

REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	6/21/2007	1065	D. Bryce	Manufacturing Release
C	02/04/2008	-	A. STEIN	Added detail. Updated BOM.

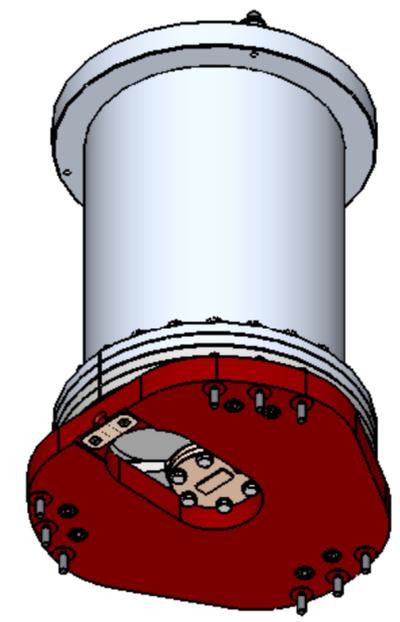
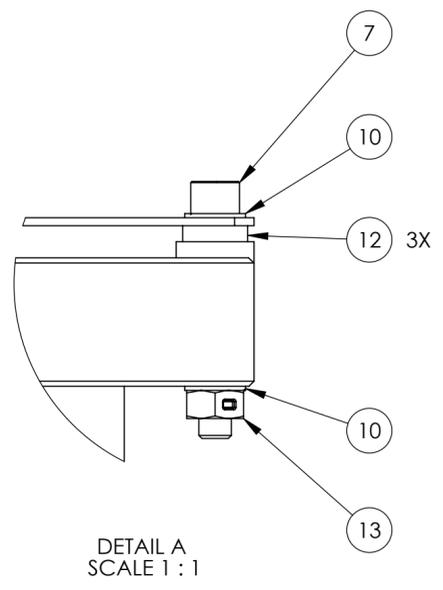
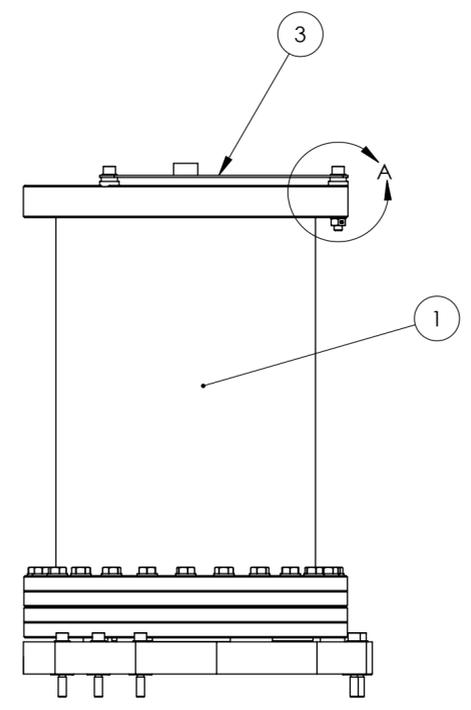
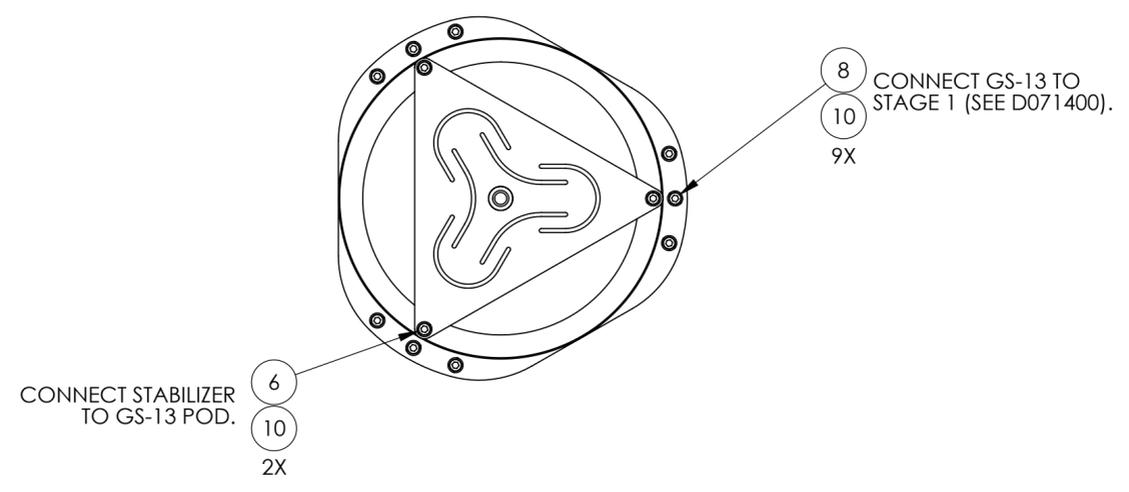
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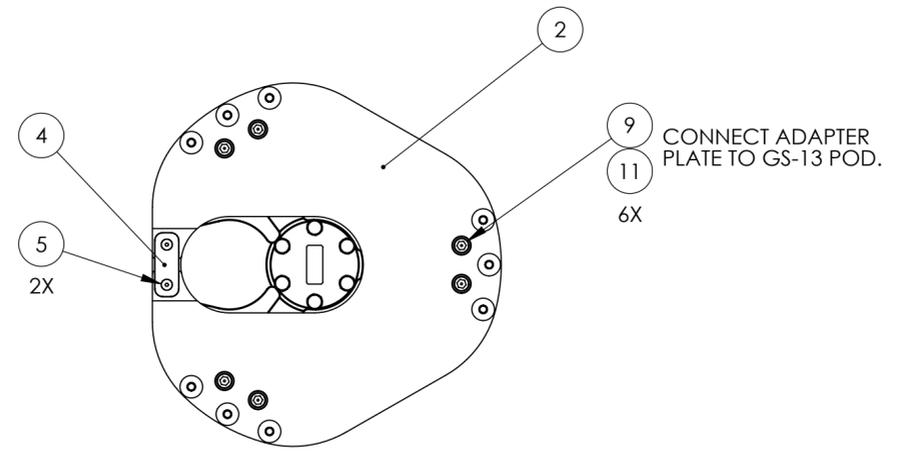
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NOTES:

- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
- GS-13 MUST BE INSTALLED IN POD (FOLLOWING A SEPARATE PROCEDURE) BEFORE BEGINNING THIS ASSEMBLY.
- INSTALL HELI-COILS IN ADAPTER PLATE, BEFORE BEGINNING ASSEMBLY.
- GS-13 IS FRAGILE. HANDLE WITH CARE.

BILL OF MATERIALS					
ITEM NO.	Horizontal/ QTY.	PART NUMBER	DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D047810	ASM, GS-13 SEISMOMETER POD	HORIZONTAL HAM	See BOM
2	1	D071180	GS-13 ADAPTER PLATE	-	6061-T6
3	1	D071471	ASM, STABILIZER, GS-13	-	See BOM
4	1	D071183	GS-13 CABLE RESTRAINT	-	6061-T6
5	2	MCMMASTER 92210A192	FHSCS	#8-32x.375"	18-8 SS
6	2	UCC C-2016-NA	SHCS	1/4"-20x1.0"	18-8 SS
7	1	UCC C-2028-NA	SHCS	1/4"-20x1.75"	18-8 SS
8	9	D071136	SHCS, CUSTOM CAPTIVE	1/4"-20x1.75" (1.125" CLEAR)	18-8 SS
9	6	UCC C-3124-A	SHCS, VENTED	5/16"-24x1.5"	18-8 SS
10	13	UCC WFV-25	VENTED WASHER	.255"IDx.468"OD	18-8 SS
11	6	UCC WFV-31	VENTED WASHER	.328"IDx.562"OD	18-8 SS
12	3	MCMMASTER 92320A660	SPACER	.288"IDx.50"ODx.125"	18-8 SS
13	1	MCMMASTER 90047A029	HEX LOCK NUT	1/4"-20	18-8 SS



UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 DECIMAL TOLERANCES:
 .XX ±.015 .XXX ±.005
 ANG TOL: ± 1° SURFACE ROUGHNESS: 63

High Precision Devices
 1668 Valtec Lane, Suite C, Boulder, Colorado 80301
 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

PRIOR P/N: p06109-470-0	APPROVALS: D. Bryce DATE: 6-21-07	MANUFACTURING: C. Danaher DATE: 6-21-07	QUALITY: See BOM	MATL: See BOM	FINISH: See BOM
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DESCRIPTION: **ASM, GS-13 WITH FIXTURES**
 P/N: **D071470** CONFIG DESC: **HORIZONTAL**
 FILE NAME: D071470-C Asm, GS-13 with Fixtures

FOLDER: **C** SIZE: **C** SCALE: **1:4** DRAWN BY: **Dan Bryce** REV: **C**
 SHEET **1** OF **2** DATE PRINTED: **2/5/2008**

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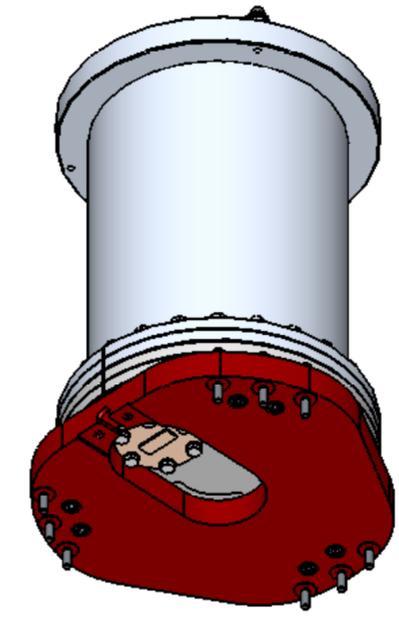
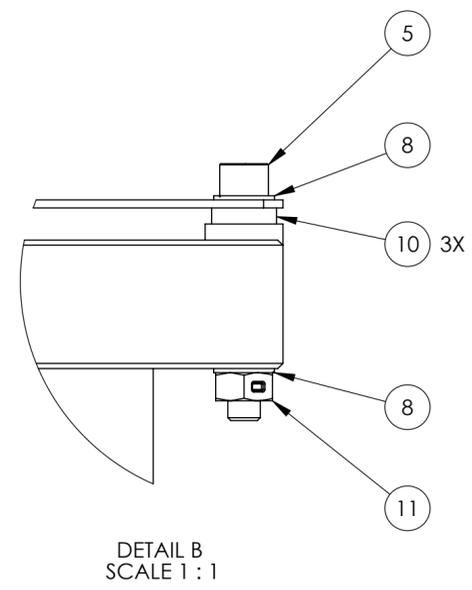
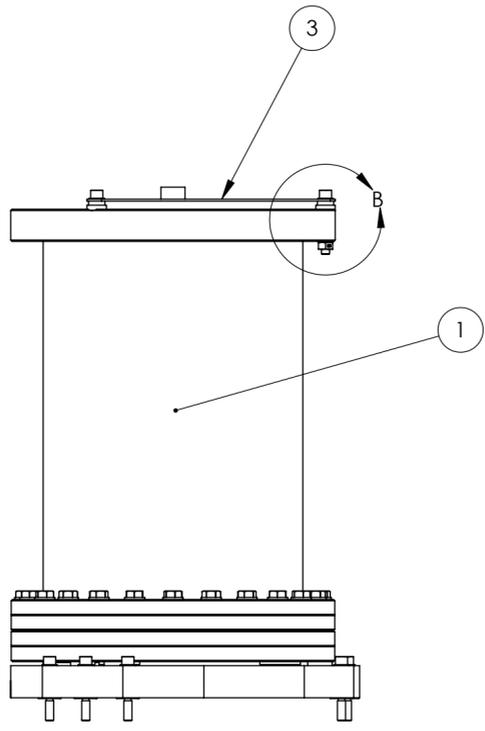
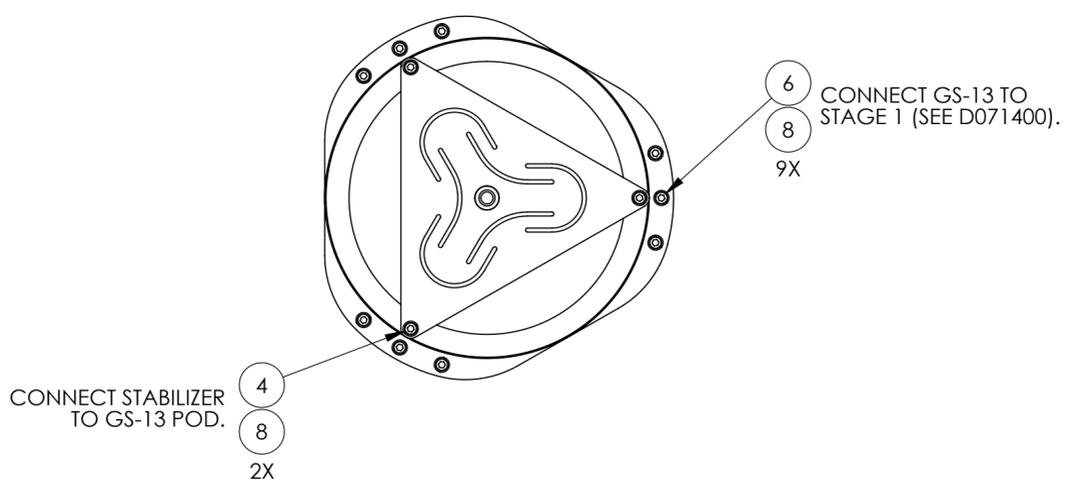
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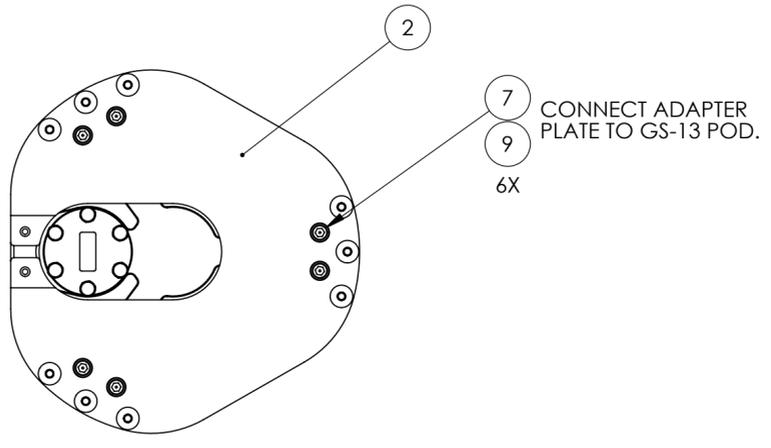
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
-	-	-	-	See Sheet1



NOTES:

- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
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BILL OF MATERIALS					
ITEM NO.	Vertical/QTY.	PART NUMBER	DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D047810	ASM, GS-13 SEISMOMETER POD	VERTICAL HAM	See BOM
2	1	D071180	GS-13 ADAPTER PLATE	-	6061-T6
3	1	D071471	ASM, STABILIZER, GS-13	-	See BOM
4	2	UCC C-2016-NA	SHCS	1/4"-20x1.0"	18-8 SS
5	1	UCC C-2028-NA	SHCS	1/4"-20x1.75"	18-8 SS
6	9	D071136	SHCS, CUSTOM CAPTIVE	1/4"-20x1.75" (1.125" CLEAR)	18-8 SS
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UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
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 .XX ±.015 .XXX ±.005
 ANG TOL: ± 1° SURFACE ROUGHNESS: 63

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DESCRIPTION: ASM, GS-13 WITH FIXTURES

P/N: **D071470** CONFIG DESC: **VERTICAL**

FILE NAME: D071470-C Asm, GS-13 with Fixtures

FOLDER:

SIZE: **C** SCALE: **1:4** DRAWN BY: **Dan Bryce** REV: **C**

SHEET **2** OF **2** DATE PRINTED: **2/5/2008**

PRIOR P/N: **p06109-470-1**

APPROVALS	DATE
ENGINEERING D. Bryce	6-21-07
MANUFACTURING	
QUALITY C. Danaher	6-21-07
MATL: See BOM	
FINISH: See BOM	

INTERNAL AND EXTERNAL INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH A CHAMFER .005/.010 X 45° OR RADIUS .005/.010.
 CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°

THIS PRINT & ITS RELATED MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL FEATURES MUST CONFORM TO .010 TOTAL WIDE PROFILE OF A SURFACE. INTERPRET DWG PER ASME Y14.5M 1994

D

C

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A