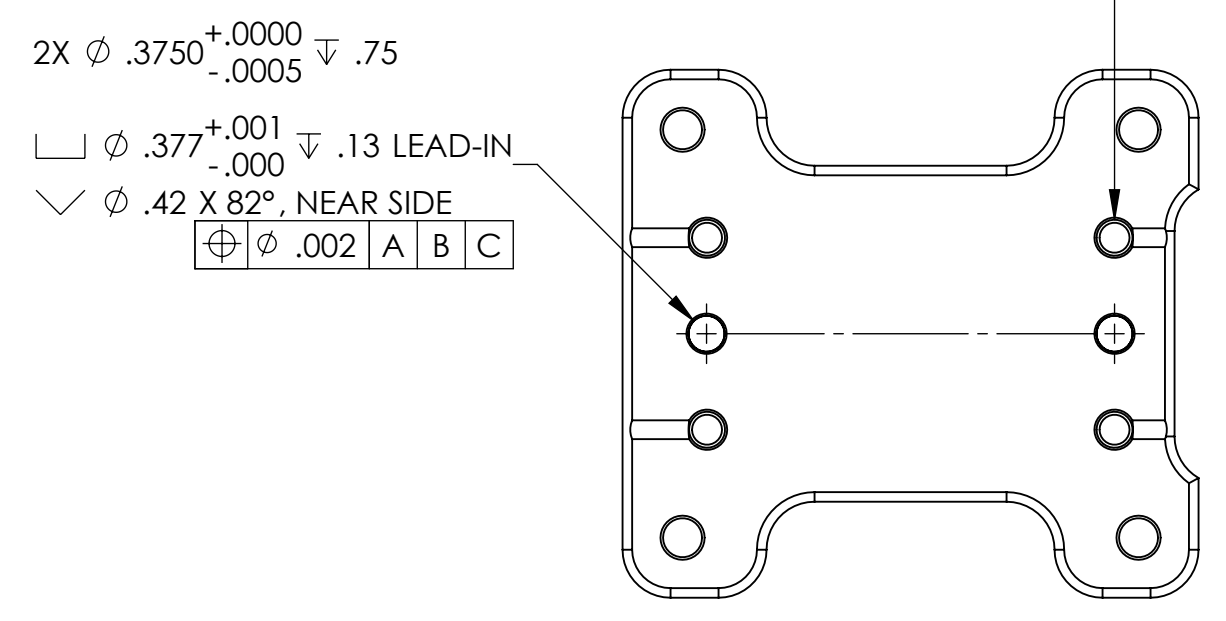
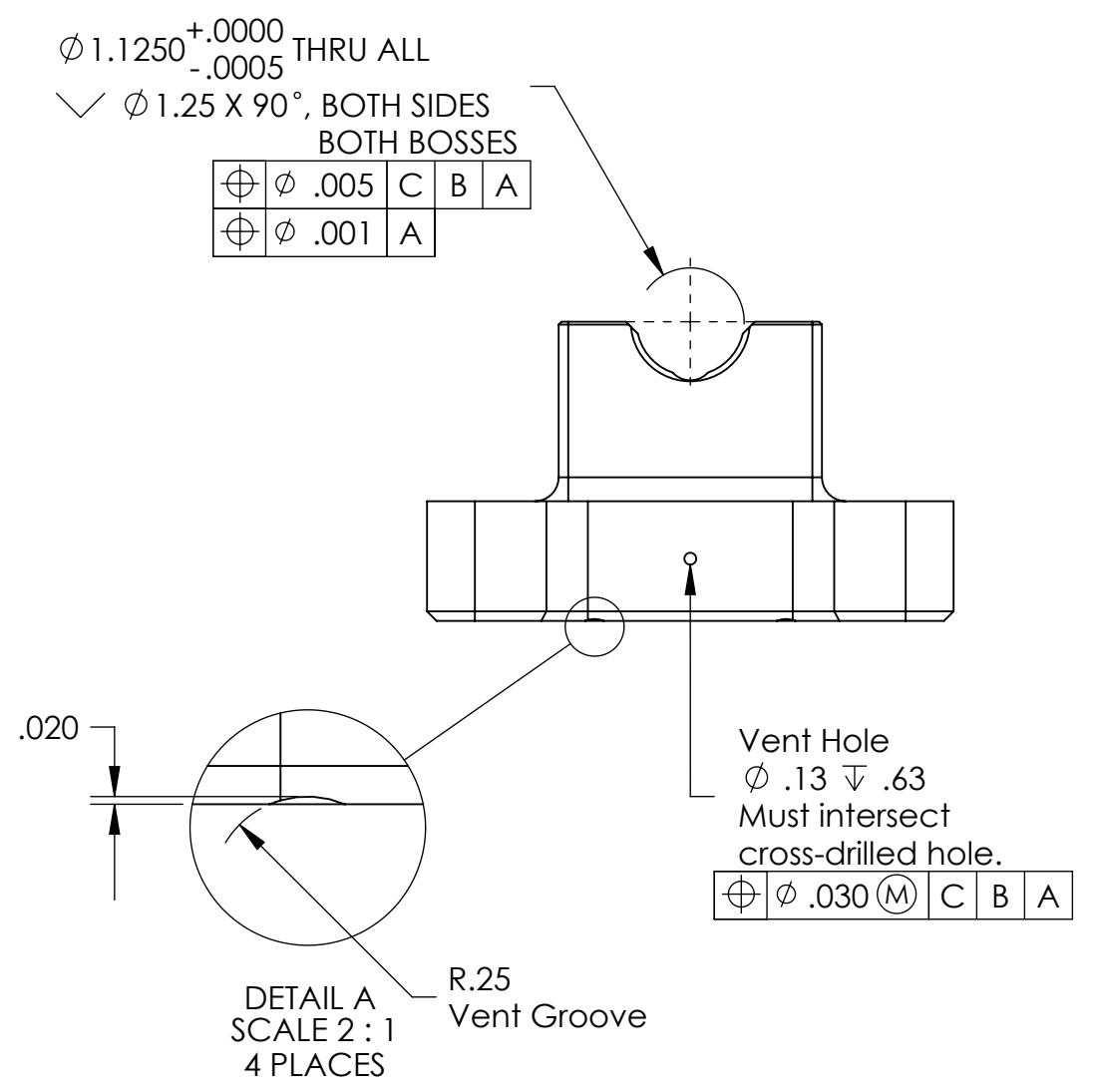
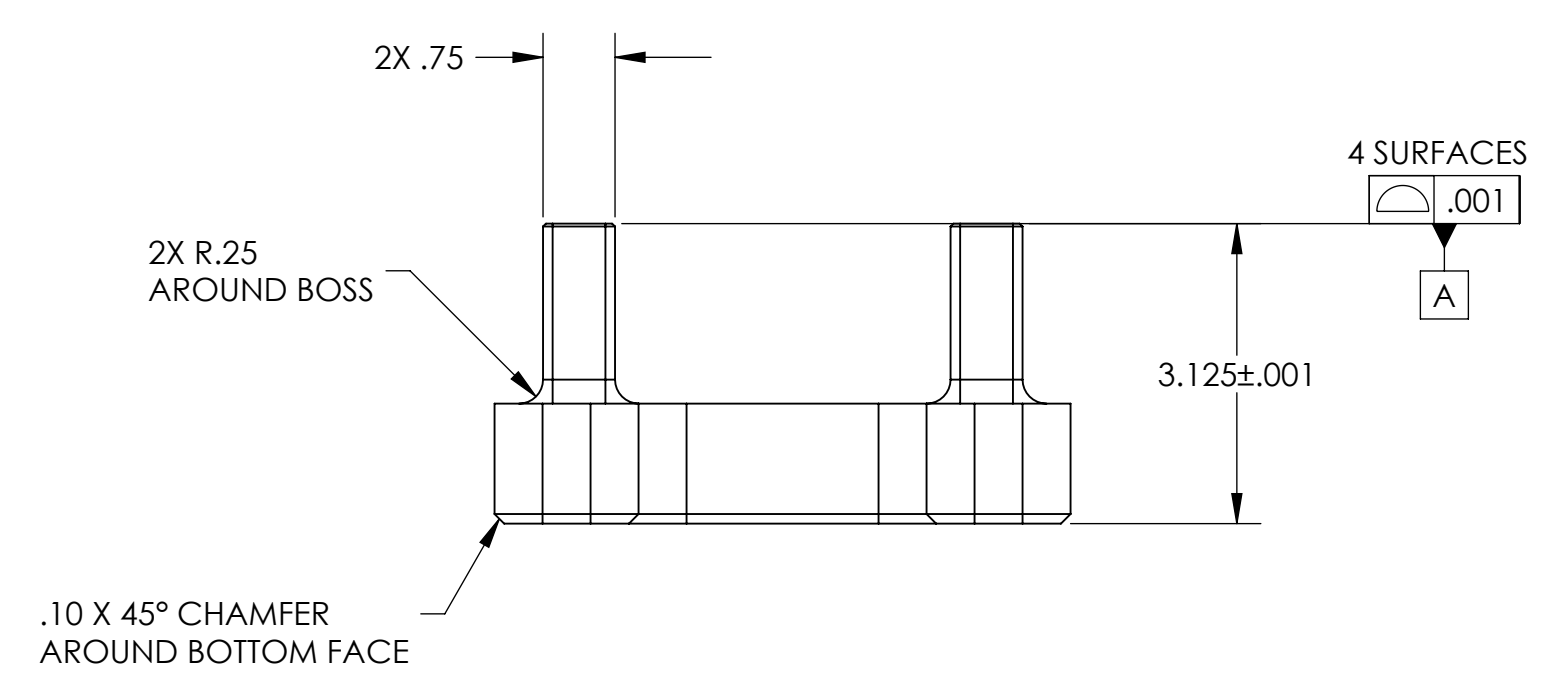
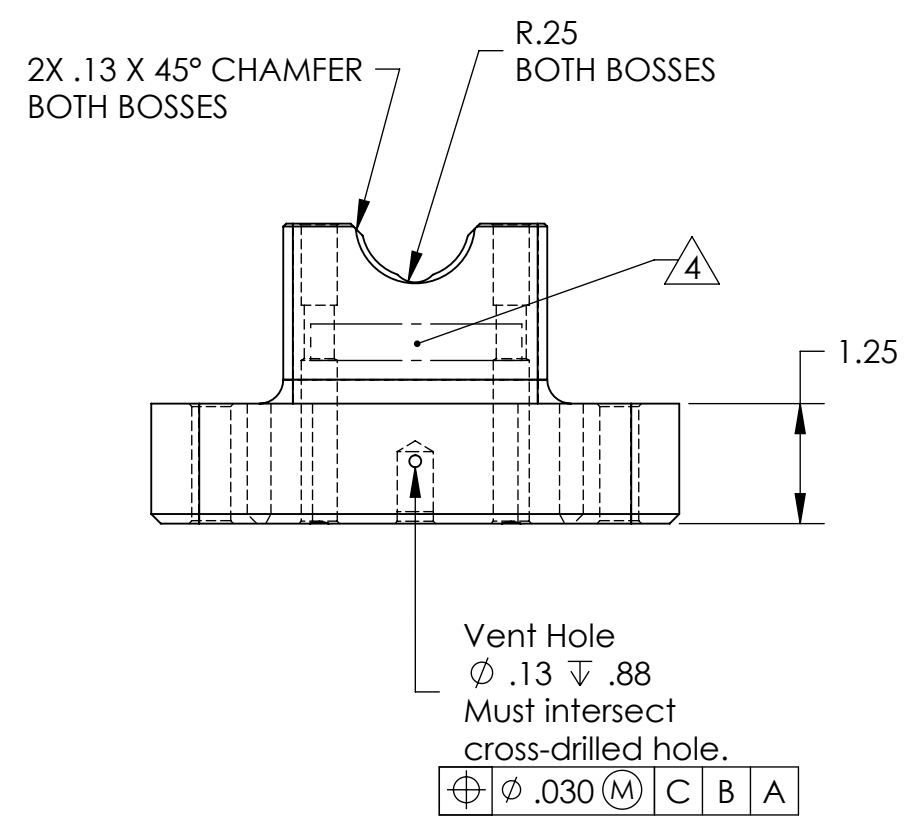
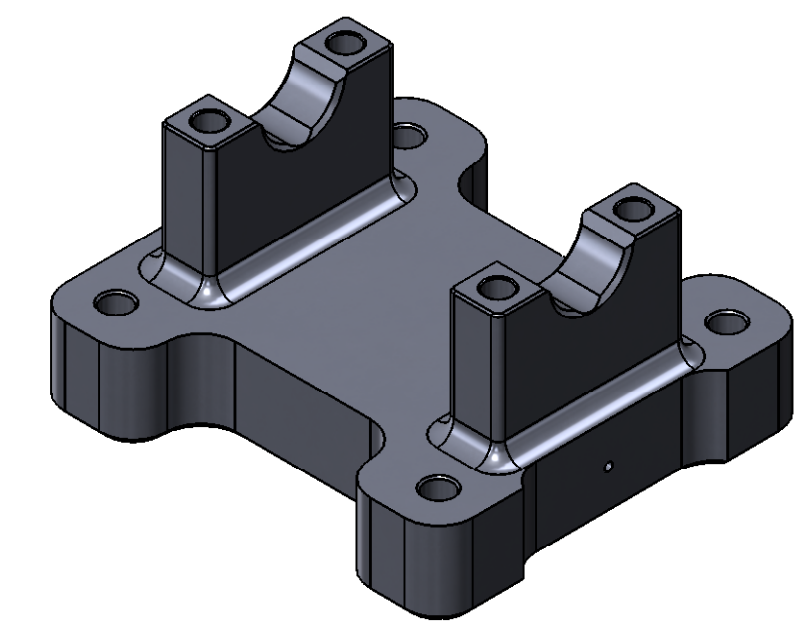
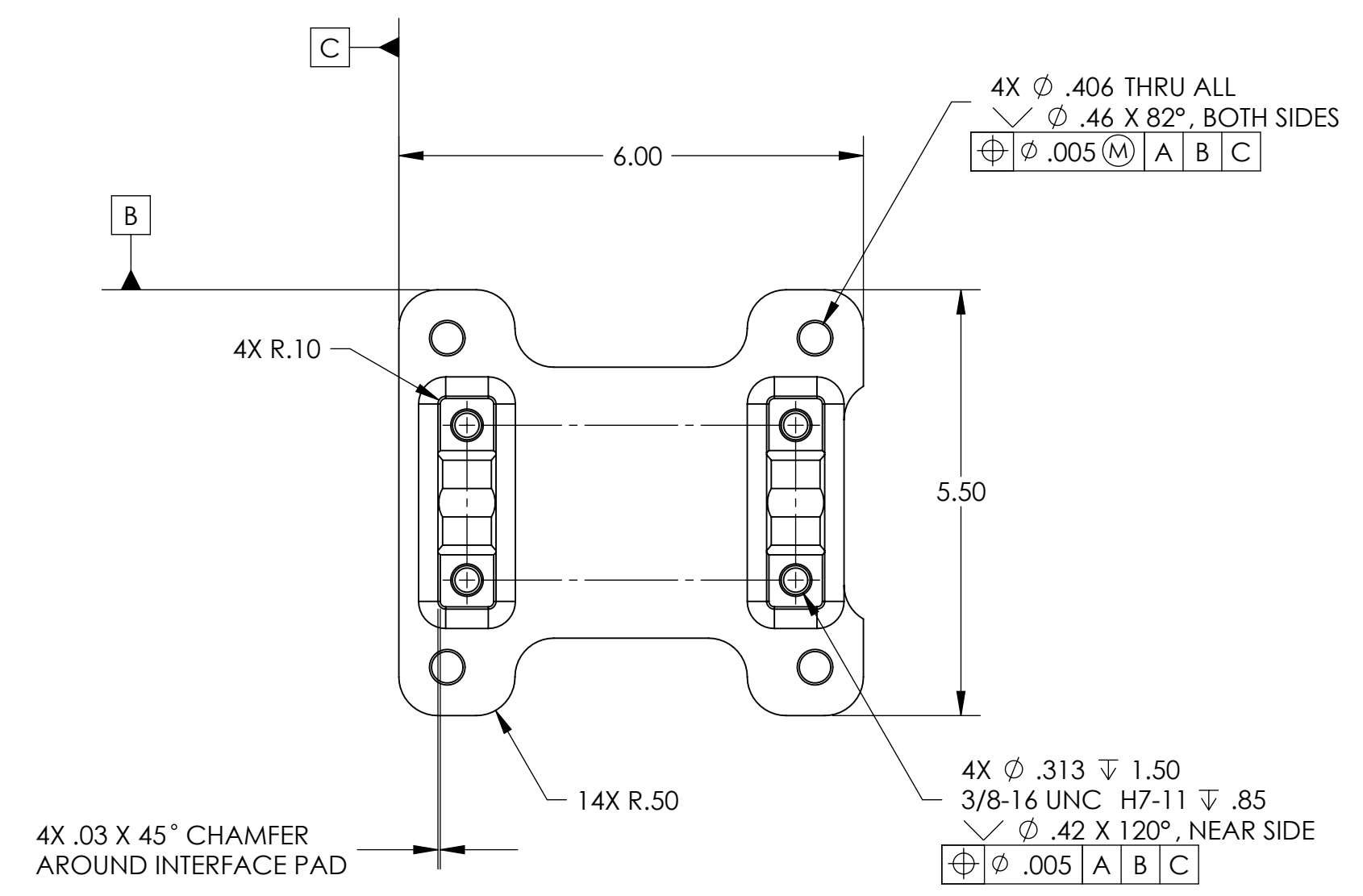


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	11 Jul 2007		A. Stein	Release for Enhanced LIGO.
V2	9 Apr 2009		A. Stein	Release for Advanced LIGO. Separated Base and Cap into 2 part numbers. Added chamfers and fillets. Changed hole venting details.



- 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.
- D047936-V2  
 S/N - ###
- POST-MANUFACTURING NOTES:
- P1) CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

APPROVALS		DATE	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX $\pm$ .015 .XXX $\pm$ .005 ANG TOL: $\pm$ 1° SURFACE ROUGHNESS: 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: $\nabla$ .010 A B C	ORIGINAL DESIGN BY: ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	MODIFIED BY: 
ENGINEERING (AS): R. Kovac		2/18/2005		DESCRIPTION: <b>Locker Pin Base</b>	
QUALITY (AS): M. King		2/18/2005	P/N: <b>D047936</b>	CONFIG: -	
MATERIAL: <b>2024-T351 Al</b>			CAD FILE NAME: D047936_Locker_Pin_Base		
FINISH: <b>None</b>			PROJECT: HAM ISI, Advanced LIGO		
MASS: <b>3.8 lbs</b>			SIZE SCALE: <b>1:2</b>	DRAWN BY: <b>Kevin Spink (ASI)</b>	
			SHEET <b>1</b> OF <b>1</b>	DATE PRINTED: <b>4/10/2009</b>	
				REV <b>V2</b>	