

NOTES CONTINUED:

REV.	DATE	DCN #	DRAWING TREE #

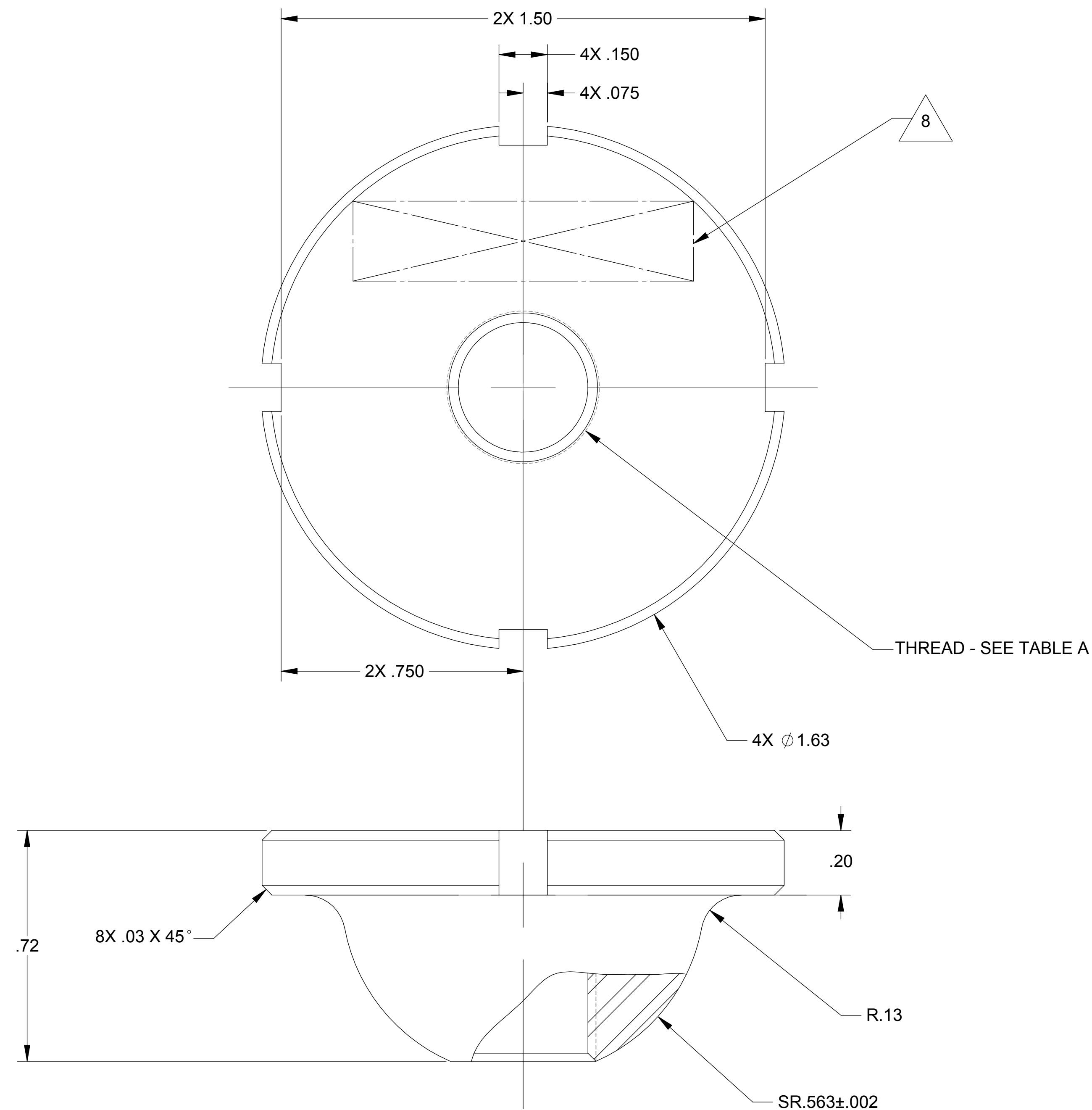


TABLE A		
DASH #	MODEL #	THREAD
-1	STS-2	M12 X 1.75-5H THRU
-2	GS-13	.375 X 24 UNF-2B THRU

NOTES: UNLESS OTHERWISE SPECIFIED.

- 5. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
- 6. REMOVE ALL BURRS AND SHARP EDGES .005-.015.
- 7. MACHINE FILLET RADII .003-.015.

8. MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.07-INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006686, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006686, TYPE II.

- 9. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING. ESTIMATED WEIGHT IS .2 LBS.

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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .03 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL CRES 15-5 PH, AMS 5659, H1025	FINISH 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME HAM GS-13 Foot	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI	DESIGNER ASI	DATE 08 Feb 2004
NEXT ASSY D047790	SCALE 4:1	CHECKER stbarnum	DATE 11 Aug 2009
APPROVAL	PROJECTION	SIZE D	DWG. NO. D047791
		REV. v2	SHEET 1 OF 1