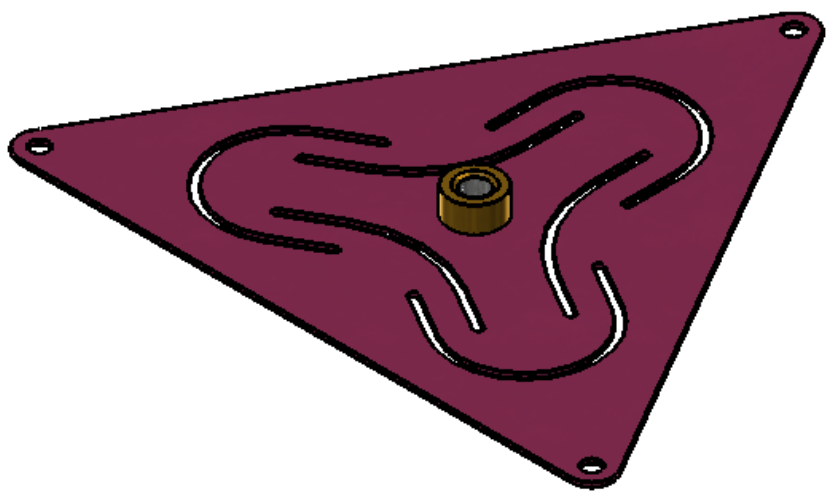
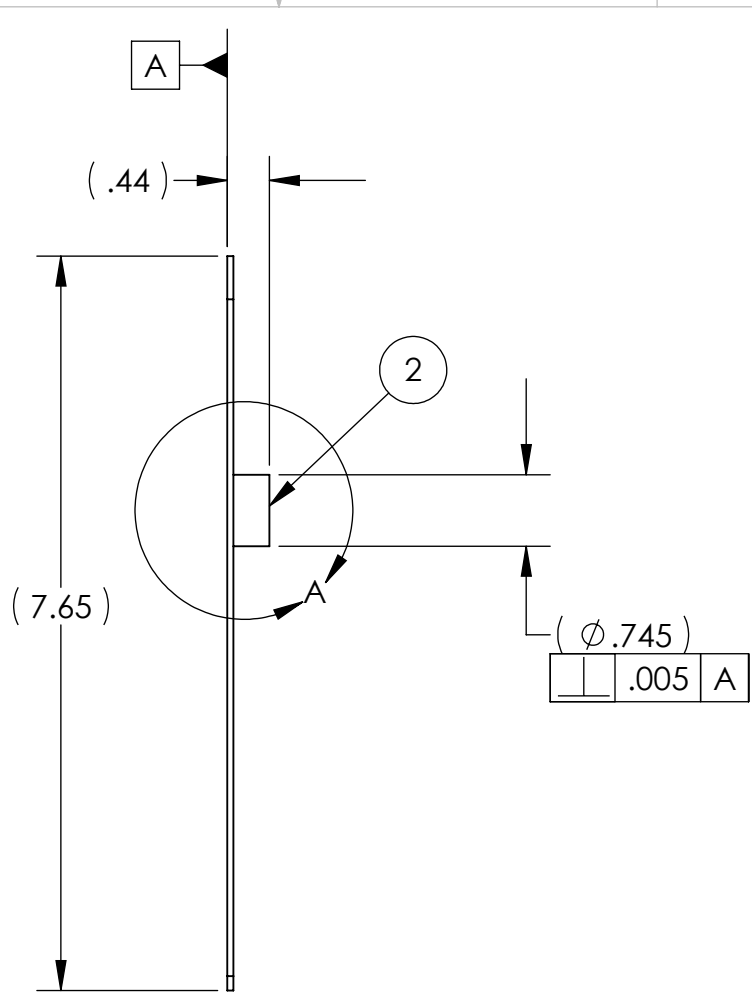
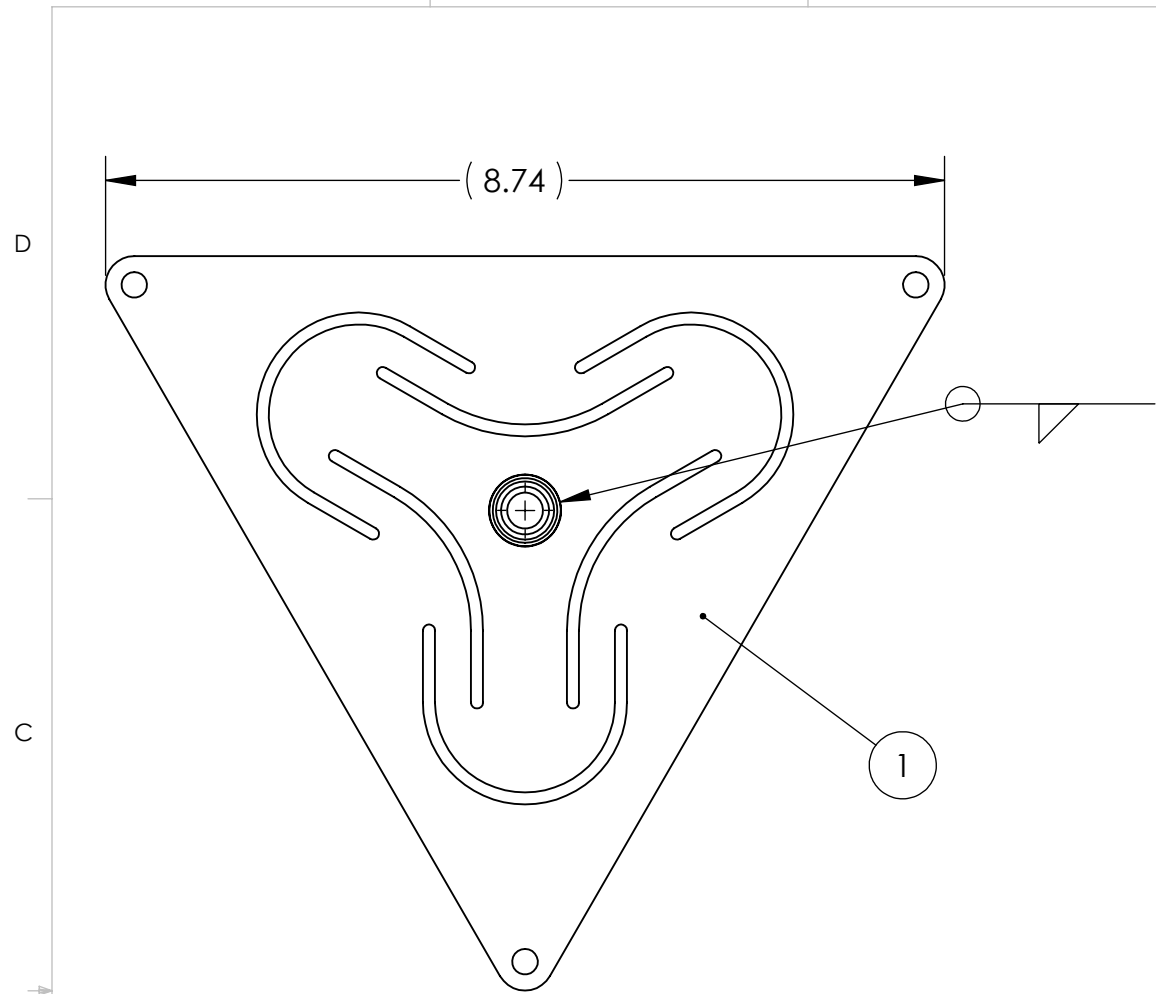


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	13 Feb 2008		A. Stein	Release for Enhanced LIGO.
V2	01 May 2009		A. Stein	Release for Advanced LIGO. Added weld symbol.



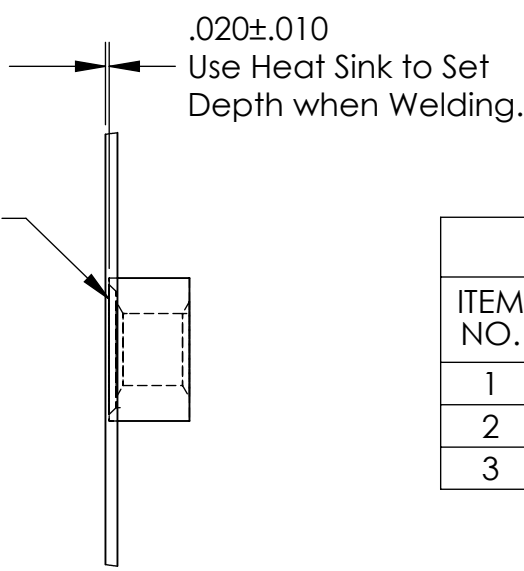
MANUFACTURING NOTES:

- 1) WELD AS SHOWN.
- 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).

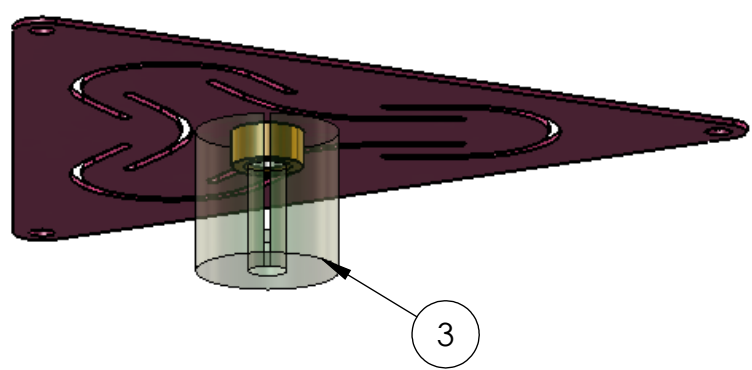
2-Step Bevel in Nut Faces This Side.



DETAIL A SCALE 1 : 1

BILL OF MATERIALS					
ITEM NO.	For Welding/ QTY.	Final Assy/ QTY.	PART NUMBER	DESCRIPTION	MATERIAL
1	1	1	D071181	GS-13 Stabilizer	304 SS
2	1	1	D071182	Weld Nut, Custom	304 SS
3	1	0	D071322	GS-13 Weld Nut Heat Sink	6061-T6 Al

Custom Heat Sink provided as welding aid, only. (Heat Sink shown transparent, below.)



3

<p>APPROVALS</p> <p>ENGINEERING (HPD): D. Bryce 5/24/2007</p> <p>QUALITY (HPD): C. Danaher 5/24/2007</p> <p>MATERIAL: See BOM</p> <p>FINISH: See BOM</p> <p>MASS: 0.6 lbs</p>	<p>DATE</p> <p>5/24/2007</p> <p>5/24/2007</p>	<p>UNLESS OTHERWISE SPECIFIED:</p> <p>DIMENSIONS ARE IN INCHES</p> <p>DECIMAL TOLERANCES:</p> <p>.XX ±.015 .XXX ±.005</p> <p>ANG TOL: ± 1° SURFACE ROUGHNESS: 63</p> <p>REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.</p> <p>THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL FEATURES MUST CONFORM TO .010 TOTAL WIDE PROFILE OF A SURFACE.</p>	<p>ORIGINAL DESIGN BY:</p> <p>High Precision Devices</p> <p>1668 Valtec Lane, Suite C, Boulder, Colorado 80301</p> <p>Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com</p> <p>MODIFIED BY:</p> <p>LIGO</p>	<p>DESCRIPTION: Asm, Stabilizer, GS-13</p> <p>P/N: D071471 CONFIG: -</p> <p>CAD FILE NAME: D071471_Asm-Stabilizer-GS-13</p> <p>PROJECT: HAM ISI, Advanced LIGO</p>	<p>SIZE B</p> <p>SCALE: 1:2</p> <p>SHEET 1 OF 1</p>	<p>DRAWN BY: Dan Bryce (HPD)</p> <p>DATE PRINTED: 5/7/2009</p>	<p>REV V2</p>
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