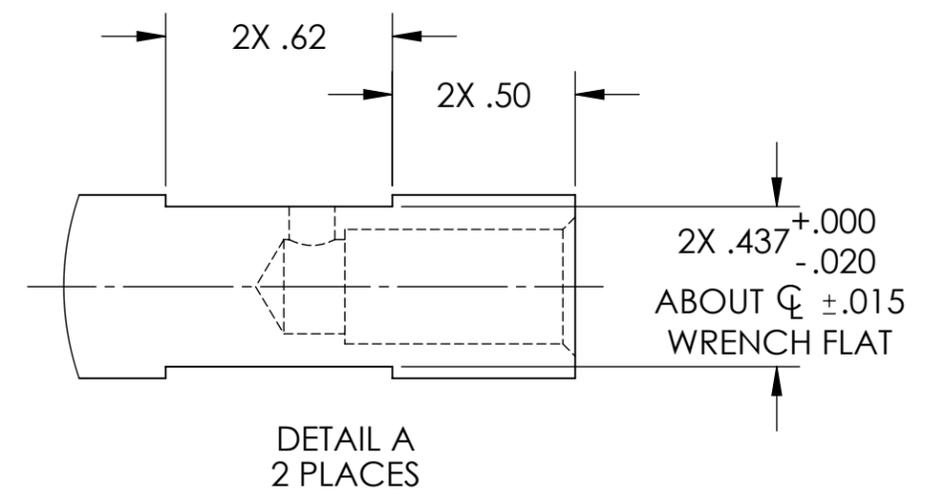
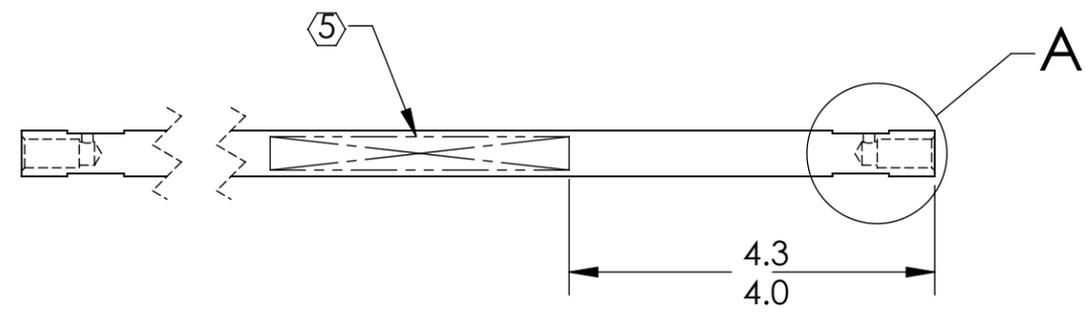
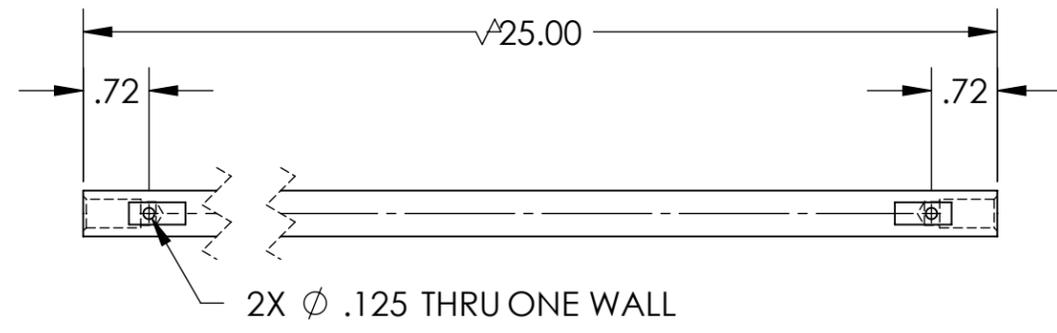
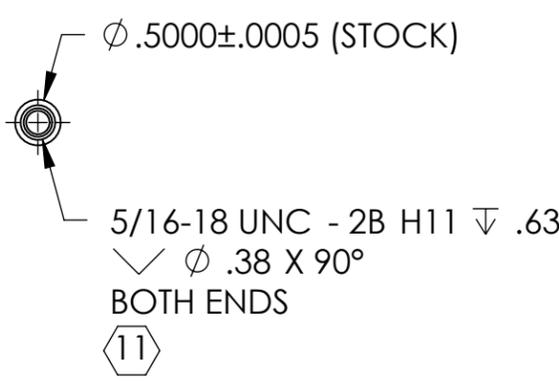
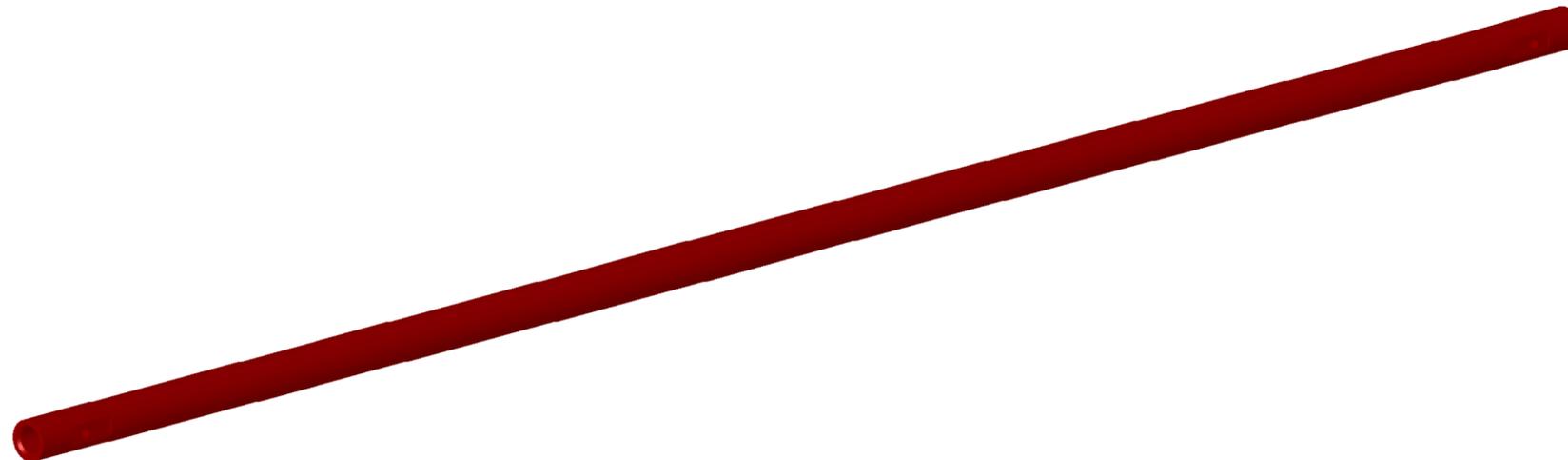


D1001941_qlIGO EARTHQUAKE STOP ROD, PART PDM REV: X-026, DRAWING PDM REV: X-024

- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 - 6. APPROXIMATE WEIGHT = 1.38 LB [.63 KG].
 - 7. MACHINE ENDS AND ALL ADDED FEATURES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION 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 (COIR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
 - 10. MATERIAL: MAKE FROM MCMMASTER-CARR P/N 8934K16 (OR EQUIV)
Ø .5000" X 6' GROUND ROD, TYPE 304 STAINLESS STEEL.
 - 11. TAPPED HOLES- USE .005 OVERSIZE BOTH DRILL & TAP.
 - 12. 63 µINCH Ra FINISH APPLIES ONLY TO MACHINED FACES, EXCLUDING THREADS & DRILL HOLES.
 - 13. ELECTRO-POLISH MACHINED PART PER LIGO SPECIFICATION E0900364, SECTION 5.2.2.

REV.	DATE	DCN #	DRAWING TREE #
v1	21 MAR 2011	E1000384-v1	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± °

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.

MATERIAL: 10
 FINISH: 63 µinch Ra 12 13

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	K. MAILAND	24 JUL 2010	SIZE DWG. NO.
DRAFTER	M. MILLER	21 MAR 2011	B
CHECKER			D1001941
APPROVAL			REV. v1
NEXT ASSY		SCALE: NONE PROJECTION:	
D1001781		SHEET 1 OF 1	

8 7 6 5 4 3 2 1

D C B A

D C B A

8 7 6 5 4 3 2 1