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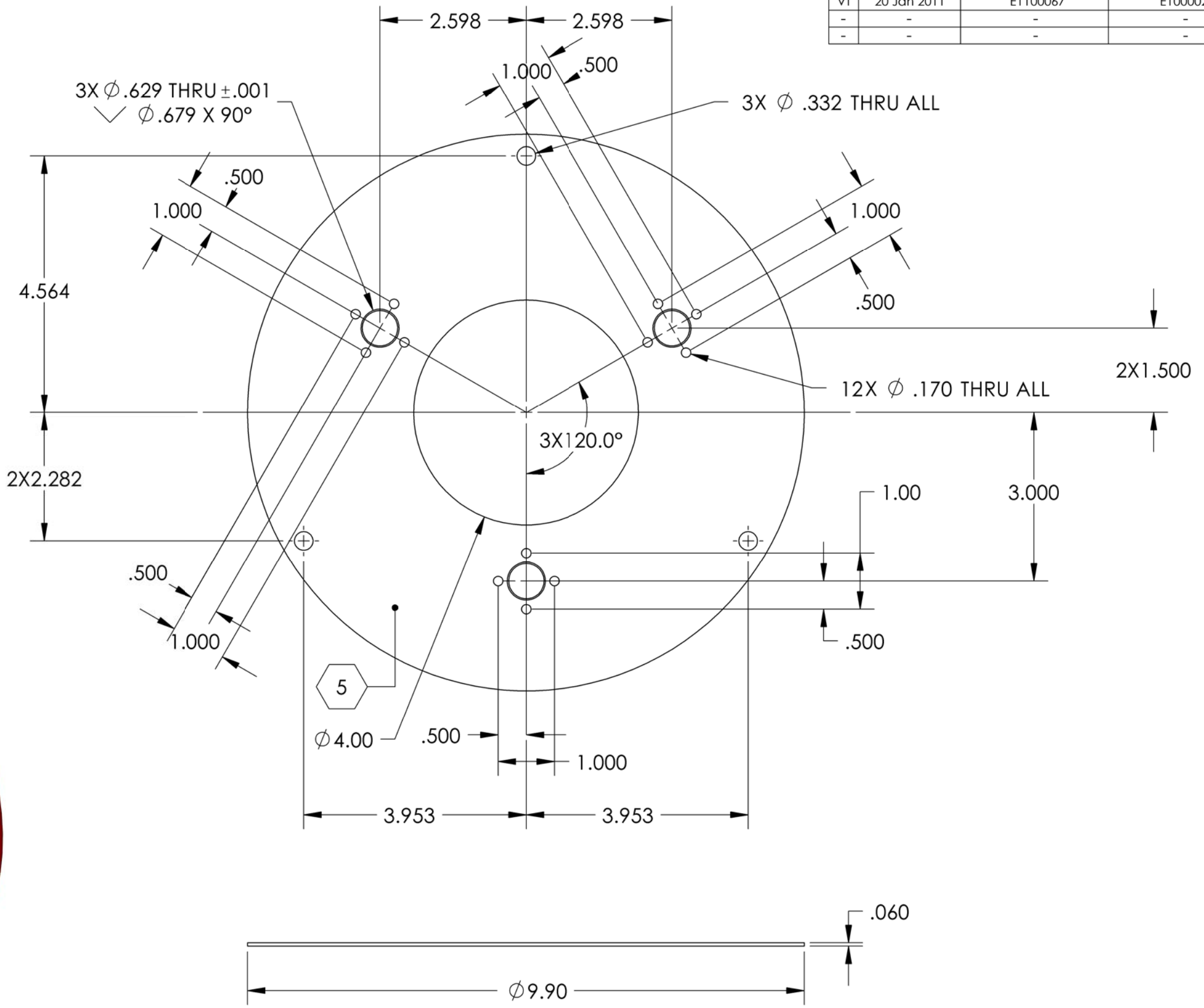
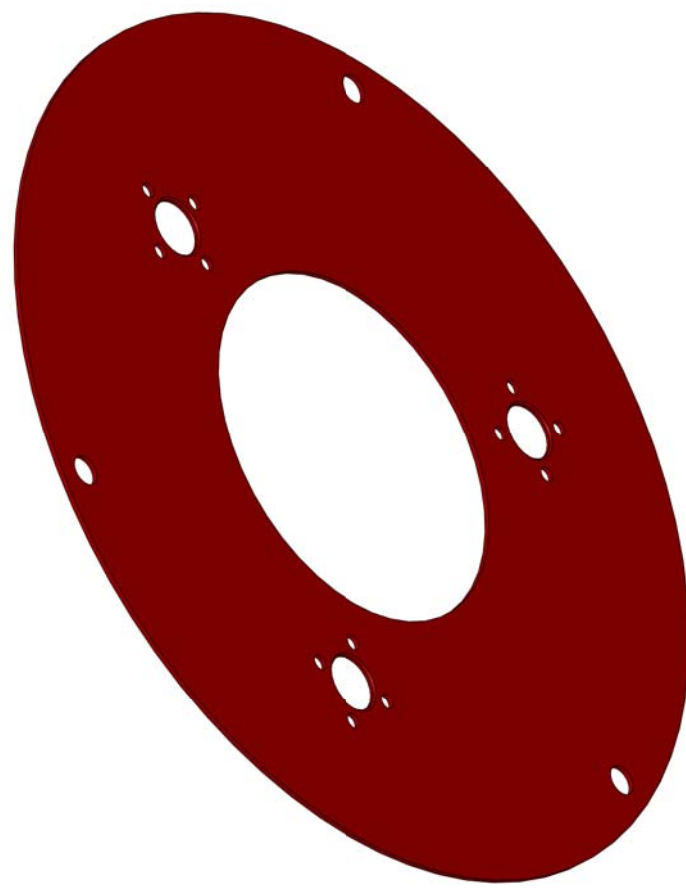
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NOTES CONTINUED:

- 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. APPROXIMATE WEIGHT = 1LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. 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.
- 10. 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.
- 11. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
- 12. 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
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-	-	-	-



D1100086 GS-13 Bolted Stabilizer Plate, PART PDM REV: X-000, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± 0.015 .XXX ± 0.005 ANGULAR ± 0.1°				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.		GS-13, Horizontal, Bolted Stabilizer Plate					
						SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI	DESIGNER S.BISCANS	DATE 20 Jan 2011	SIZE B	DWG. NO. D1100086
MATERIAL 304 S3TL		FINISH 32 μinch		NEXT ASSY D1100088		CHECKER F.MATICHARD	DATE 20 Jan 2011	APPROVAL K.MASON	SCALE: 1:4	PROJECTION:	SHEET 1 OF 1

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