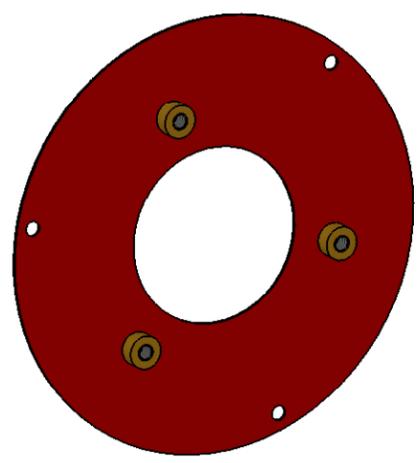
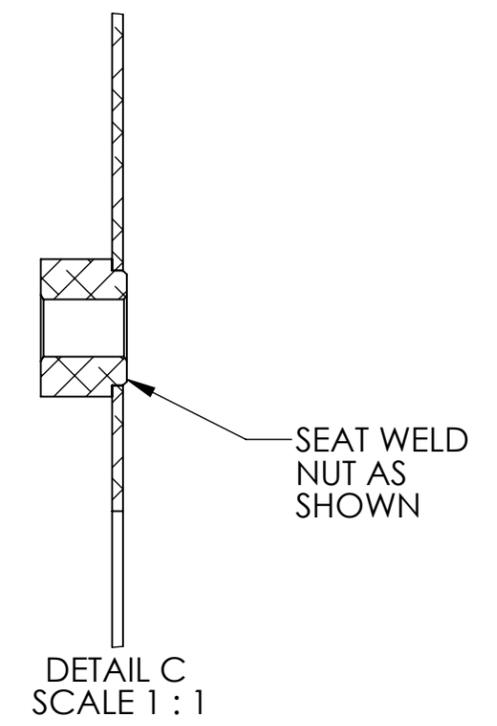
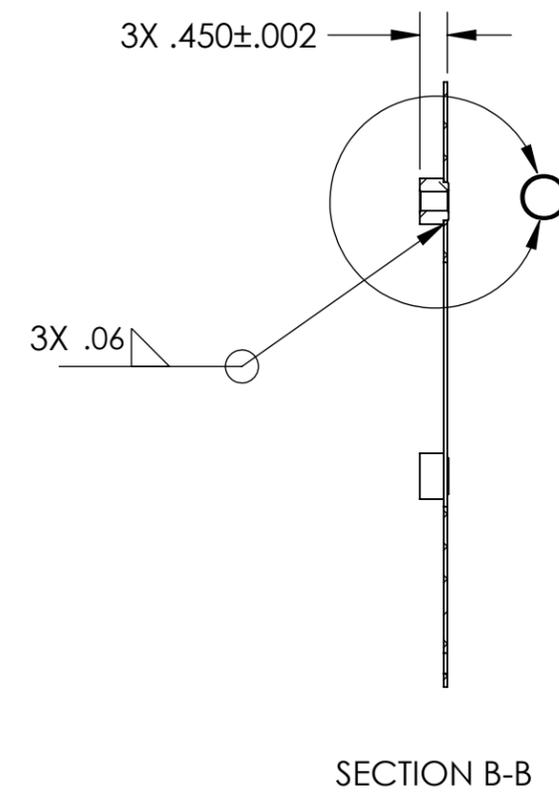
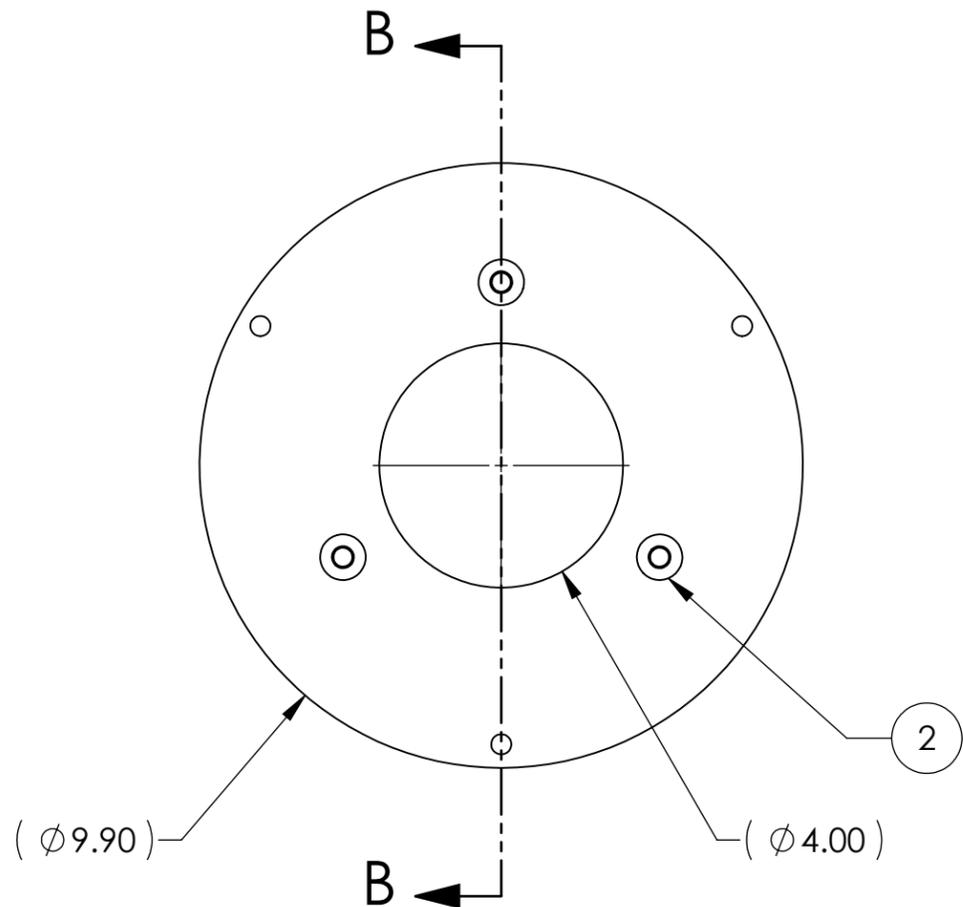


NOTES CONTINUED:

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
v2	6 FEB 2010	E1000178	E1000025



2	D0902800	Custom Weld Nut, Gs-13 Pod, 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)**

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 ± .5°

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM SEI	
MATERIAL		PART NAME	
304 SSTL		GS-13, Horizontal, Stabilizer	
FINISH	63 μinch	DESIGNER	S.BARNUM 6 FEB 2010
NEXT ASSY	D0902778	DRAFTER	M.HILLARD 6 FEB 2010
		CHECKER	F.MATICHARD 6 FEB 2010
		APPROVAL	K.MASON 6 FEB 2010

SCALE: 1:3 PROJECTION: SHEET 1 OF 1

D0901832\_GS-13 Horiz Stabilizer Assembly, PART PDM REV: X-035, DRAWING PDM REV: X-005