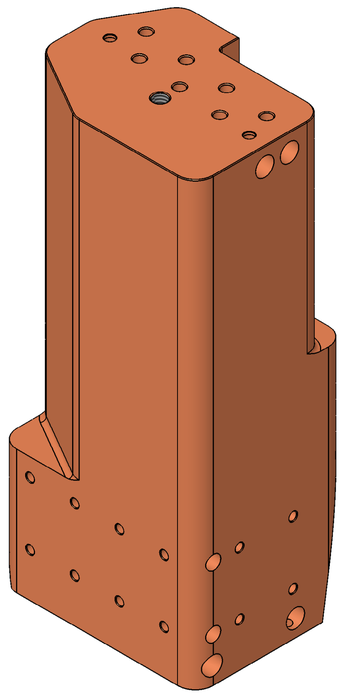
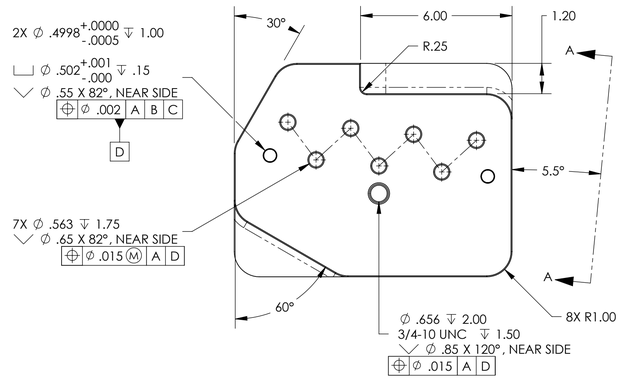
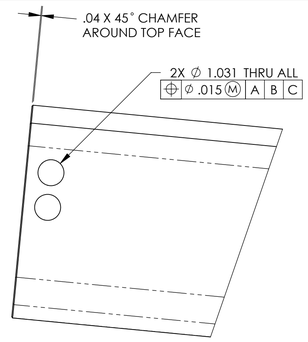
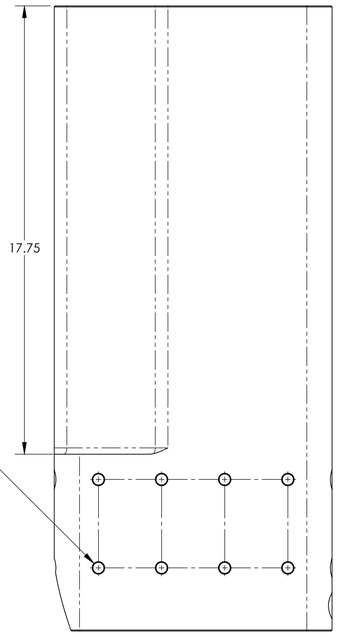
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	21 Jun 2007	1065	Daniel Bryce	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers around interface surfaces. Changed cable-clamp hole details. Changed vent groove details. Added lead-ins to press-fit pin holes. Added/modified c'sinks.

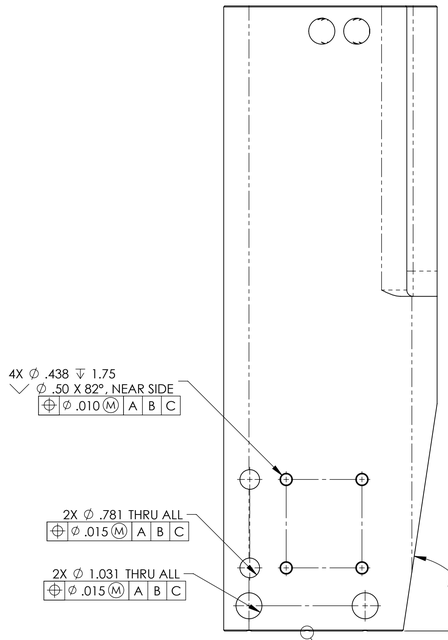


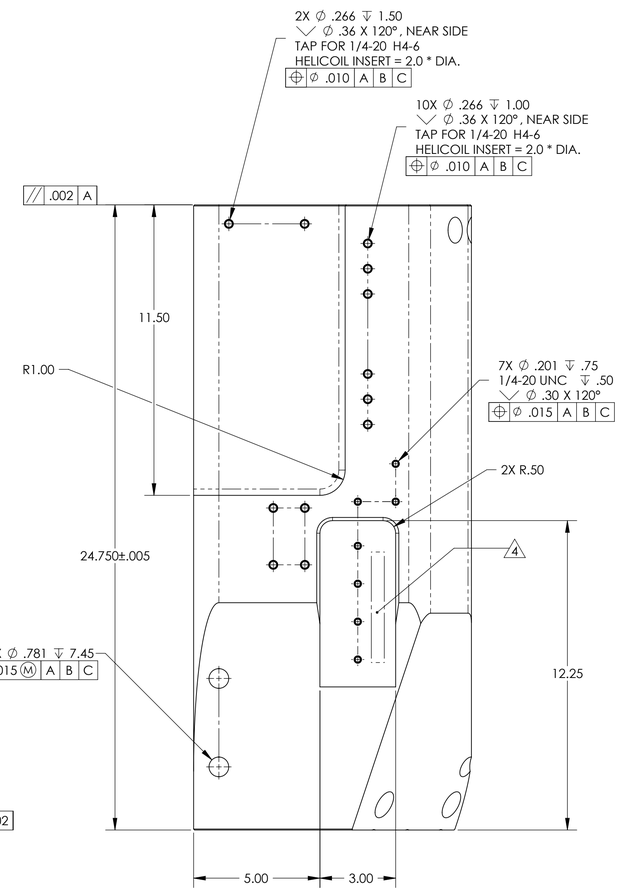


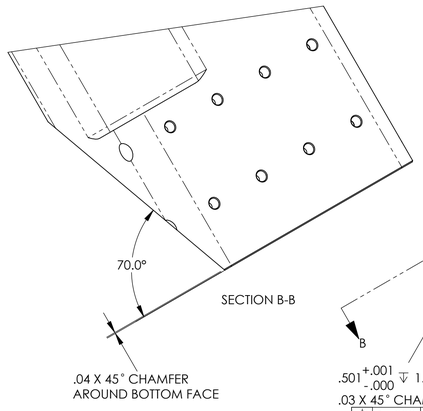


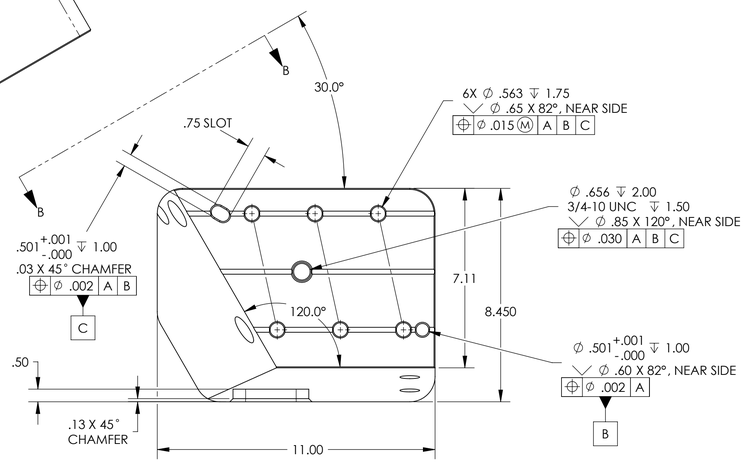
SECTION A-A

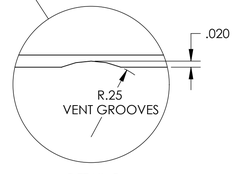












DETAIL C
SCALE 4 : 1
3 PLACES

MACHINING NOTES:

1) MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES (OTHER THAN DRESSED BLANCHARD GRINDING) ARE NOT ACCEPTABLE.

2) ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.

3) THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.

4) WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE THE FOLLOWING INFORMATION AS SHOWN BELOW: **PART NUMBER-REVISION** (AND **TYPE** IF INDICATED), FOLLOWED ON THE NEXT LINE WITH A UNIQUE 3-DIGIT **SERIAL NUMBER** STARTING AT 001 FOR THE FIRST PART AND INCREMENTING THEREAFTER. USE 0.38" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.

D071002-V2
S/N - ###

5) DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.

POST-MACHINING NOTES:

P1) CLEAN TO LIGO STANDARDS, CLASS A.

P2) INSTALL CLASS-A CLEAN HELI-COILS. BREAK OFF AND REMOVE TANGS. CHECK THAT END OF EACH INSERT REMAINS ENGAGED IN THREAD AFTER TANG REMOVAL.

HELI-COIL TABLE
(See Note 5)

Item No.	Thread Size	Material	Heli-Coil P/N 1185...	Qty.
1	1/4"-20 x .50"	Nitronic 60	-4EN500	12

APPROVALS	DATE
ENGINEERING (MFD): D. Bryce	5/22/07
QUALITY (MFD): C. Danaher	5/22/07
MATERIAL: **6061-T6 Al**	
FINISH: **None**	
MASS: **180 lbs**	

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
.XX ±.015 .XXX ±.005
ANG TOL: ± 1° SURFACE ROUGHNESS: 63
REMOVE ALL SHARP EDGES, LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.
THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS IN THE MODEL ARE BASIC, WITH TOLERANCES GIVEN BY: .010 A B C

ORIGINAL DESIGN BY: **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
MODIFIED BY: LIGO

DESCRIPTION: **Support Post**
P/N: **D071002** CONFIG: **-**
CAD FILE NAME: D071002_Support_Post
PROJECT: HAM ISI, Advanced LIGO
SIZE **D** SCALE: **1:3** DRAWN BY: **Dan Bryce (HPD)** SHEET **1** OF **1** DATE PRINTED: **3/13/2009** REV **V2**

Model: #D071002 Rev: V2
Dwg: #D071002 Rev: X-007