

D0902800\_Custom Weld Nut, Gs-13 Diaphragm, aLIGO BSC-ISI, PART PDM REV: X-000, DRAWING PDM REV: X-002

**NOTES CONTINUED:**

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

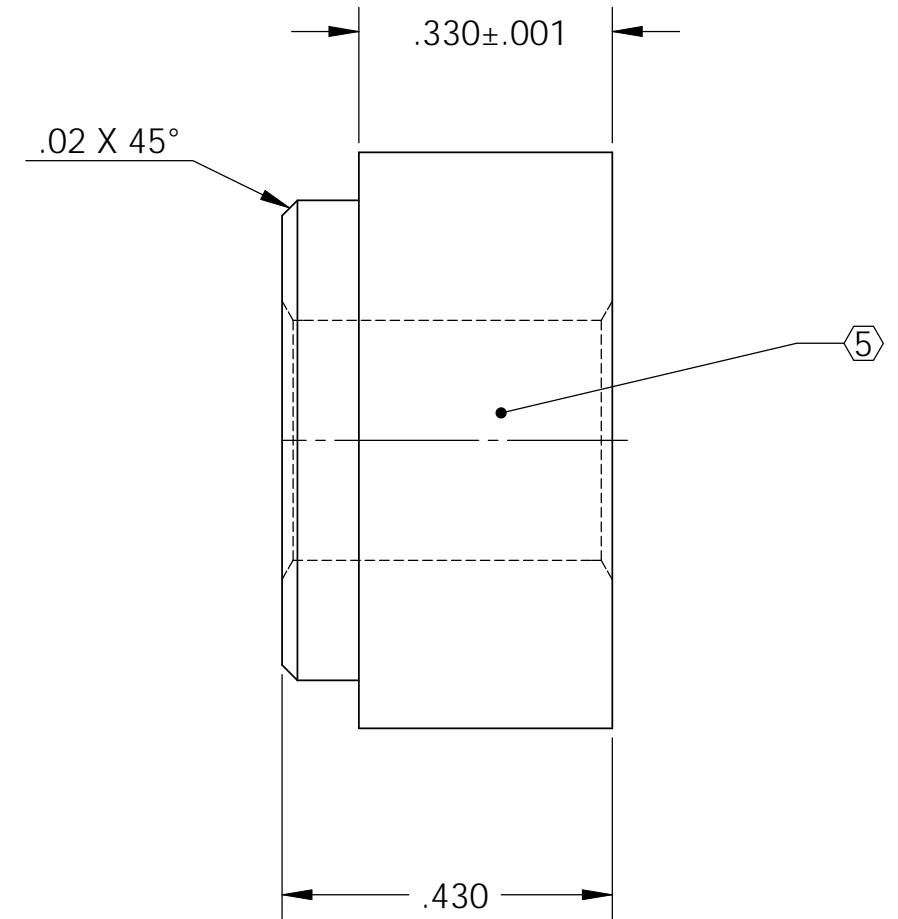
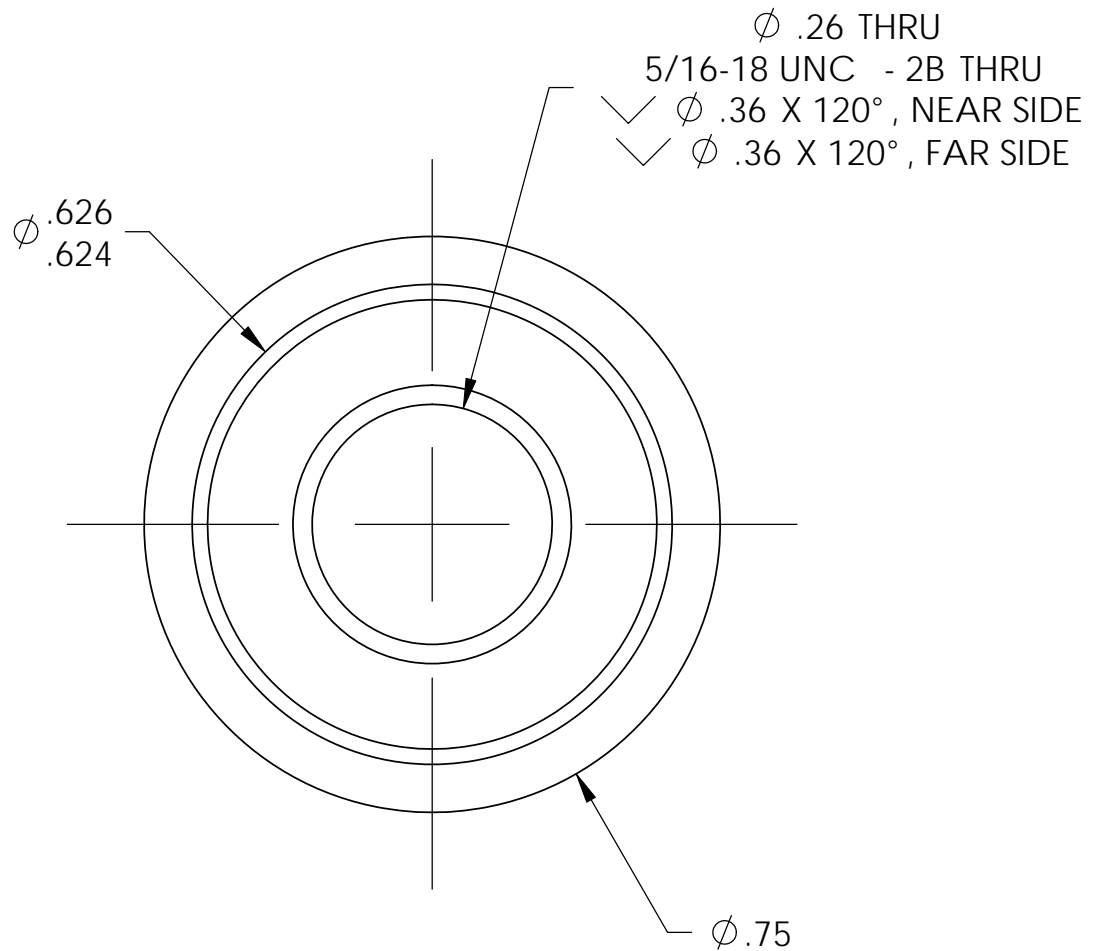
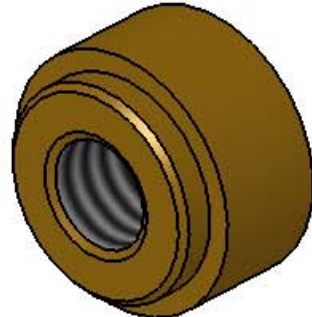
7. APPROXIMATE WEIGHT: 0.04LB.

8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.

9. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.

10. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION.

REV.	DATE	DCN #	DRAWING TREE #
v1	6 FEB 2010	E0900444	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES		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.		ADVANCED LIGO		SUB-SYSTEM SEI		Custom Weld Nut, Gs-13 Pod, aLIGO BSC-ISI			
TOLERANCES: .XX ± .015 .XXX ± .005		MATERIAL 304 SSSL		FINISH 63 μinch		NEXT ASSY D0901832		DESIGNER S.Barnum 7 Dec. 2009	SIZE B	DWG. NO. D0902800	REV. v1
ANGULAR ± .5°						APPROVAL K.MASON 6 FEB 2010		SCALE: 4:1	PROJECTION:	SHEET 1 OF 1	