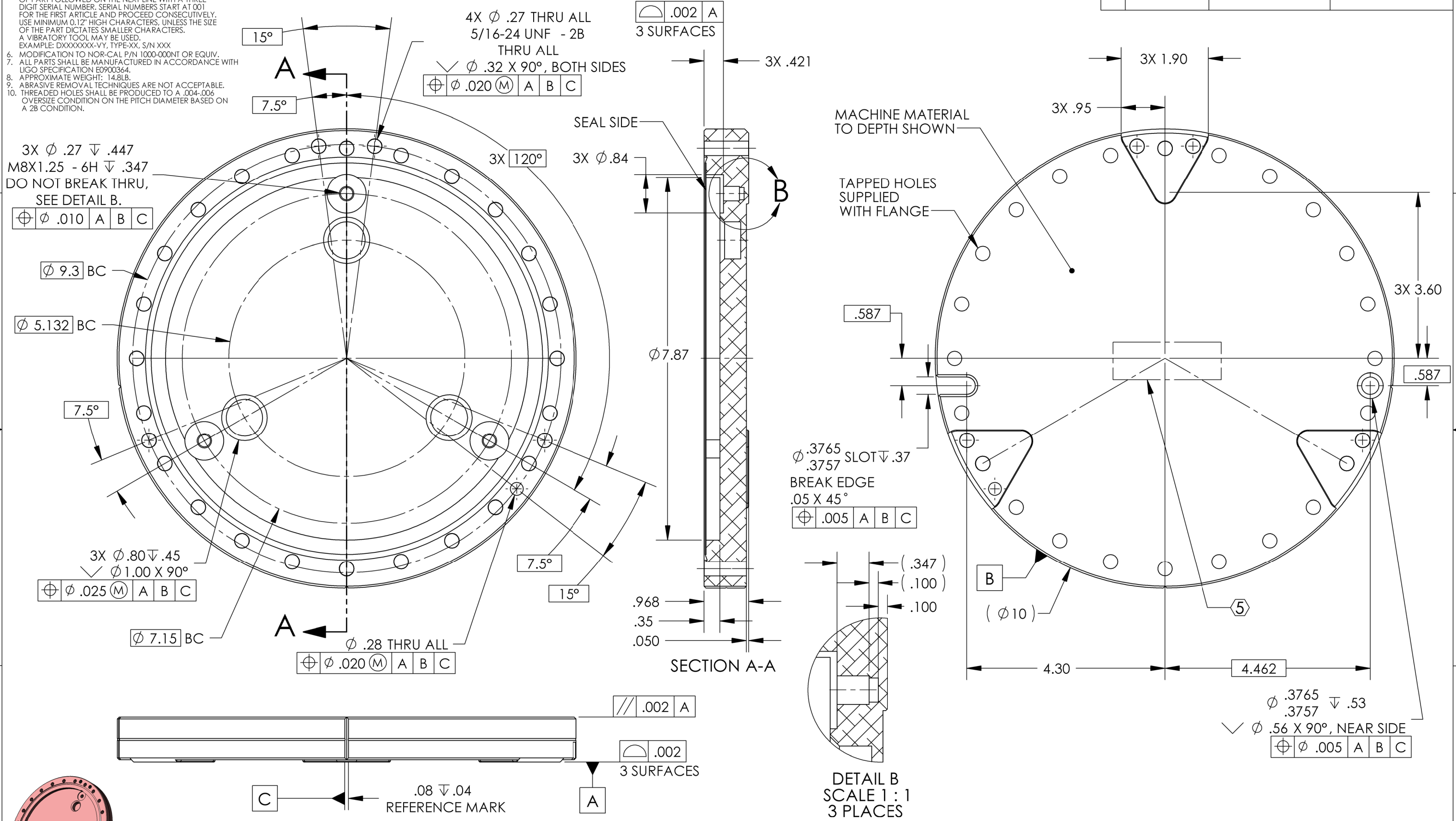


D0900860_GS-13_Base_Flange, PART PDM REV: X-019, DRAWING PDM REV: X-011

- 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



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm .015$.XXX $\pm .005$ ANGULAR $\pm 0.1^\circ$				Flange Pod Base GS-13	
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.				ADVANCED LIGO SEI	
MATERIAL: 304 SSSL, NOTE 6		FINISH: 63 μ inch		NEXT ASSY: D0900857	
DESIGNER: S.BARNUM		DRAFTER: M.HILLARD		CHECKER: J.MATICHARD	
DATE: 04 FEB 2010		DATE: 04 FEB 2010		DATE: 06 FEB 2010	
APPROVAL: K.MAON		SCALE: 1:2		PROJECTION:	
DIMENSIONS ARE IN INCHES				SHEET 1 OF 1	