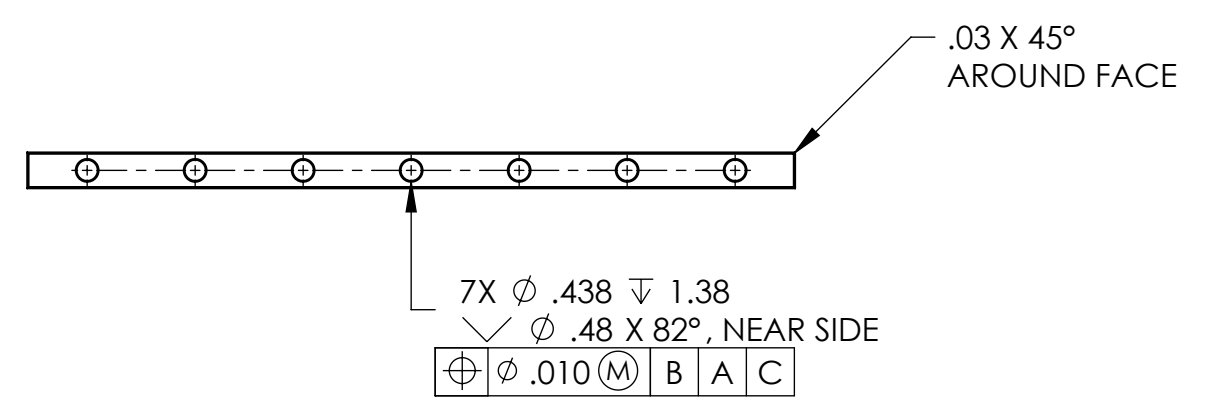
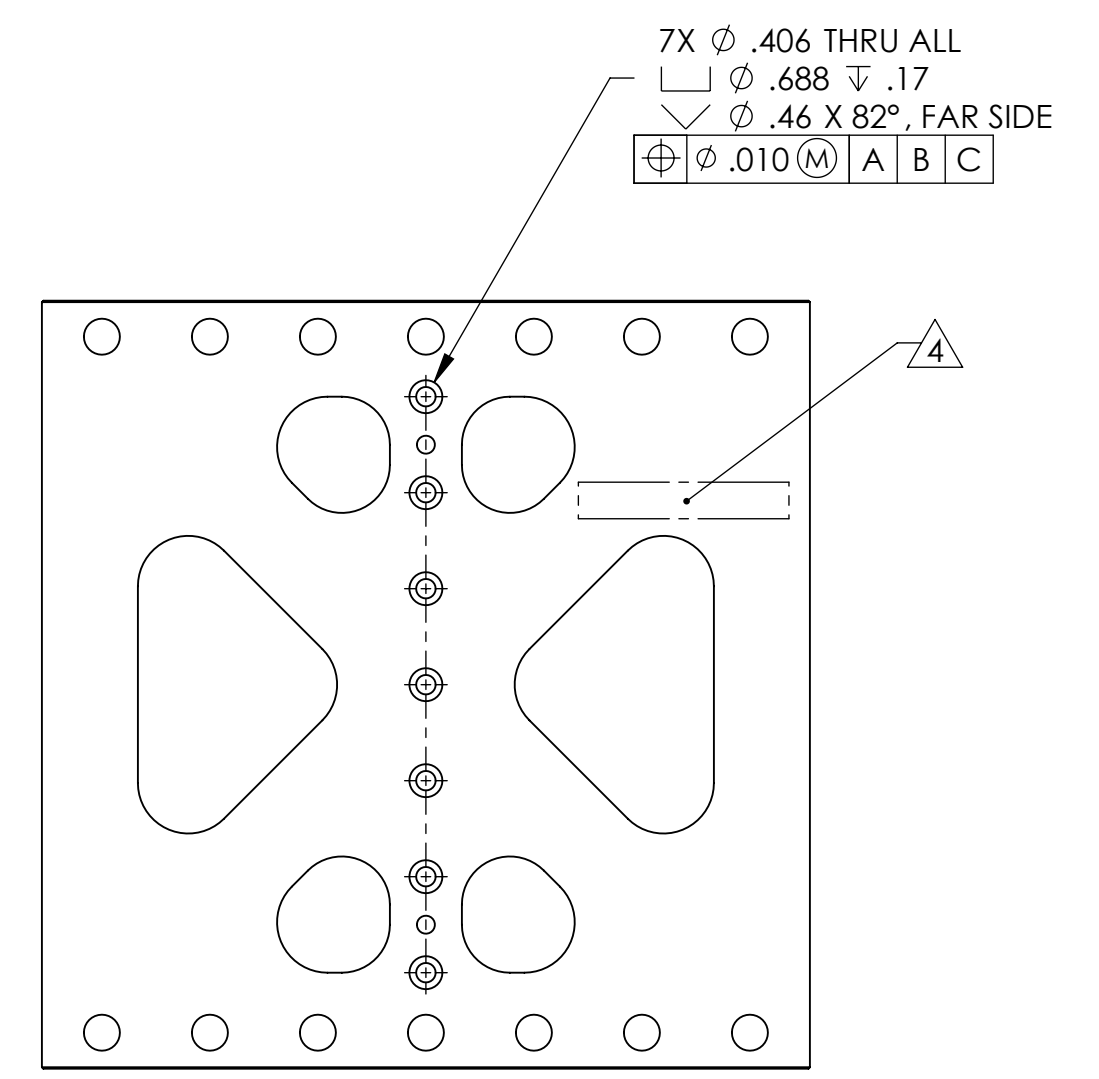
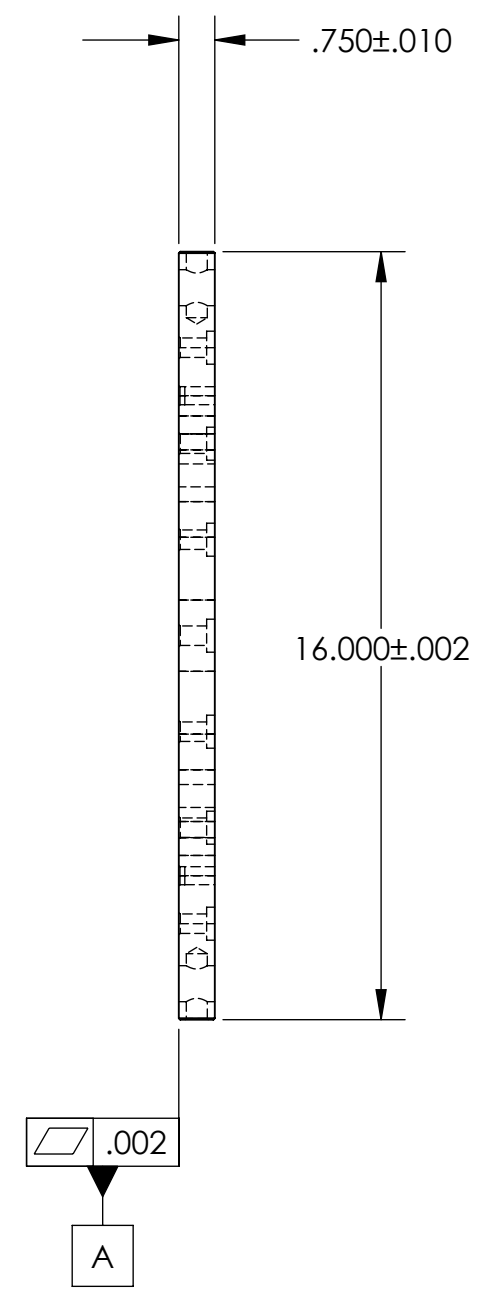
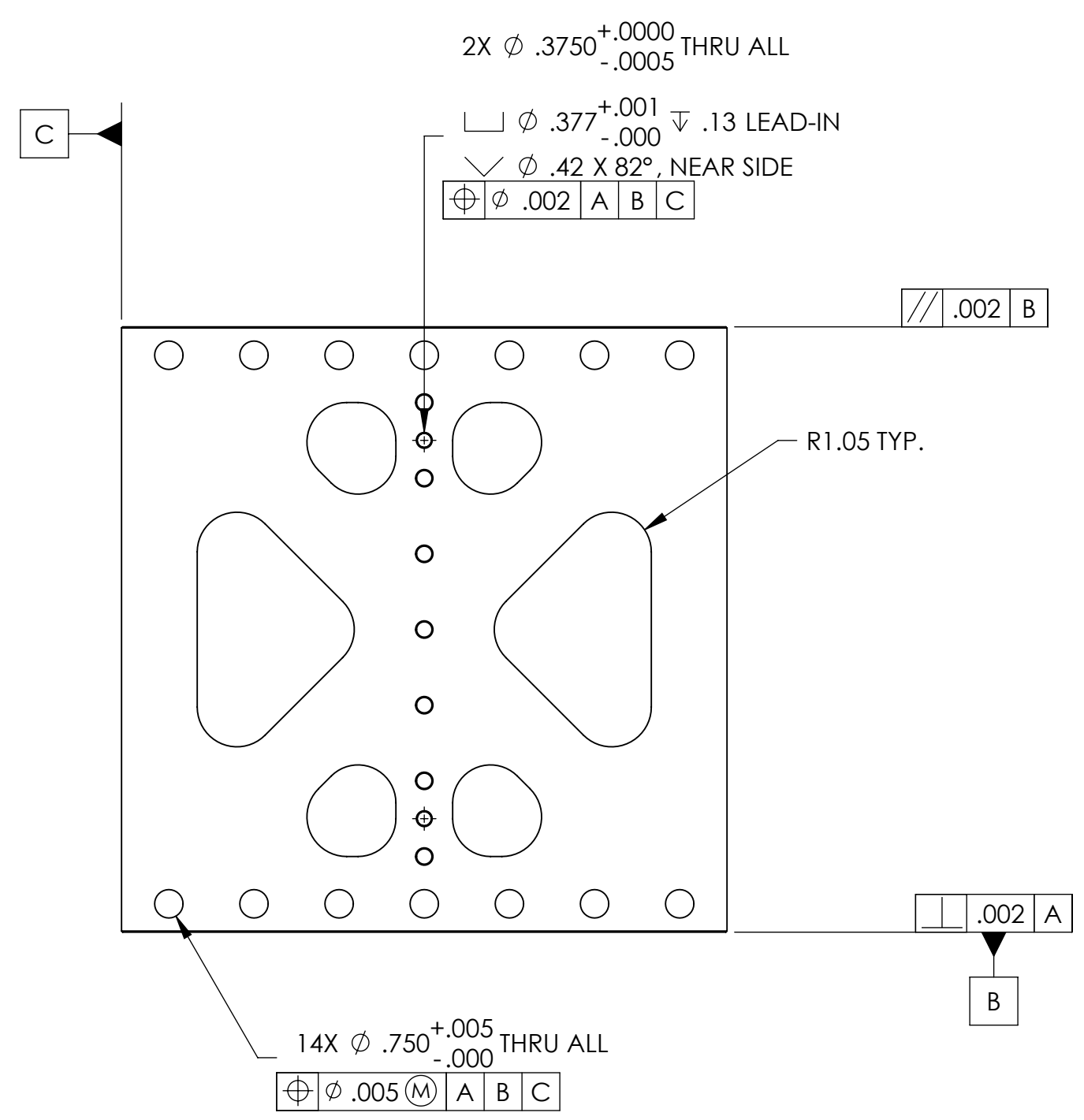
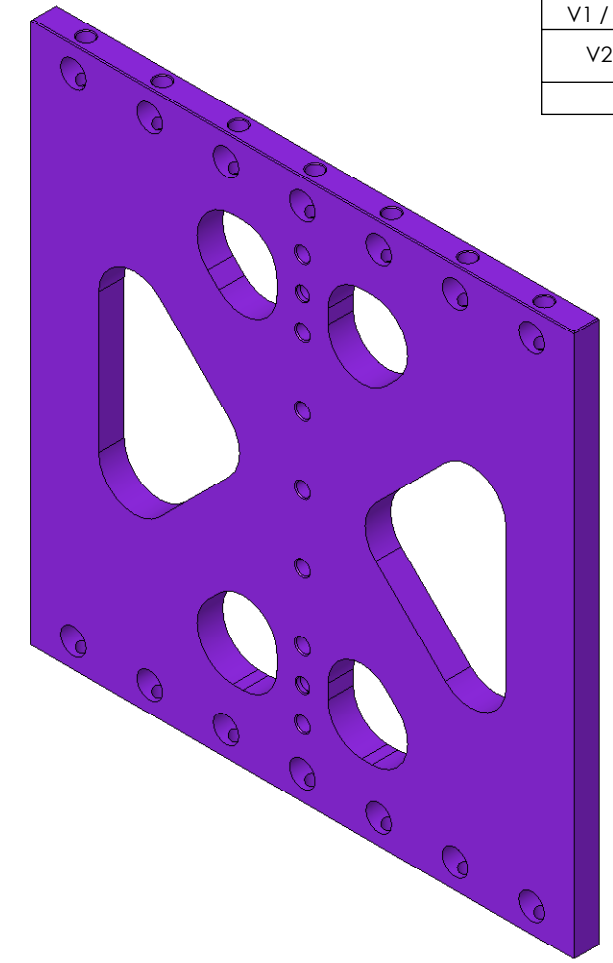
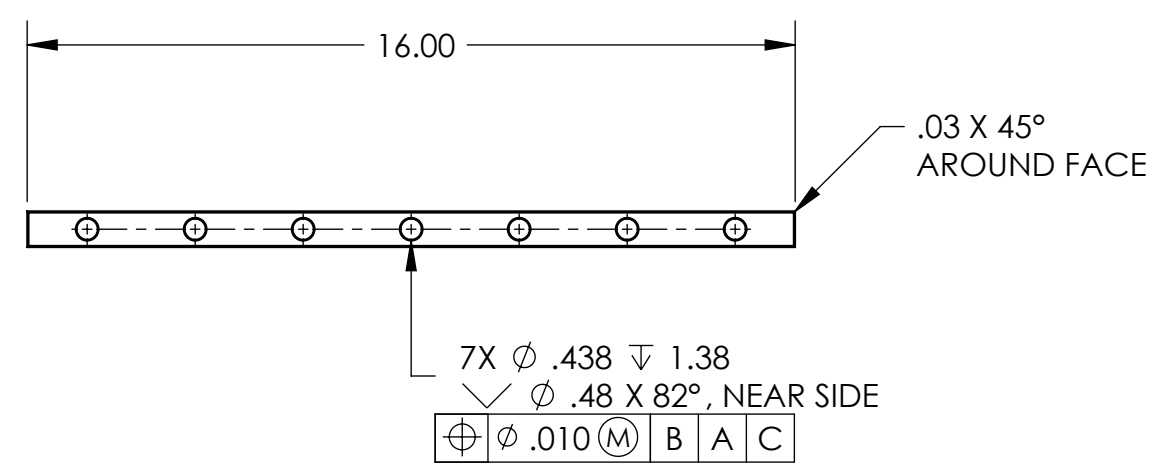


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	12 Jun 2007	1064	D. Senders	Release for Enhanced LIGO.
V2	31 Mar 2009		A. Stein	Release for Advanced LIGO. Added lead-ins for press-fit pin holes. Added chamfers and c/sinks.



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.

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: REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.	ORIGINAL DESIGN BY: High Precision Devices	MODIFIED BY: LIGO
ENGINEERING (HPD): D. Senders		5/22/2007		1468 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
QUALITY (HPD): C. Danaher		5/22/2007	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:	DESCRIPTION: Rib, Tan, GS-13 Cen	
MATERIAL: 6061-T6 Al				P/N: D071053	CONFIG: -
FINISH: None				CAD FILE NAME: D071053_Rib-Tan-GS-13_Cen	
MASS: 14.0 lbs				PROJECT: HAM ISI, Advanced LIGO	
				SIZE: C	SCALE: 1:4
				DRAWN BY: Dave Senders (HPD)	REV: V2
				DATE PRINTED: 3/31/2009	