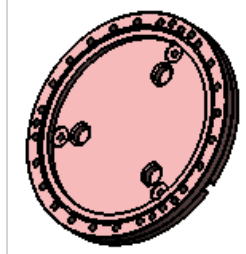
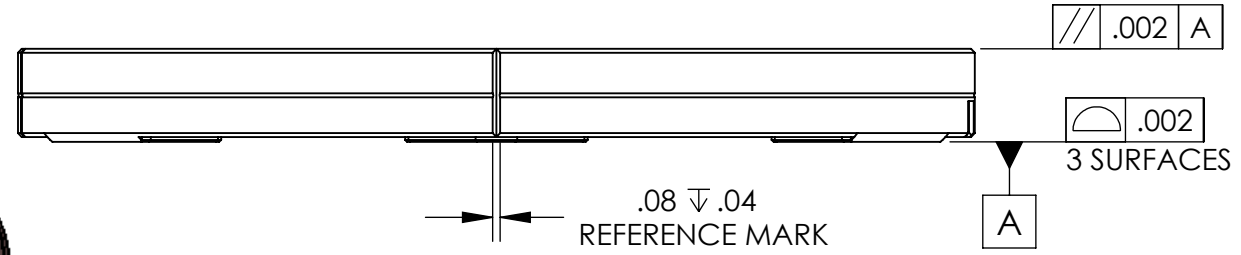
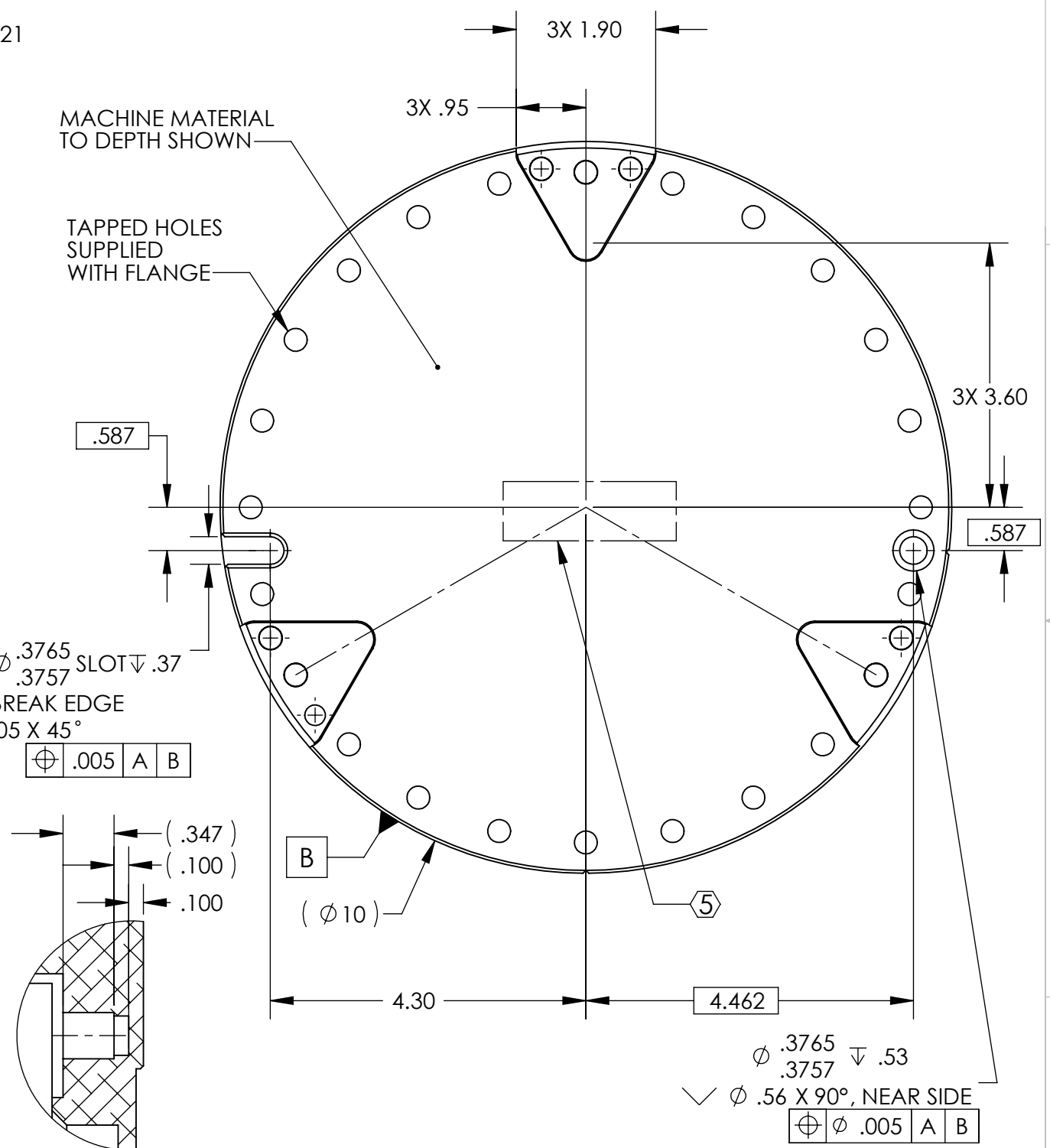
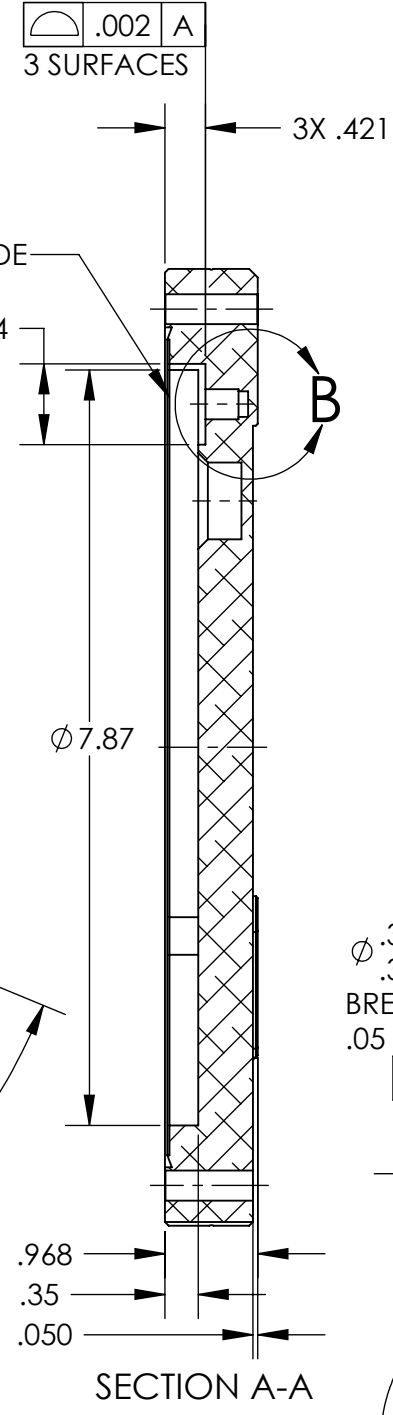
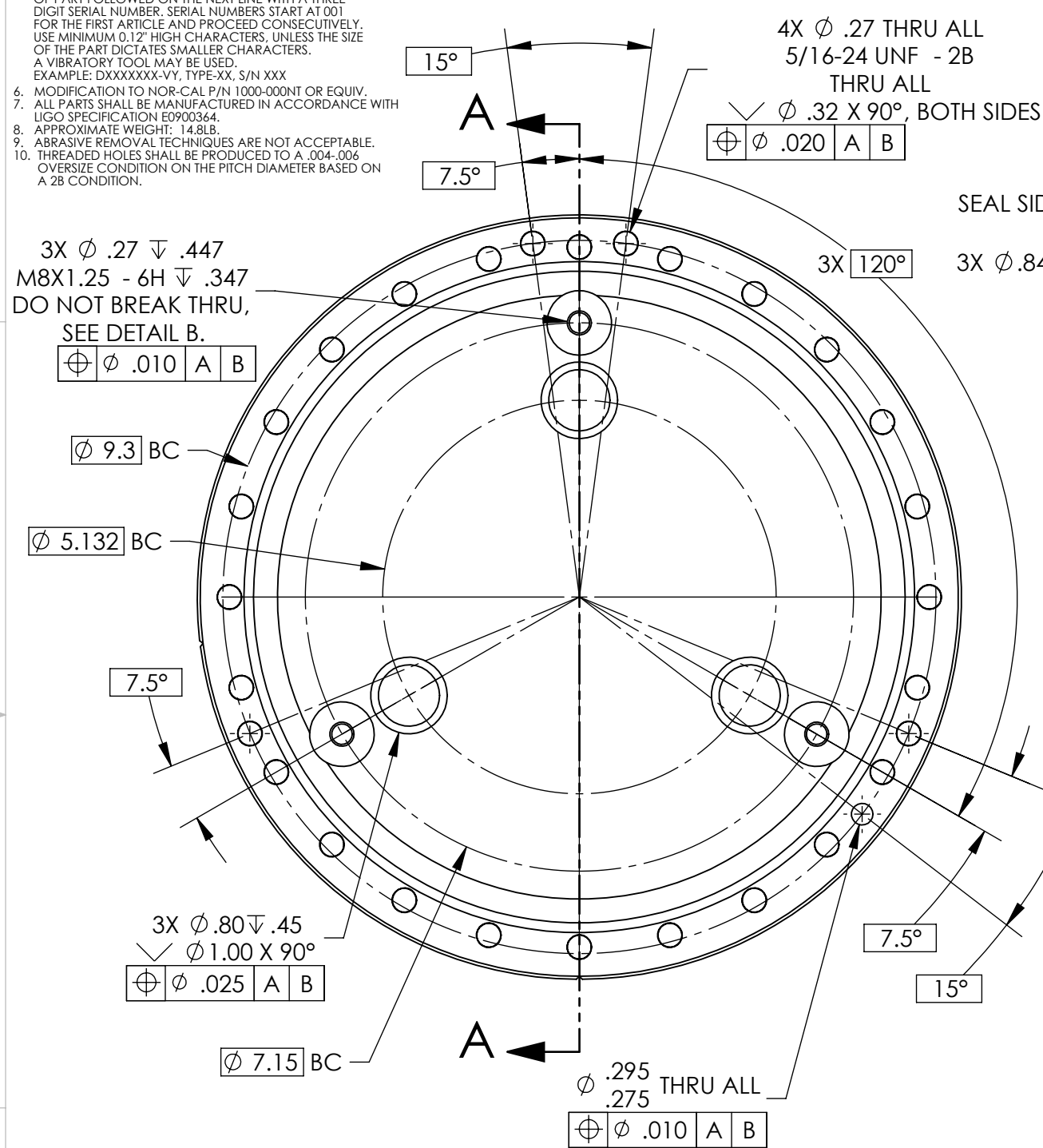


**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. MODIFICATION TO NOR-CAL P/N 1000-000NT OR EQUIV.  
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.  
 8. APPROXIMATE WEIGHT: 14.8LB.  
 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	06 FEB 2010	E0900444-X0	E1000025
V2	23 MAR 2010	E0900444-V1	E1000025
V3	20 May 2010	E0900171-V1	E1000025



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .015  
 .XXX ± .005  
 ANGULAR ± 0.1°

MATERIAL	304 SSSL, NOTE 6	FINISH	63 µinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		Flange Pod Base GS-13	
DESIGNER	S.BARNUM	04 FEB 2010	SIZE DWG. NO.
DRAFTER	M.HILLARD	04 FEB 2010	B
CHECKER	F.MATICHARD	06 FEB 2010	D0900860
APPROVAL	K.MAON	06 FEB 2010	REV. v3
NEXT ASSY		D0900857	
SCALE: 1:2		PROJECTION:	
SHEET 1 OF 1			

D0900860\_GS-13\_Base\_Flange, PART PDM REV: X-019, DRAWING PDM REV: X-013