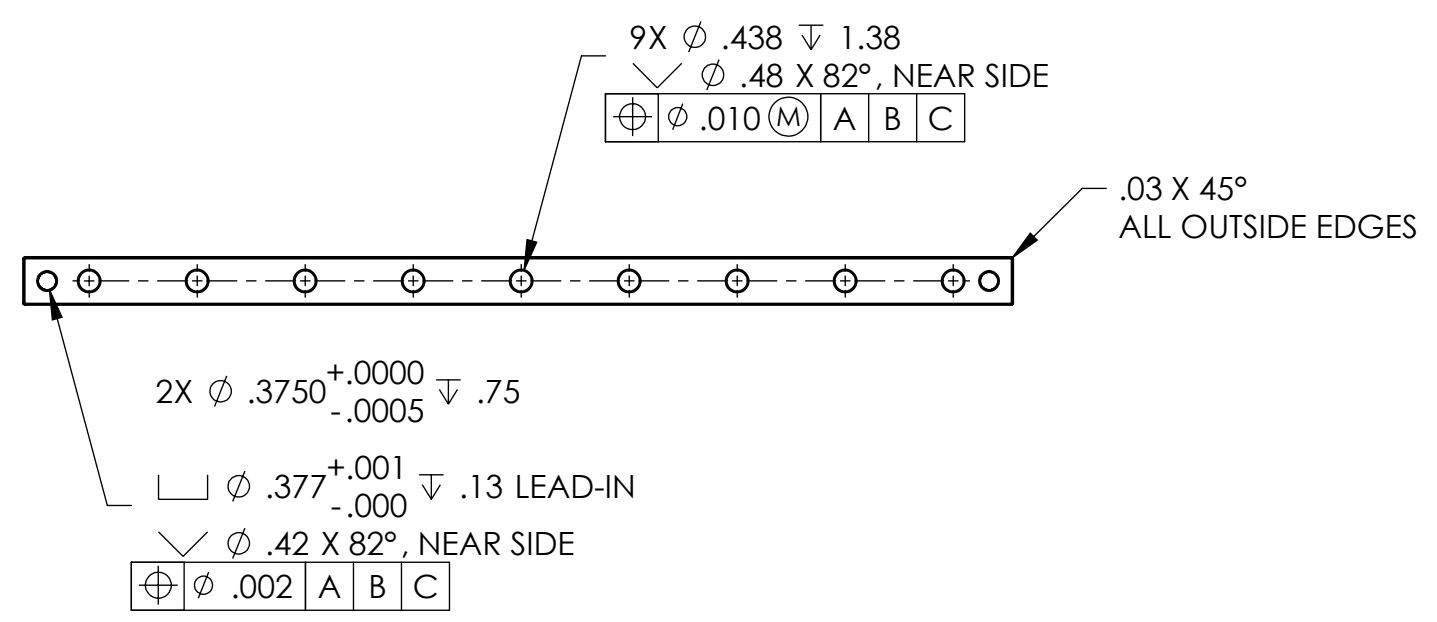
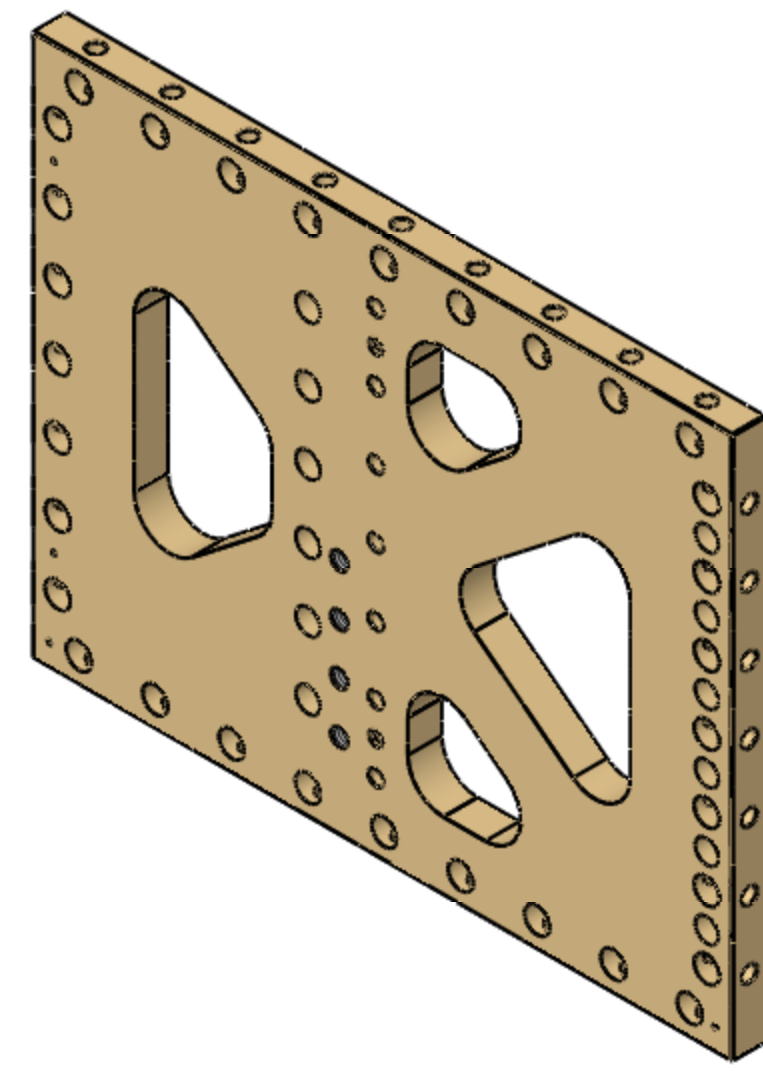
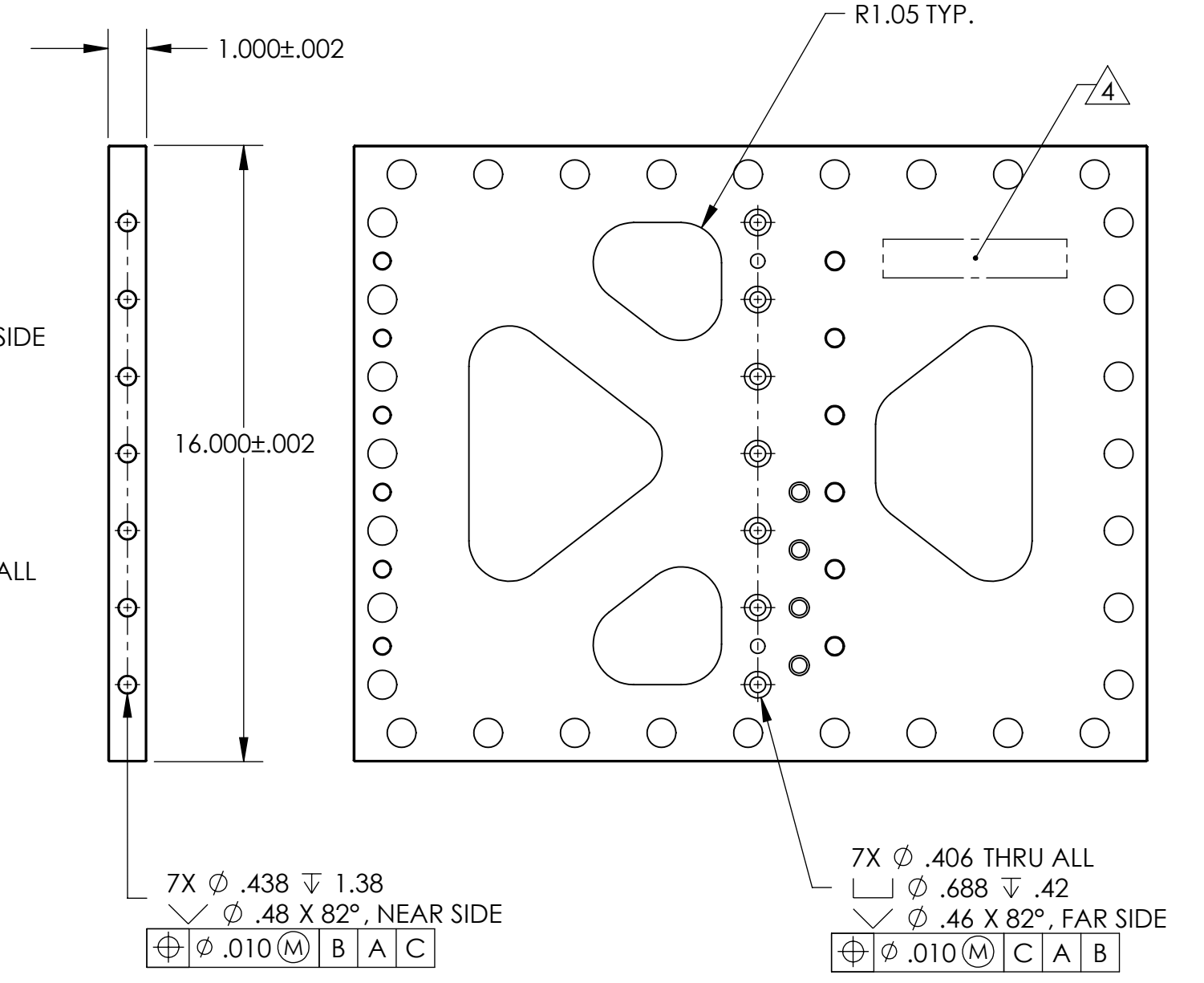
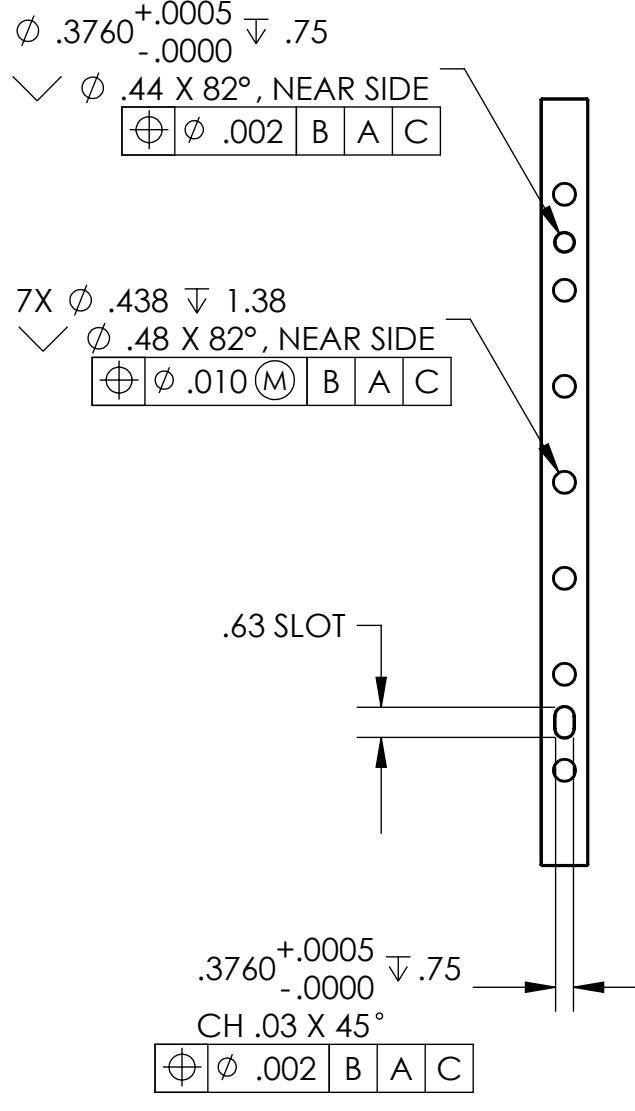
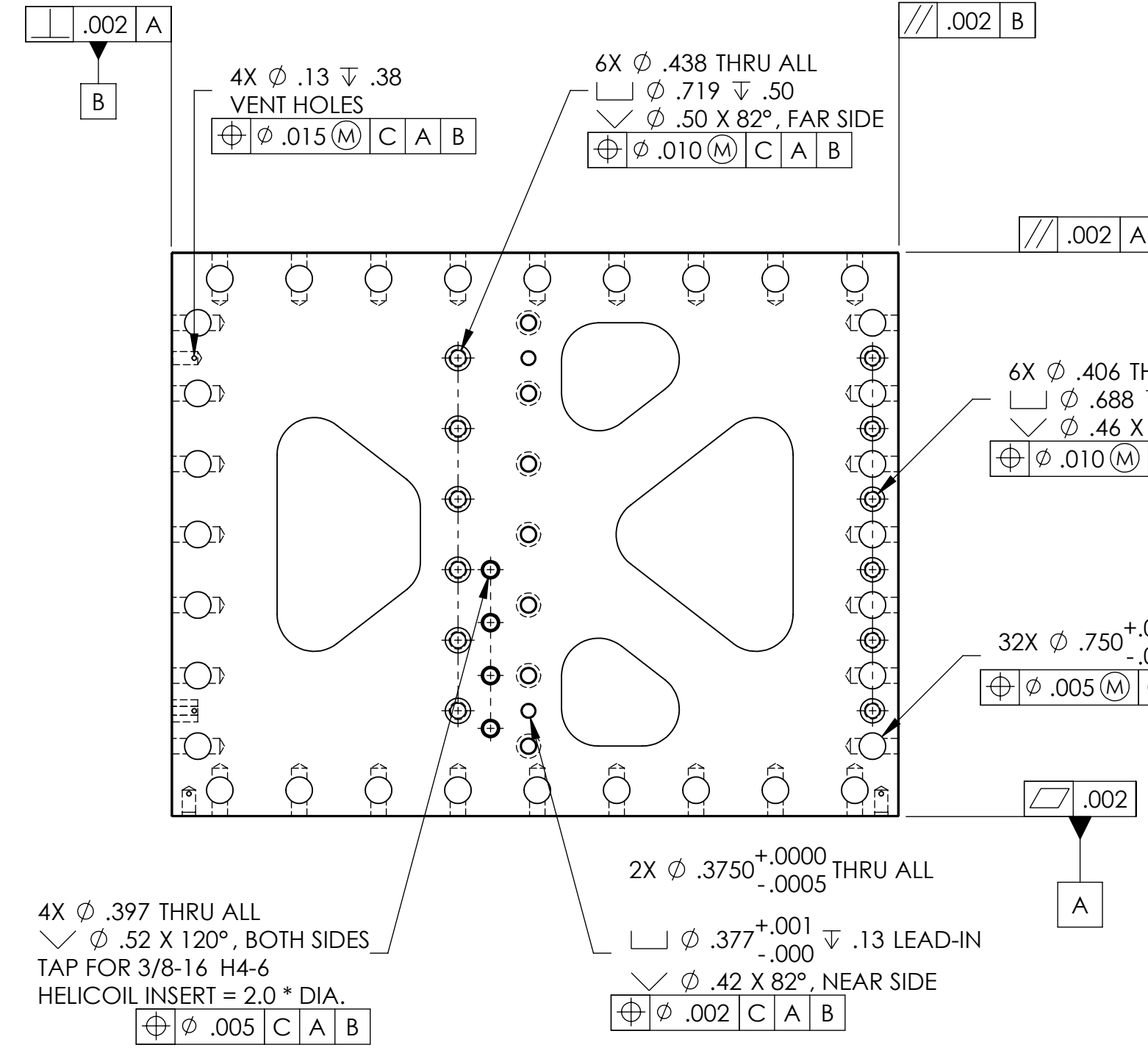
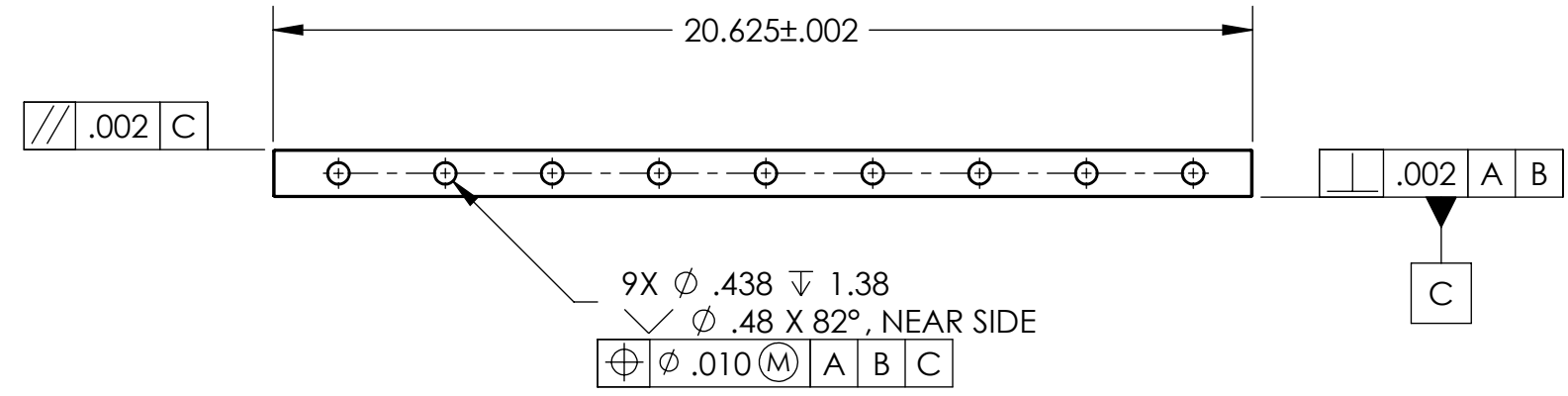


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	27 Jun 2007	1066	D. Senders	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers around outer faces. Added/modified c'sinks. Modified c'bores. Added lead-ins to press-fit pin holes.



- 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.
D071069-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	3/8"-16 x .75"	Nitronic 60	-6EN750	4

APPROVALS	DATE
ENGINEERING (HPD): D. Senders	5/22/2007
QUALITY (HPD): C. Danaher	5/22/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	24.1 lbs

UNLESS OTHERWISE SPECIFIED:			
DIMENSIONS ARE IN INCHES			
DECIMAL TOLERANCES:			
.XX	±.015	.XXX	±.005
ANG TOL: ± 1° SURFACE ROUGHNESS: .43			
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:		MODIFIED BY:	
High Precision Devices		LIGO	
1468 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com			
DESCRIPTION: Rib, Rad, Flexure Out 2		P/N: D071069	
CAD FILE NAME: D071069_Rib-Rad-Flexure_Out_2		PROJECT: HAM ISI, Advanced LIGO	
SIZE: C	SCALE: 1:4	DRAWN BY: Dave Senders (HPD)	REV: V2
SHEET 1 OF 1	DATE PRINTED: 3/17/2009		