

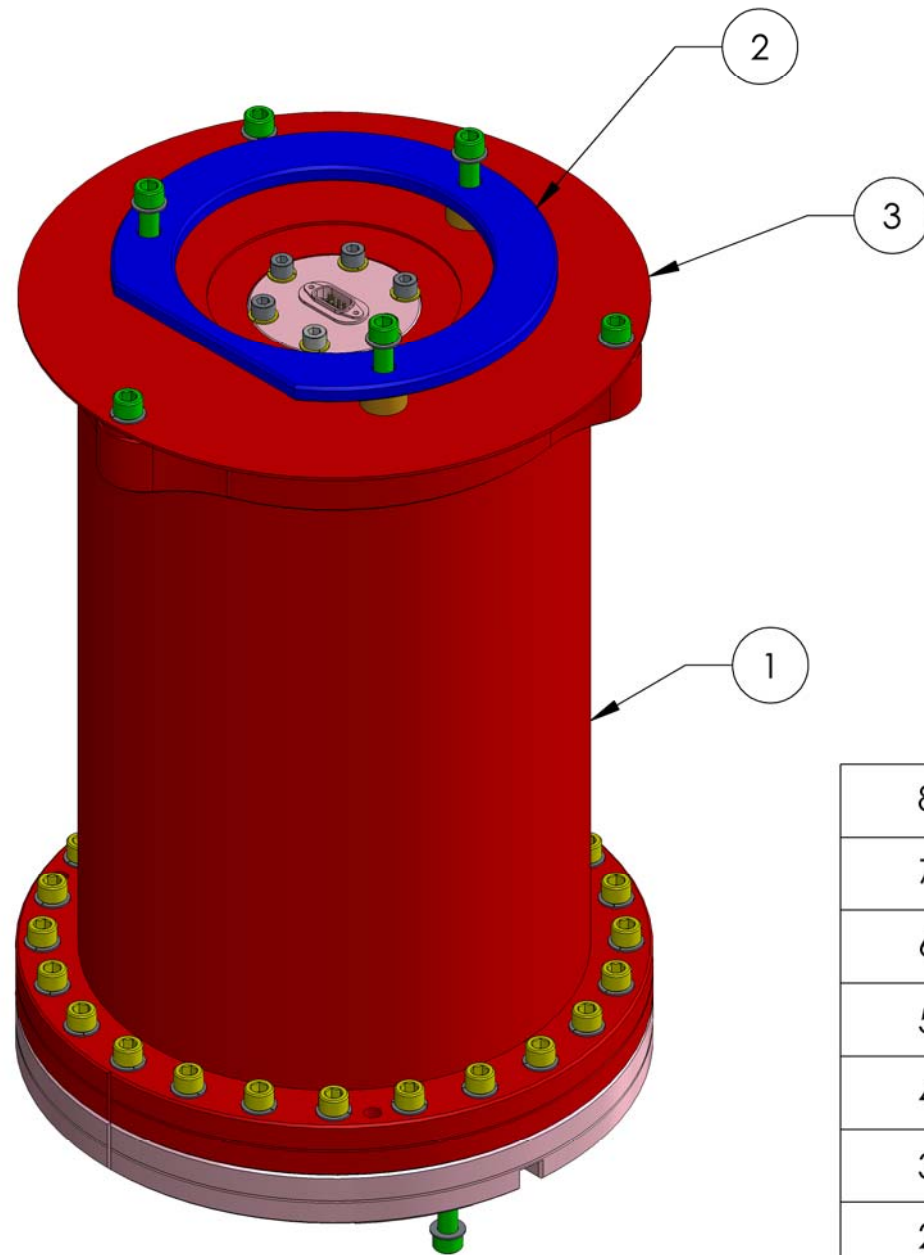
D0902778 GS-13 Pod-Horizontal - aLIGO BSC-ISI, PART PDM REV: X-018, DRAWING PDM REV: X-008

**NOTES CONTINUED:**  
 5. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.  
 6. REFER TO LIGO DOC T0900592 FOR DETAILED INSTRUCTION OF THE POD ASSEMBLY PROCEDURE, INSTRUCTIONS AND PROCEDURES MUST BE CAREFULLY FOLLOWED. REFER TO LIGO DOC E0900357 FOR THE INSTALLATION PROCEDURE OF THE POD ON THE BSC ISI.  
 △ ASSEMBLY TO BE ADJUSTED USING SHIMS IN TABLE 2 SELECT CLOSEST SHIM. MEASURE ASSEMBLY PRIOR INSTALLATION USING A CMM ARM AND SELECT APPROPRIATE SHIM THICKNESS.

△ 7 TABLE 2

MISUMI P/N	Thickness	# of Shims Req per Pod Assembly
WASS20-10-2	2 mm (.079")	3
WASS20-10-3	3 mm (0.118") Nominal Thickness	3

REV.	DATE	DCN #	DRAWING TREE #
v1	5 FEB 2010	E0900444	E1000025
v2	21 May. 2010	E1000178	E1000025
v3	10 Aug. 2010	E1000302	E1000025



8	U-C Components_C-3116-NA	Screw shcs 5/16-24 UNF-2A X 1" lg Ag plated	Ag-PLATED 300 SSSL	3
7	SEE TABLE 2	Washer 20mm OD x 10mm ID Thk precision washer	304 SSSL	3
6	U-C Components_C-3120-NA	Screw shcs 5/16-24 UNF-2A X 1.25" lg. Ag plated	Ag-PLATED 300 SSSL	7
5	UC_COMPONENTS_WFV-31	Washer Vented, .328 ID X .562 OD X .032 THK #5/16	18-8 SSSL	10
4	McMaster_90145A630	Dowel Pin 3/8" (.3751) +/- .0001" x 1.75" +/- .01"	18-8 SSSL	1
3	D0901832	GS-13, Horizontal, Stabilizer	304 SSSL	1
2	D0902583	Spacer, Horz GS-13 Stiffener, BSC ISI	6061-T6 Al	1
1	D0900857	GS-13 Pod Assembly	N/A	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± N/A .XXX ± N/A		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
ANGULAR ± N/A *		MATERIAL N/A		FINISH N/A μinch		NEXT ASSY D0901182	
				DESIGNER S.BARNUM		DATE 5 FEB 2010	
				DRAFTER M.HILLARD		DATE 5 FEB 2010	
				CHECKER F.MATICHARD		DATE 6 FEB 2010	
				APPROVAL K.MASON		DATE 6 FEB 2010	
				SCALE: 1:3		PROJECTION:	
				DWG. NO. D0902778		REV. v3	
				SHEET 1 OF 2			

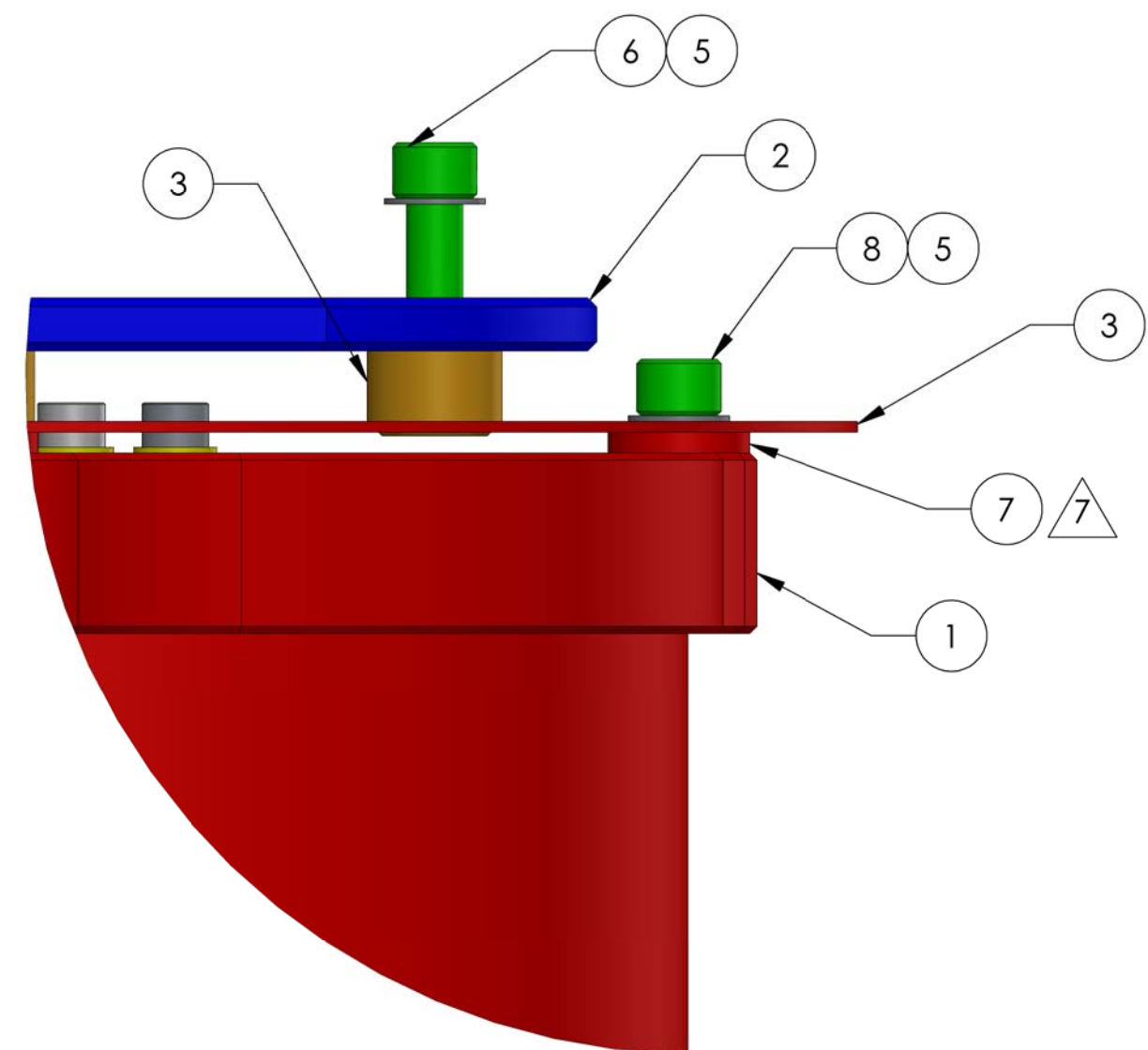
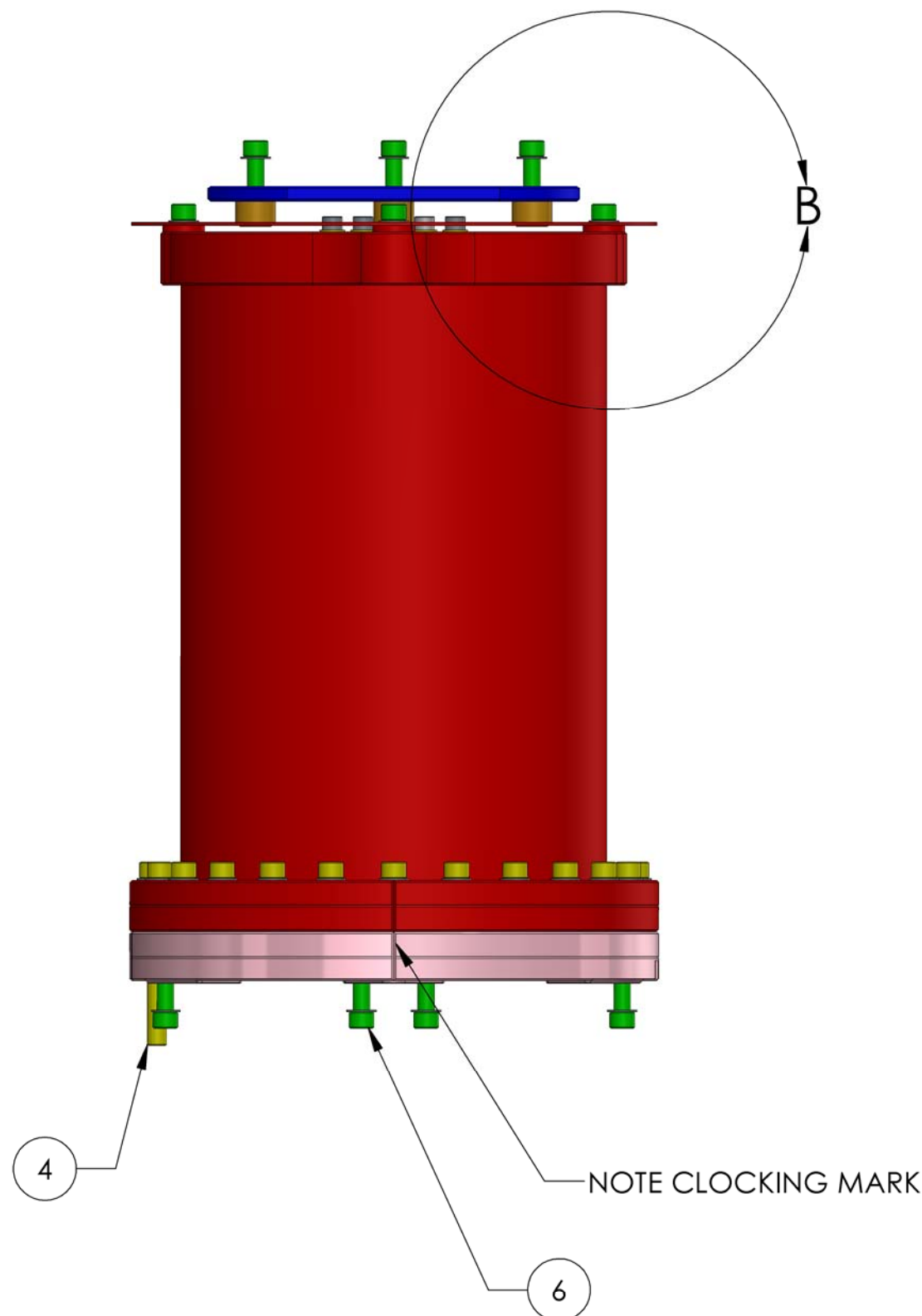
8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A

8 7 6 5 4 3 2 1

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DETAIL B  
SCALE 1 : 1

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE <b>B</b>	DWG. NO. D0902778
SCALE: 1:3	PROJECTION:  SHEET 2 OF 2
REV. v3	

8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A

8 7 6 5 4 3 2 1