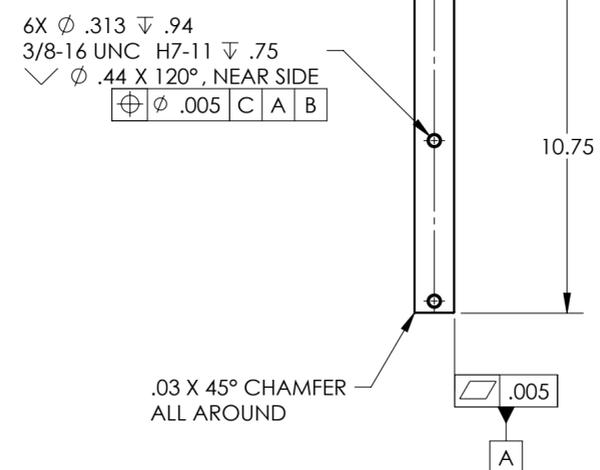
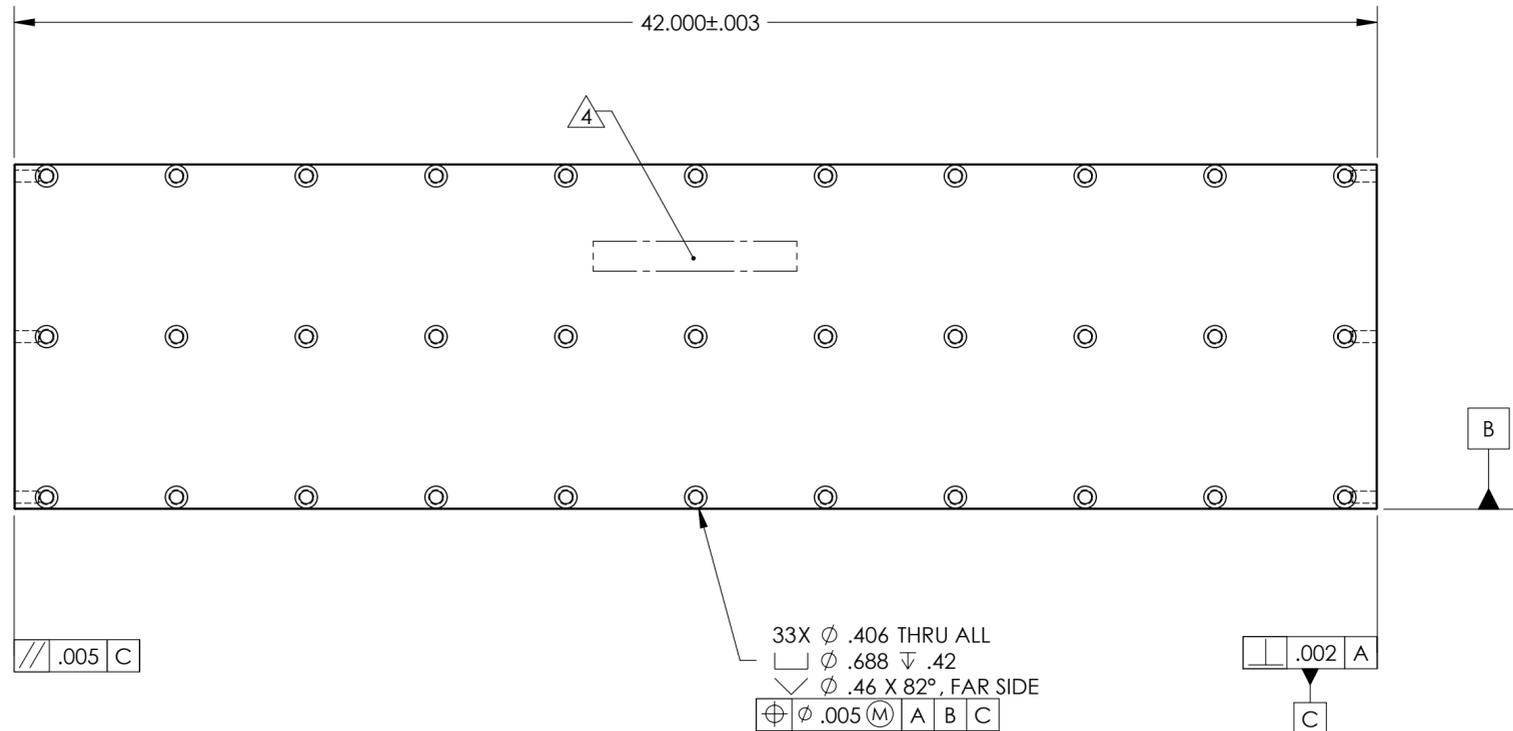
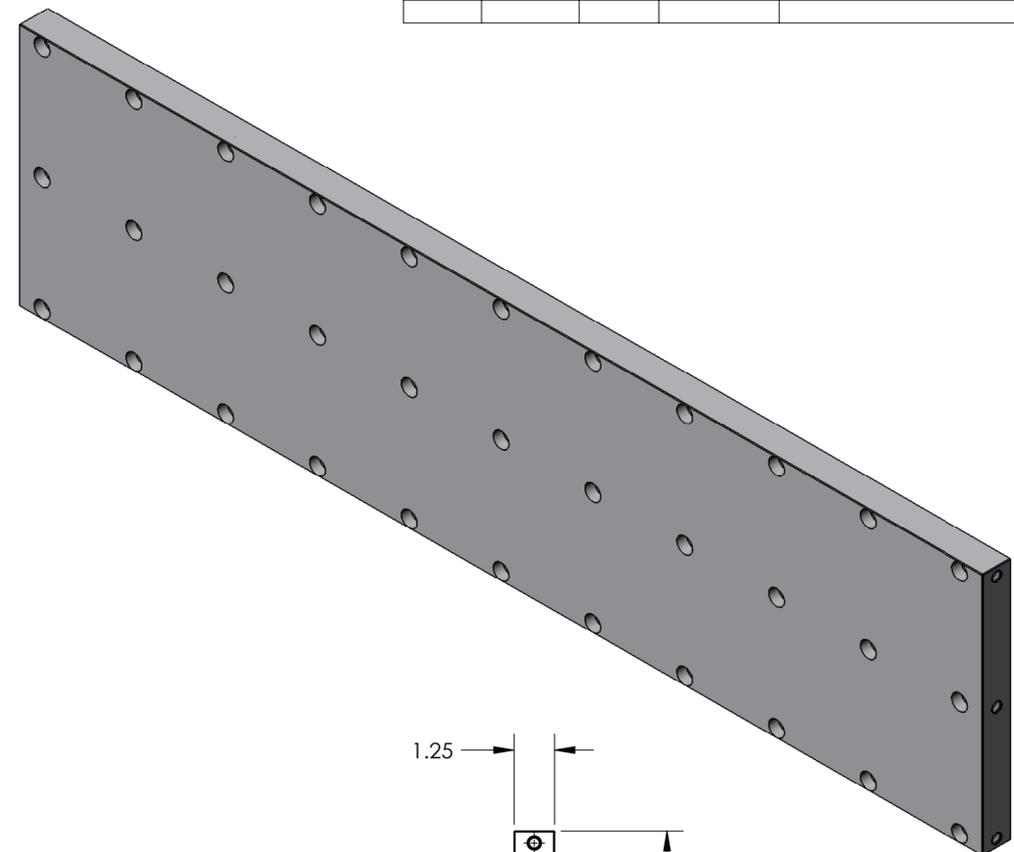


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	10 Jul 2007	1068	Daniel Bryce	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers. Added c/sinks.



MACHINING NOTES:

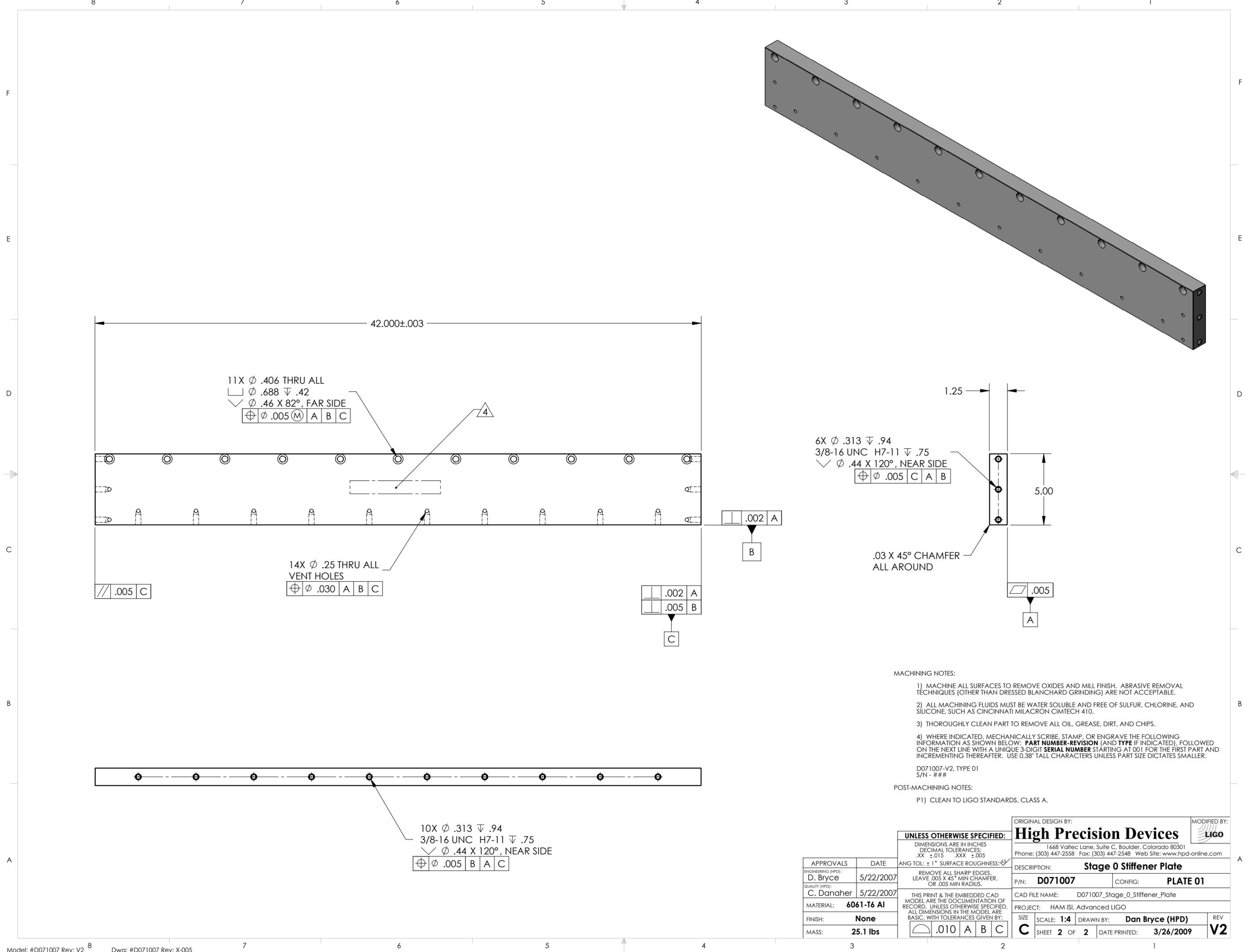
- 1) MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES (OTHER THAN DRESSED BLANCHARD GRINDING) ARE NOT ACCEPTABLE.
- 2) ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.
- 3) THOROUGHLY CLEAN 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.

D071007-V2, TYPE 00  
 S/N - ###

POST-MACHINING NOTES:

P1) CLEAN TO LIGO STANDARDS, CLASS A.

APPROVALS		DATE	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: $\square$ .010 A B C	ORIGINAL DESIGN BY: <b>High Precision Devices</b> 1448 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	MODIFIED BY: 
ENGINEERING (HPD): D. Bryce		5/22/2007		DESCRIPTION: <b>Stage 0 Stiffener Plate</b>	
QUALITY (HPD): C. Danaher		5/22/2007	P/N: <b>D071007</b>	CONFIG: <b>PLATE 00</b>	
MATERIAL: <b>6061-T6 Al</b>			CAD FILE NAME: D071007_Stage_0_Stiffener_Plate		
FINISH: <b>None</b>			PROJECT: HAM ISI, Advanced LIGO		
MASS: <b>54.1 lbs</b>			SIZE SCALE: <b>1:4</b>	DRAWN BY: <b>Dan Bryce (HPD)</b>	
			SHEET <b>1</b> OF <b>2</b>	DATE PRINTED: <b>3/26/2009</b>	
				REV <b>V2</b>	



11X  $\phi$  .406 THRU ALL  
 $\square$   $\phi$  .688  $\nabla$  .42  
 $\sphericalangle$   $\phi$  .46 X 82°, FAR SIDE  
 $\oplus$   $\phi$  .005 (M) A B C

14X  $\phi$  .25 THRU ALL  
 VENT HOLES  
 $\oplus$   $\phi$  .030 A B C

6X  $\phi$  .313  $\nabla$  .94  
 3/8-16 UNC H7-11  $\nabla$  .75  
 $\sphericalangle$   $\phi$  .44 X 120°, NEAR SIDE  
 $\oplus$   $\phi$  .005 C A B

10X  $\phi$  .313  $\nabla$  .94  
 3/8-16 UNC H7-11  $\nabla$  .75  
 $\sphericalangle$   $\phi$  .44 X 120°, NEAR SIDE  
 $\oplus$   $\phi$  .005 B A C

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.  
 D071007-V2, TYPE 01  
 S/N - ###

POST-MACHINING NOTES:  
 P1) CLEAN TO LIGO STANDARDS, CLASS A.

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/22/2007
QUALITY (HPD): C. Danaher	5/22/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	25.1 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.  
 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:  
 $\square$  .010 A B C

ORIGINAL DESIGN BY:	MODIFIED BY:
<b>High Precision Devices</b>	
1448 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
DESCRIPTION:	<b>Stage 0 Stiffener Plate</b>
P/N: <b>D071007</b>	CONFIG: <b>PLATE 01</b>
CAD FILE NAME: D071007_Stage_0_Stiffener_Plate	
PROJECT: HAM ISI, Advanced LIGO	
SIZE	REV
SCALE: <b>1:4</b>	DRAWN BY: <b>Dan Bryce (HPD)</b>
SHEET <b>2</b> OF <b>2</b>	DATE PRINTED: <b>3/26/2009</b>
<b>C</b>	<b>V2</b>