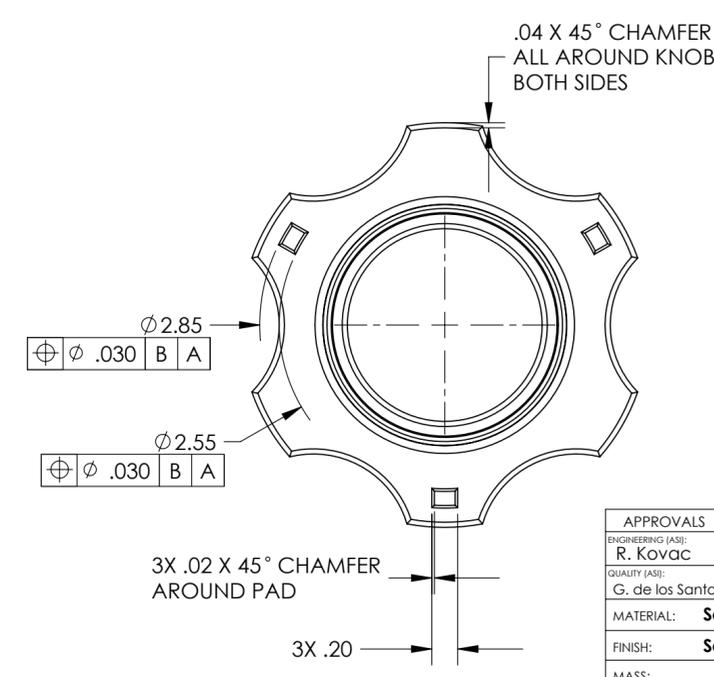
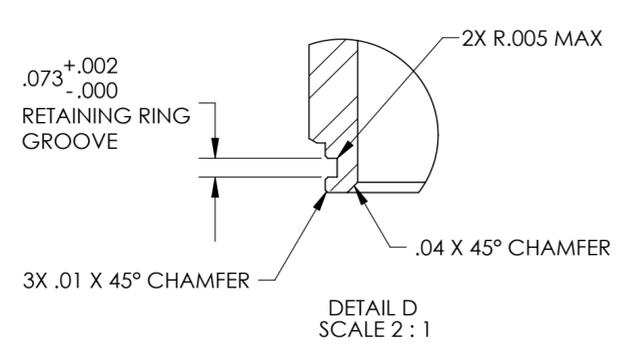
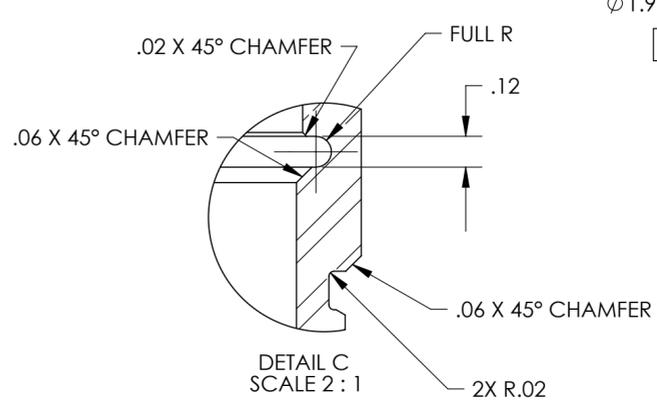
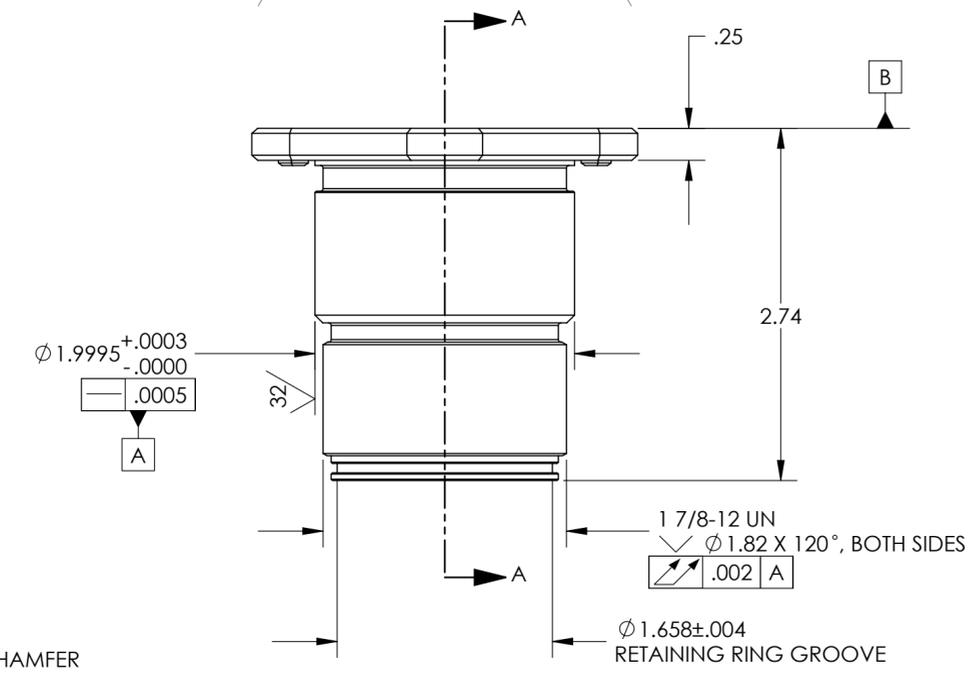
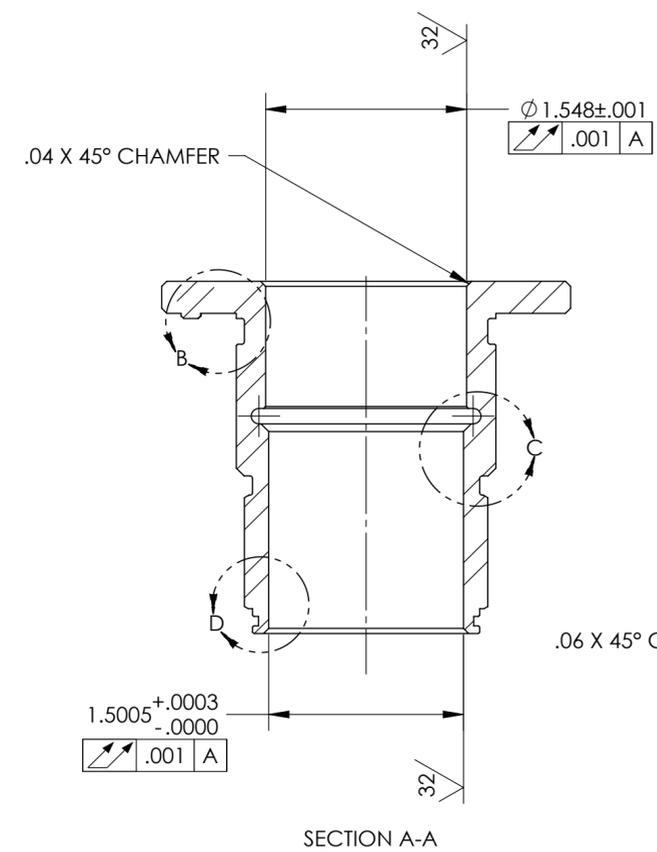
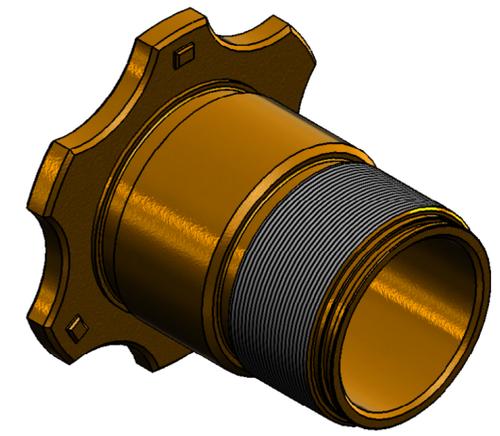
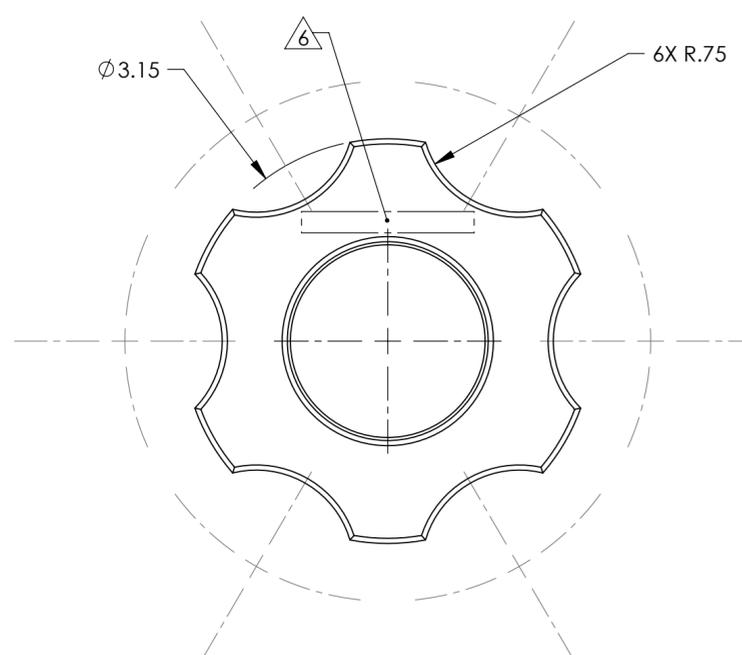
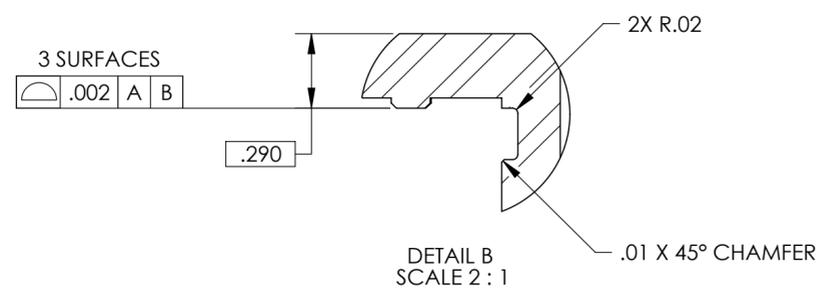


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / A	19 Jul 2007		K. Mason	Release for Enhanced LIGO.
V2	9 Apr 2009		A. Stein	Release for Advanced LIGO. Added 6x R.75 grooves. Added 3x pads to back of knob. Added chamfers and fillets. Minor changes to tolerances.



- MANUFACTURING NOTES:
- 1) MAKE FROM 440C CRES PER AMS 5630.
 - 2) BEFORE FINAL MACHINE, HEAT TREAT TO RC57 PER AMS-H-6875A.
 - 3) MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES (OTHER THAN DRESSED BLANCHARD GRINDING) ARE NOT ACCEPTABLE.
 - 4) ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.
 - 5) THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
 - 6) 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.
 D070270-V2
 S/N - ###
 - 7) COAT ALL SURFACES WITH OERLIKON BALZERS BALINIT C-WC/C. DIMENSIONS APPLY BEFORE COATING.
- 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 ±.015 .XXX ±.005 ANG TOL: ± 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:												
ENGINEERING (AS): R. Kovac		1/24/2005		<table border="1"> <tr> <td>SIZE</td> <td>SCALE: 1:1</td> <td>DRAWN BY:</td> <td>R.D. Billing (ASI)</td> <td>REV</td> <td></td> </tr> <tr> <td>C</td> <td>SHEET 1 OF 1</td> <td>DATE PRINTED:</td> <td>4/10/2009</td> <td>V2</td> <td></td> </tr> </table>	SIZE	SCALE: 1:1	DRAWN BY:	R.D. Billing (ASI)	REV		C	SHEET 1 OF 1	DATE PRINTED:	4/10/2009	V2
SIZE	SCALE: 1:1	DRAWN BY:	R.D. Billing (ASI)		REV										
C	SHEET 1 OF 1	DATE PRINTED:	4/10/2009		V2										
QUALITY (AS): C. de los Santos		1/25/2005													
MATERIAL: See Notes															
FINISH: See Notes															
MASS: 1.0 lbs															

ORIGINAL DESIGN BY:	ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103	MODIFIED BY:	LIGO
DESCRIPTION:	Locker Sleeve		
P/N:	D070270	CONFIG:	-
CAD FILE NAME:	D070270_Locker_Sleeve		
PROJECT:	HAM ISI, Advanced LIGO		