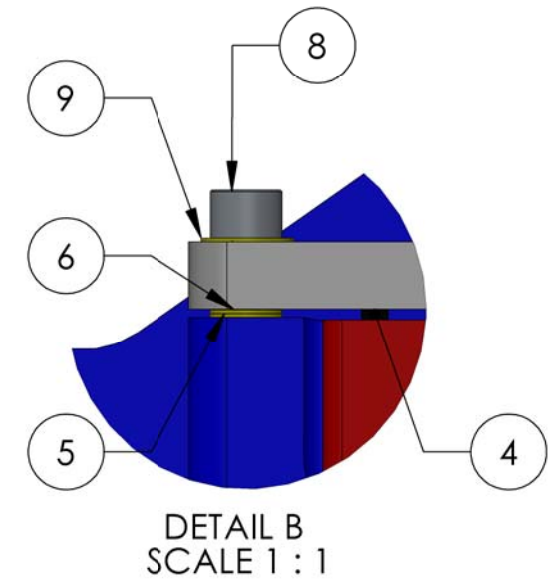
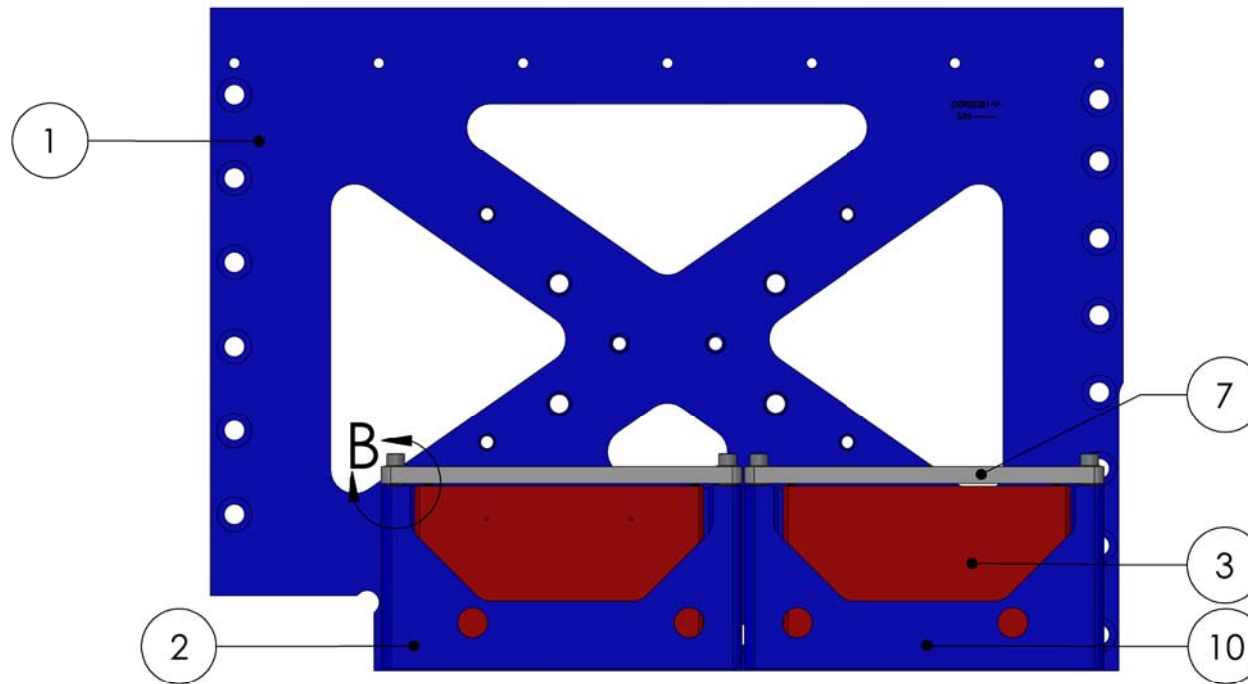
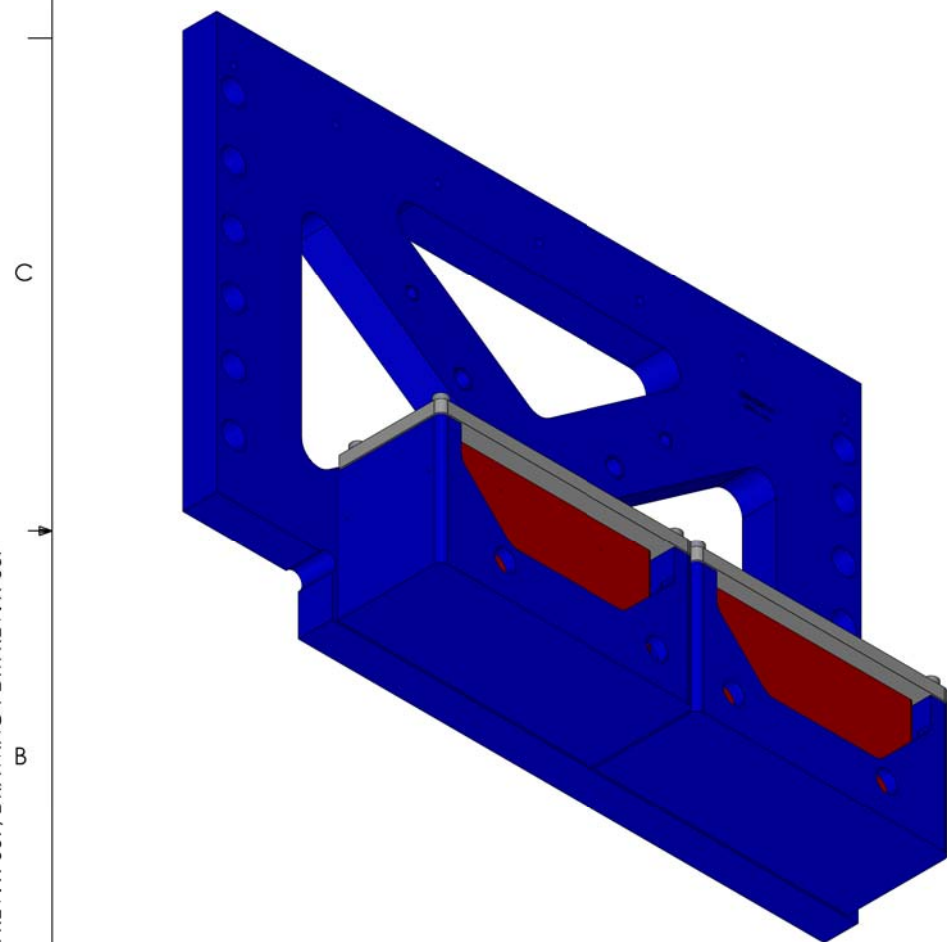


D1001760 - Stage 1 Vibration Absorber (door), PART PDM REV: X-009, DRAWING PDM REV: X-007

NOTES CONTINUED:

5. APPROXIMATE WEIGHT FOR ONE VIBRATION ABSORBER = 15.86 LBS.
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
10. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
V1	12 OCT 2010	E1100092	-
-	-	-	-
-	-	-	-



D1000939		
Type 01	.50"x.50"	.0625" thck
Type 02	.75"x.75"	.0625" thck
Type 03	.50"x.50"	.125" thck
Type 04	.75"x.75"	.125" thck
Type 05	.50"x.50"	.250" thck
Type 06	.75"x.75"	.250" thck

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	TOTAL
11	MSC 48632822	Low Head 3/8"-16, 1" length	304, 316 OR 302 SSSL	8
10	D1001764	Right clamp for Stage 1 Vibration Absorber	6061-T6 Al	1
9	MC MASTER 96861A600	Washer .47 od x .25 id x .02-.04 thk vented	18-8 SSSL	8
8	HOLOKROME_78062	SHCS, 1/4"-20x1.0"	18-8 SS	8
7	D1001757	Top clamp for Stage 1 Vibration Absorber	6061-T6 Al	2
6	MCMaster_93574A505	washer 0.373" od, 0.253" id, 0.003" thck	18-8 SSSL	8
5	MCMaster_93574A513	washer 0.373" od, 0.253" id, 0.02" thck	18-8 SSSL	16
4	D1000939	Viton for SEI vibration absorbers 5 Lb version	FLUROELASTOMER	16
3	D1001758	Mass for Stage 1 Vibration Absorber	304, 316 OR 302 SSSL	2
2	D1001759	Left clamp for Stage 1 Vibration Absorber	6061-T6 Al	1
1	D0902281	Door, Stage 1, aLIGO BSC ISI	6061-T6 Al	1

PARTS LIST

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		PART NAME Stage 1 Vibration Absorber (door)	
MATERIAL N/A		FINISH N/A μinch		SYSTEM ADVANCED LIGO SUB-SYSTEM SEI		DESIGNER S.BISCANS 02 JULY 2010 DRAFTER S.BISCANS 12 OCT 2010 CHECKER F.MATICHARD 12 OCT 2010 APPROVAL K.MASON 12 OCT 2010	
				SIZE DWG. NO. B D1001760 SCALE: 1:4 PROJECTION:		REV. v1 SHEET 1 OF 1	