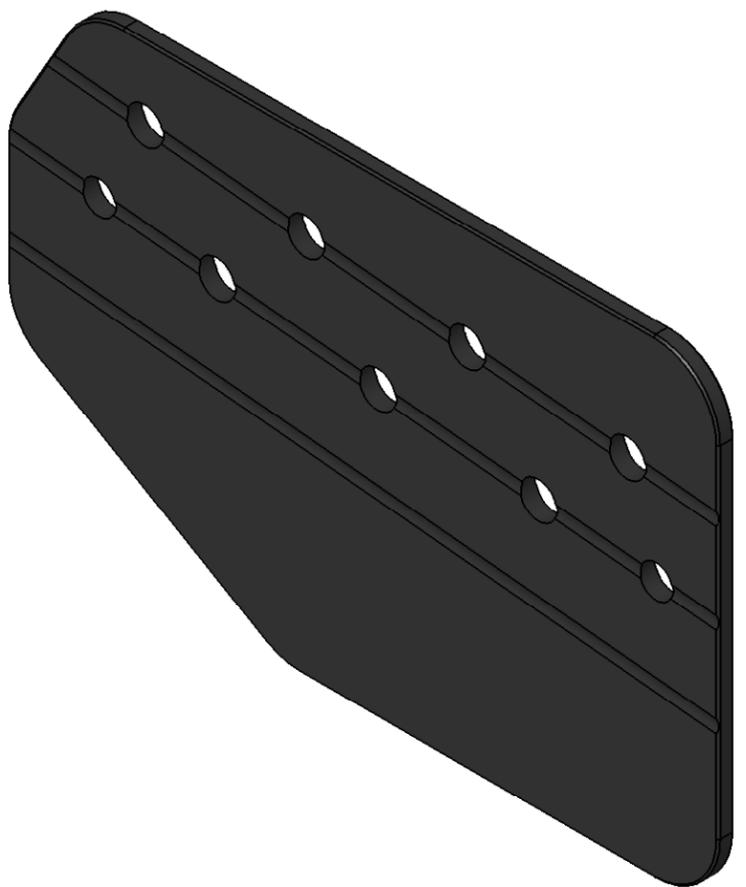
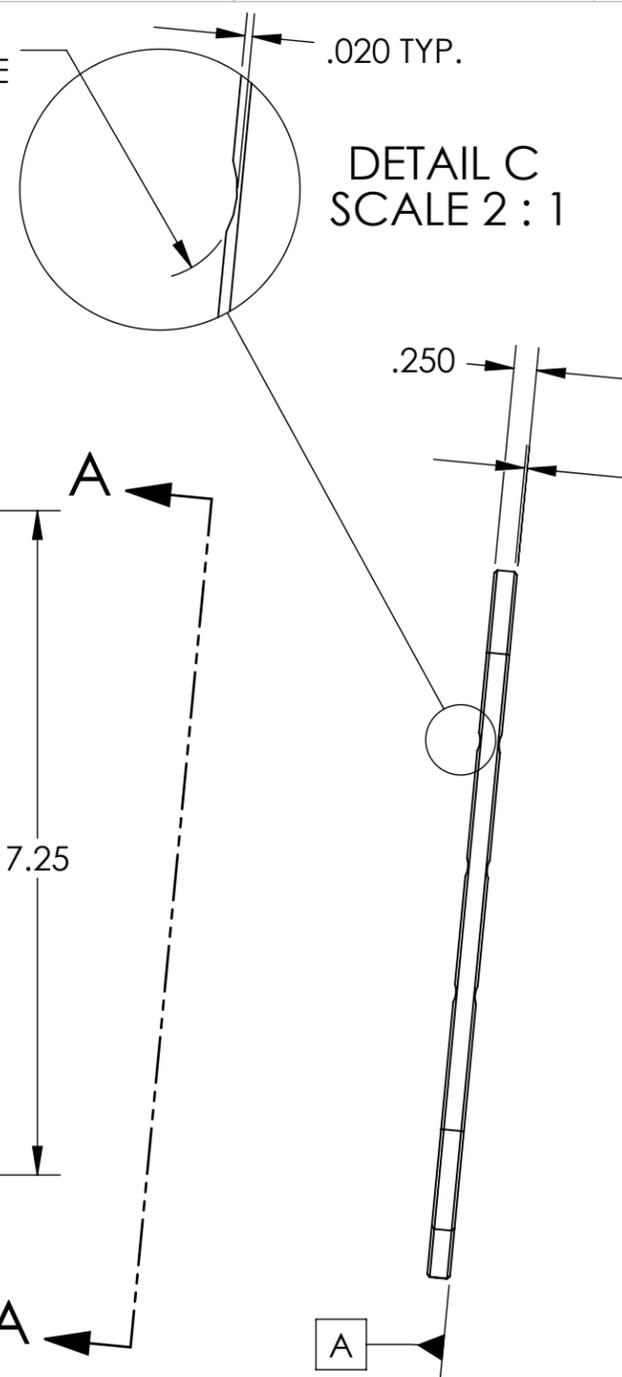
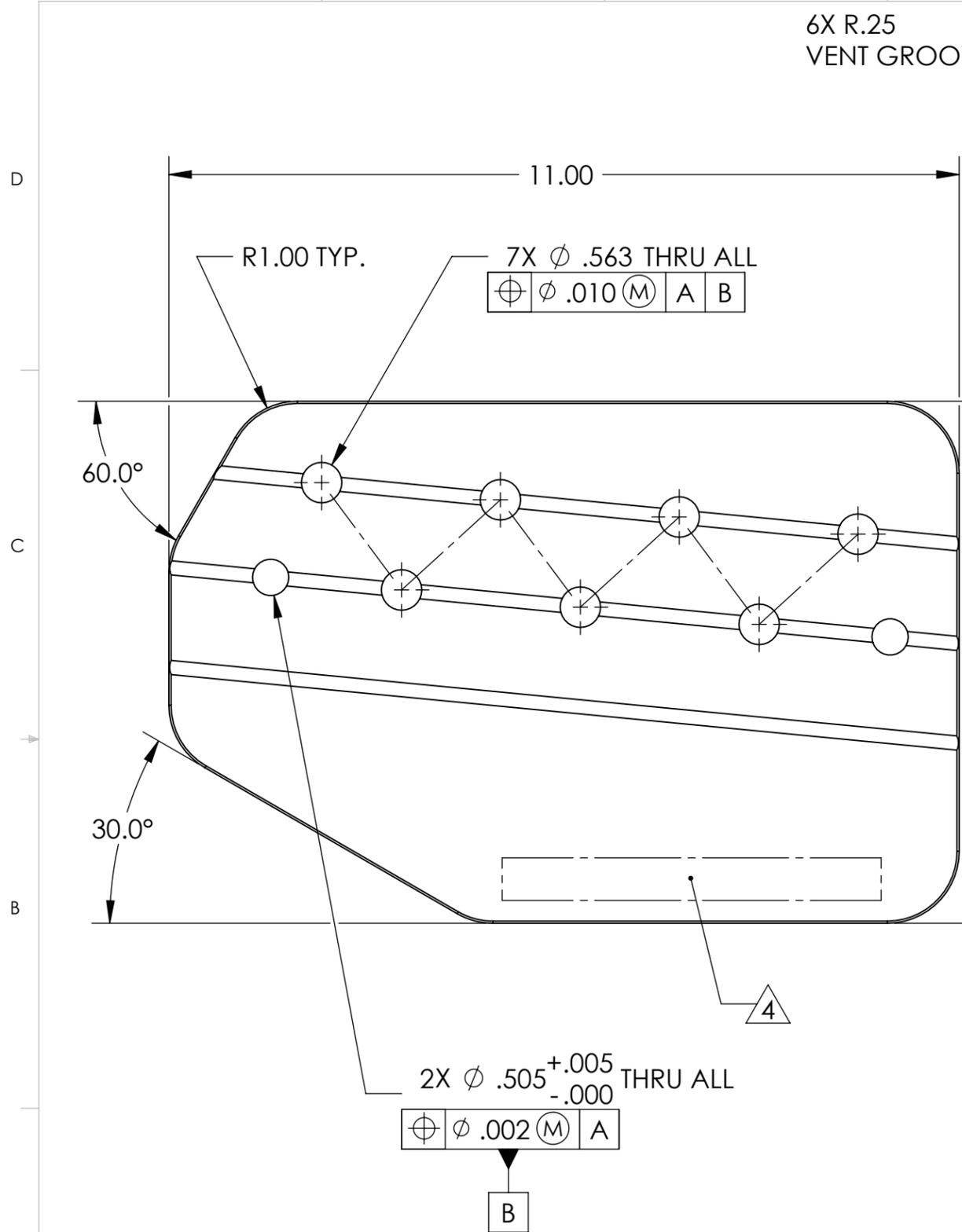


8 7 6 5 4 3 2 1

REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / B	12 Jul 2007	1068	Dan Bryce	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Changed vent groove details. Added chamfers, top and bottom.



**MACHINING 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.

D071003-V2  
S/N - ###

**POST-MACHINING NOTES:**

P1) CLEAN TO LIGO STANDARDS, CLASS A.

**SECTION A-A**

APPROVALS	DATE
ENGINEERING (HPD): (HPD)	
QUALITY (HPD): (HPD)	
MATERIAL: <b>304 SS</b>	
FINISH: <b>Electropolish</b>	
MASS: <b>5.1 lbs</b>	

**UNLESS OTHERWISE SPECIFIED:**

DIMENSIONS ARE IN INCHES  
DECIMAL TOLERANCES:  
.XX ±.015 .XXX ±.005

ANG TOL: ± 1° SURFACE ROUGHNESS: 63

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:

.010 A B

ORIGINAL DESIGN BY:		<b>High Precision Devices</b>		MODIFIED BY:
		1668 Valtec Lane, Suite C, Boulder, Colorado 80301		
		Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		
DESCRIPTION: <b>Support Post Cap</b>				
P/N: <b>D071003</b>		CONFIG: -		
CAD FILE NAME: D071003_Support_Post_Cap				
PROJECT: HAM ISI, Advanced LIGO				
SIZE	SCALE: <b>1:2</b>	DRAWN BY: <b>Bryce/Waterman (HPD)</b>		REV
<b>B</b>	SHEET <b>1</b> OF <b>1</b>	DATE PRINTED: <b>3/13/2009</b>		<b>V2</b>