

NOTES CONTINUED:

5. APPROXIMATE WEIGHT = 1,355 LB.
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.
10. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
11. REFER TO LIGO DOC E1000564 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 ISL.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 Jan 2011	E1100067	E1000025
-	-	-	-
-	-	-	-

D

D

C

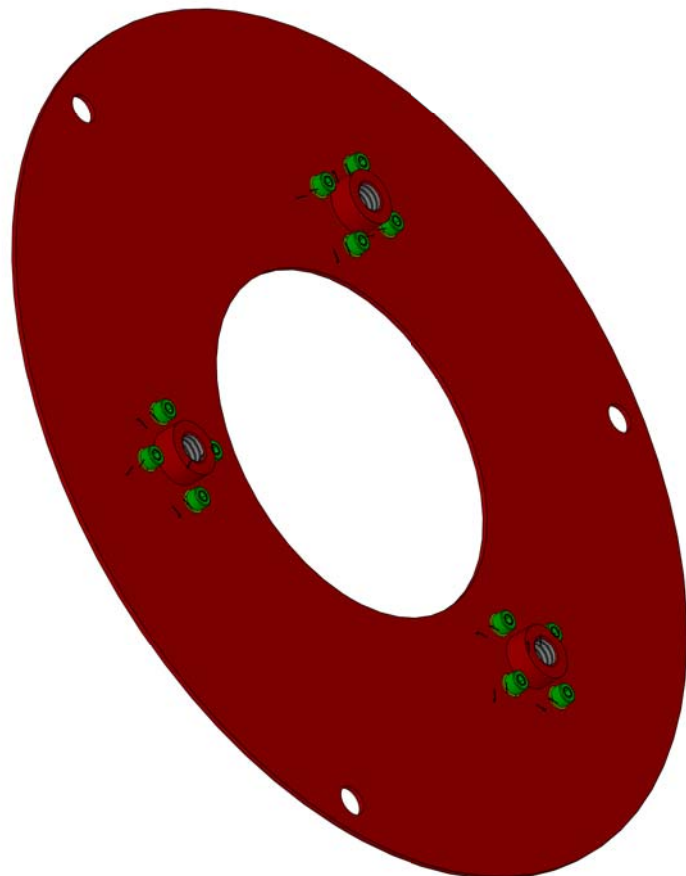
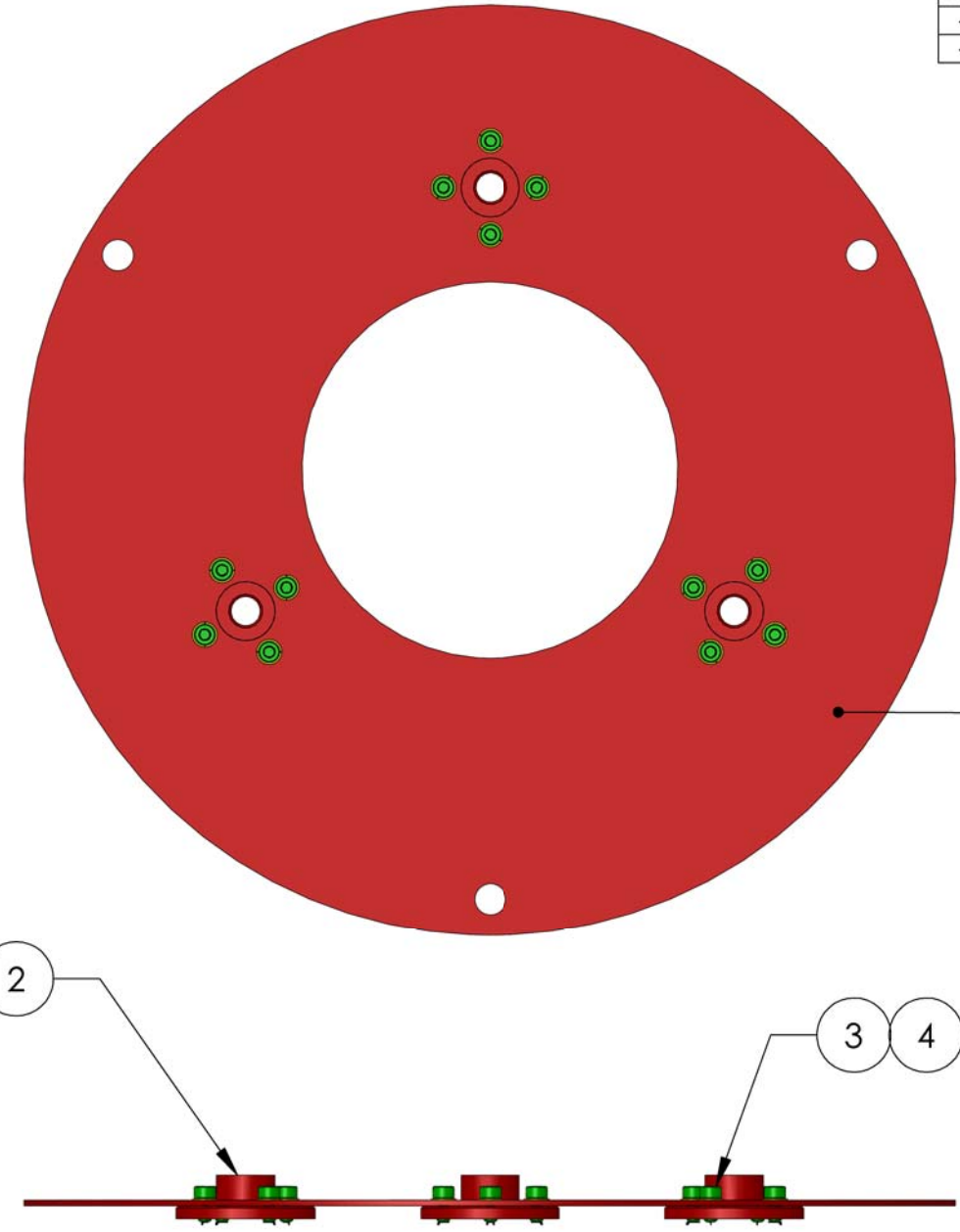
C

B

B

A

A



4	UCC WFV-04	Flat Washer, #4, .115 id x .209 od x .016 thk	18-8 SSTL	12
3	UC-COMPONENTS C-604-NA	#6-32, 1/4 lg, AG Plated	Ag-PLATED 300 SSTL	12
2	D1100087	Custom Bolted Nut, Gs-13 Diaphragm	304 SSTL	3
1	D1100086	GS-13, Horizontal, Bolted Stabilizer Plate	304 SSTL	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	TOTAL

**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 ± 0.015  
 .XXX ± 0.005  
 ANGULAR ± 0.1°

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

**PART NAME**  
 Gs13 Stabilizer and Custom Bolted Nuts

DESIGNER	S.BISCANS	20 Jan 2011	SIZE	DWG. NO.	REV.
DRAFTER	S.BISCANS	20 Jan 2011	<b>B</b>	<b>D1100088</b>	v1
CHECKER	F.MATICHARD	20 Jan 2011	SCALE:	1:4	PROJECTION:
APPROVAL	K.MASON	20 Jan 2011	SHEET	1 OF 1	

**SYSTEM** ADVANCED LIGO    **SUB-SYSTEM** SEI    **NEXT ASSY** D0902778