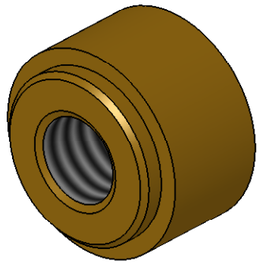
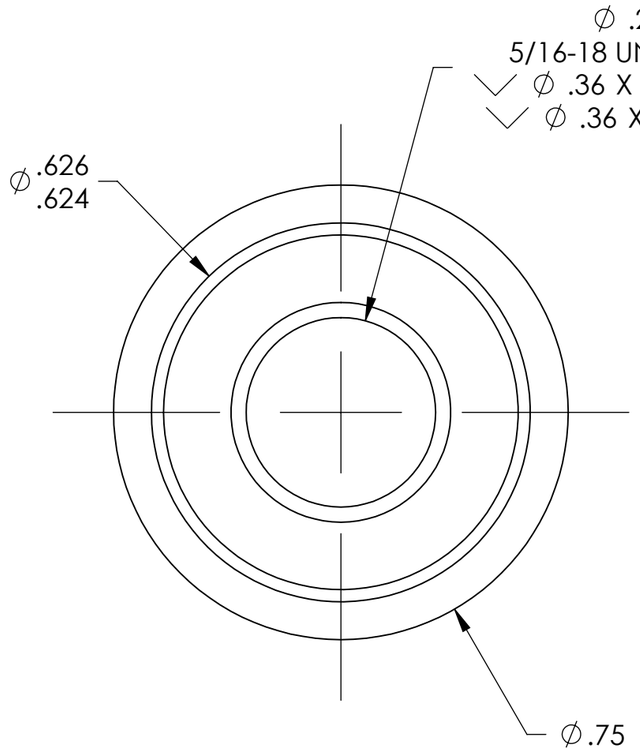
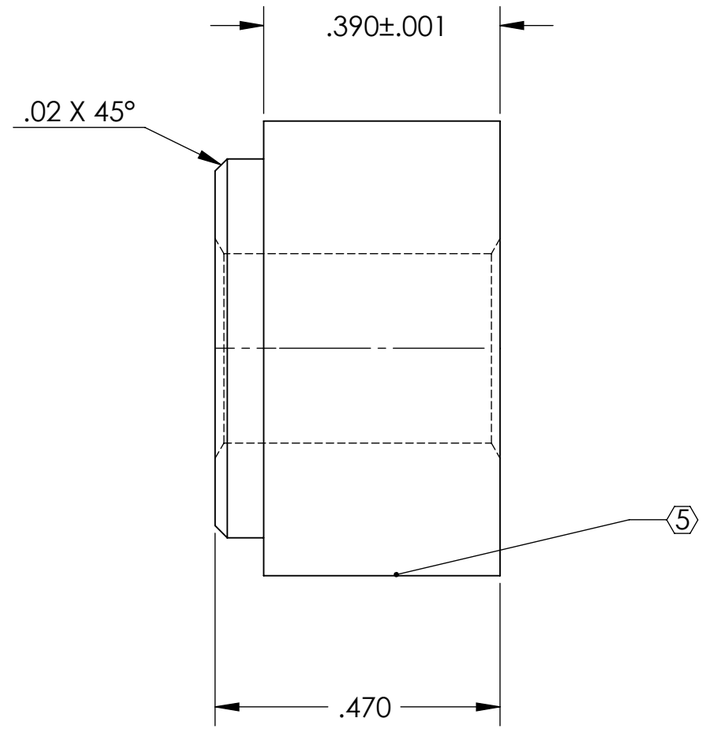
REV.	DATE	DCN #	DRAWING TREE #
v1	6 FEB 2010	E0900444	E1000025
v2	21 May 2010	E1000178	E1000025

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: DXXXXXXX-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.







D0902800_Custom Weld Nut, GS-13 Diaphragm, aLIGO BSC-ISI, PART PDM REV: X-002, DRAWING PDM REV: X-004

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)										
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: Custom Weld Nut, Gs-13 Pod, aLIGO BSC-ISI					
	MATERIAL: 304 SSTL	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	DESIGNER	S.Barnum	7 Dec. 2009	SIZE: B	DWG. NO.: D0902800	REV.: v2
			NEXT ASSY: D0901832		DRAFTER	M.HILLARD	6 FEB 2010			
					CHECKER	F.MATICHARD	6 FEB 2010			
					APPROVAL	K.MASON	6 FEB 2010	SCALE: 4:1	PROJECTION:	SHEET 1 OF 1