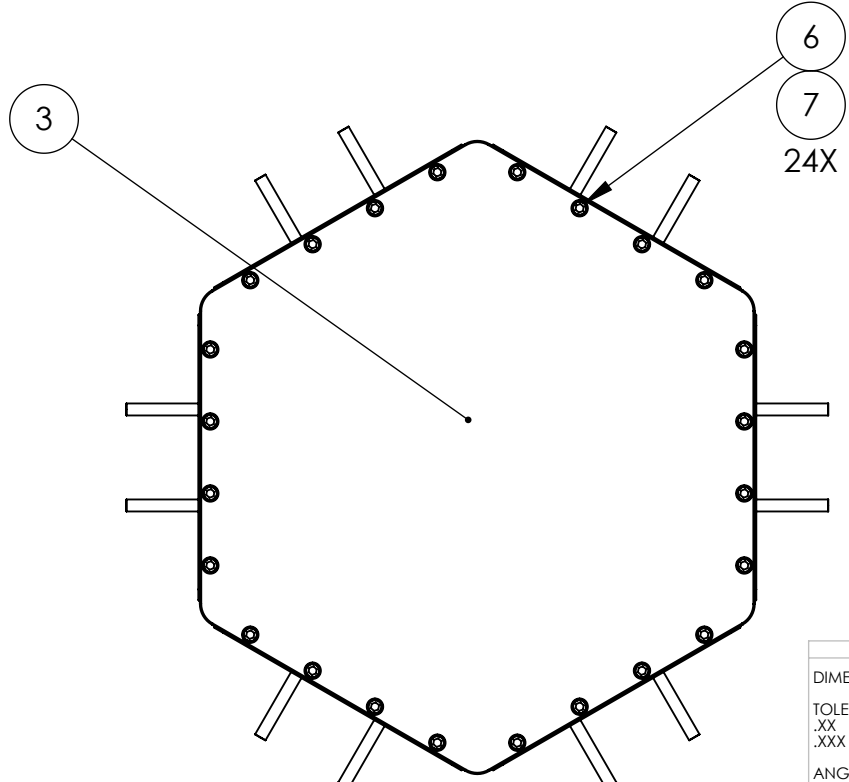
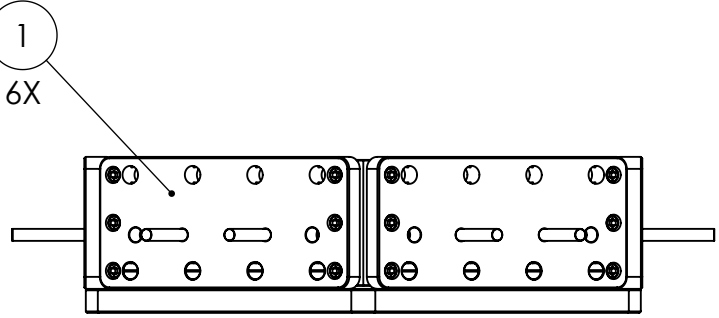
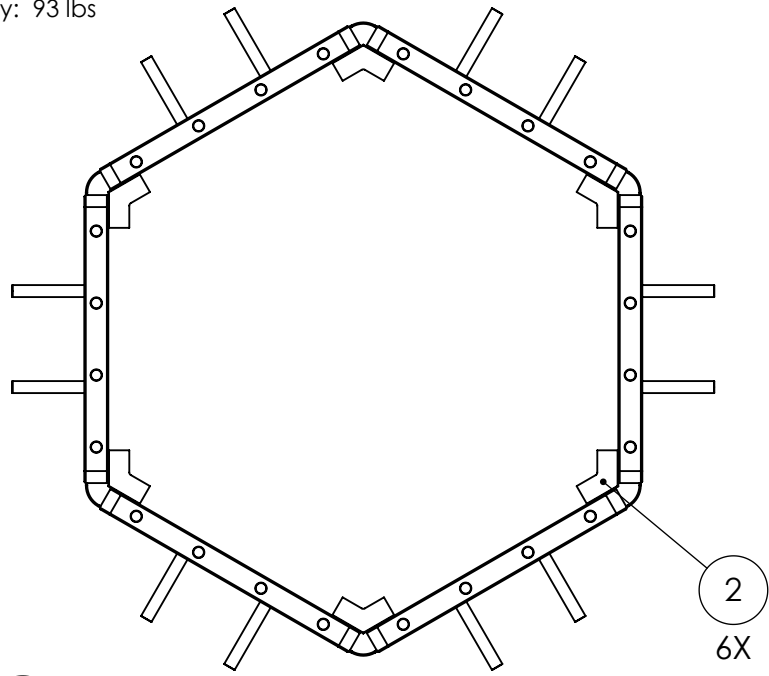


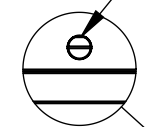
8 7 6 5 4 3 2 1

NOTES CONTINUED:  
 5. Refer to LIGO-E0900216 for detailed assembly instructions.  
 6. Weight of finished assembly: 93 lbs

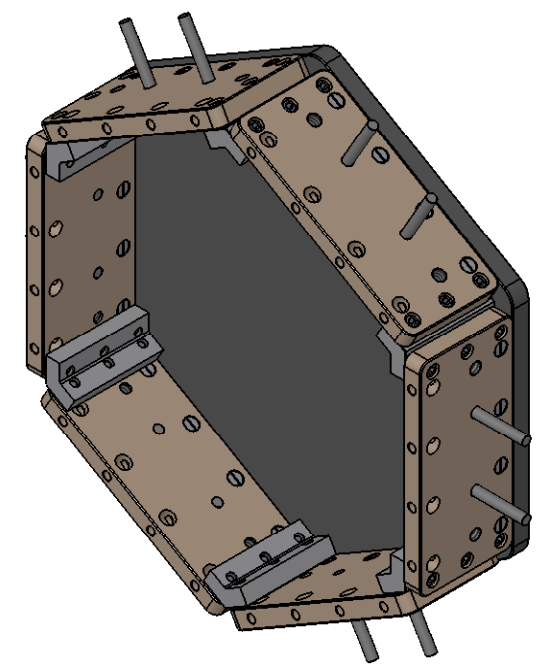
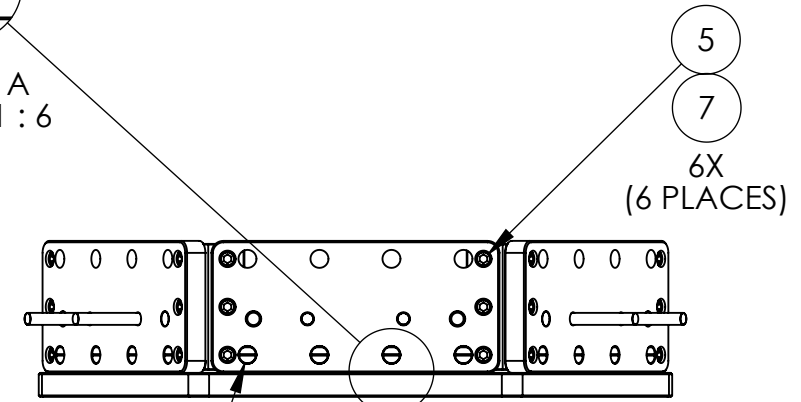
REV.	DATE	DCN #	DRAWING TREE #
v1 / C	08 JAN 2008	N/A	N/A
v2	11 JAN 2010	E1000001	T0900305
-	-	-	-



Flat on Barrel Nut faces away from screw. TYP.



DETAIL A  
SCALE 1 : 6



ITEM NO.	PART NUMBER	DESCRIPTION	SIZE / TYPE	MATERIAL	Default/QTY.
7	UCC_WFV-38	Vented Washer, 3/8"	3/8" (.39"x.63")	18-8 SS	60
6	HOLOKROME_78104	SHCS, 3/8"-16x1.75"	3/8"-16x1.75"	18-8 SS	24
5	HOLOKROME_78100	SHCS, 3/8"-16x1.25"	3/8"-16x1.25"	18-8 SS	36
4	D071250	Barrel Nut	3/8-16 x 1.0L	2024-T351	24
3	D071065	Keel Base	-	6061-T6 Al	1
2	D071060	Outer Wall, Bracket 120	Keel Bracket (Short)	6061-T6 Al	6
1	D071425	Asm, Keel Wall	-	See BOM	6

PARTS LIST

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

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

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SEI**

PART NAME: **Asm, Keel**

DESIGNER	Andy Stein	17 FEB 2009	SIZE	DWG. NO.	REV.
DRAFTER	Andy Stein	04 JAN 2010	<b>B</b>	<b>D071424</b>	<b>v2</b>
CHECKER			SCALE: 1:8	PROJECTION:	SHEET 1 OF 1
APPROVAL	Ken Mason	11 JAN 2010			

NEXT ASSY: **D0900154**

D071424\_Asm-Keel, PART PDM REV: V1-015, DRAWING PDM REV: X-002

8 7 6 5 4 3 2 1