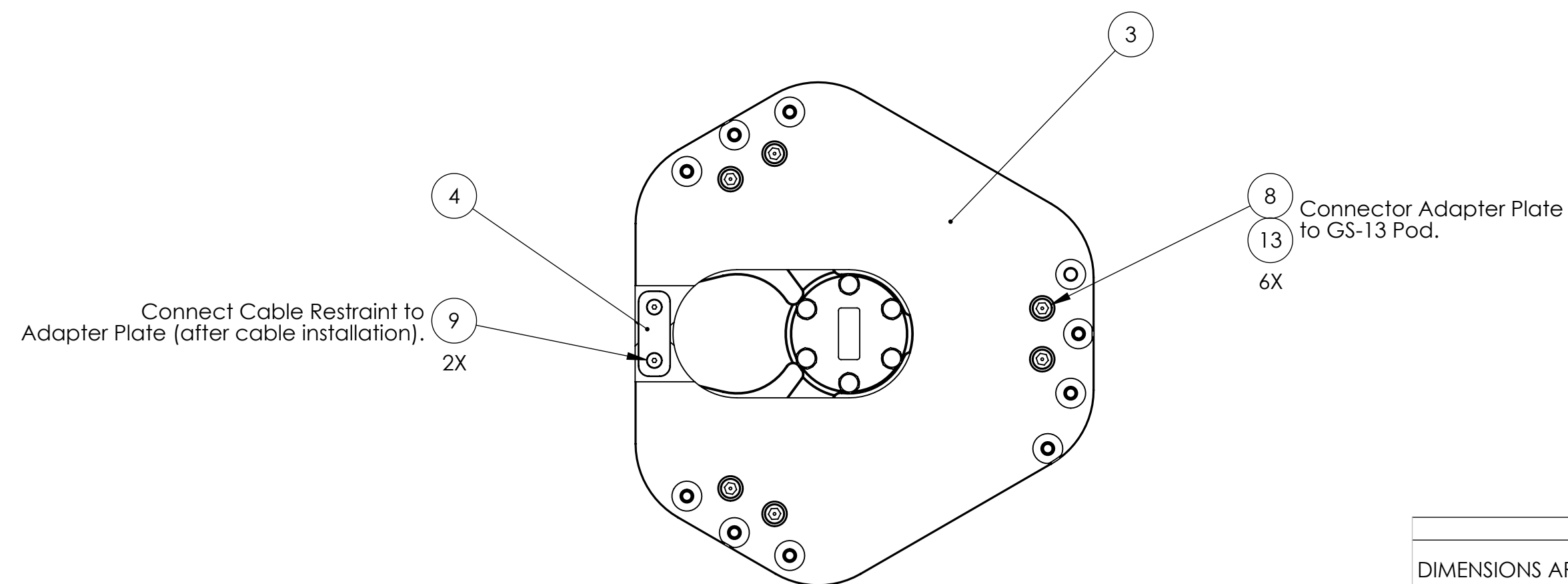
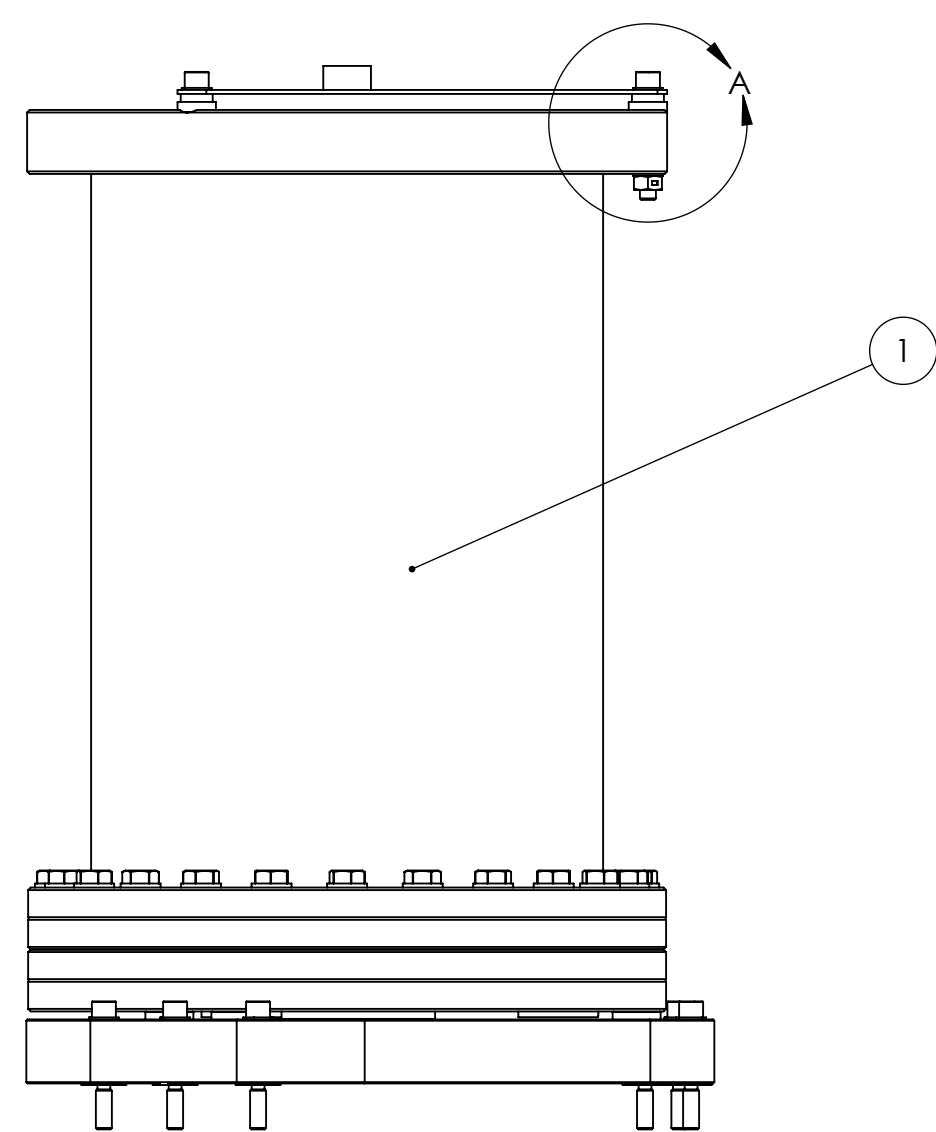
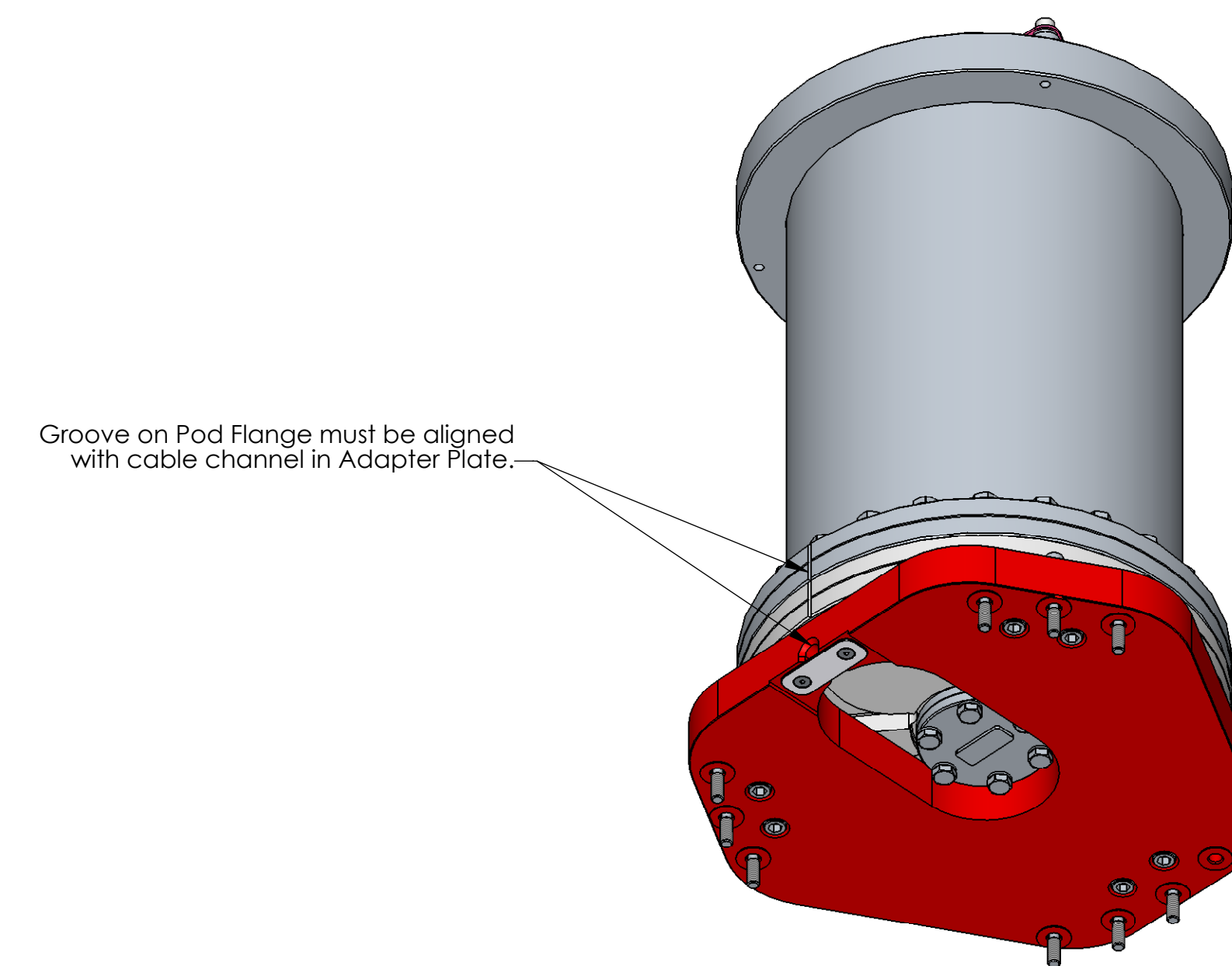
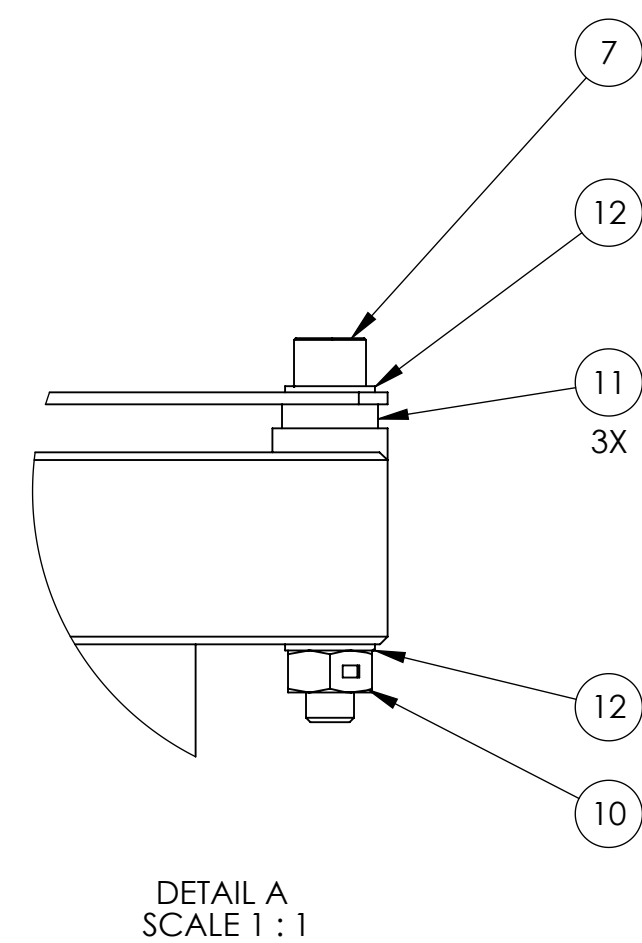
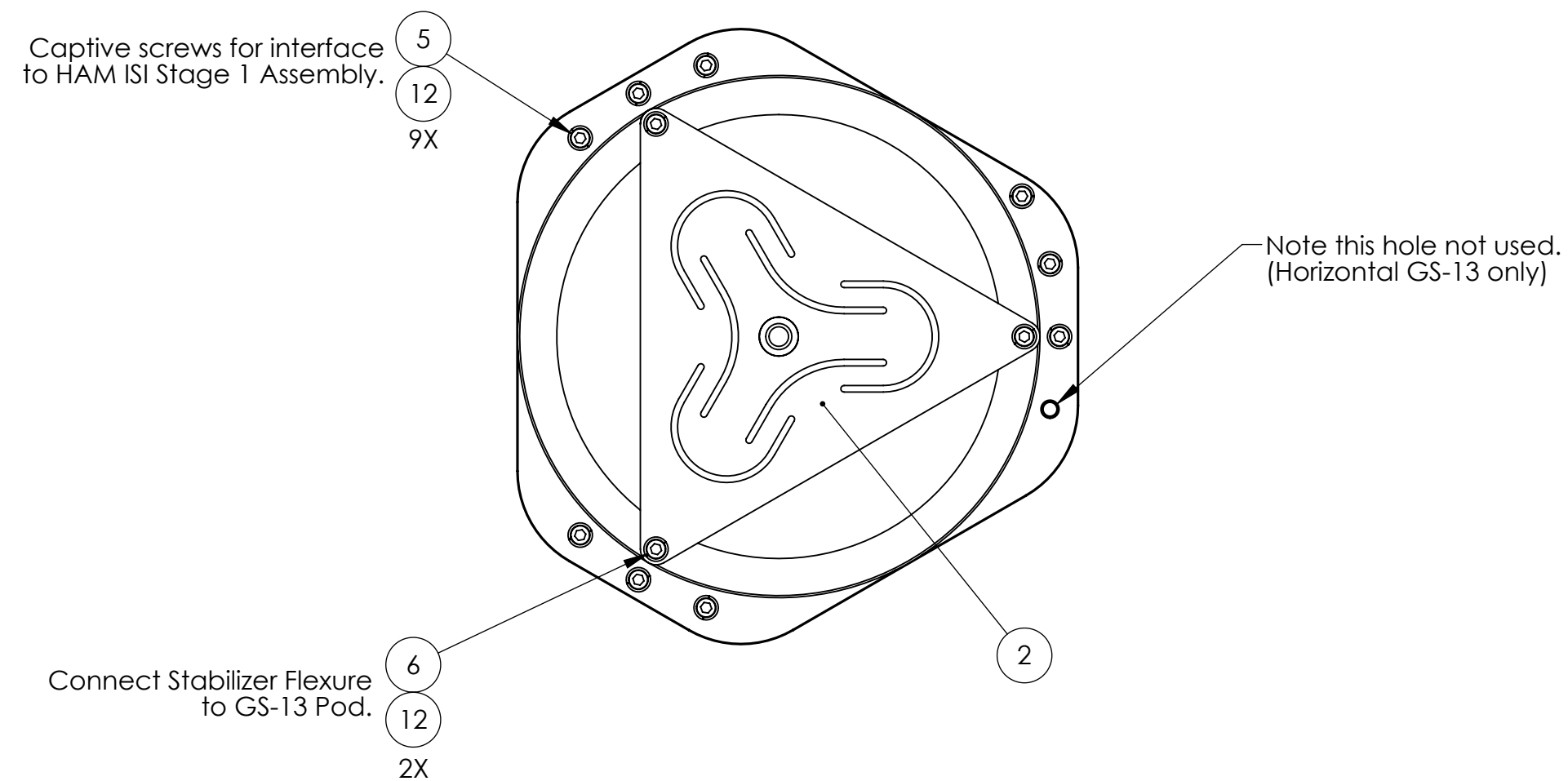


- NOTES CONTINUED:
- Refer to LIGO-E0900216 for detailed assembly instructions.
 - Weight of finished assembly: 81 lbs

REV.	DATE	DCN #	DRAWING TREE #
v1 / C	04 FEB 2008	N/A	N/A
v2	18 FEB 2010	E1000001	T0900305



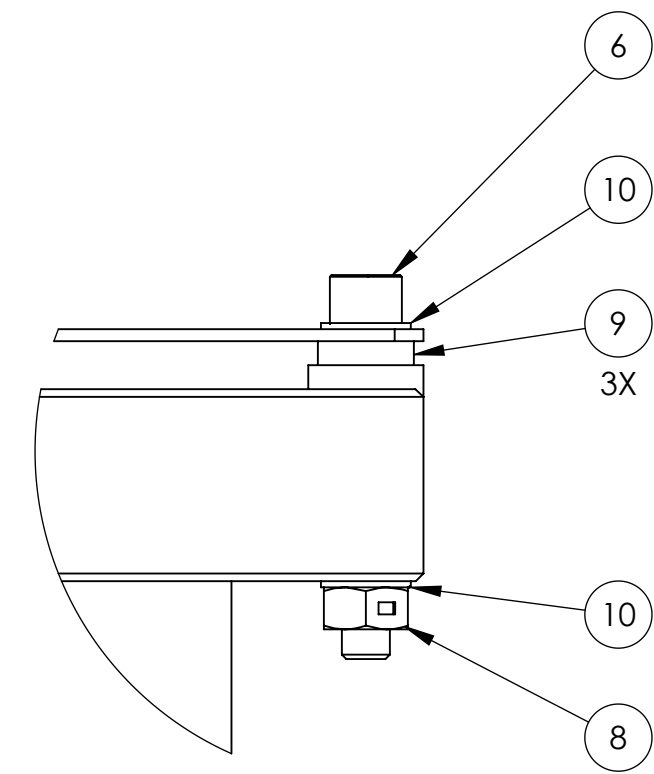
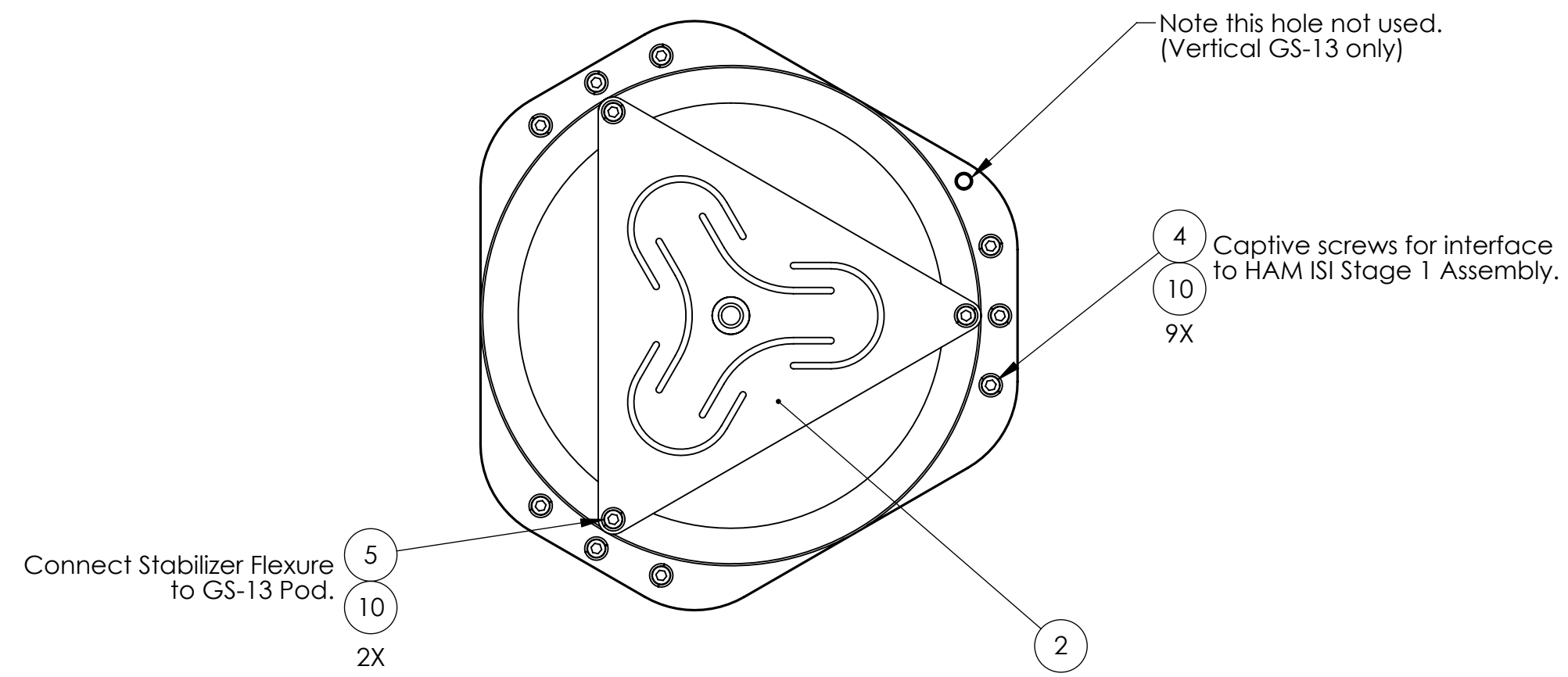
HORIZONTAL Configuration

ITEM NO.	PART NUMBER	DESCRIPTION	SIZE / TYPE	MATERIAL	Horizontal/ QTY.
13	UCC_WFV-31	Vented Washer, 5/16"	5/16" (.33"x.56")	18-8 SSSL	6
12	UCC_WFV-25	Vented Washer, 1/4"	1/4" (.26"x.47")	18-8 SSSL	13
11	MCMaster_92320A660	Spacer	1/4" (.25"x.50"x.125")	18-8 SS	3
10	MCMaster_90047A029	Hex Locknut, 1/4"-20	1/4"-20	18-8 SS	1
9	MCMaster_92210A192	FHSCS, #8-32x.375"	#8-32x.375"	18-8 SS	2
8	UCC_C-3124-A	SHCS, Ag-Plated, Vented, 5/16"-24x1.5"	5/16"-24x1.5", Ag-Plated	18-8 SS	6
7	UCC_C-2028-NA	SHCS, Ag-Plated, 1/4"-20x1.75"	1/4"-20x1.75", Ag-Plated	18-8 SS	1
6	UCC_C-2016-NA	SHCS, Ag-Plated, 1/4"-20x1.0"	1/4"-20x1.0", Ag-Plated	18-8 SS	2
5	D071136	SHCS, Custom Captive	1/4"-20x1.75" (1.125" CLEAR)	18-8 SS	9
4	D071183	GS-13 Cable Restraint	-	6061-T6 Al	1
3	D071180	GS-13 Adapter Plate	-	6061-T6 Al	1
2	D071471	Asm, Stabilizer, GS-13	Final Assy	See BOM	1
1	D047810	Asm, GS-13 Seismometer Pod	HORIZONTAL HAM	See BOM	1

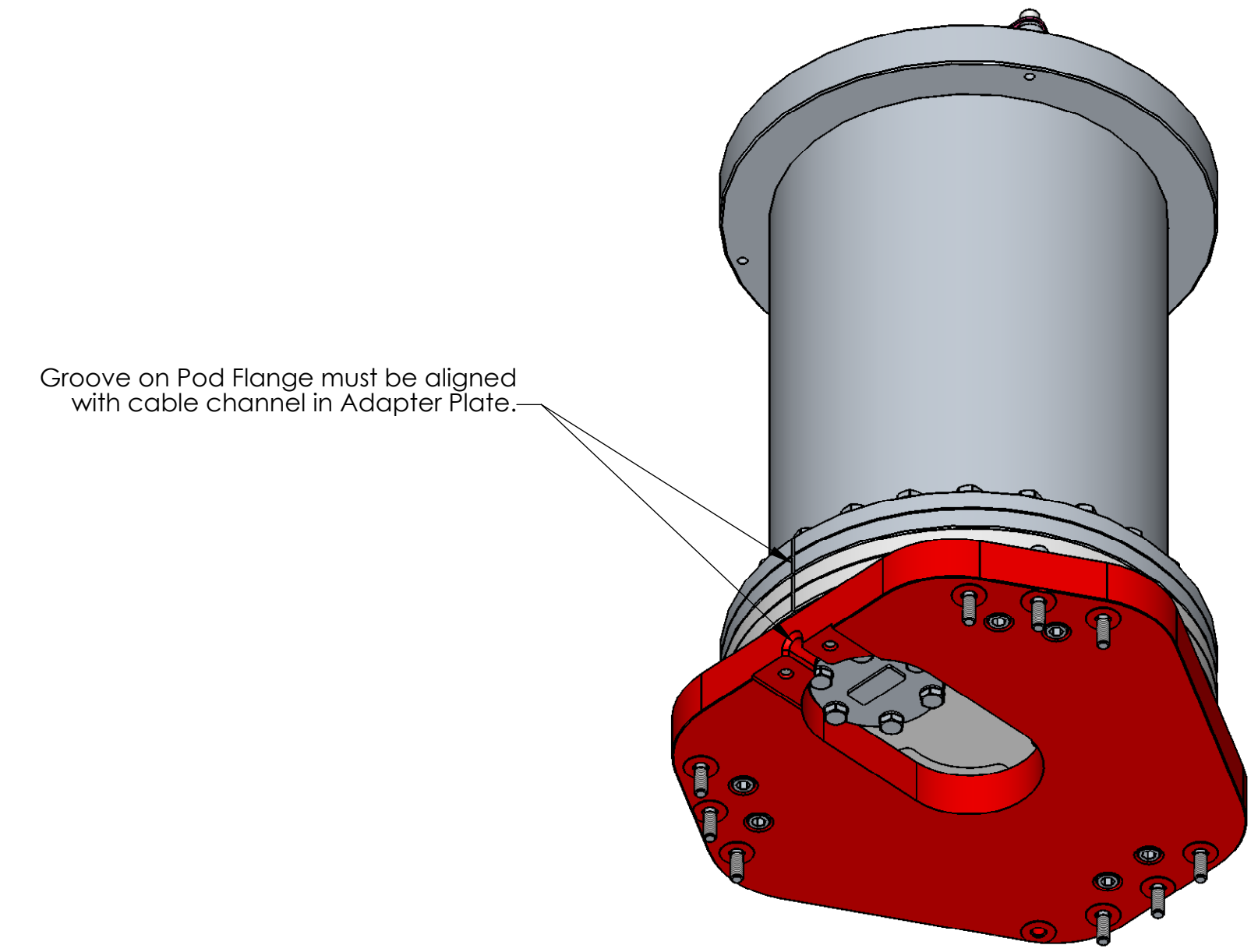
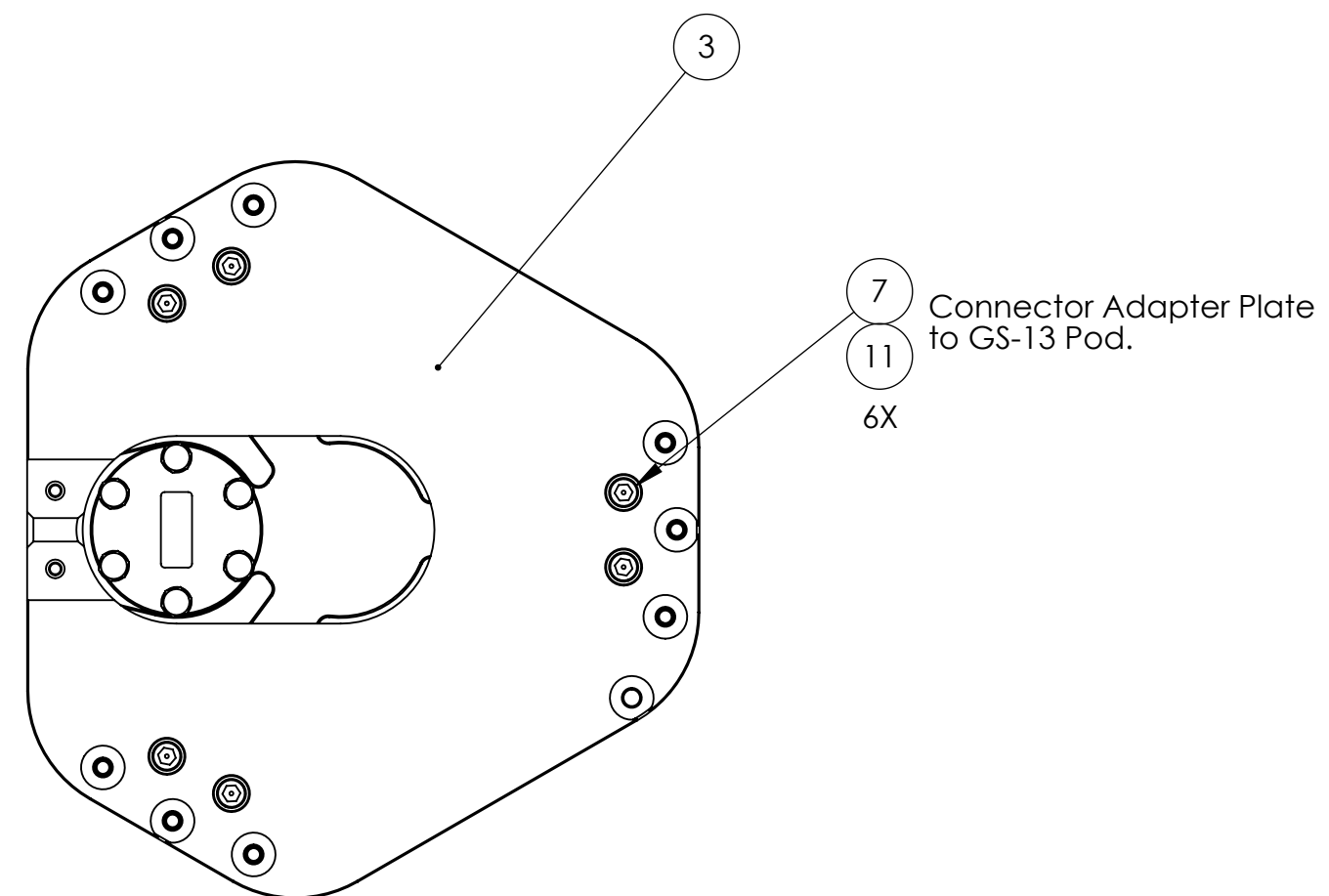
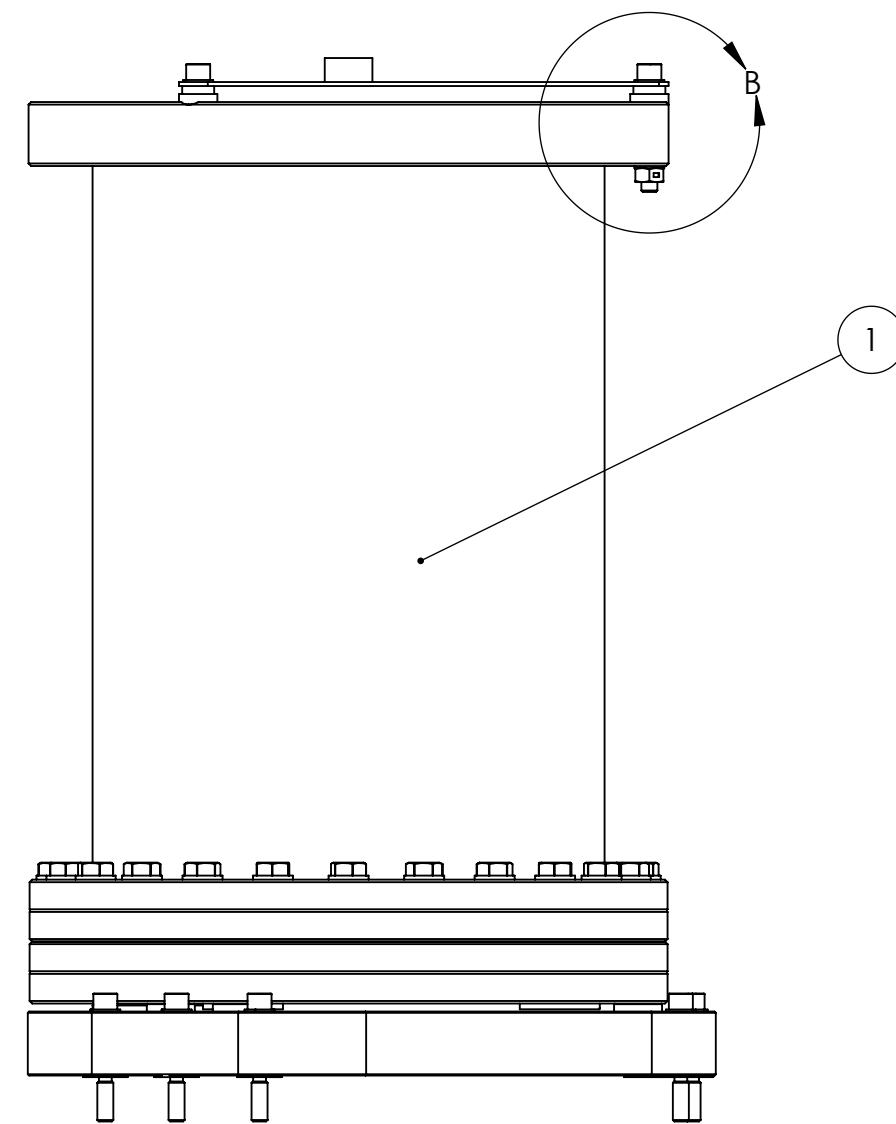
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°	MATERIAL See BOM FINISH See BOM

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO NEXT ASSY D0900124	SUB-SYSTEM SEI	Asm, GS-13 with Fixtures	
DESIGNER Andy Stein DRAFTER Andy Stein CHECKER APPROVAL Ken Mason	06 FEB 2009 04 JAN 2010 18 FEB 2010	SIZE DWG. NO. D D071470	REV. v2
SCALE: 1:3 PROJECTION:		SHEET 1 OF 2	

D071470_Asm-GS-13_with_Fixtures_PART PDM REV: X-018 DRAWING PDM REV: X-002



DETAIL B
SCALE 1 : 1



VERTICAL Configuration

ITEM NO.	PART NUMBER	DESCRIPTION	SIZE / TYPE	MATERIAL	Vertical/ QTY.
11	UCC_WFV-31	Vented Washer, 5/16"	5/16" (.33"x.56")	18-8 SSSL	6
10	UCC_WFV-25	Vented Washer, 1/4"	1/4" (.26"x.47")	18-8 SSSL	13
9	MCMMASTER_92320A660	Spacer	1/4" (.25"x.50"x.125")	18-8 SS	3
8	MCMMASTER_90047A029	Hex Locknut, 1/4"-20	1/4"-20	18-8 SS	1
7	UCC_C-3124-A	SHCS, Ag-Plated, Vented, 5/16"-24x1.5"	5/16"-24x1.5", Ag-Plated	18-8 SS	6
6	UCC_C-2028-NA	SHCS, Ag-Plated, 1/4"-20x1.75"	1/4"-20x1.75", Ag-Plated	18-8 SS	1
5	UCC_C-2016-NA	SHCS, Ag-Plated, 1/4"-20x1.0"	1/4"-20x1.0", Ag-Plated	18-8 SS	2
4	D071136	SHCS, Custom Captive	1/4"-20x1.75" (1.125" CLEAR)	18-8 SS	9
3	D071180	GS-13 Adapter Plate	-	6061-T6 Al	1
2	D071471	Asm, Stabilizer, GS-13	Final Assy	See BOM	1
1	D047810	Asm, GS-13 Seismometer Pod	VERTICAL HAM	See BOM	1

PARTS LIST

D071470_Asm-GS-13_with_Futures_PART PDM REV: X-018 DRAWING PDM REV: X-002