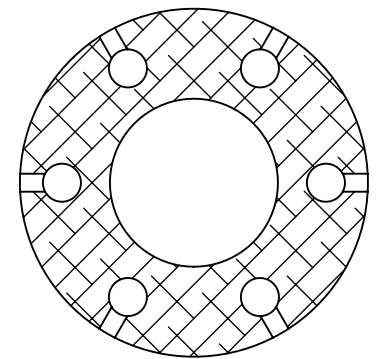
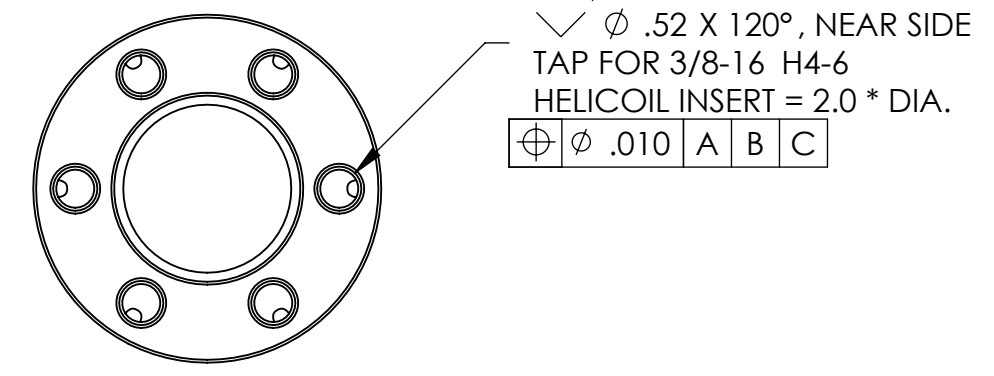
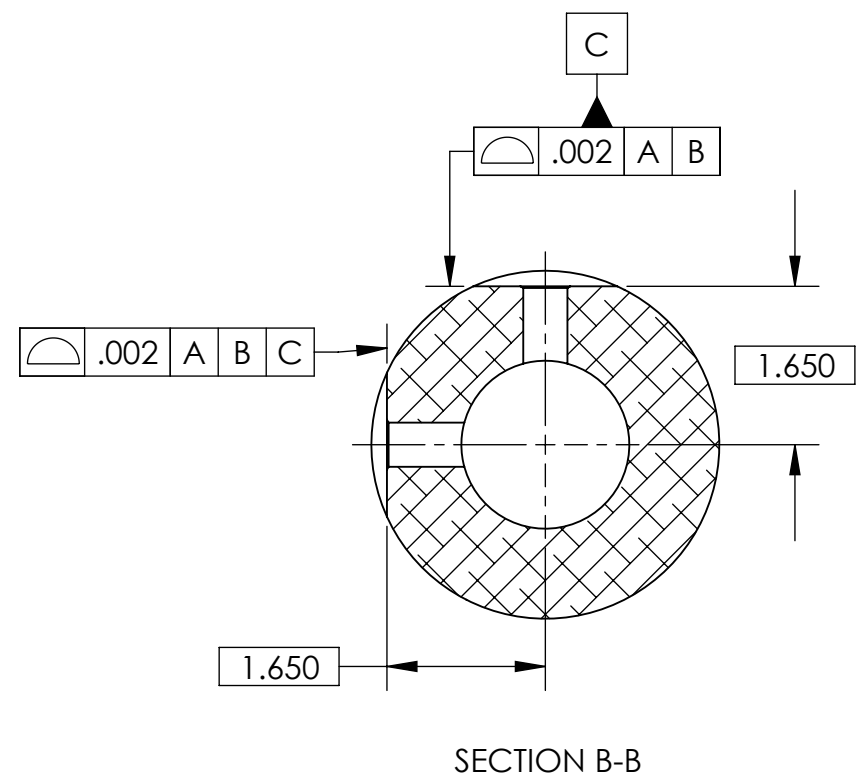
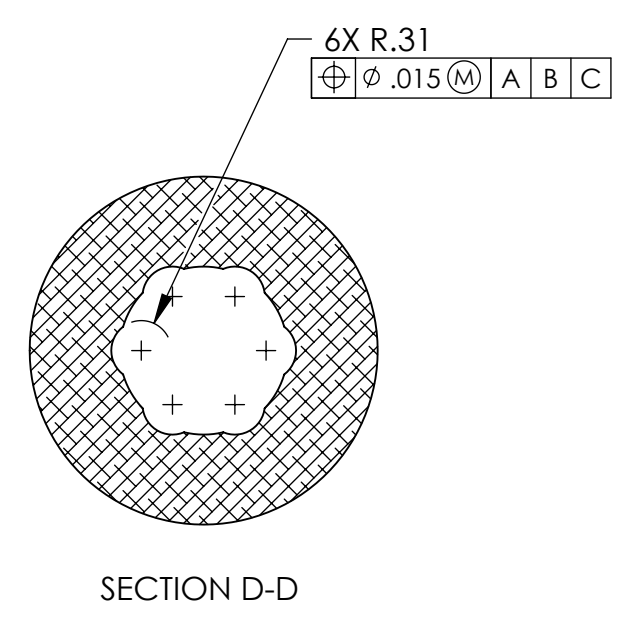
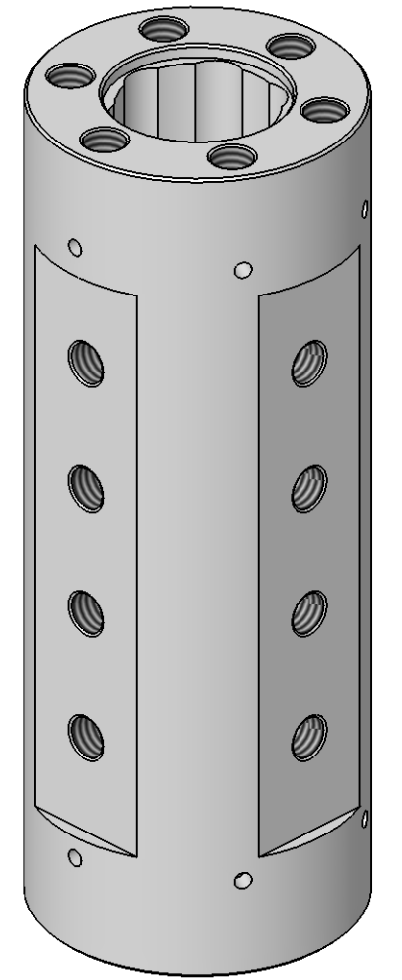
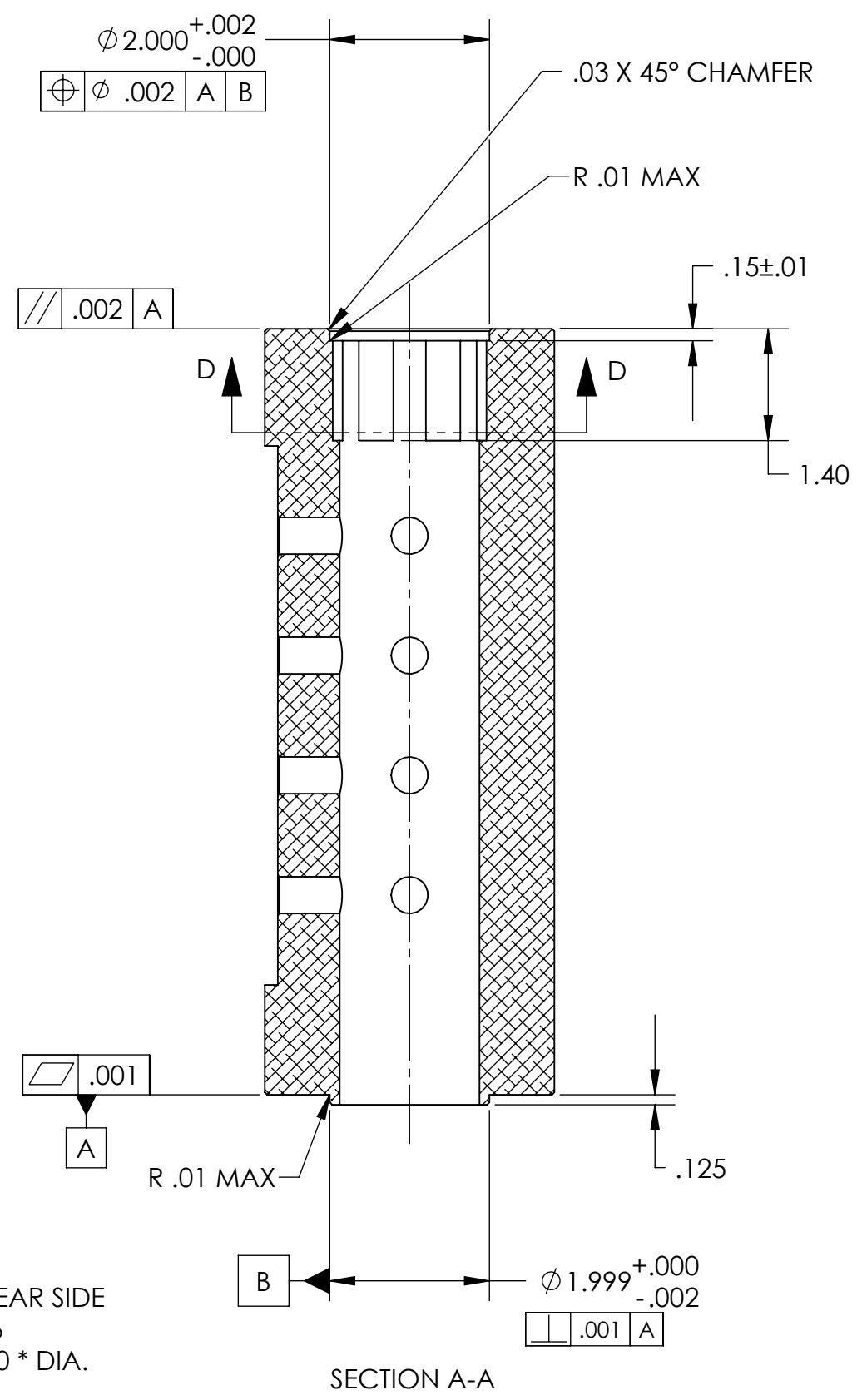
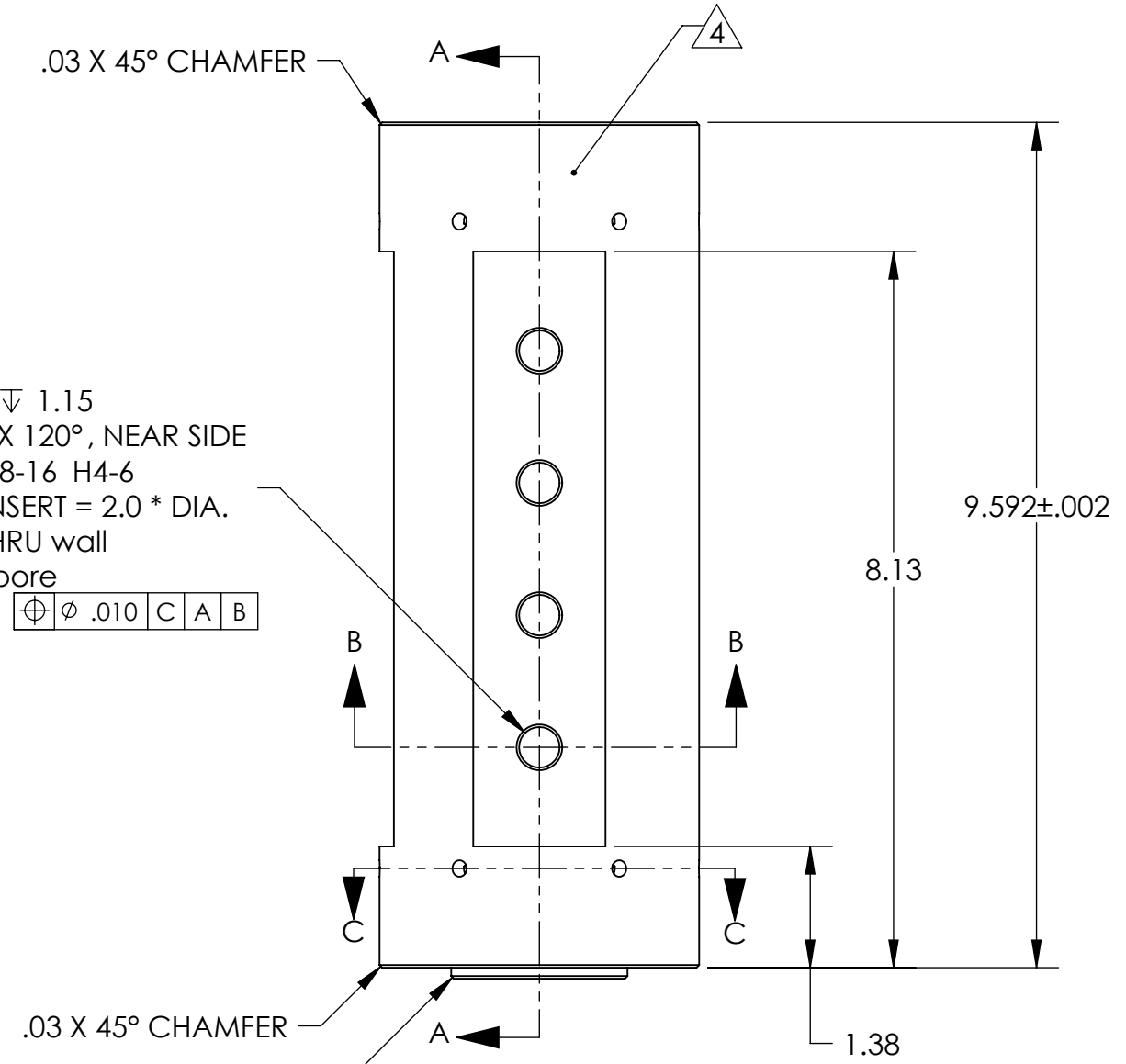
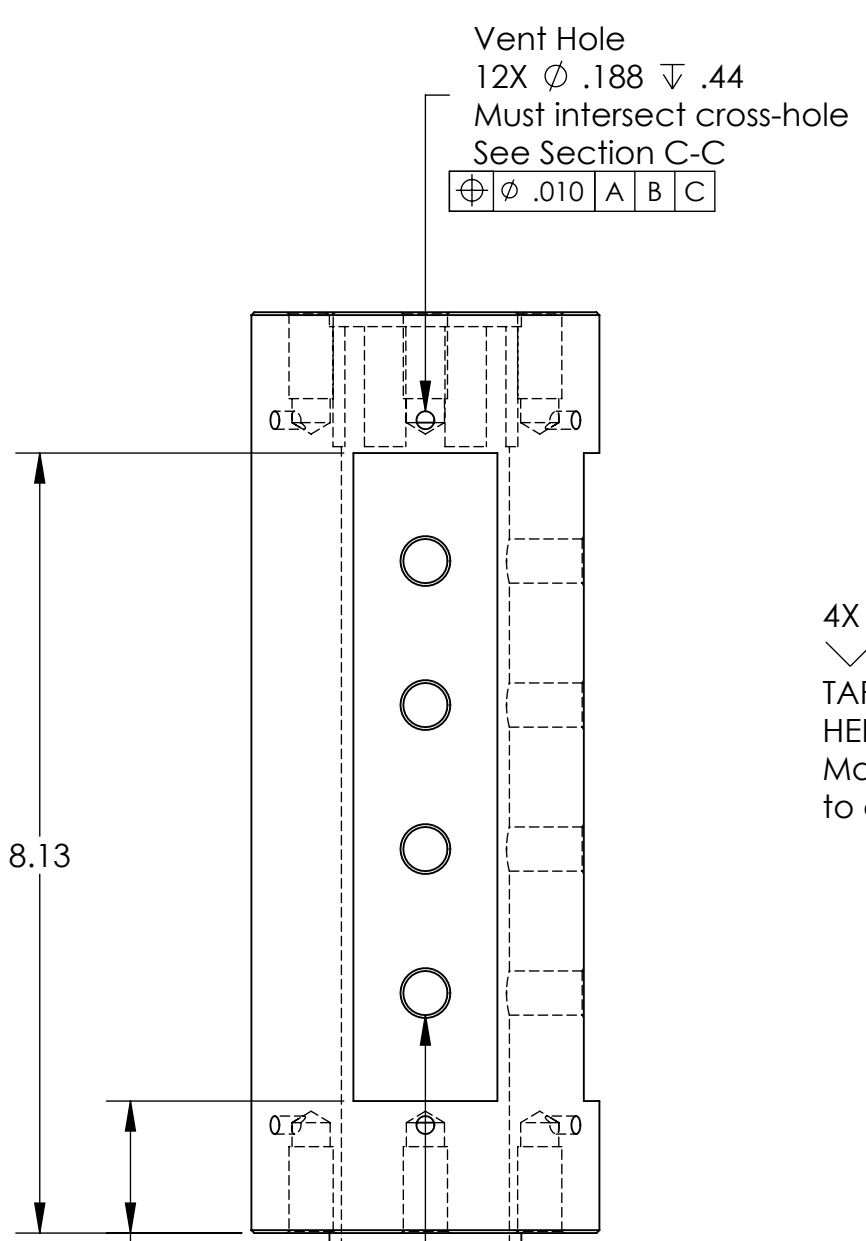
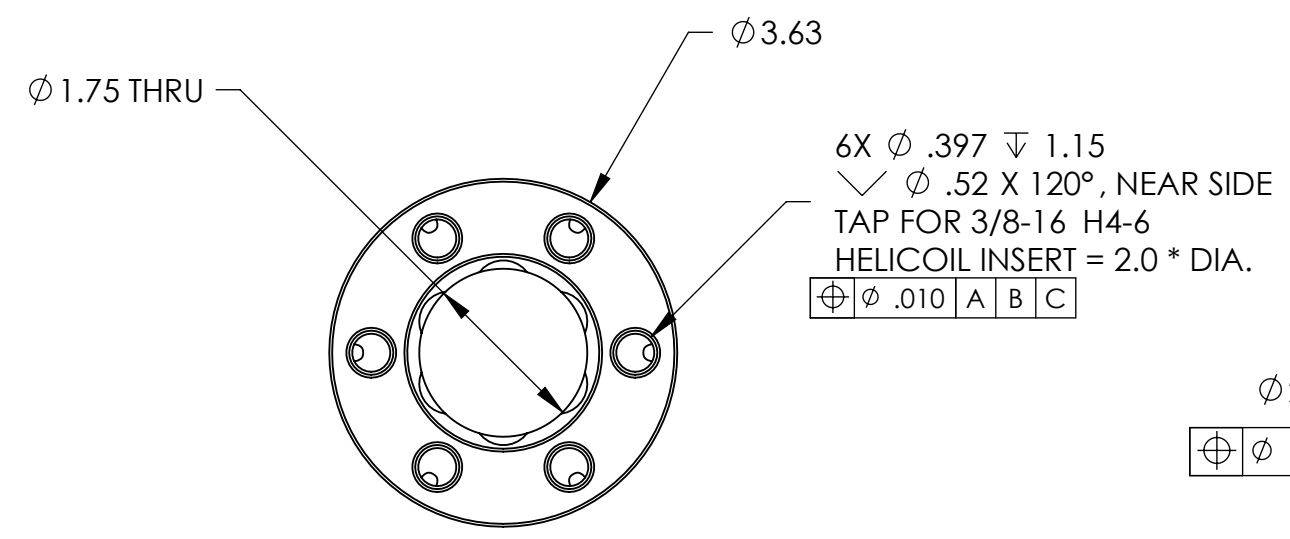


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	8 Aug 2007	1071	D.Senders	Release for Enhanced LIGO.
V1	30 Mar 2009		A. Stein	Release for Advanced LIGO. Added 6x pockets to bore for hardware clearance. Small changes to chamfer and c/sink dims.



- 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.
- D071074-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.

SECTION C-C
Vent Hole Detail

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	20

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX ±.015 .XXX ±.005 ANG TOL: ± 1° SURFACE ROUGHNESS: 6.3		ORIGINAL DESIGN BY: High Precision Devices 1448 Valtrec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	MODIFIED BY:
APPROVALS ENGINEERING (HPD): D. Senders 6/1/2007 QUALITY (HPD): C. Danaher 6/1/2007	DATE 6/1/2007	DESCRIPTION: Flexure Post	P/N: D071074 CONFIG: -
MATERIAL: 6061-T6 Al FINISH: None MASS: 6.8 lbs	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: 	CAD FILE NAME: D071074_Flexure_Post PROJECT: HAM ISI, Advanced LIGO	SIZE: C SCALE: 1:2 SHEET 1 OF 1
DRAWN BY: Dave Senders (HPD) DATE PRINTED: 3/30/2009		REV: V2	