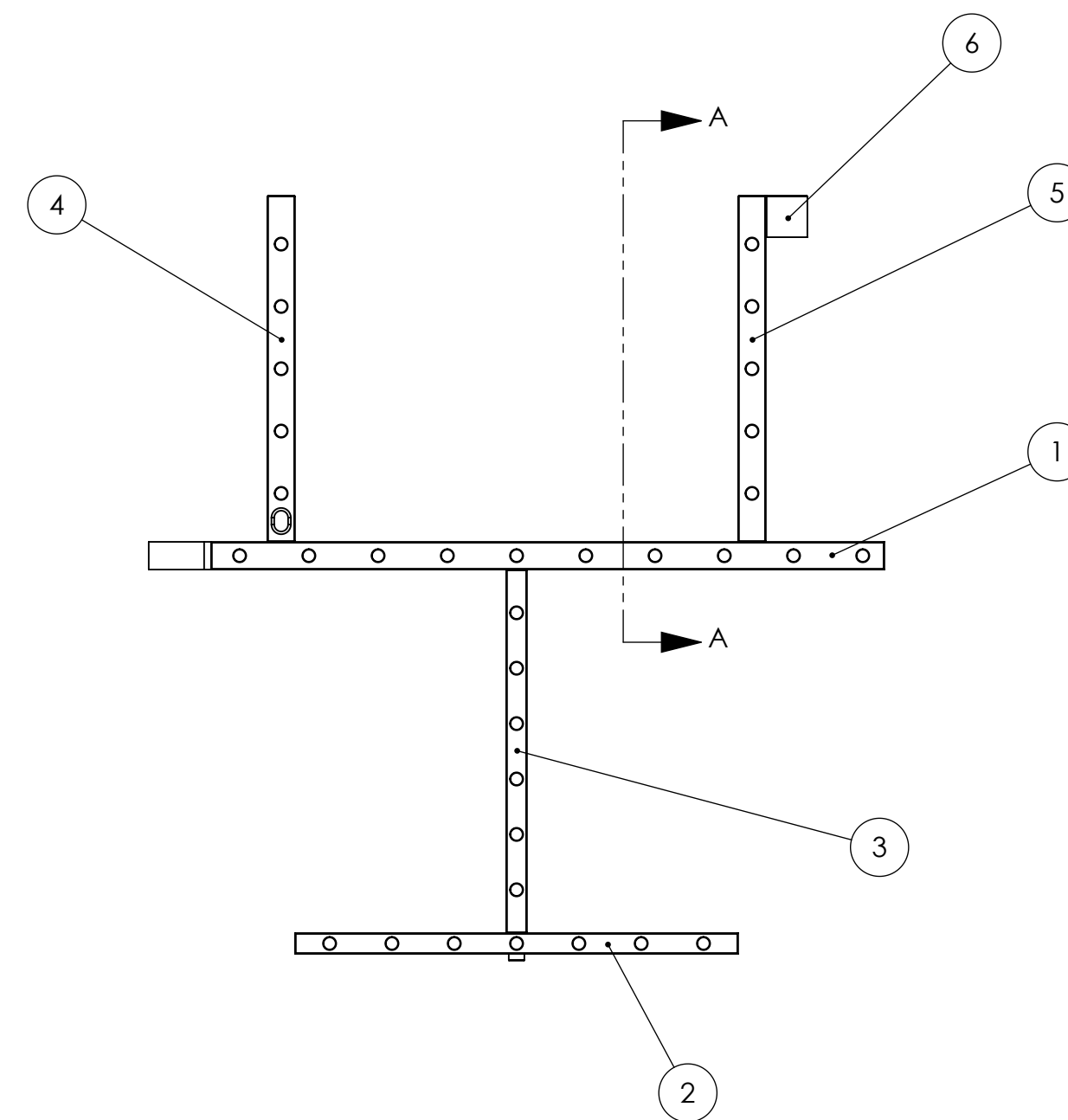


SECTION A-A

10

12

6X

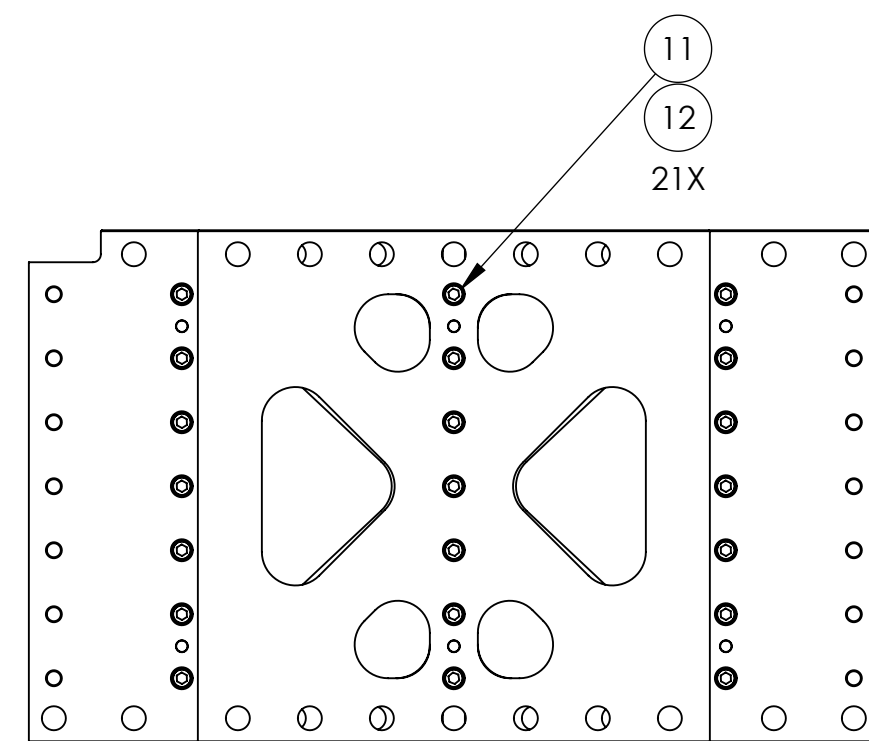


8

7X

7

14X



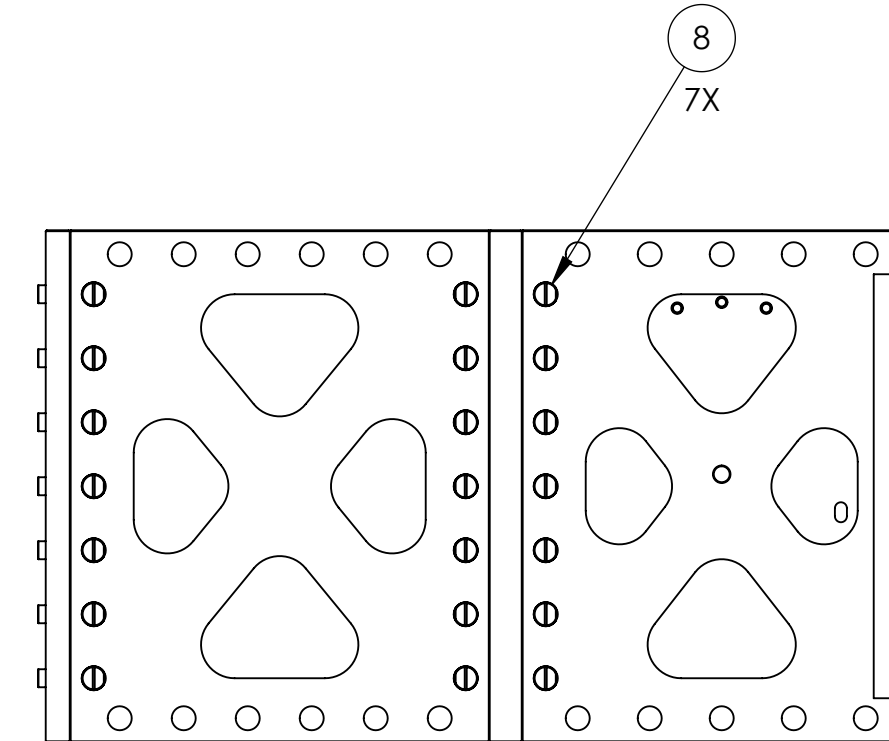
11

12

21X

9

12X



8

7X

ITEM NO.	PART NUMBER	DESCRIPTION	SIZE / TYPE	MATERIAL	REQ
12	UCC_WFV-38	Vented Washer, 3/8"	3/8" (.39"x.63")	18-8 SS	34
11	HOLOKROME_78104	SHCS, 3/8"-16x1.75"	3/8"-16x1.75"	18-8 SS	28
10	HOLOKROME_78100	SHCS, 3/8"-16x1.25"	3/8"-16x1.25"	18-8 SS	6
9	MCMASTER_90145A622	Dowel Pin, 3/8"x.75"	3/8"x.75"	18-8 SS	12
8	D071250	Barrel Nut	3/8-16 x 1.0L	2024-T351	14
7	D071250	Barrel Nut	3/8-16 x .75L	2024-T351	14
6	D071061	Outer Wall, Bracket 90	-	6061-T6 Al	1
5	D071056	Rib, Rad, GS-13 Out 2	-	6061-T6 Al	1
4	D071055	Rib, Rad, GS-13 Out 1	-	6061-T6 Al	1
3	D071054	Rib, Rad, GS-13 Mid	-	6061-T6 Al	1
2	D071053	Rib, Tan, GS-13 Cen	-	6061-T6 Al	1
1	D071052	Rib, Tan, GS-13 Mid	-	6061-T6 Al	1

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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES:	
.XX ± .015	
.XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	See BOM
FINISH	See BOM

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D0900154

PART NAME					
Asm, Pitchfork					
DESIGNER	Andy Stein	13 FEB 2009	SIZE	DWG. NO.	REV.
DRAFTER	Andy Stein	04 JAN 2010	D	D071423	v2
CHECKER			SCALE: 1:6	PROJECTION:	SHEET 1 OF 1
APPROVAL	Ken Mason	06 JAN 2010			

D071423_AsmPitchfork_PART PDM REV: V1-020 DRAWING PDM REV: X-002