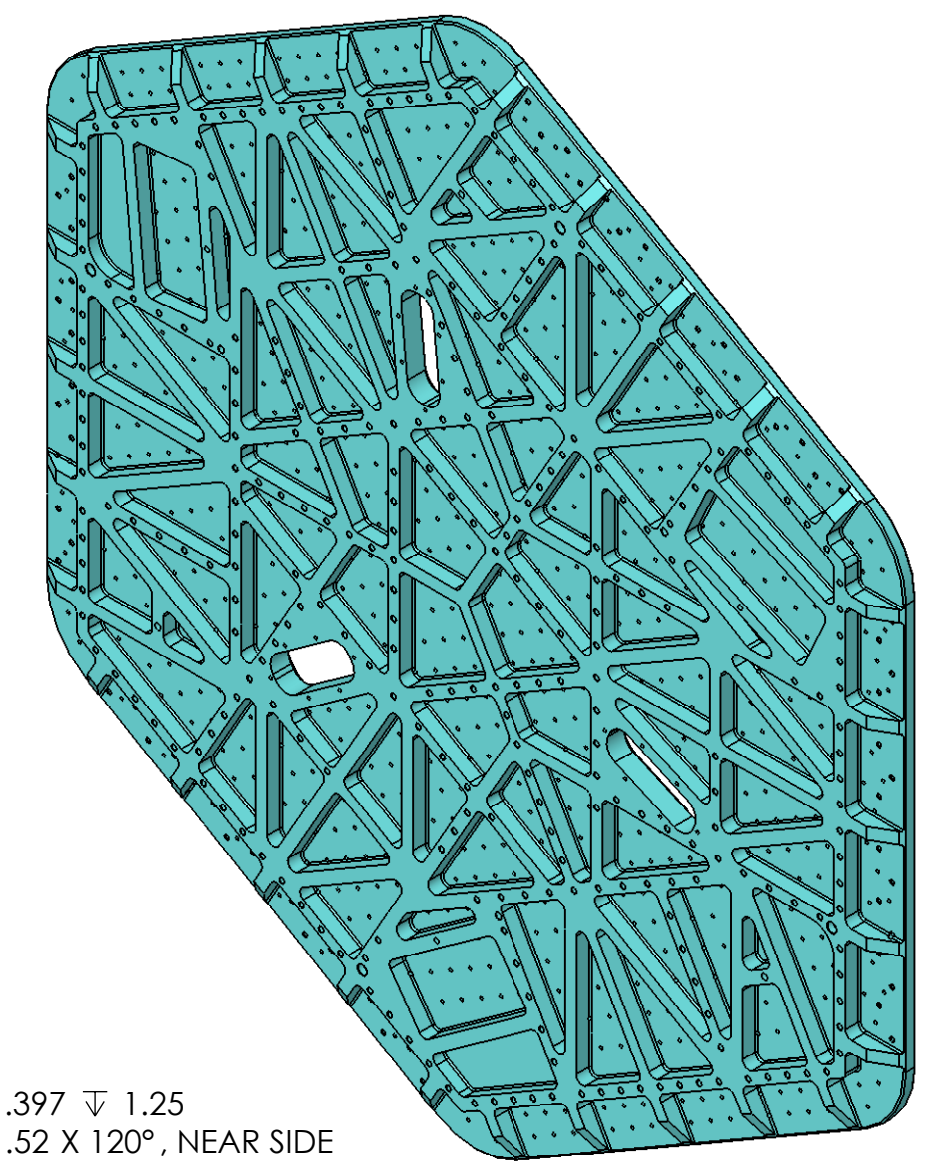
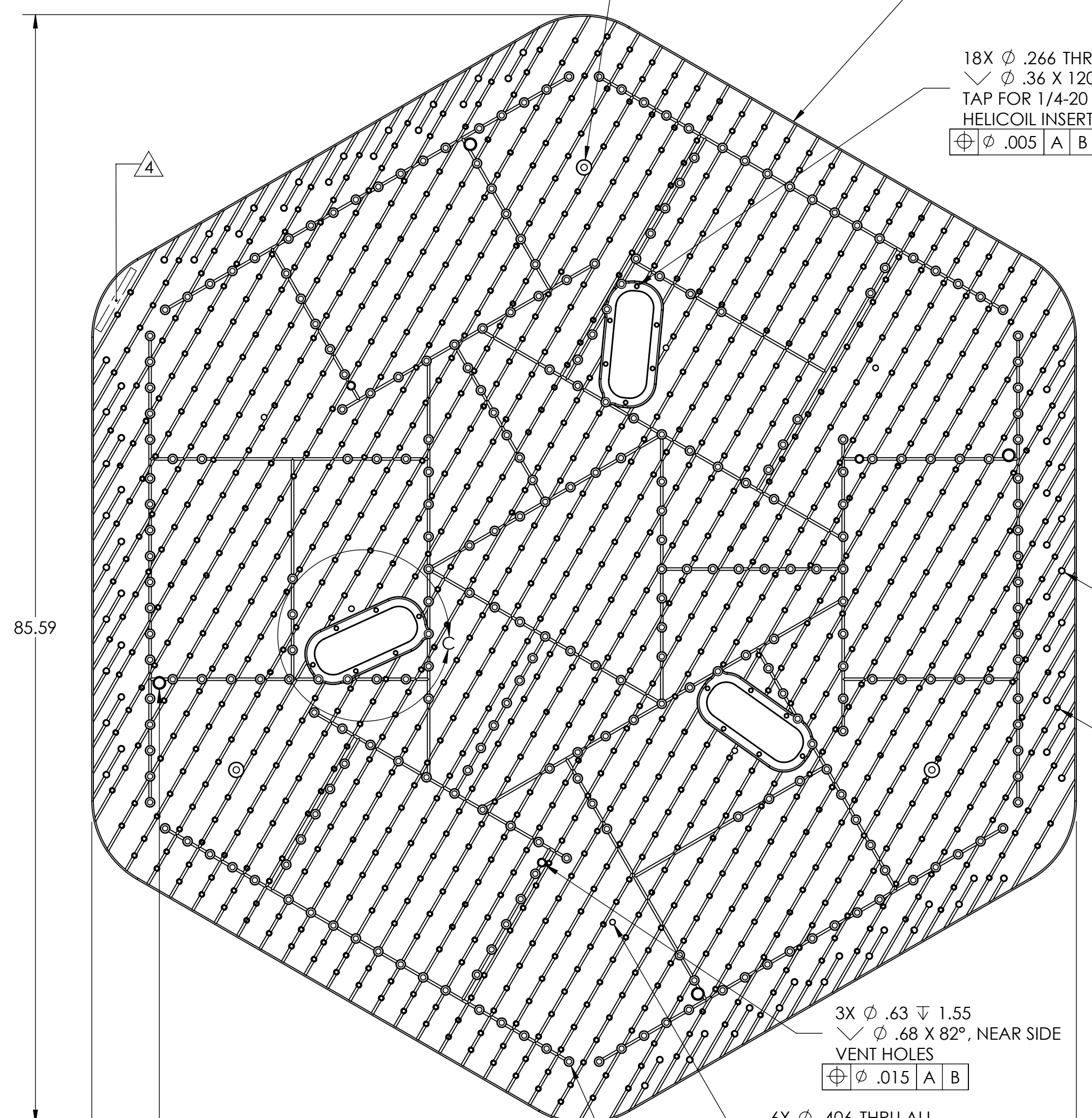
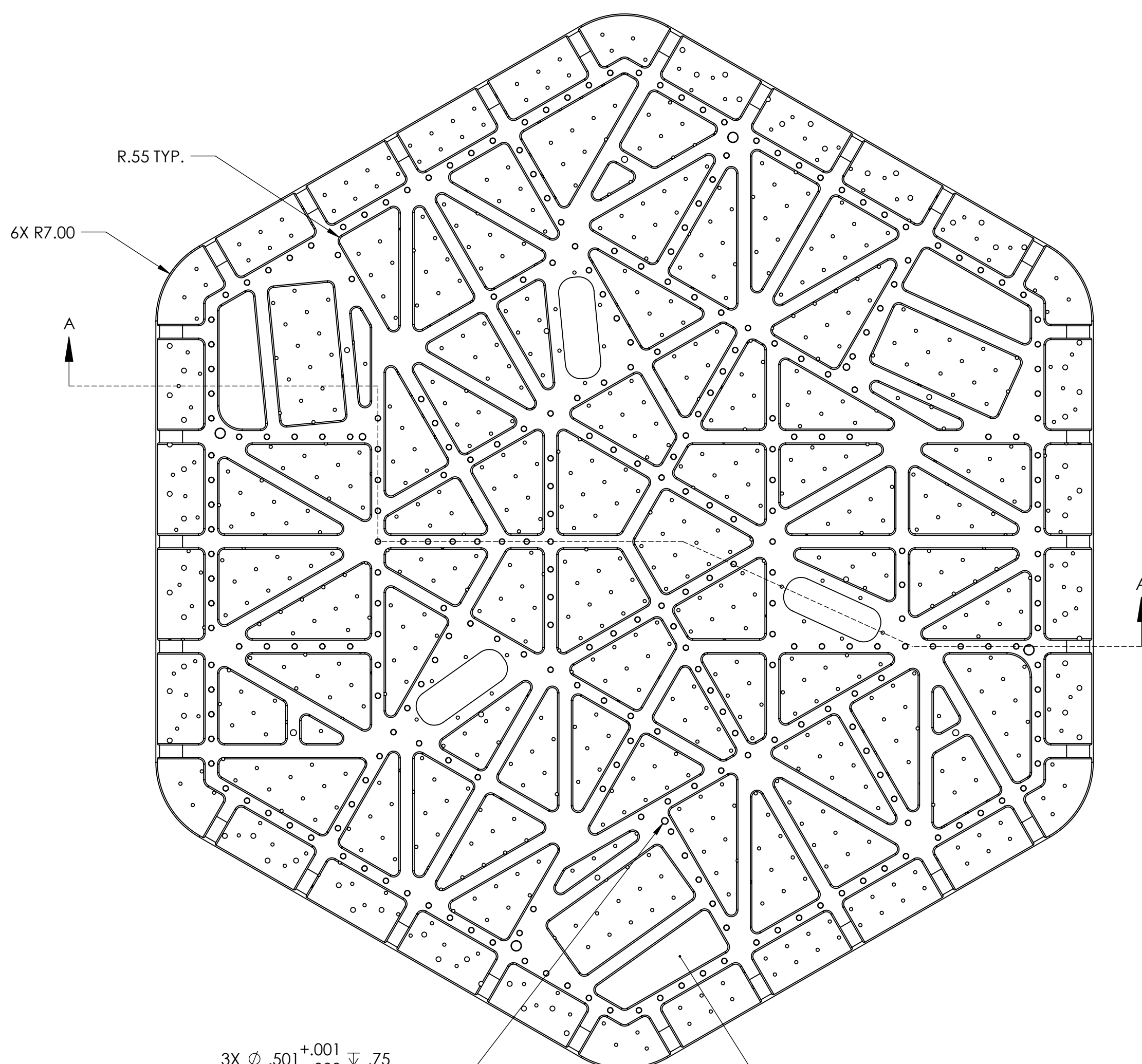
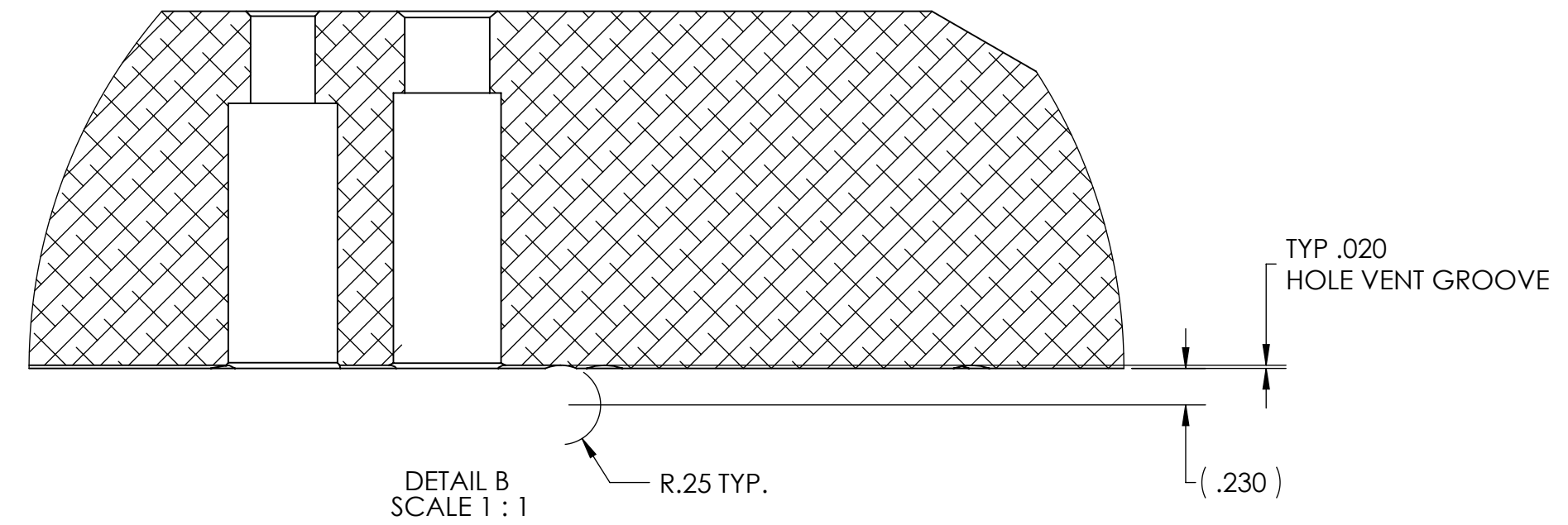
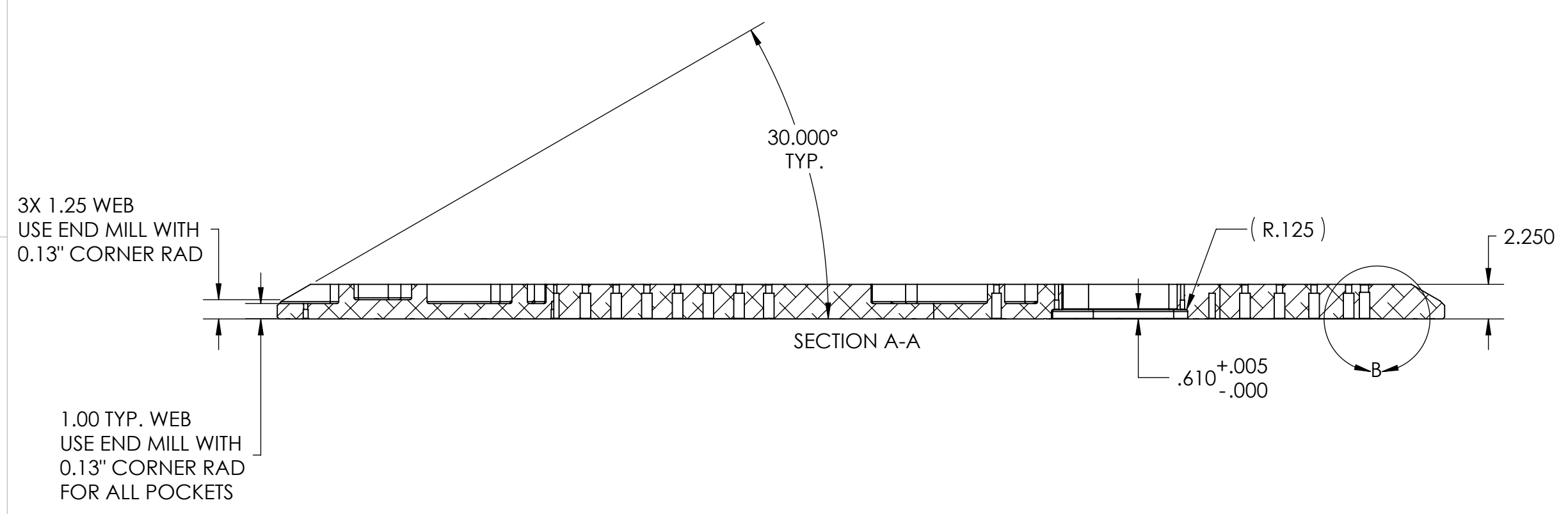
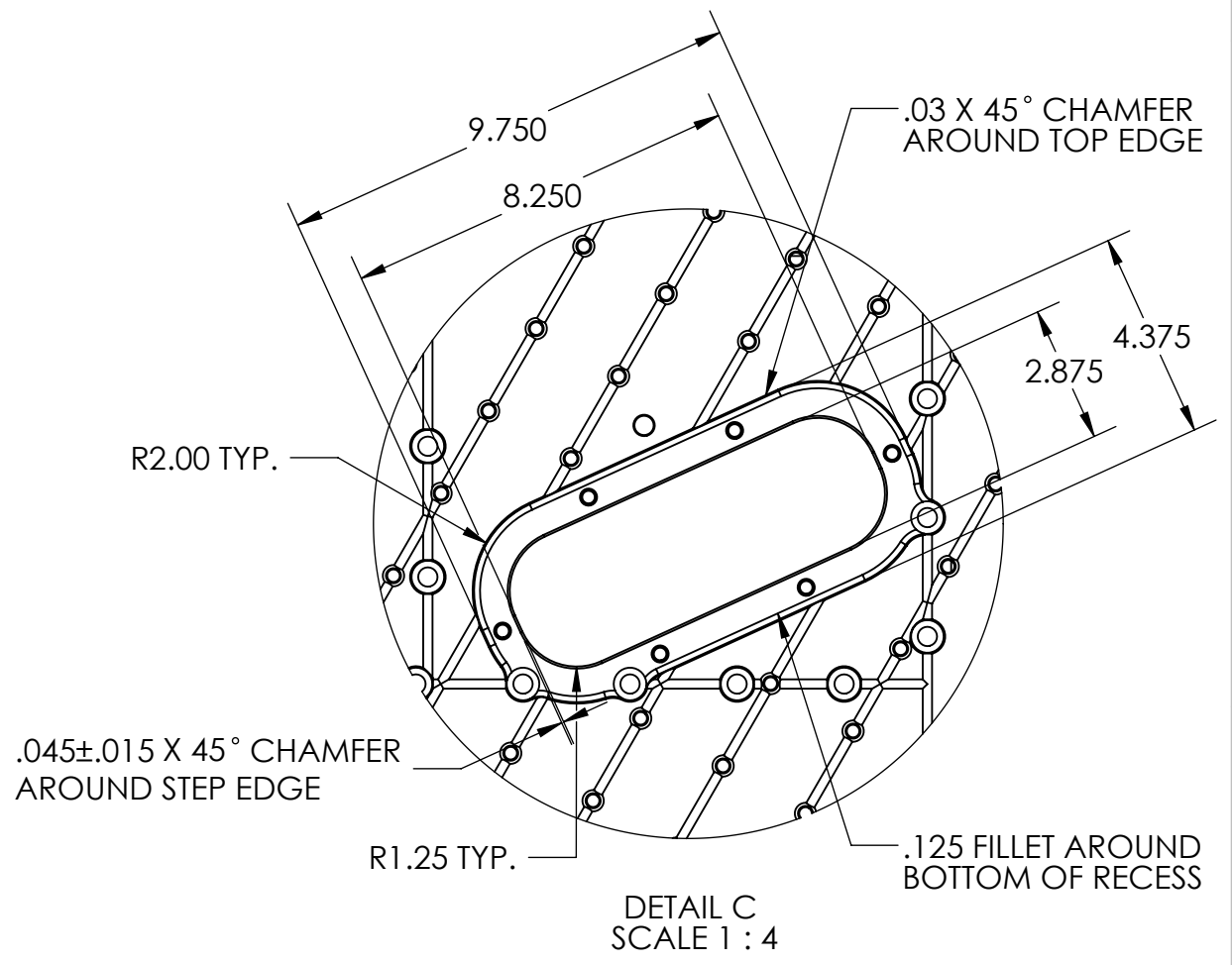


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	5/22/07	1060	Daniel Bryce	Manufacturing Release
C	6/07/07	1063	Daniel Bryce	Loosened Tols on 1/4-20 holes
D	6/15/07	1064	Daniel Bryce	Minor Changes, Added View
E	6/19/07	1065	Daniel Bryce	Fix Broken Dim's/Tols, Per Redline
V1 / F	8/16/07	1071	Dave Sanders	Changed c'sinks, added c'sinks, chamfer to Detail C
V2	3/6/2009		Andy Stein	Added 2 rows of 1/4"-20 Heli-Coils and 4 pairs of rows of 3/8"-16 Heli-Coils. Reduced vent groove depth, Changed c'sink details.



68X ϕ .397 \mp 1.25 ϕ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 H4-6 HELICOIL INSERT = 2.0 * DIA. ϕ .015 A B

1085X ϕ .266 \mp 1.13 ϕ .45 X 120°, NEAR SIDE TAP FOR 1/4-20 H4-6 HELICOIL INSERT = 2.0 * DIA. ϕ .015 A B



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 0.36" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.

D071050-V2
5/N - ###

POST-MACHINING NOTES:

- P1) CLEAN ACCORDING TO LIGO-E0810022.
- 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	QTY.
1	1/4"-20 x .50"	NITRONIC 60	-4EN500	1103
2	3/8"-16 x .75"	NITRONIC 60	-6EN750	68
3	3/4"-10 x 1.50"	STAINLESS STEEL	-12CN1500	4

APPROVALS	DATE
D. Bryce	5/22/07
C. Danaher	5/22/07

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
XX \pm .015 XXX \pm .005
ANG TOL: \pm 1° SURFACE ROUGHNESS: \sqrt{Ra}
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: D. Bryce, C. Danaher
DATE: 5/22/07, 5/22/07
MATERIAL: 6061-16 Al
FINISH: None
MASS: 637 lbs

ORIGINAL DESIGN BY: **High Precision Devices**
1668 Valtrec Lane, Suite C, Boulder, Colorado 80301
Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

DESCRIPTION: **Optical Table**
P/N: **D071050** CONFIG: -
CAD FILE NAME: D071050_Optical_Table
PROJECT: HAM ISI, Advanced LIGO
SCALE: 1:8 DRAWN BY: **Dan Bryce (HPD)**
SHEET 1 OF 1 DATE PRINTED: 3/6/2009