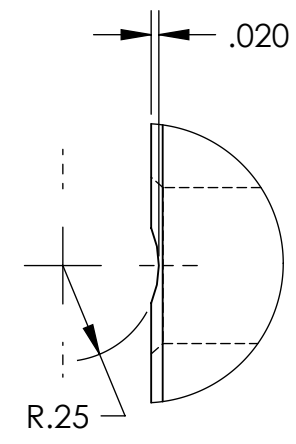
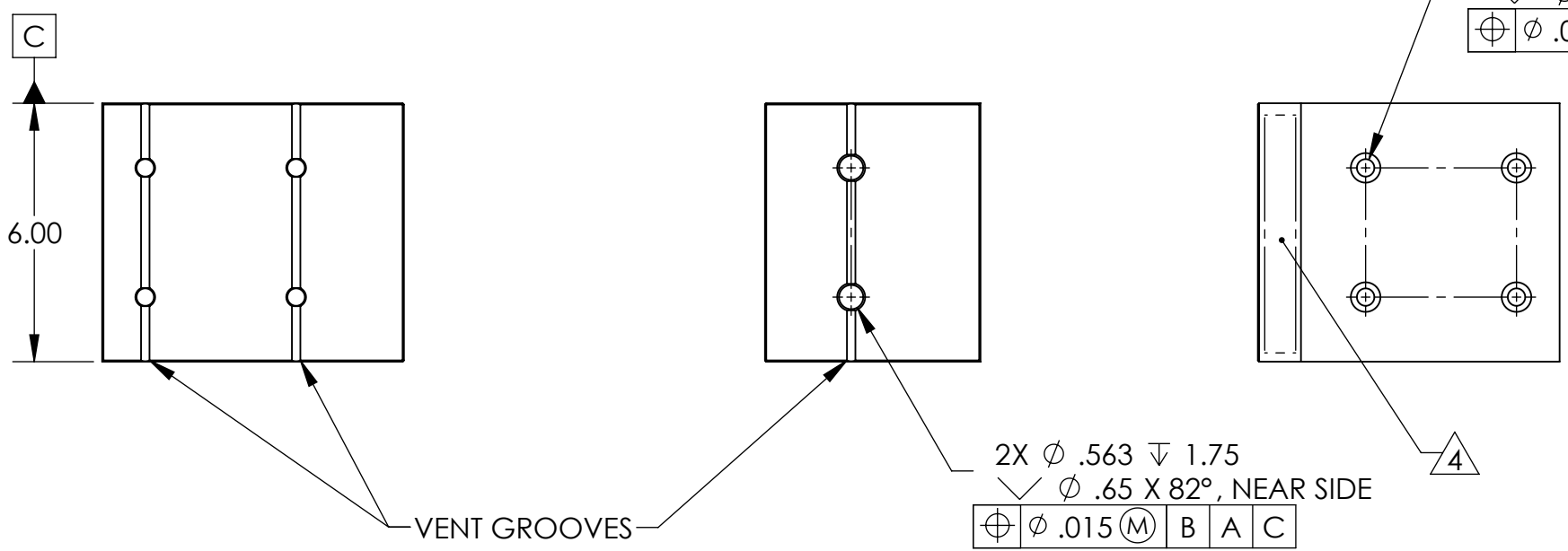
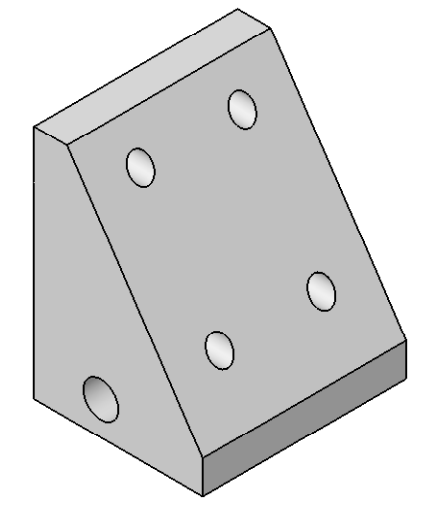
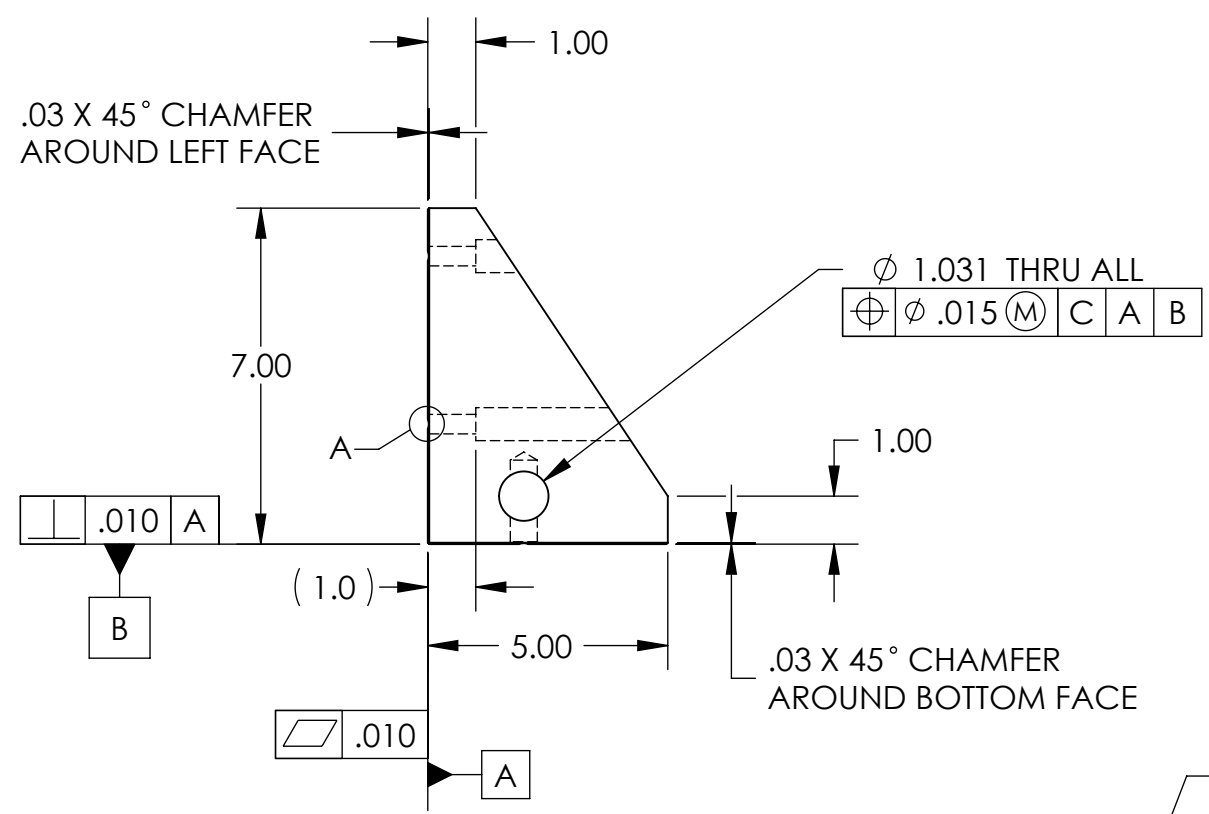


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	21 Jun 2007	1065	Daniel Bryce	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers to faces. Changed vent groove details. Added c'sinks.



DETAIL A
SCALE 2 : 1
VENT GROOVES
3 PLACES



4X ϕ .406 THRU ALL
 \square ϕ .688 ∇ 4.00
 \sphericalangle ϕ .46 X 82°, FAR SIDE
 \oplus ϕ .005 (M) A B C

2X ϕ .563 ∇ 1.75
 \sphericalangle ϕ .65 X 82°, NEAR SIDE
 \oplus ϕ .015 (M) B A C

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.

D071004-V2
S/N - ###

POST-MACHINING NOTES:

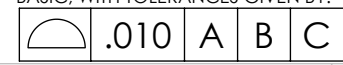
- P1) CLEAN TO LIGO STANDARDS, CLASS A.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
 DECIMAL TOLERANCES:
 .XX \pm .015 .XXX \pm .005
 ANG TOL: \pm 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:



APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/22/2007
QUALITY (HPD): C. Danaher	5/22/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	12.6 lbs

ORIGINAL DESIGN BY:		High Precision Devices		MODIFIED BY:
		1668 Valtec Lane, Suite C, Boulder, Colorado 80301		LIGO
		Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		
DESCRIPTION: Support Post Gusset, Aux				
P/N: D071004		CONFIG: -		
CAD FILE NAME: D071004_Support_Post_Gusset-Aux				
PROJECT: HAM ISI, Advanced LIGO				
SIZE	SCALE: 1:4	DRAWN BY: Dan Bryce (HPD)	REV	
B	SHEET 1 OF 1	DATE PRINTED: 3/13/2009	V2	