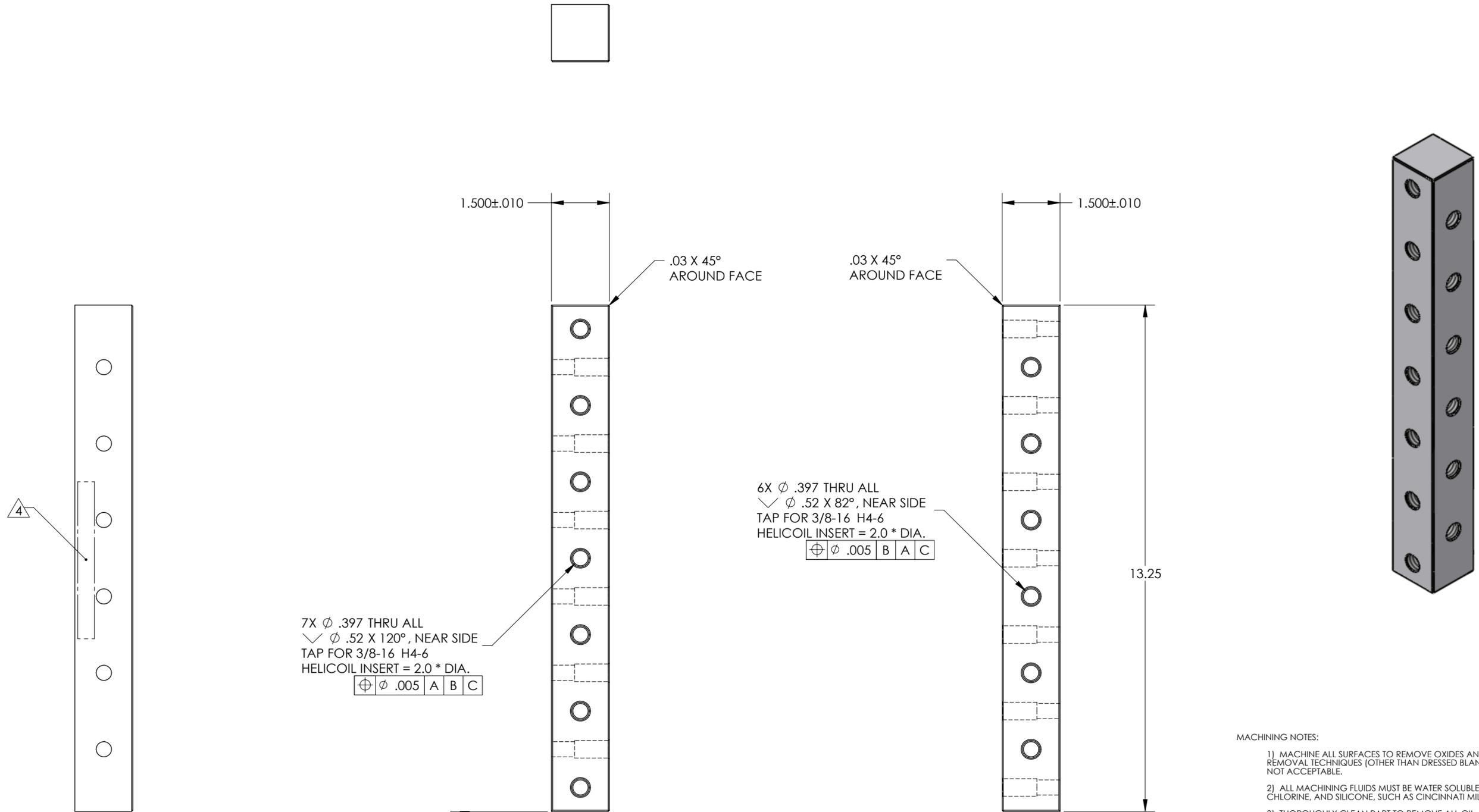


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	10 Jul 2007	1068	D. Bryce	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers around interface surfaces.



- 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.
- D071061-V2  
S/N - ###
- 5) DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.
- POST-MACHINING NOTES:
- P1) CLEAN TO LIGO STANDARDS, CLASS A.
- P2) INSTALL CLASS-A CLEAN HELI-COILS. BREAK OFF AND REMOVE TANGS. CHECK THAT END OF EACH INSERT REMAINS ENGAGED IN THREAD AFTER TANG REMOVAL.

HELI-COIL TABLE (See Note 5)				
Item No.	Thread Size	Material	Heli-Coil P/N 1185...	Qty.
1	3/8"-16 x .75"	Nitronic 60	-6EN750	13

APPROVALS	DATE
ENGINEERING (HPD): D. Senders	5/22/2007
QUALITY (HPD): C. Danaher	5/22/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	2.6 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:			

ORIGINAL DESIGN BY: **High Precision Devices**

1448 Valtec Lane, Suite C, Boulder, Colorado 80301  
Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

DESCRIPTION: **Outer Wall, Bracket 90**

P/N: **D071061** CONFIG: -

CAD FILE NAME: D071061\_Outer\_Wall-Bracket\_90

PROJECT: HAM ISI, Advanced LIGO

SIZE	SCALE: 1:2	DRAWN BY: Dave Senders (HPD)	REV
C	SHEET 1 OF 1	DATE PRINTED: 3/17/2009	V2