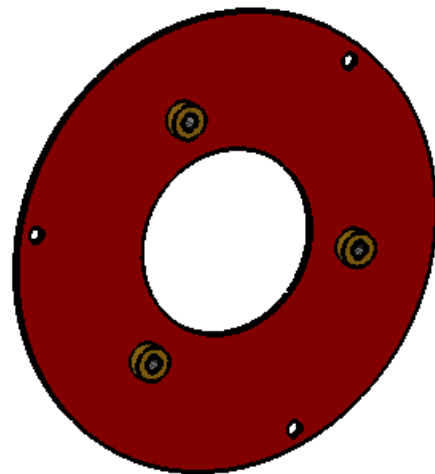
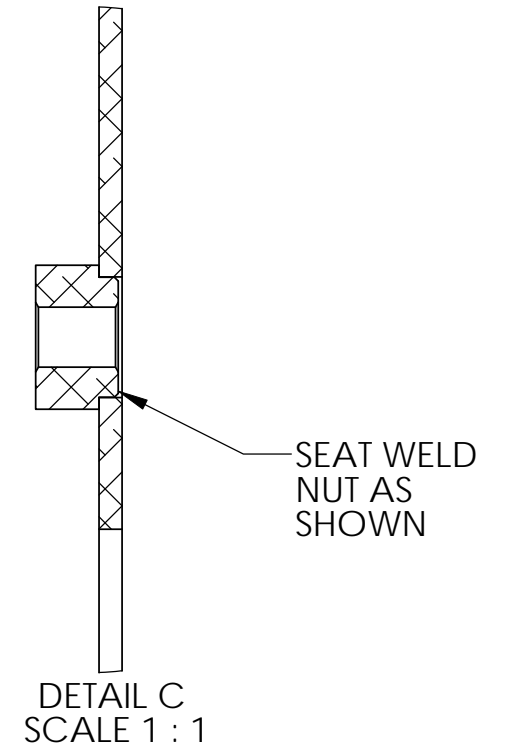
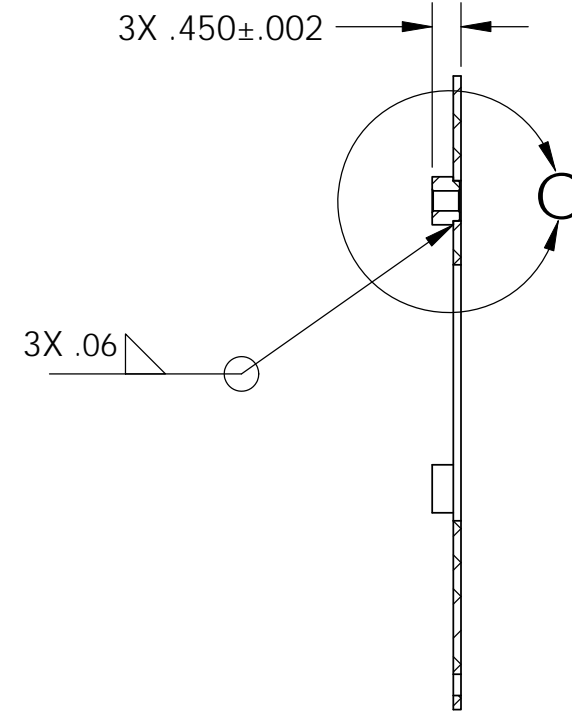
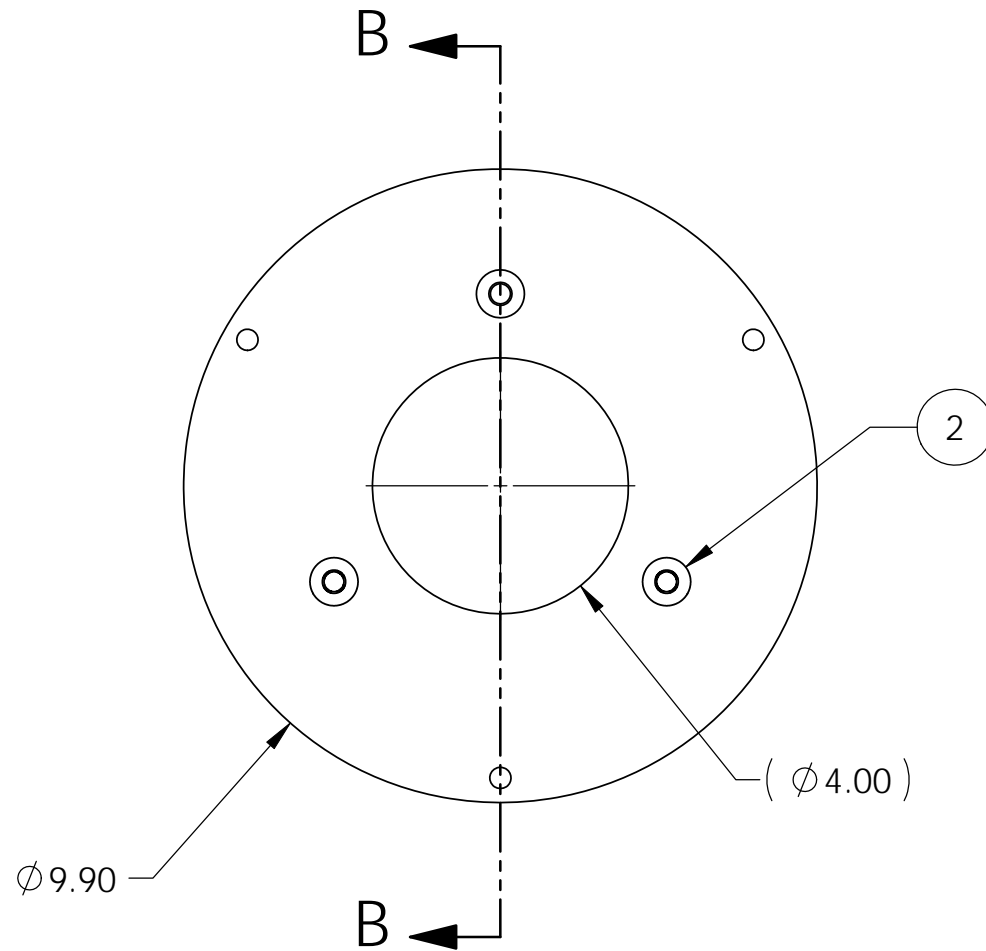


NOTES CONTINUED:

5. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS MEETING ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
6. ALL WELDMENTS MUST BE FABRICATED IN COMPLIANCE WITH SPECIFICATIONS DEFINED IN LIGO DOCUMENT E0900048.
7. ALL WELDS TO BE EXTERNAL FUSION GTAW UHV WELDS.
8. JOINT CONFIGURATION TO BE DETERMINED BY VENDOR.
9. SURFACES EXPOSED TO HIGH VACUUM. ALL SURFACES MUST BE FREE OF WELD RESIDUE, SCALE, DIRT AND INK.
10. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
11. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
12. ELECTROPOLISH PARTS PRIOR TO WELDING PER BEST COMMERCIAL PRACTICE

REV.	DATE	DCN #	DRAWING TREE #
v1	6 FEB 2010	E0900444	E1000025



2	D0902800	Custom Weld Nut, Gs-13 Diaphragm, aLIGO BSC-ISI	304 SSTL	3
1	D0901829	GS-13, Horizontal, Stabilizer Plate	304 SSTL	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°				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.		GS-13, Horizontal, Stabilizer	
MATERIAL		FINISH		NEXT ASSY		DESIGNER S.BARNUM 6 FEB 2010 DRAFTER M.HILLARD 6 FEB 2010 CHECKER F.MATICHARD 6 FEB 2010 APPROVAL K.MASON 6 FEB 2010	
304 SSTL		63 μinch		D0902778		SIZE DWG. NO. B D0901832	
SCALE: 1:3 PROJECTION:				SHEET 1 OF 1			

D0901832_GS-13 Horiz Stabilizer Assembly, PART PDM REV: X-034, DRAWING PDM REV: X-003