

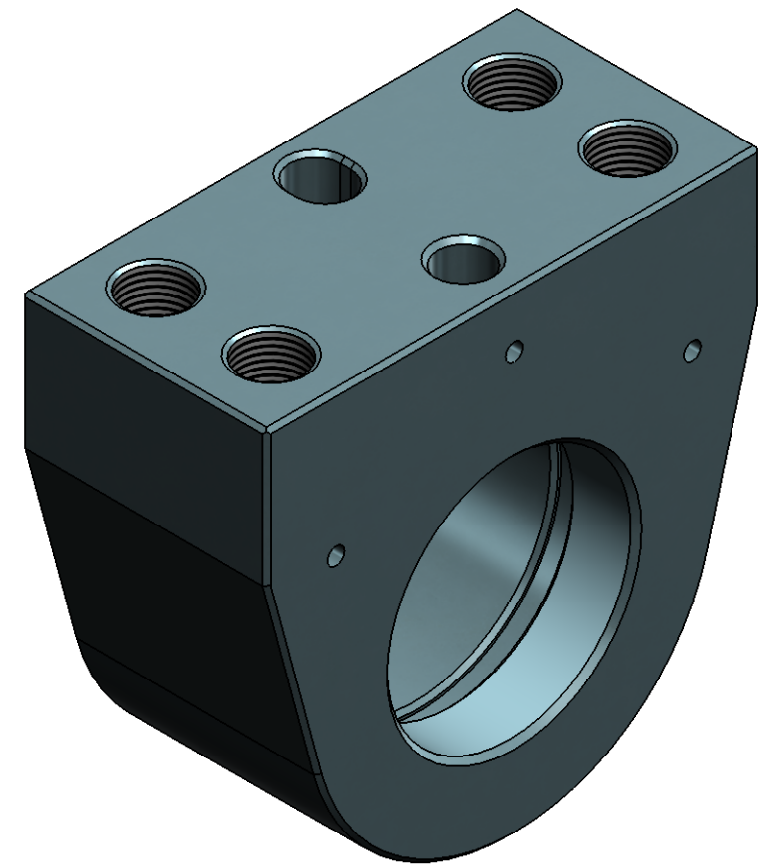
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	19 Jul 2007		A. Stein	Release for Enhanced LIGO.
V2	6 Apr 2009		A. Stein	Release for Advanced LIGO. Changed height, to match latest Locker Base. Removed vent groove and replaced with 2x vent holes. Replaced 3/8"-16 tapped holes with Heli-Coils. Added chamfers and c/sinks. Minor changes to tolerances.

$\phi .3760^{+.0005}_{-.0000} \downarrow .50$
 $\checkmark \phi .44 \times 82^\circ$, NEAR SIDE
 $\oplus \phi .002$ C A B

4X $\phi .397 \downarrow 1.15$
 $\checkmark \phi .52 \times 120^\circ$, NEAR SIDE
 TAP FOR 3/8-16 H4-6
 HELICOIL INSERT = 2.0 * DIA.
 $\oplus \phi .005$ C A B

$\square .001$
 A

$\phi .3760^{+.0005}_{-.0000} \downarrow .50$
 CH .03 X 45°
 $\oplus \phi .002$ C A B

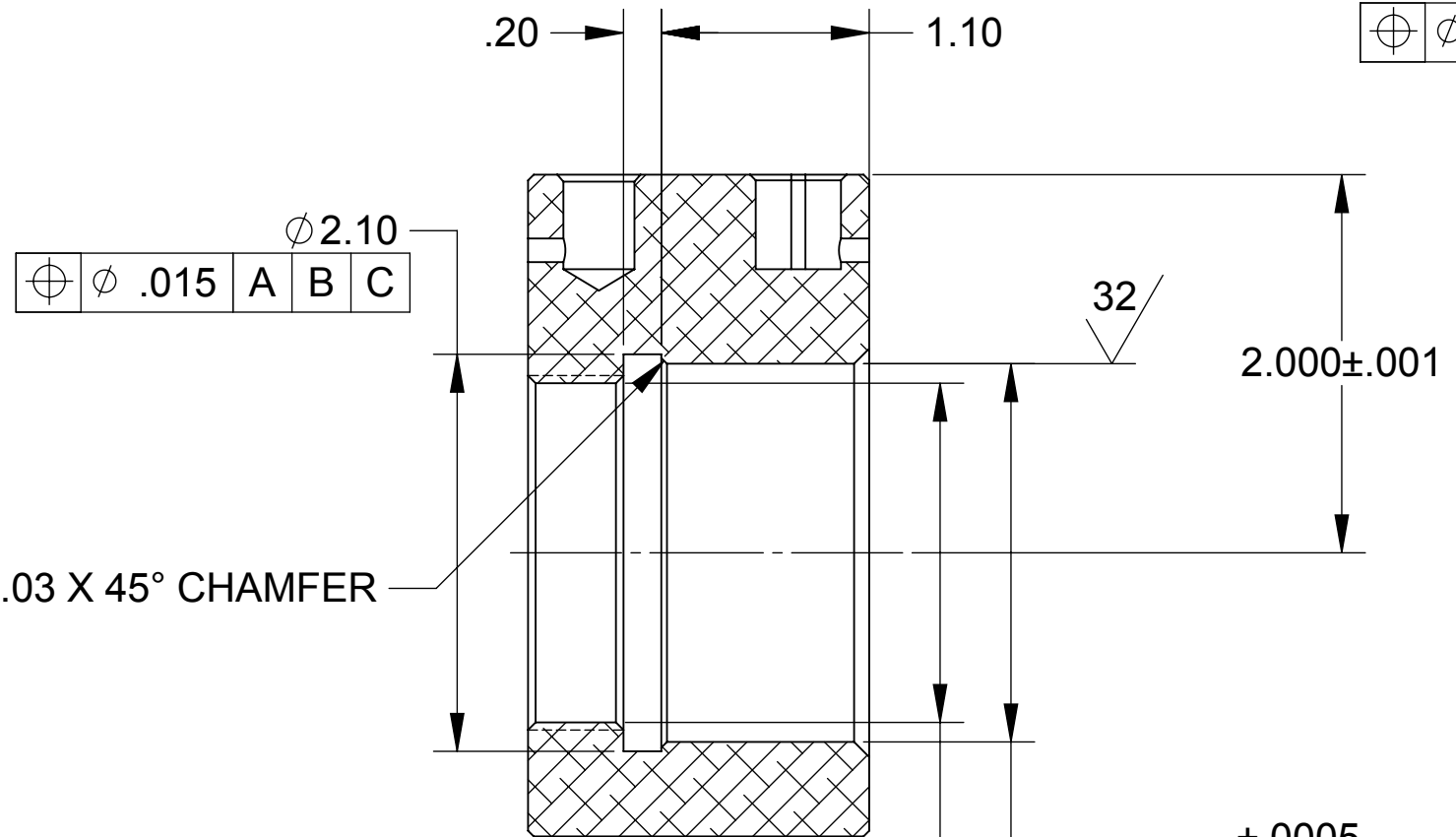


Vent Hole
 2X $\phi .13 \downarrow .50$
 Must intersect
 cross-drilled hole.
 Both sides.
 $\oplus \phi .015$ (M) A B C

Vent Hole
 $\phi .13 \downarrow .38$
 Must intersect
 cross-drilled hole.
 Both sides.
 $\oplus \phi .015$ (M) A B C

$\square .001$ A
 C

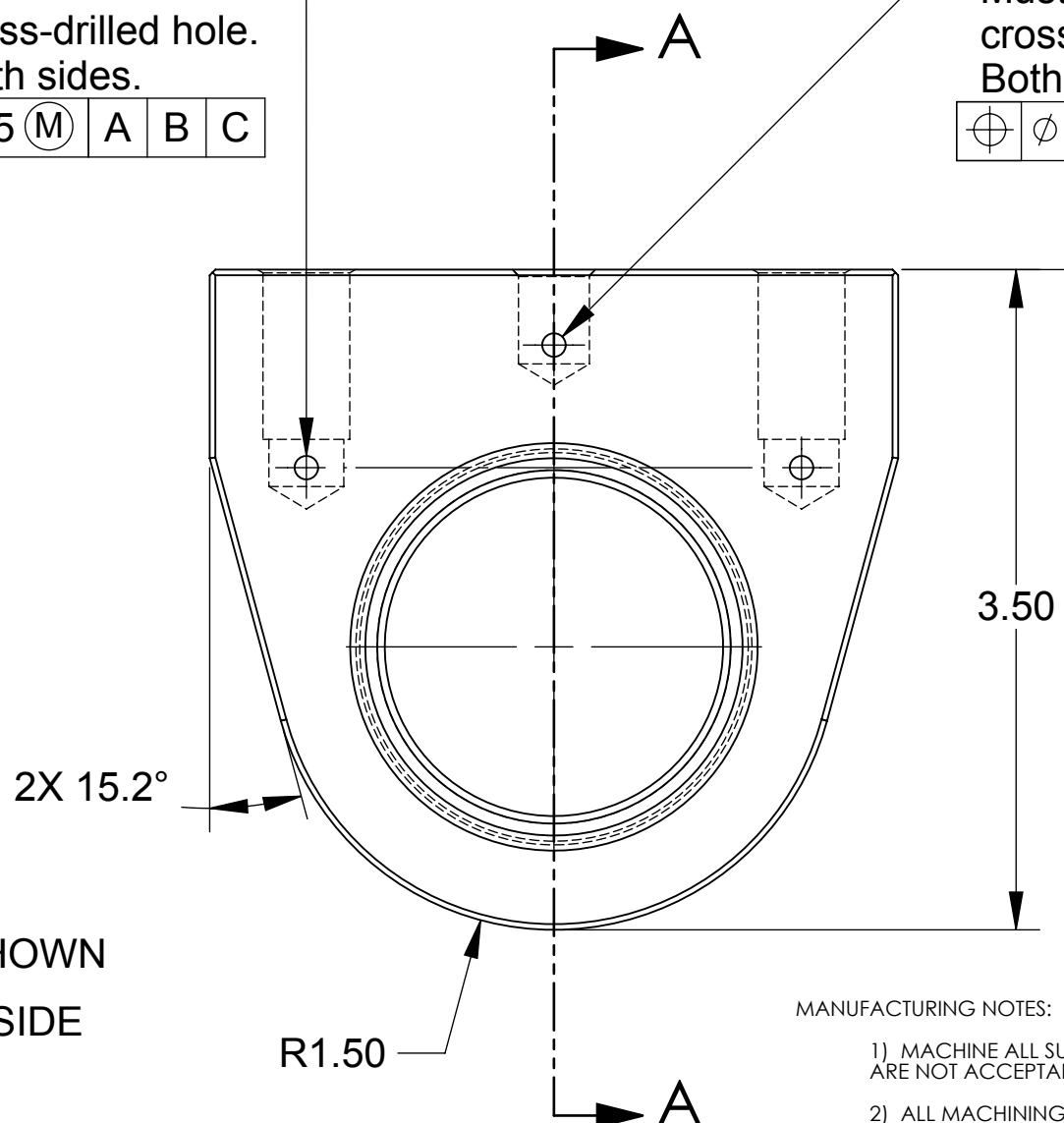
.03 X 45° CHAMFER
 AROUND ALL EDGES



SECTION A-A

$\phi 2.0006^{+.0005}_{-.0000} \downarrow$ DP SHOWN
 $\checkmark \phi 2.16 \times 90^\circ$, NEAR SIDE
 $\square .001$ A
 $\square .0005$
 B

1 7/8-12 UN H7-11
 $\checkmark \phi 1.87 \times 90^\circ$, BOTH SIDES
 $\square .002$ B



MANUFACTURING 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.
- D047932-V2
 S/N - ###

POST-MANUFACTURING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).
- 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	Qty.
1	3/8"-16 x .75"	Nitronic 60	-6EN750	4

APPROVALS	DATE
ENGINEERING (ASI): R. Kovac	1/23/2005
QUALITY (ASI): C. de Los Santos	1/24/2005
MATERIAL: 2024-T351 AI	
FINISH: None	
MASS: 1.3 lbs	

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 DECIMAL TOLERANCES:
 .XX ±.015 .XXX ±.005
 ANG TOL: ± 1° SURFACE ROUGHNESS:
 REMOVE ALL SHARP EDGES.
 LEAVE .005 X 45° MIN CHAMFER,
 OR .005 MIN RADIUS.

ORIGINAL DESIGN BY: asi	ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	MODIFIED BY: LIGO
DESCRIPTION: Locker Sleeve Housing		
P/N: D047932	CONFIG: -	
CAD FILE NAME: D047932_Locker_Sleeve_Housing		
PROJECT: HAM ISI, Advanced LIGO		
SIZE: C	SCALE: 1:1	DRAWN BY: R.D. Billing (ASI)
SHEET 1 OF 1	DATE PRINTED: 4/9/2009	REV V2