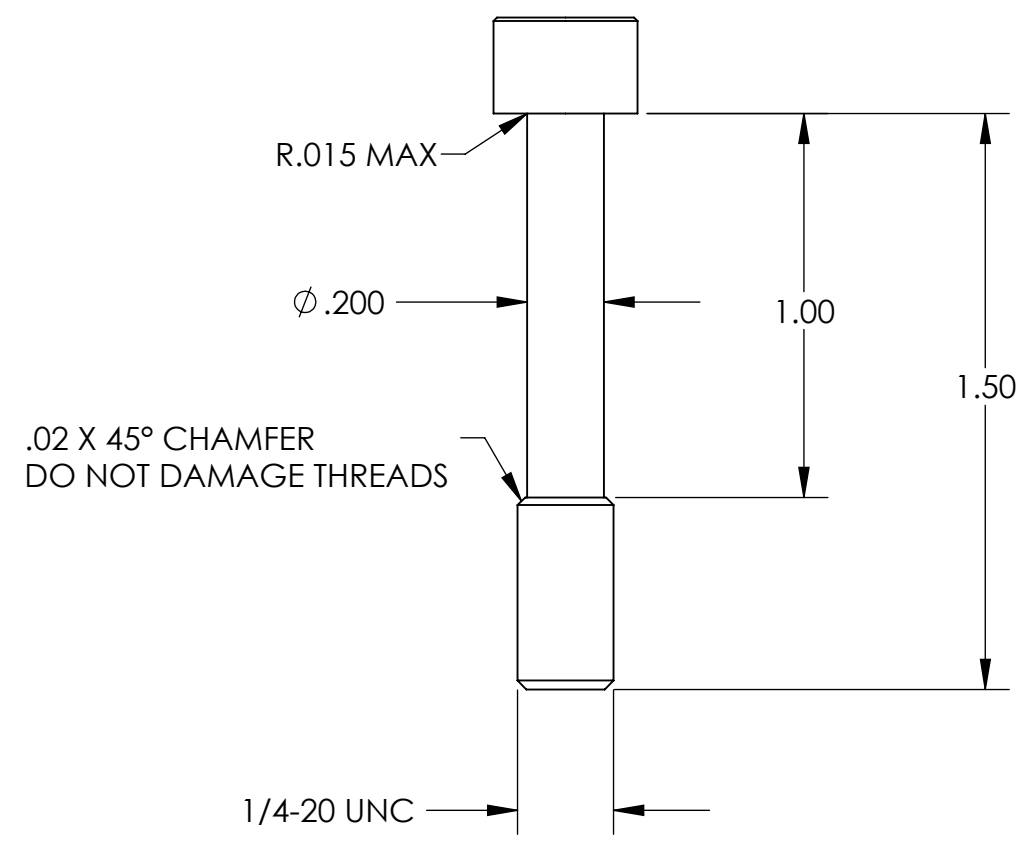
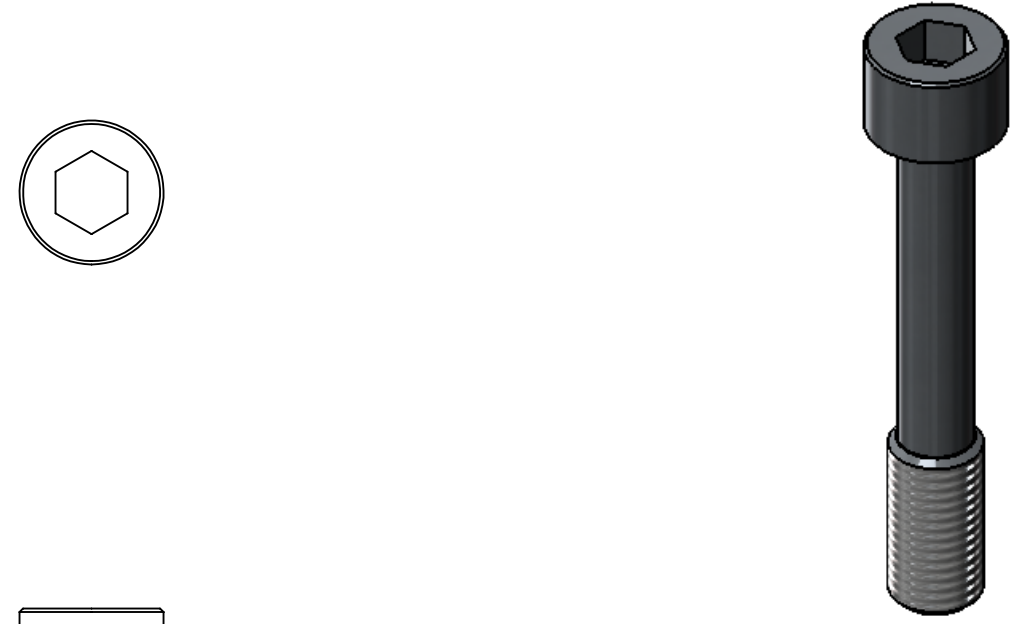


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / B	15 Oct 2007	1072	D. Senders	Release for Enhanced LIGO.
V2	16 Apr 2009		A. Stein	Release for Advanced LIGO. Changes to Notes, only.



MANUFACTURING NOTES:

- 1) MAKE FROM **McMASTER-CARR P/N 92196A546**.
- 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.

POST-MANUFACTURING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

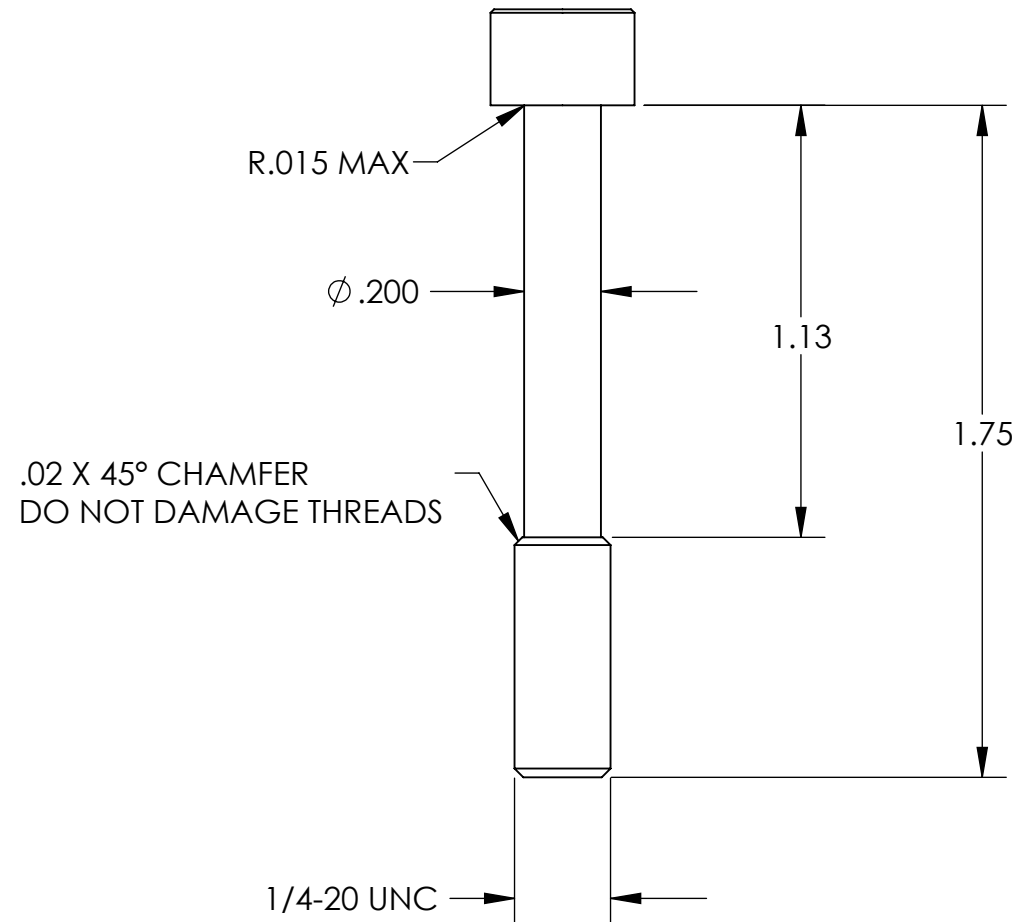
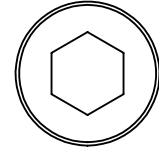
LIGO Type 00

APPROVALS		DATE	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX ±.015 .XXX ±.005 ANG TOL: ± 1° SURFACE ROUGHNESS: 63	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:
ENGINEERING (HPD): B. Schiffner		7/18/2007		DESCRIPTION: SHCS, Custom Captive		P/N: D071136 CONFIG: 1/4"-20x1.5" (1.0" CLEAR)
QUALITY (HPD): C. Danaher		7/18/2007	REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.		CAD FILE NAME: D071136_SHCS-Custom_Captive	
MATERIAL:		18-8 SS		PROJECT: HAM ISI, Advanced LIGO		SIZE: B
FINISH:		None		THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD.		SCALE: 2:1 DRAWN BY: Senders/Schiffner (HPD) REV: V2
MASS:		0.023 lbs		SHEET 1 OF 2 DATE PRINTED: 4/16/2009		

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



MANUFACTURING NOTES:

- 1) MAKE FROM **McMASTER-CARR P/N 92196A548**.
- 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.

POST-MANUFACTURING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

LIGO Type 01

APPROVALS	DATE
ENGINEERING (HPD): B. Schiffner	7/18/2007
QUALITY (HPD): C. Danaher	7/18/2007
MATERIAL:	18-8 SS
FINISH:	None
MASS:	0.026 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.

ORIGINAL DESIGN BY:		MODIFIED 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			
DESCRIPTION: SHCS, Custom Captive			
P/N:	D071136	CONFIG:	1/4"-20x1.75" (1.125" CLEAR)
CAD FILE NAME: D071136_SHCS-Custom_Captive			
PROJECT: HAM ISI, Advanced LIGO			
SIZE	SCALE: 2:1	DRAWN BY: Senders/Schiffner (HPD)	REV
B	SHEET 2 OF 2	DATE PRINTED: 4/16/2009	V2

8 7 6 5 4 3 2 1