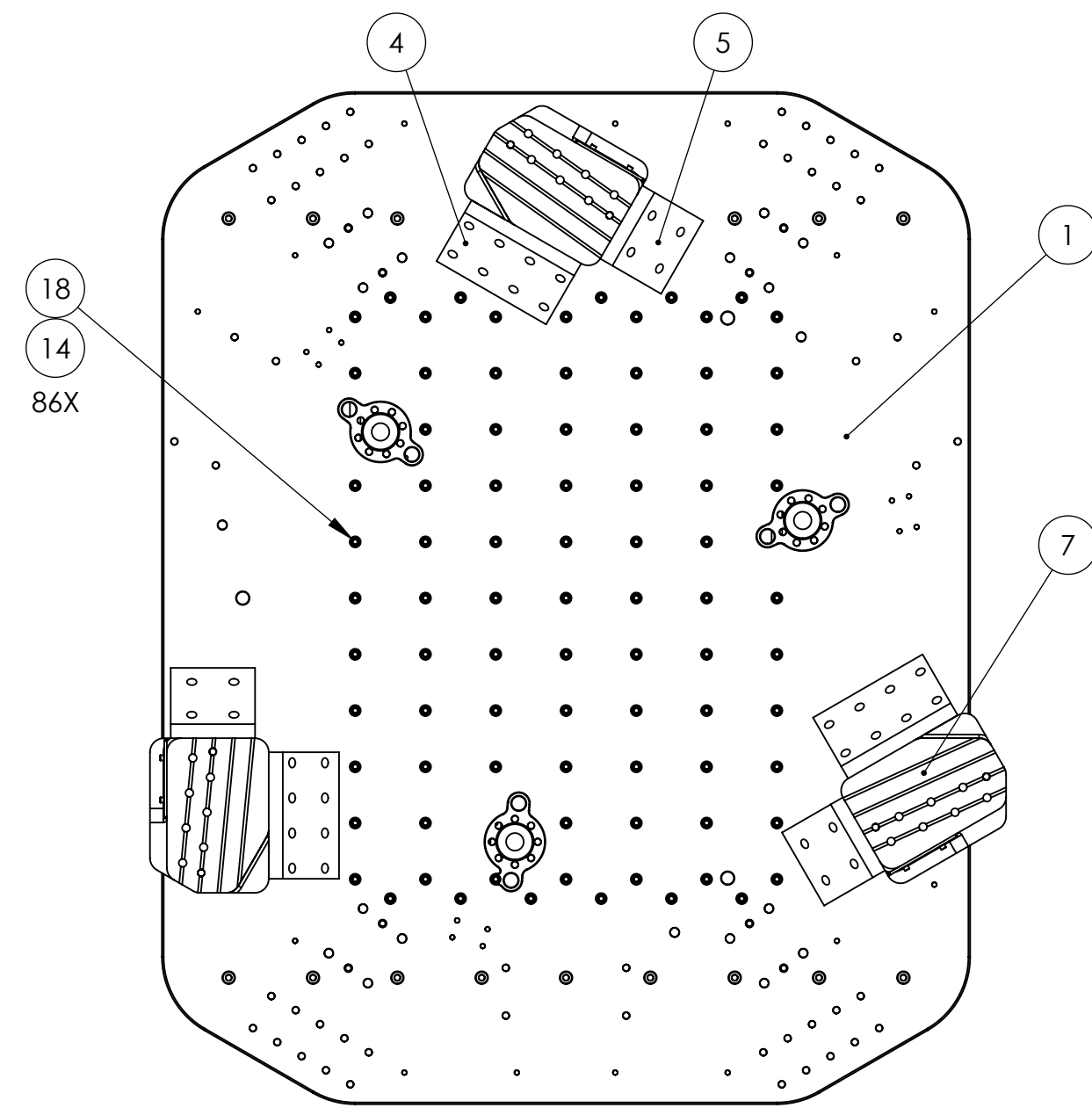
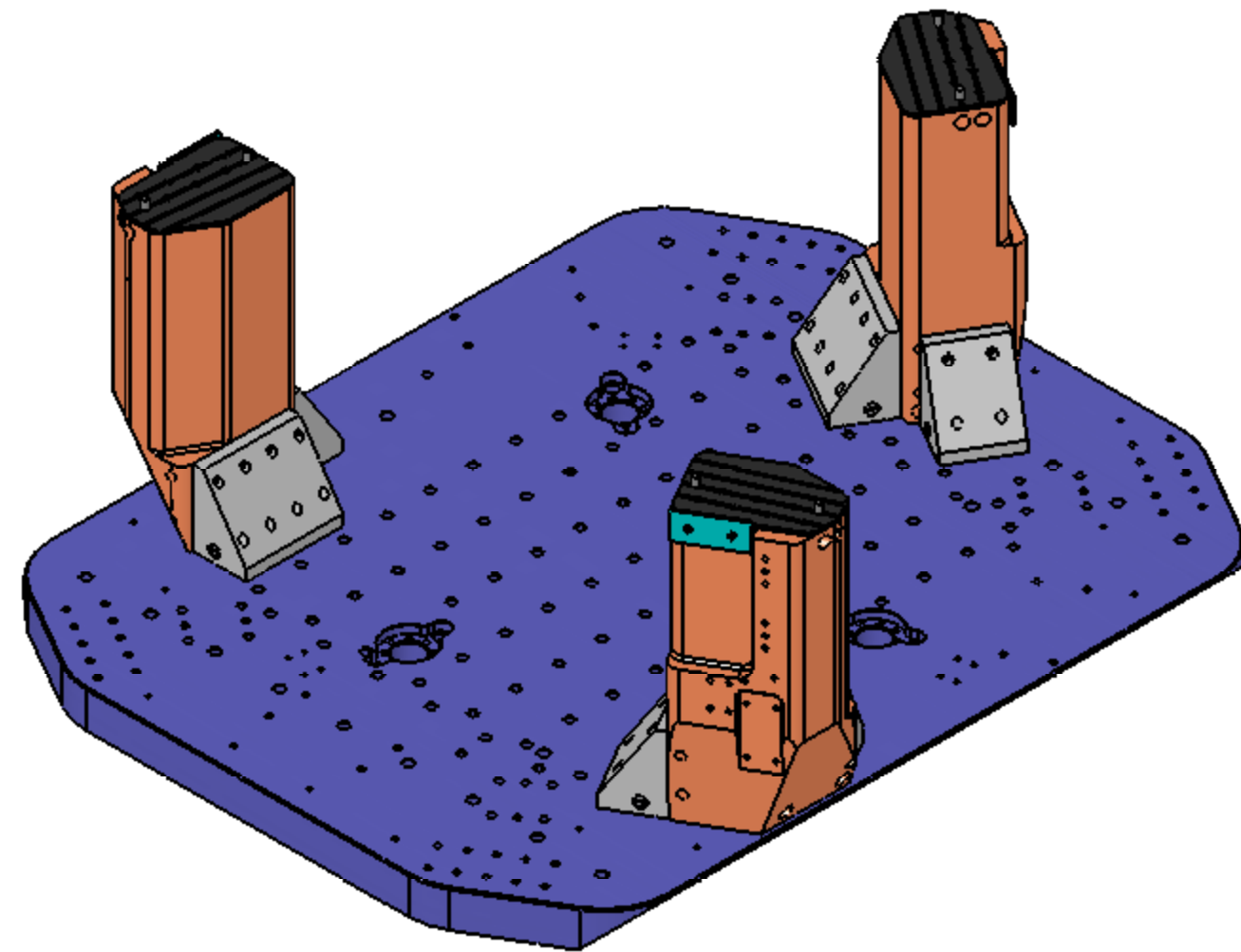
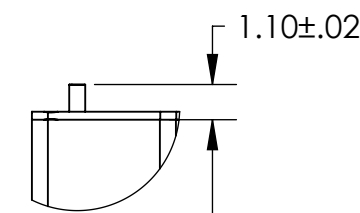


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	6-1-07	1062	Dan Bryce	Manufacturing Release
C	01-03-08	-	A. STEIN	Added detail, updated BOM.



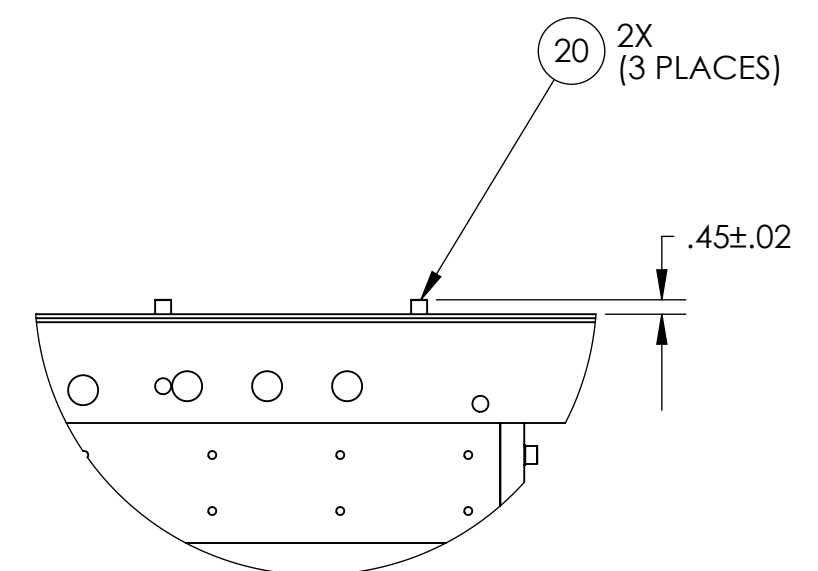
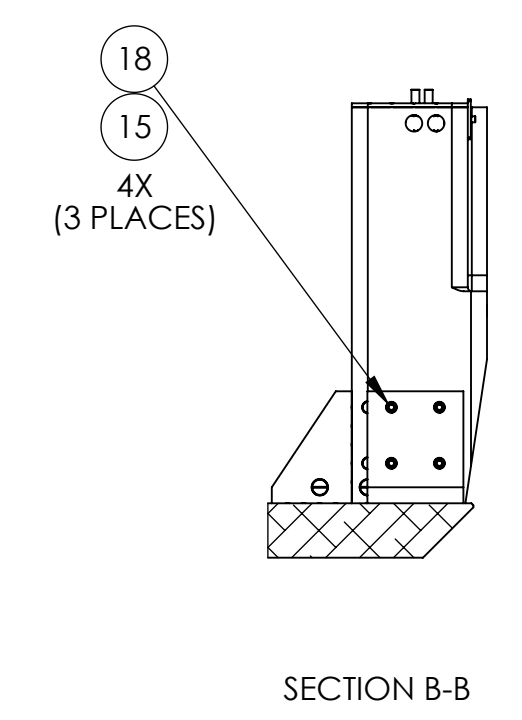
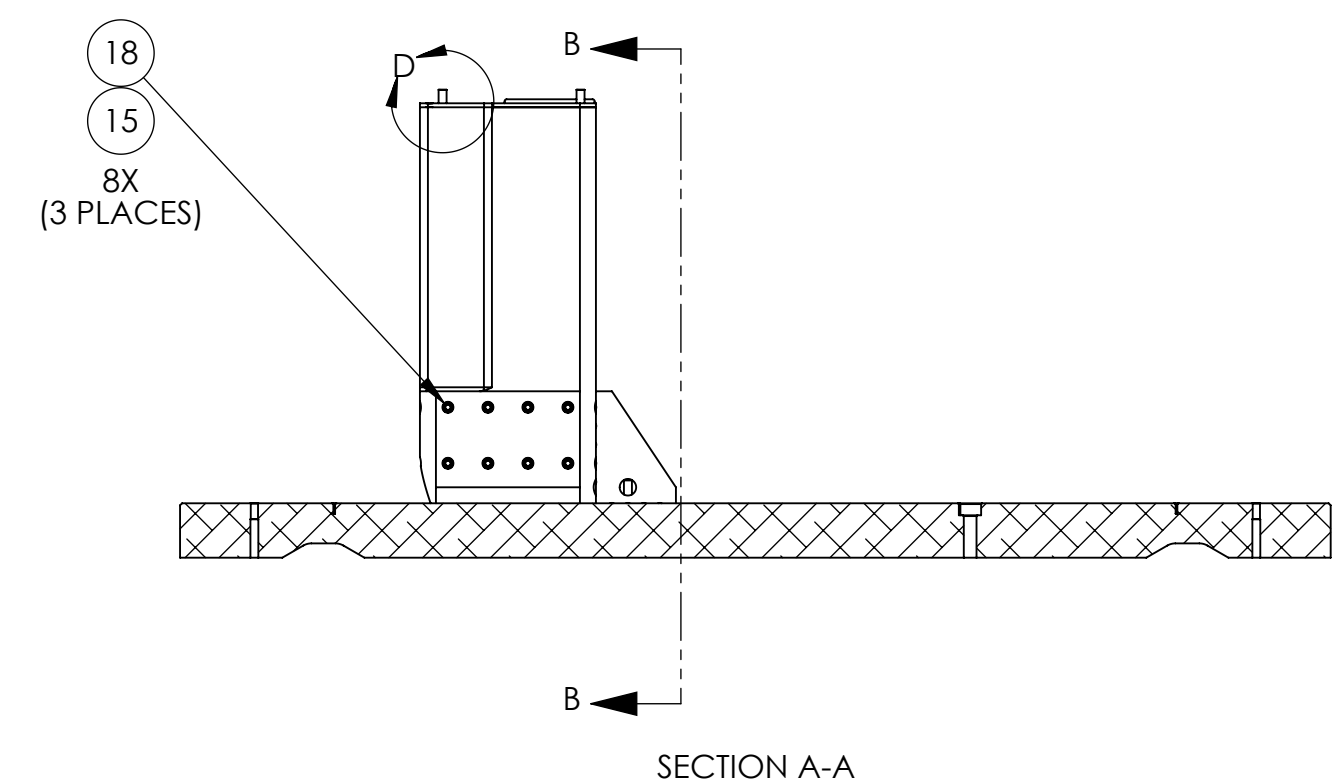
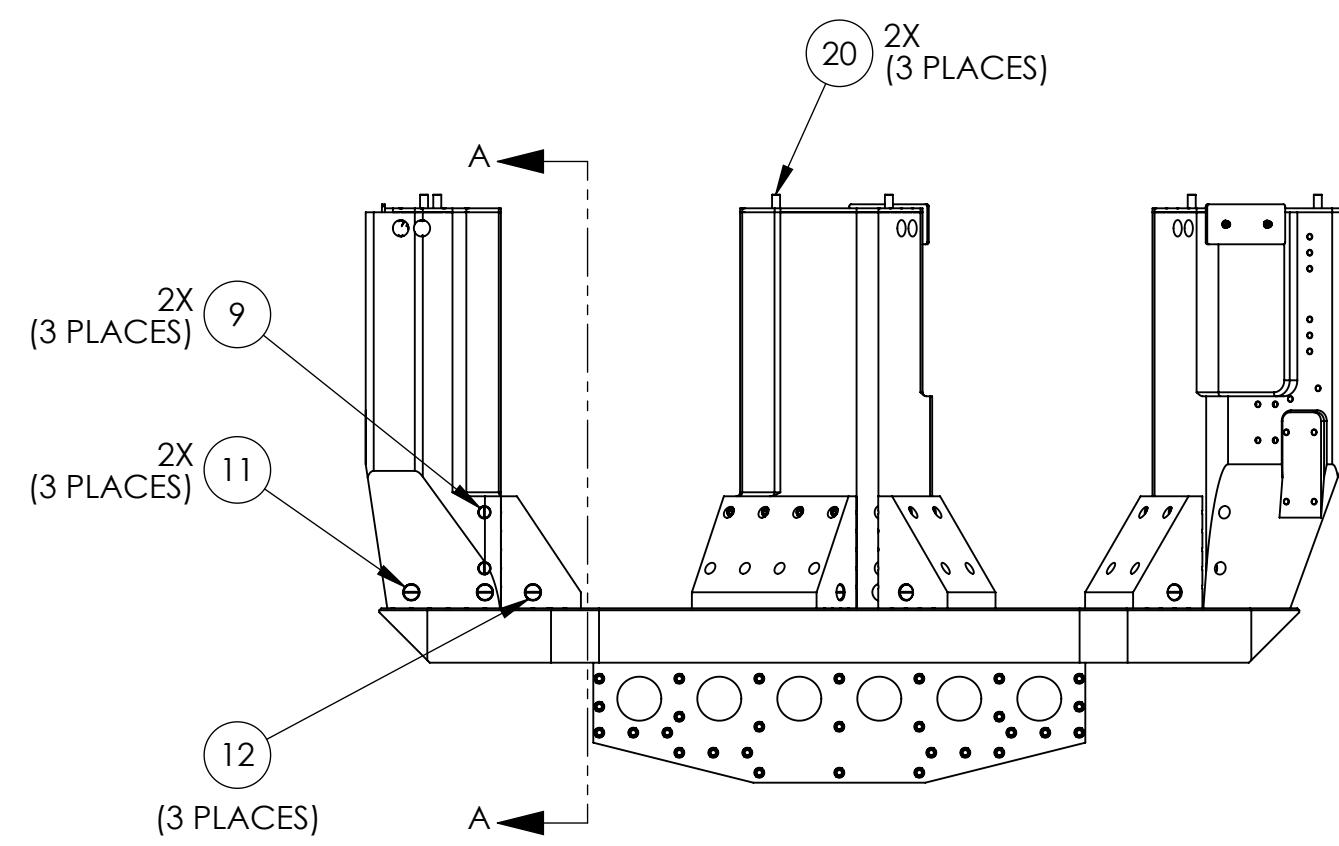
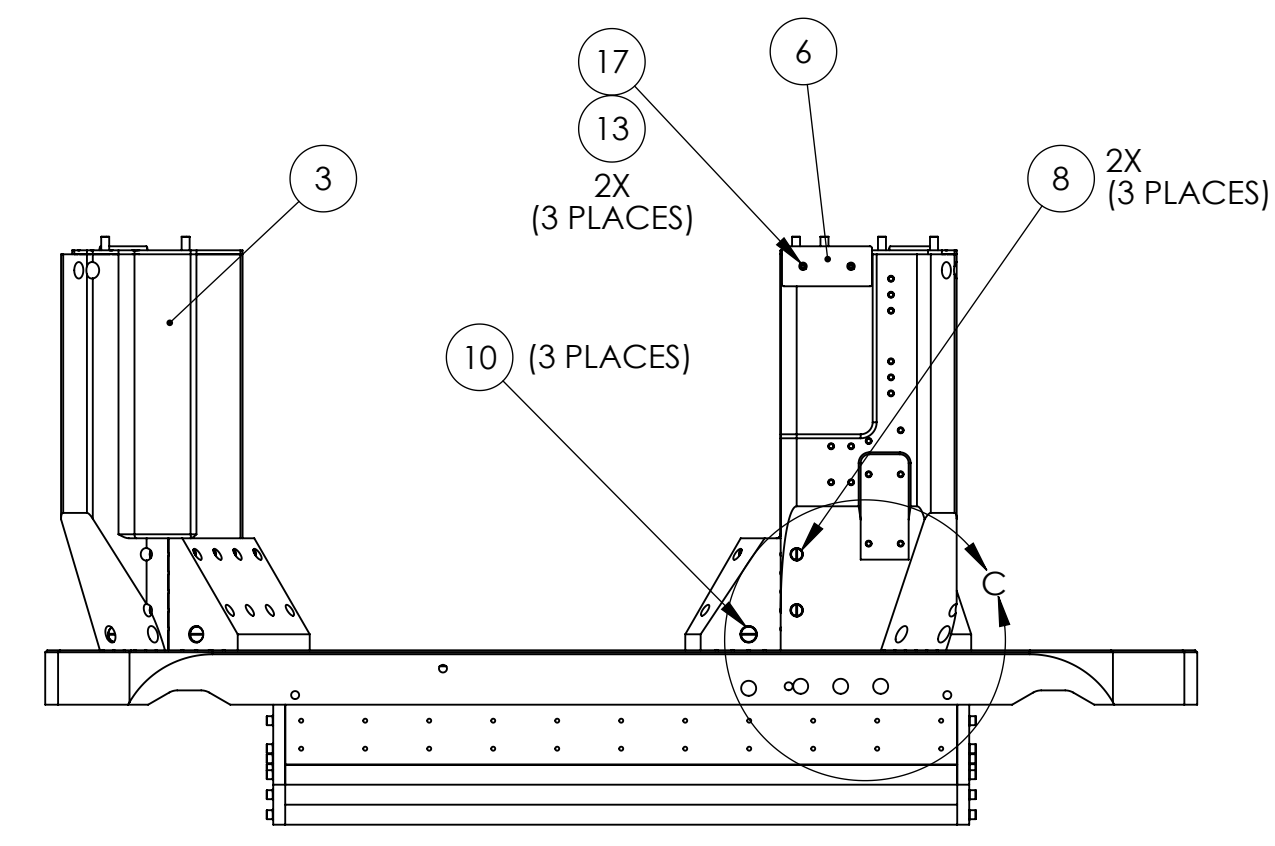
NOTES:

- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
- BEFORE ASSEMBLY, ALL HELI-COIL INSERTS AND DOWEL PINS SHOULD ALREADY BE INSTALLED.
- TO ALLOW ACCESS TO ALL MOUNTING HARDWARE, THIS SYSTEM SHOULD BE BUILT ON D070350 (PRE-ASSEMBLY STAND), OR SOMETHING SIMILAR.



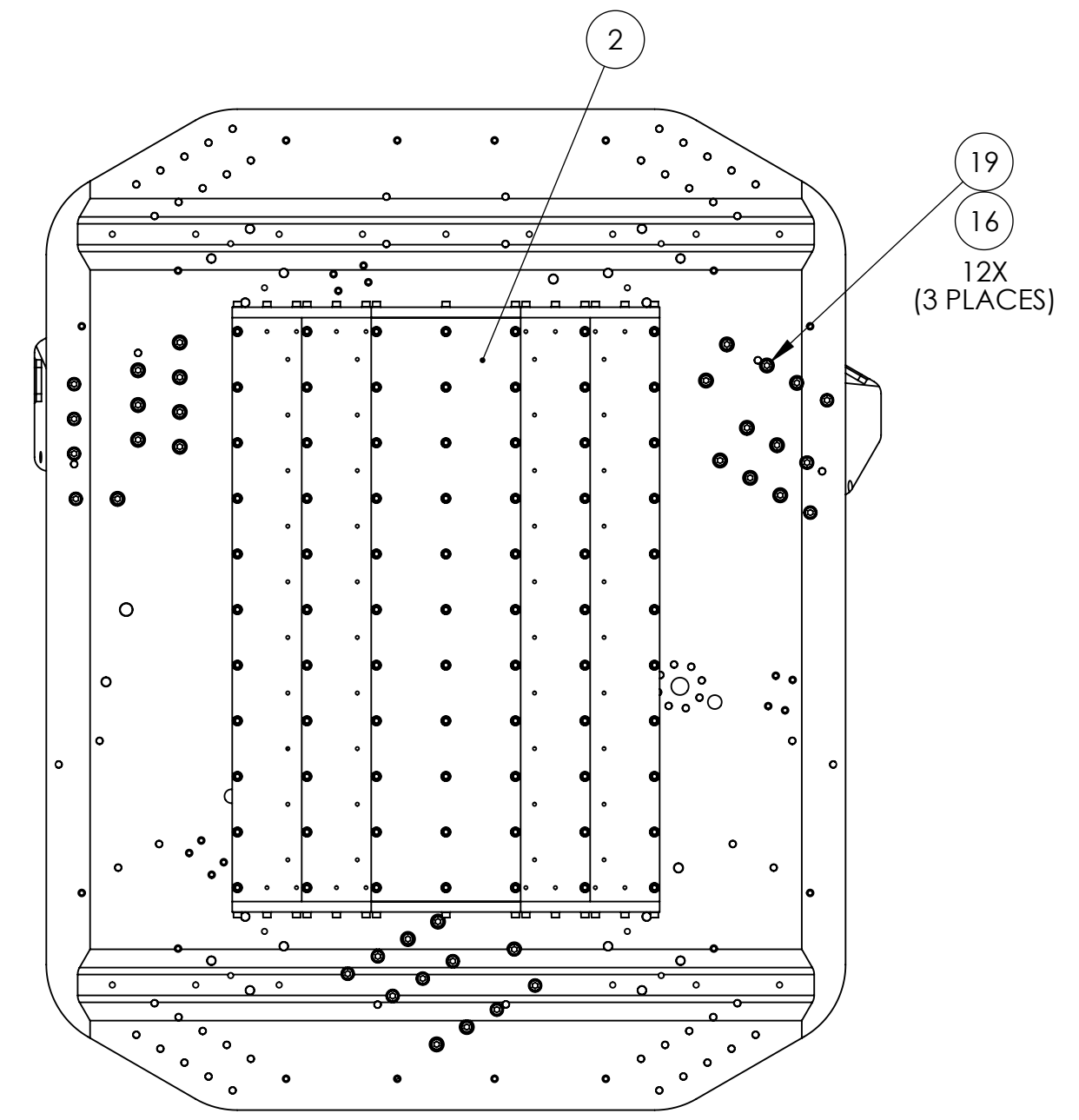
PINS IN SUPPORT POSTS ALIGN SPRINGS.
NOTE: DIMENSION REFERENCED TO TOP OF POST, NOT CAP.

DETAIL D
SCALE 1 : 6



SUPPORT POSTS AND GUSSETS NOT SHOWN.
PINS IN STAGE 0 BASE ALIGN THE POSTS.

DETAIL C
SCALE 1 : 6



BILL OF MATERIALS					
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D071001	STAGE 0 BASE	-	6061-T6
2	1	D071412	ASM, STAGE 0 STIFFENER	-	See BOM
3	3	D071002	SUPPORT POST	-	6061-T6
4	3	D071005	SUPPORT POST GUSSET, MAIN	-	6061-T6
5	3	D071004	SUPPORT POST GUSSET, AUX	-	6061-T6
6	3	D071009	PARTICLE FENCE	-	6061-T6
7	3	D071003	SUPPORT POST CAP	-	304 SS
8	6	D071251	GANG BARREL NUT	2x 3/8"-16 (spaced 3.0")	17-4 PH H1150
9	6	D071251	GANG BARREL NUT	4x 3/8"-16 (spaced 2.5")	17-4 PH H1150
10	3	D071251	GANG BARREL NUT	2x 1/2"-13 (spaced 3.0")	17-4 PH H1150
11	6	D071251	GANG BARREL NUT	3x 1/2"-13 (spaced 2.5")	17-4 PH H1150
12	3	D071251	GANG BARREL NUT	4x 1/2"-13 (spaced 2.5")	17-4 PH H1150
13	6	HOLOKROME 78058	SHCS	1/4"-20x.75"	18-8 SS
14	86	HOLOKROME 78104	SHCS	3/8"-16x1.75"	18-8 SS
15	36	HOLOKROME 78108	SHCS	3/8"-16x2.5"	18-8 SS
16	36	MICMASTER 9219A6720	SHCS	1/2"-13x2.0"	18-8 SS
17	6	UC #WFV-25	VENTED WASHER	.25	18-8 SS
18	122	UCC WFV-38	VENTED WASHER	.39"IDx.625"OD	18-8 SS
19	36	UCC WFV-50	VENTED WASHER	.515"IDx.875"OD	18-8 SS
20	12	MICMASTER 90145A716	DOWEL PIN	1/2"x1.5"	18-8 SS

PRIOR APPROVALS: p06109-410-0
ENGINEERING: Dan Bryce
MANUFACTURING: C. Danaher
MATERIALS: See BOM
FINISH: See BOM

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
XX +.015 XXX +.005
ANG TOL: ± 1° SURFACE ROUGHNESS: .63
INTERNAL AND EXTERNAL INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH A CHAMFER .005/.010 X 45° OR RADIUS .005/.010
CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°

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: ASM, STAGE 0
P/N: D071410 CONFIG: -
FILE NAME: D071410-C Asm, Stage 0

SCALE: 1:12 DRAWN BY: Jonas Waterman
SHEET 1 OF 1 DATE PRINTED: 1/3/2008