

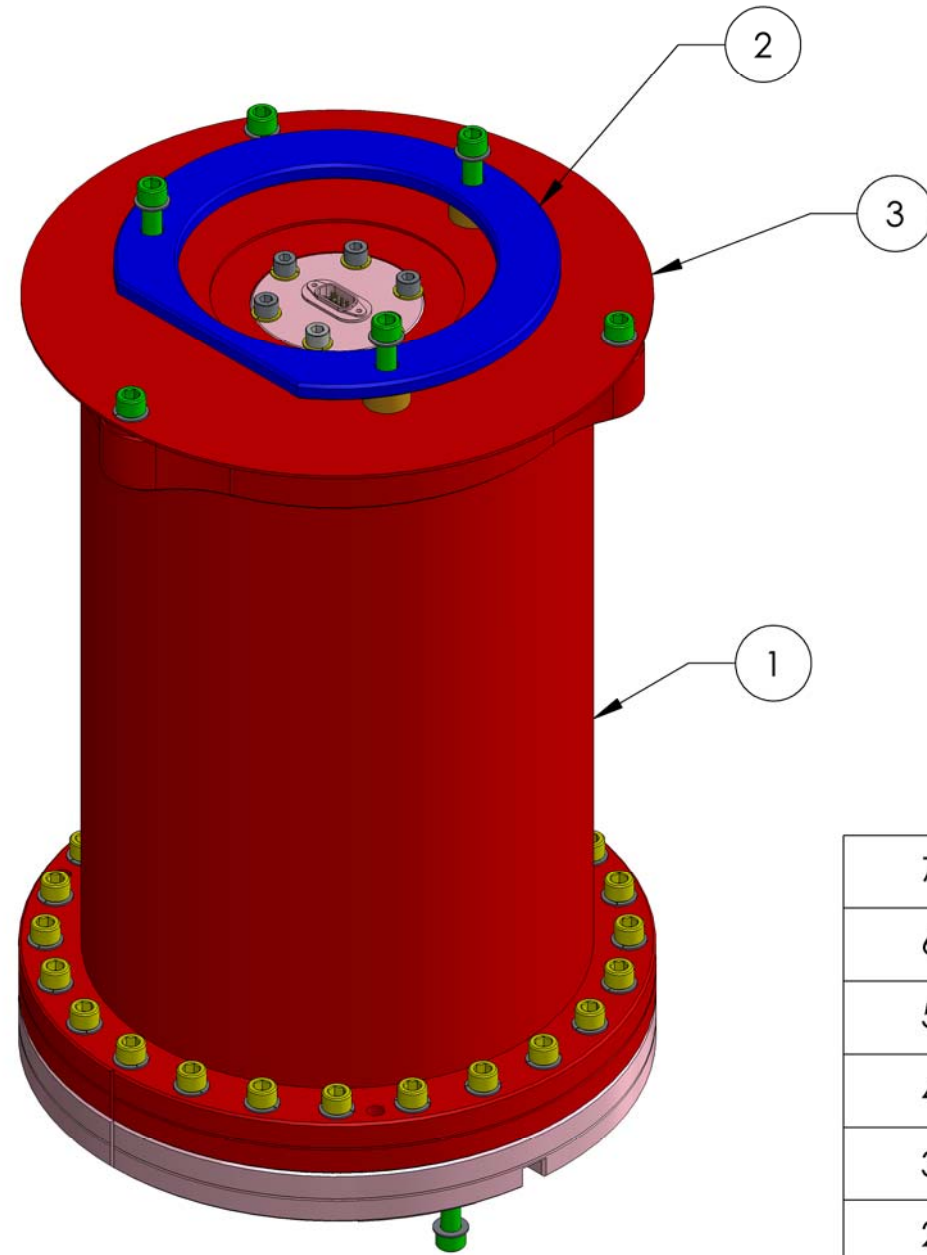
D0902778 GS-13 Pod-Horizontal - aLIGO BSC-ISI, PART PDM REV: X-019, DRAWING PDM REV: X-009

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 SELECT CLOSEST SHIM. MEASURE ASSEMBLY PRIOR INSTALLATION USING A CMM ARM AND SELECT APPROPRIATE SHIM THICKNESS.

7 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

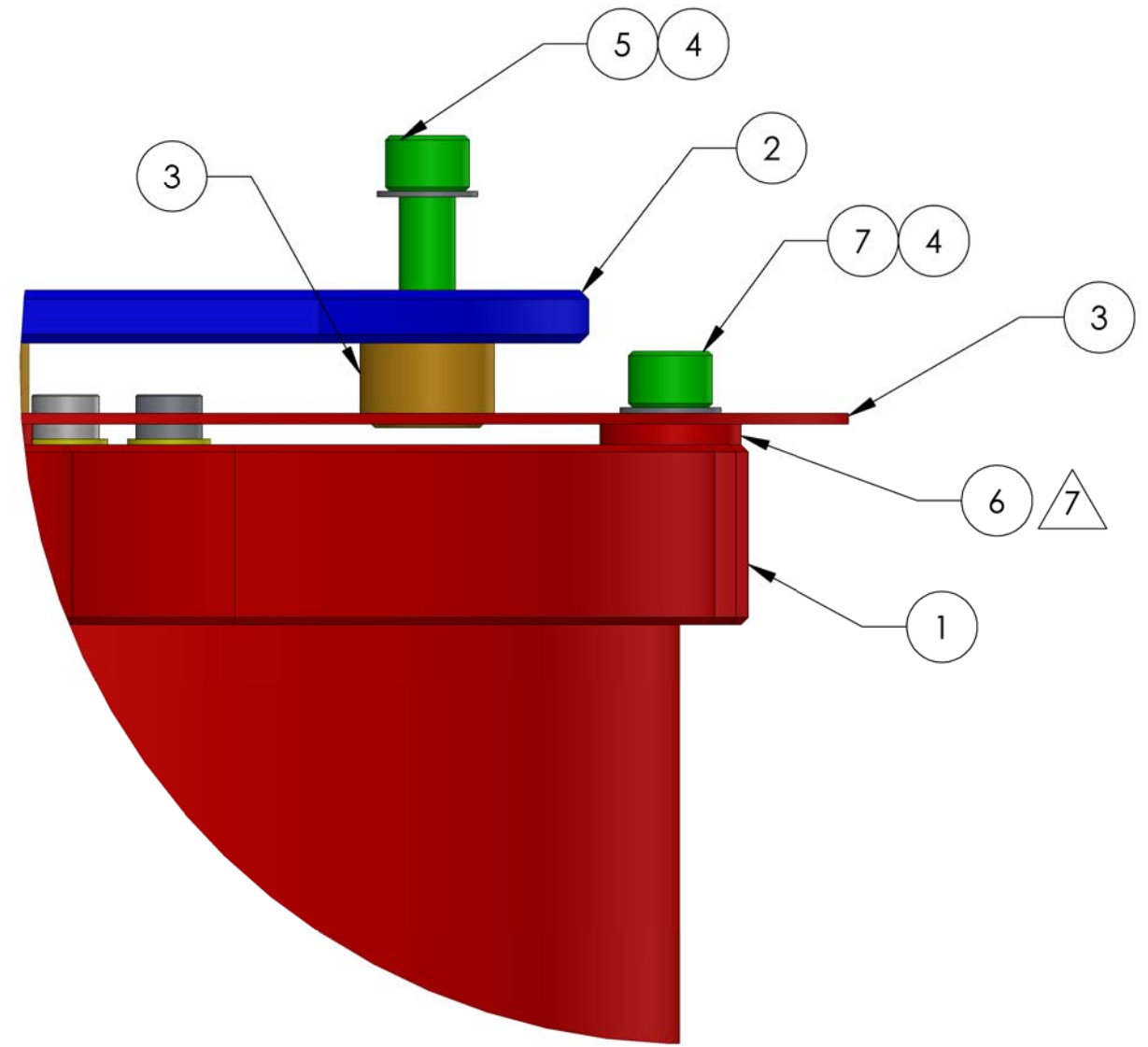
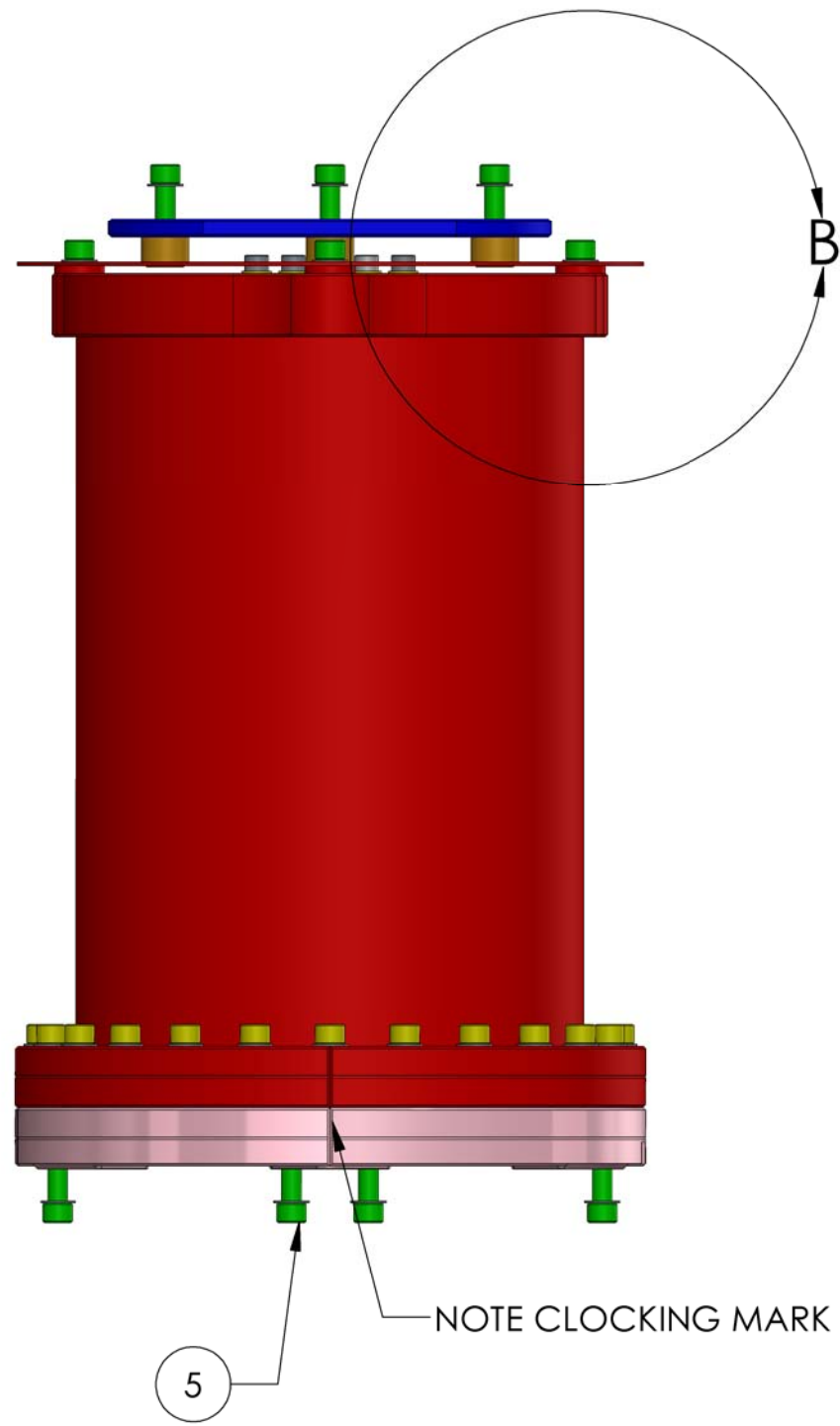
REV.	DATE	DCN #	DRAWING TREE #
v1	5 FEB 2010	E0900444	E1000025
v2	21 May. 2010	E1000178	E1000025
v3	10 Aug. 2010	E1000302	E1000025
v4	24 Aug. 2010	E1000353	E1000025



7	U-C Components_C-3116-NA	Screw shcs 5/16-24 UNF-2A X 1" lg Ag plated	Ag-PLATED 300 SSSL	3
6	SEE TABLE 2	Washer 20mm OD x 10mm ID Thk precision washer	304 SSSL	3
5	U-C Components_C-3120-NA	Screw shcs 5/16-24 UNF-2A X 1.25" lg. Ag plated	Ag-PLATED 300 SSSL	7
4	UC_COMPONENTS_WFV-31	Washer Vented, .328 ID X .562 OD X .032 THK #5/16	18-8 SSSL	10
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

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± N/A .XXX ± N/A ANGULAR ± N/A *		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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY SYSTEM: ADVANCED LIGO SUB-SYSTEM: SEI 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.: v4	SCALE: 1:3 PROJECTION: SHEET 1 OF 2
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D0902778 GS-13 Pod-Horizontal - aLIGO BSC-ISI, PART PDM REV: X-019, DRAWING PDM REV: X-009



DETAIL B
SCALE 1 : 1

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D0902778	REV. v4
SCALE: 1:3	PROJECTION:	SHEET 2 OF 2

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

8 7 6 5 4 3 2 1