

NOTES CONTINUED:
 5. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
 6. 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 ISI.
 △ ASSEMBLY TO BE ADJUSTED USING SHIMS IN TABLE 2 AND TABLE 3. MEASURE ASSEMBLY PRIOR INSTALLATION USING A CMM ARM AND SELECT APPROPRIATE SHIM THICKNESS.

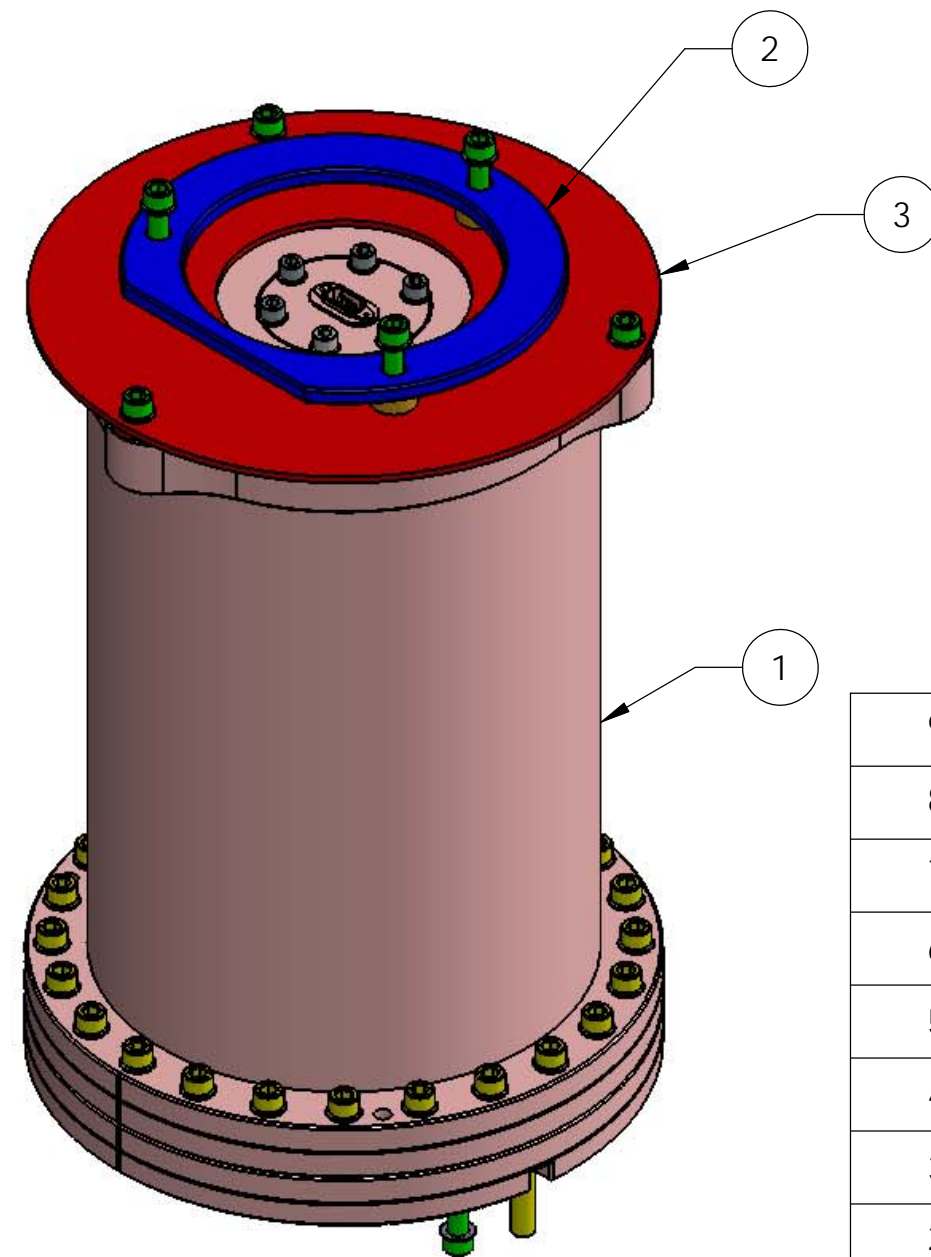
REV.	DATE	DCN #	DRAWING TREE #
v1	5 FEB 2010	E0900444	E1000025

△ TABLE 2

MISUMI P/N	Thickness	# of Shims Req per Pod Assembly
WASS20-10-2	2 mm (.079")	3
WASS20-10-3	3 mm (0.118") Nominal Thickness	3

△ TABLE 3

Mc Master P/N (Packs of 50)	Thickness	# of Shims Req per Pod Assembly
99040A702	0.002	6
94773A614	0.005	6
94773A655	0.010	3
94773A688	0.016	3
94773A714	0.020	3
94773A745	0.030	3



9	U-C Components_C-3116-NA	Screw shcs 5/16-24 UNF-2A X 1" lg Ag plated	Ag-PLATED 300 SSSL	3
8	SEE TABLE 2	Washer 20mm OD x 10mm ID Thk precision washer	304 SSSL	3
7	U-C Components_C-3116-NA	Screw shcs 5/16-24 UNF-2A X 1.25" lg. Ag plated	Ag-PLATED 300 SSSL	7
6	UCC_WFV-31	Vented Washer, 5/16"	18-8 SSSL	10
5	McMaster_90145A626	Dowel Pin 3/8" (.3751) +/- .0001" x 1.25" +/- .01"	18-8 SSSL	1
4	McMaster_90145A630	Dowel Pin 3/8" (.3751) +/- .0001" x 1.75" +/- .01"	18-8 SSSL	1
3	D0901832	GS-13, Horizontal, Stabilizer	304 SSSL	1
2	D0902583	Spacer, Horz GS-13 Stiffener, BSC ISI	6061-T6 Al	1
1	D0900857	GS-13 Pod Assembly	N/A	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*

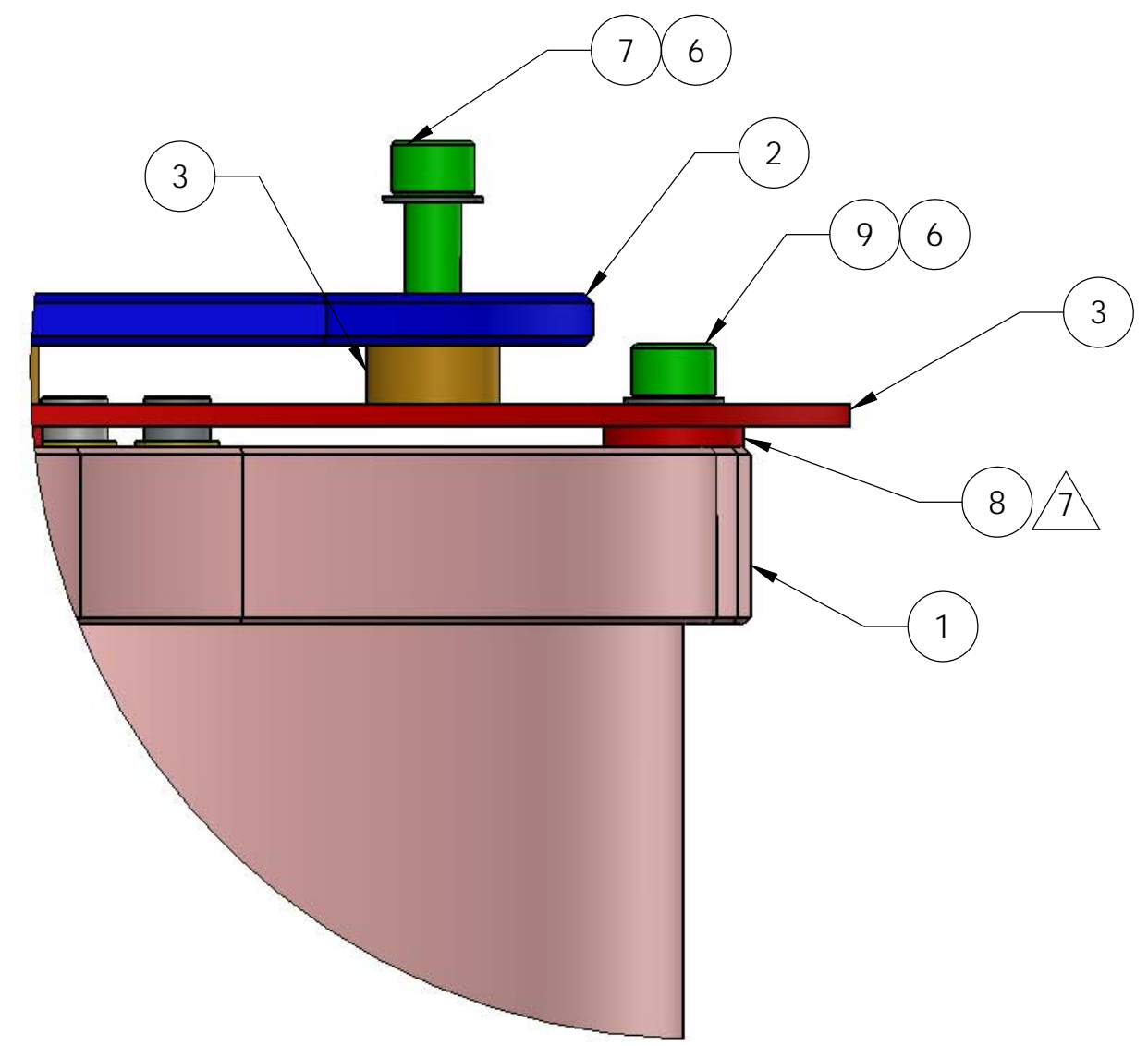
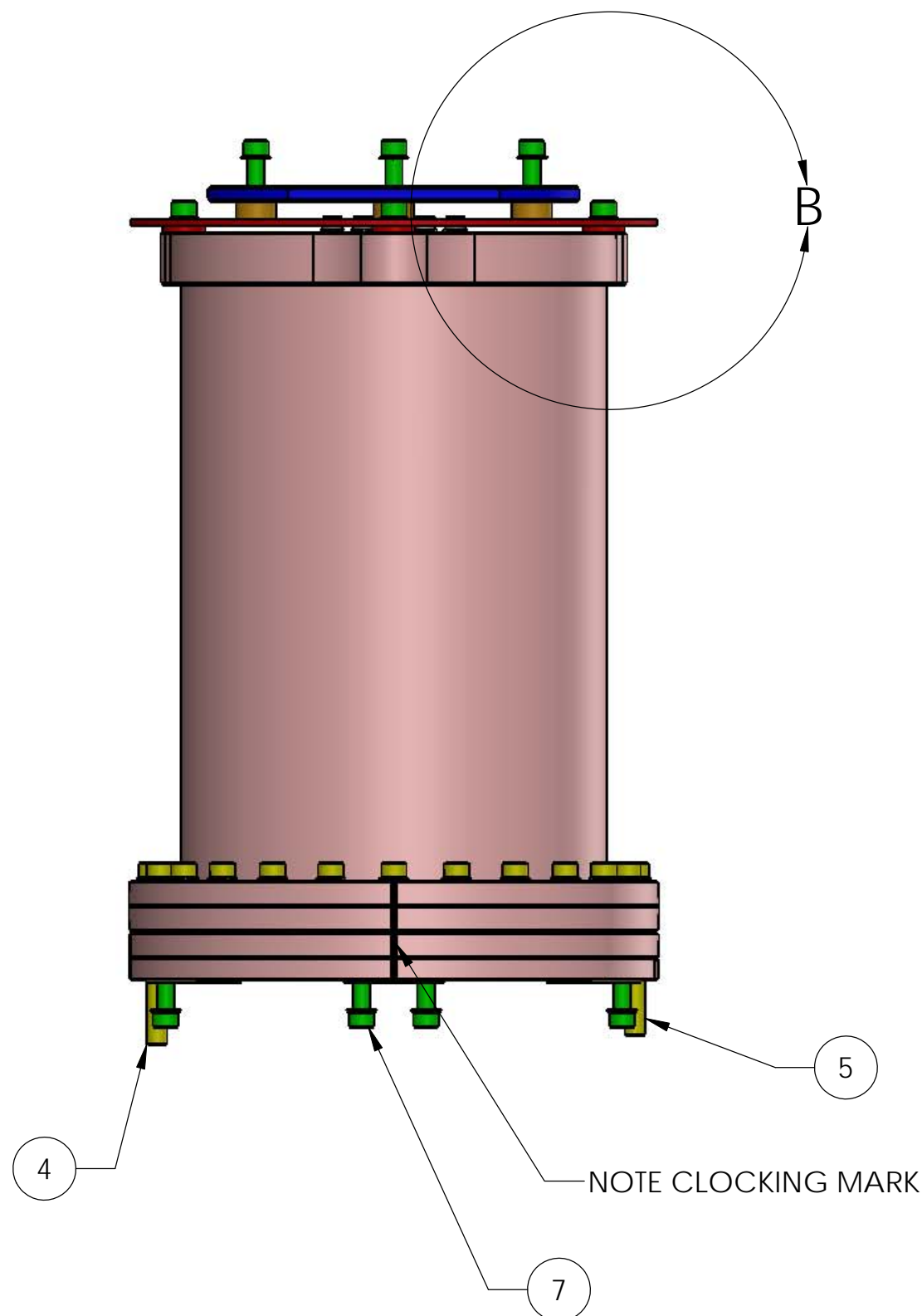
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SYSTEM **ADVANCED LIGO** SUB-SYSTEM **SEI**
 MATERIAL **N/A** FINISH **N/A μinch** NEXT ASSY **D0901182**

PART NAME **GS-13 Pod - Horizontal - BSC**
 DESIGNER **S.BARNUM** 5 FEB 2010
 DRAFTER **M.HILLARD** 5 FEB 2010
 CHECKER **F.MATICHARD** 6 FEB 2010
 APPROVAL **K.MASON** 6 FEB 2010



SIZE **B** DWG. NO. **D0902778** REV. **v1**
 SCALE: 1:3 PROJECTION: SHEET 1 OF 2

D0902778 GS-13 Pod-Horizontal - aLIGO BSC-ISI, PART PDM REV: X-009, DRAWING PDM REV: X-004

D0902778 GS-13 Pod-Horizontal - aLIGO BSC-ISI, PART PDM REV: X-009, DRAWING PDM REV: X-004



DETAIL B
SCALE 1 : 1

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SIZE B	DWG. NO. D0902778
SCALE: 1:3	PROJECTION:  SHEET 2 OF 2
REV. V1	