

- NOTES CONTINUED:**
- VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS MEETING ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
 - ELECTRONIC COMPONENTS IN MODELS AND BOMS ARE FOR LAYOUT AND ASSEMBLY PURPOSES ONLY AND NOT TO BE USED FOR PURCHASING.
 - REFER TO LIGO DOC T0900592 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.
 - ASSEMBLY TO BE ADJUSTED USING SHIMS IN TABLE 1 ACCORDING TO PROCEDURE T0900592.
 - REFER TO EACH INDIVIDUAL PART DRAWINGS FOR LIGO MACHINING AND WELDING SPECIFICATIONS.

REV.	DATE	DCN #	DRAWING TREE #
V1	06 FEB 2010	E0900444-X0	E1000025
V2	23 MAR 2010	E0900444-V1	E1000025

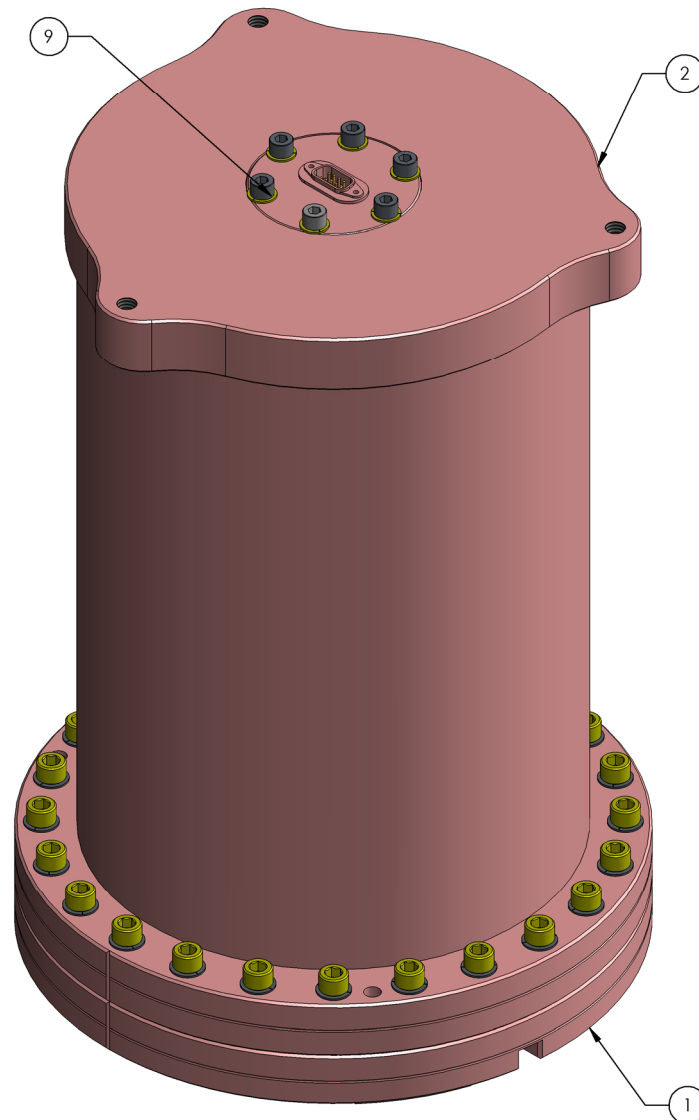


TABLE 1 - SHIM THICKNESSES FOR ITEM #17

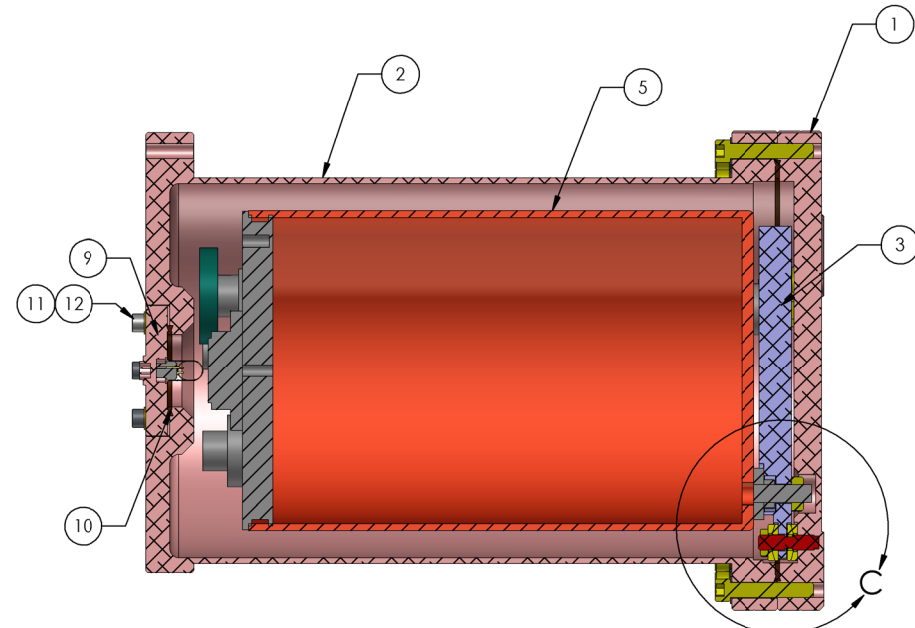
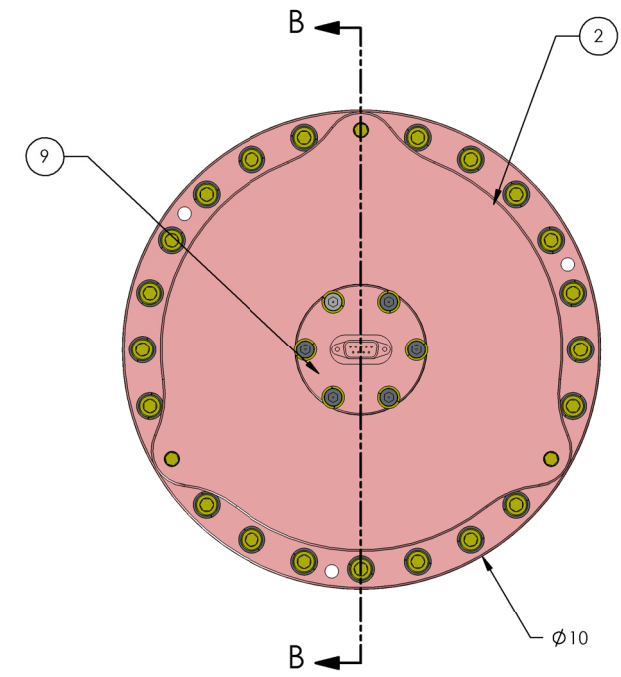
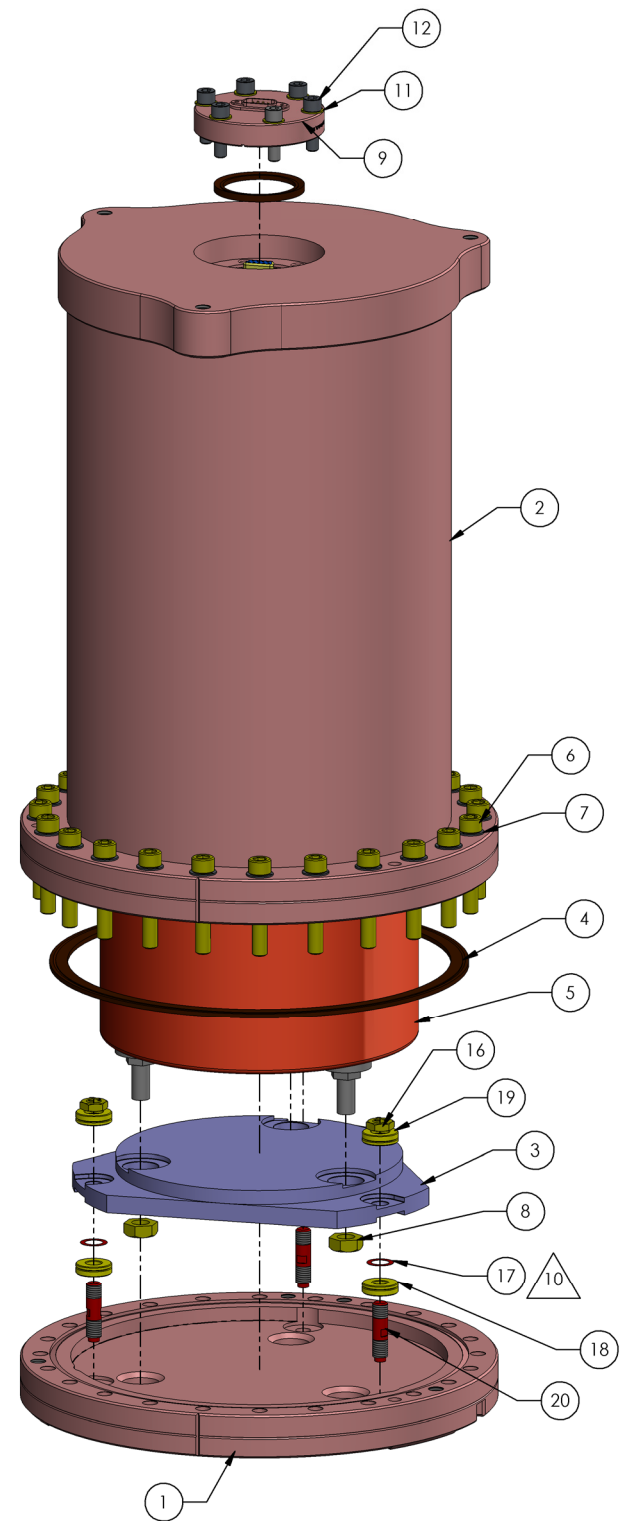
MC MASTER P/N	THICKNESS	REQ
98126A123	0.001	1 PACK OF 10 FOR EVERY 3 PODS
98126A210	0.003	1 PACK OF 10 FOR EVERY 3 PODS
98126A291	0.005	1 PACK OF 10 FOR EVERY 3 PODS

20	M8 Modified Stud	Misumi Custom P/N FWB58_32_E12_FB_SC14 (Ligo special)	304 SSSL	3
19	Jergins Inc_41203	Spherical Washer 5/16 bolt size concave half	300 SSSL	6
18	Jergins Inc_41203	Spherical Washer 5/16 bolt size convex half	300 SSSL	6
17	SEE TABLE 1	ShimWasher 3/8" ID, 5/8" OD.	316 SSSL	-
16	McMaster_90710A120	M8x1.25 Hex Nut x 4 mm Thk	18-8 SSSL	3
15	N/A (pre order)	DE19977-47_ITT_CANNON_90deg_BackShell for 9 pin SUB-D	N/A	1
14	N/A (pre order)	DE44994_ITT_CANNON_Metal_Connector_Backshell	N/A	1
13	N/A (pre order)	D-Sub 9 Pin Connector	N/A	1
12	U-C Components_C-2814-A	Screw SHCS 1/4-28 UNF-2A x 7/8 lg. vented Ag plated	18-8 SSSL	6
11	UC_COMPONENTS_WF V-25	Vented Washer, .255 ID X .468 OD X .032 THK #1/4	18-8 SSSL	6
10	Nor-Cal_G-275	CF Flange 2 3/4 Nominal od Gasket	COPPER	1
9	Accu-Glass_100200	9 Pin, D-Type Feedthrough on a 2.75 CF Flange, model 9D-275	304 SSSL	1
8	McMaster_91841A235	Hex Nut 3/8-24 UNF-2B x .25 thk	18-8 SSSL	3
7	UC_COMPONENTS_WF V-31	Washer Vented, .328 ID X .562 OD X .032 THK #5/16	18-8 SSSL	24
6	U-C Components_C-3128-NA	Screw SHCS 5/16-24 UNF-2A x 1 3/4 lg Ag plated	18-8 SSSL	24
5	GeoTech Inst_S-13	Seismometer Model S-13	N/A	1
4	Nor-Cal_G-1000	CF Flange 10 inch Nominal od Gasket	COPPER	1
3	D0900858	GS13 Pod Interposer Plate	6061-T6 Al	1
2	D0900859	GS13 Pod Top Hat	304 SSSL	1
1	D0900860	Flange Pod Base GS-13	304 SSSL	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ

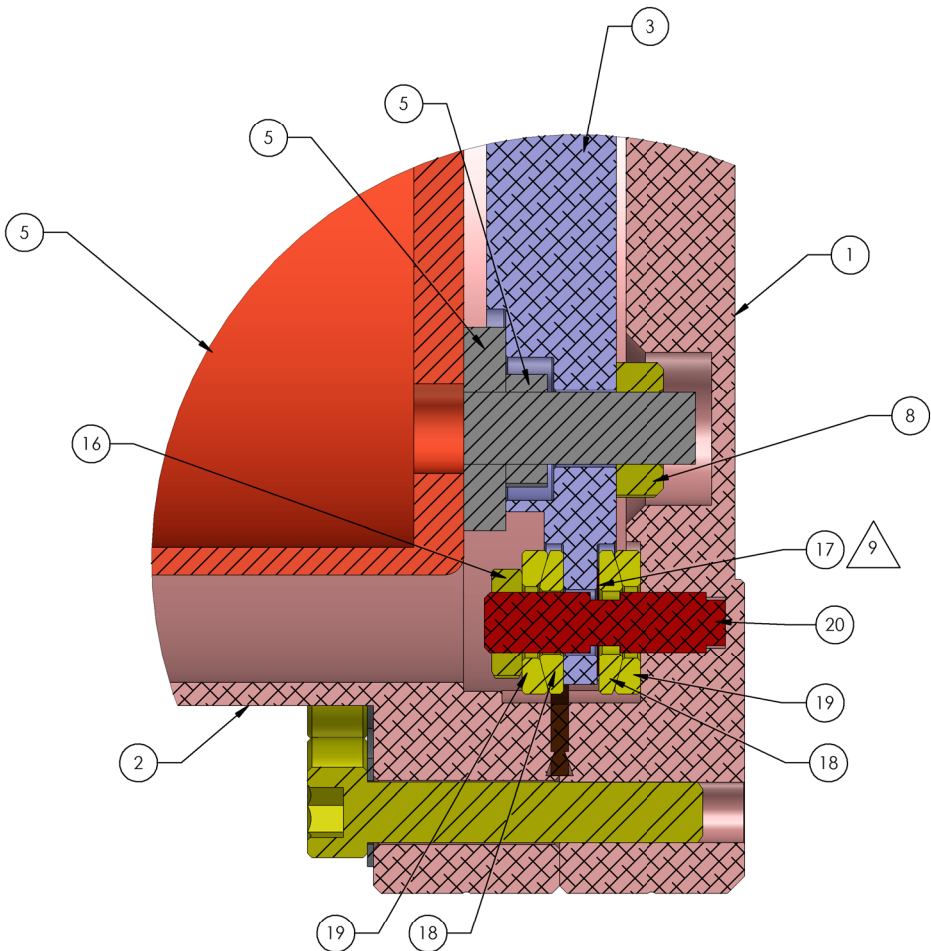
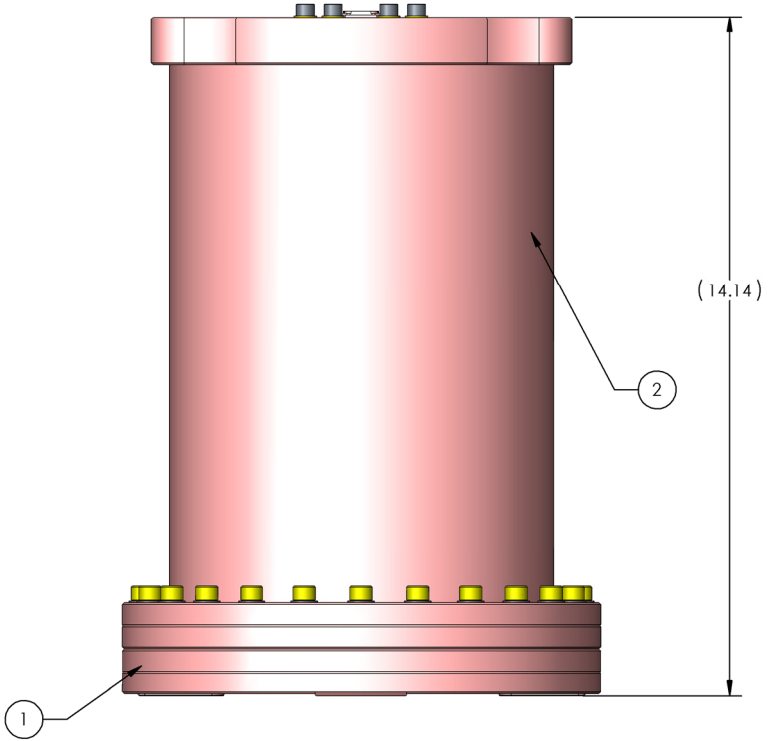
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES	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

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		GS-13 Pod Assembly	
DESIGNER	S.BARNUM	04 FEB 2010	SIZE
DRAFTER	M.HILLARD	04 FEB 2010	DWG. NO.
CHECKER	F.MATICHARD	06 FEB 2010	D
APPROVAL	K.MASON	06 FEB 2010	SCALE: 2:3
NEXT ASSY		PROJECTION:	
D0902777 and D0902778		SHEET 1 OF 2	
		REV. v2	

D:\PROJETS_GS-13_Pod_PART_PDM_REV_X.002_DRAWING_PDM_REV_X.009



SECTION B-B
SCALE 1 : 2



DETAIL C
SCALE 2 : 1