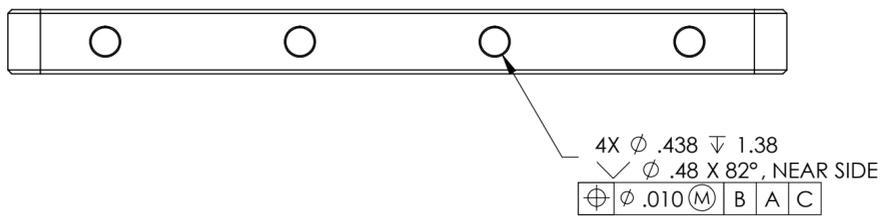
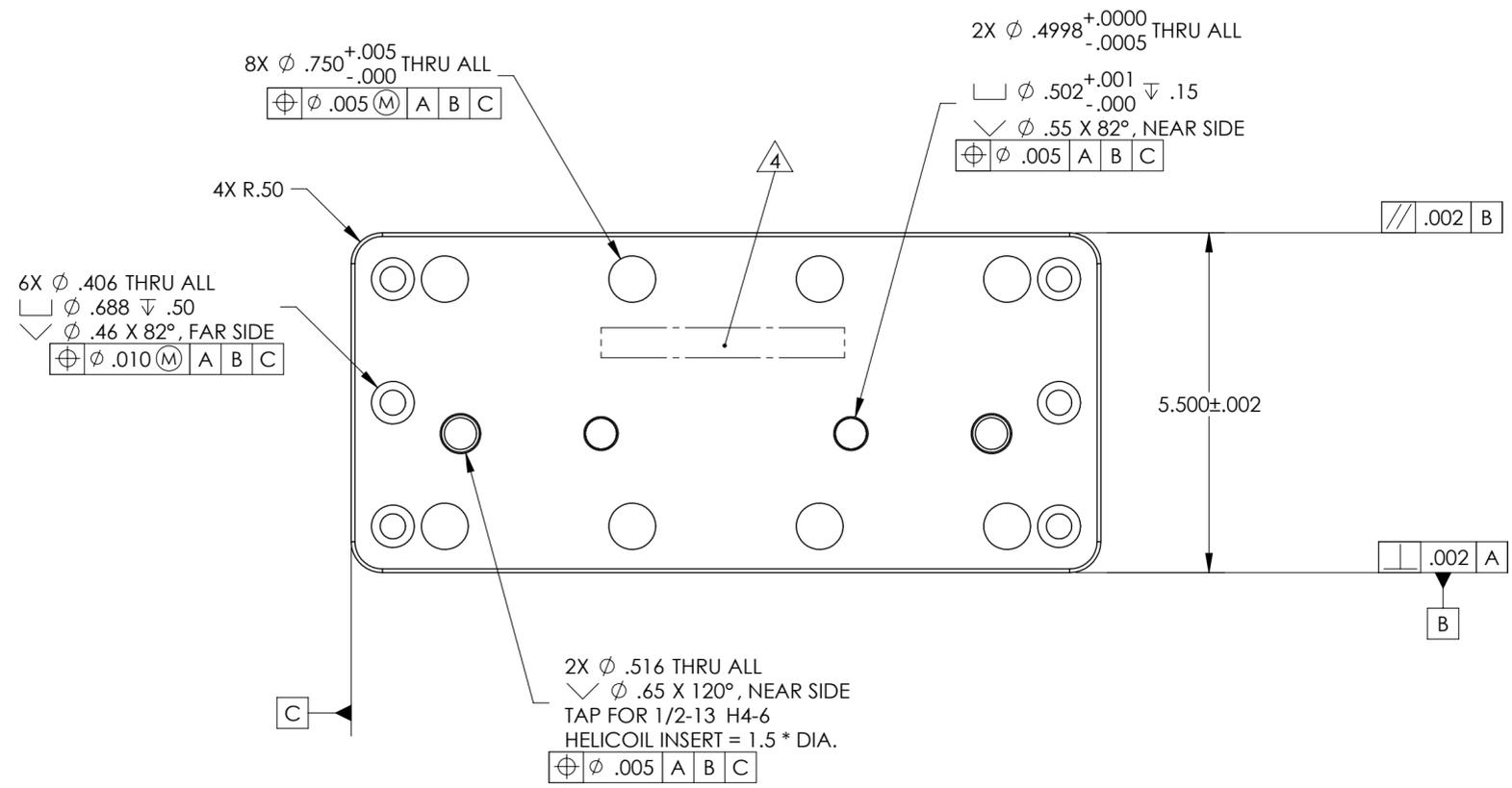
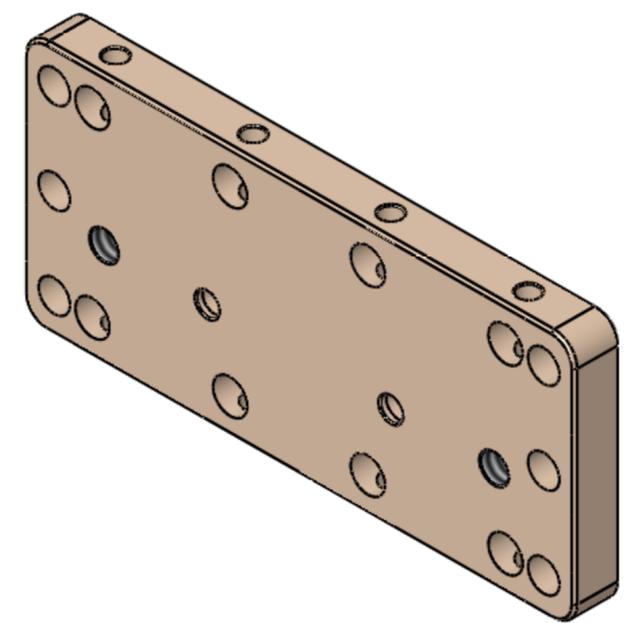
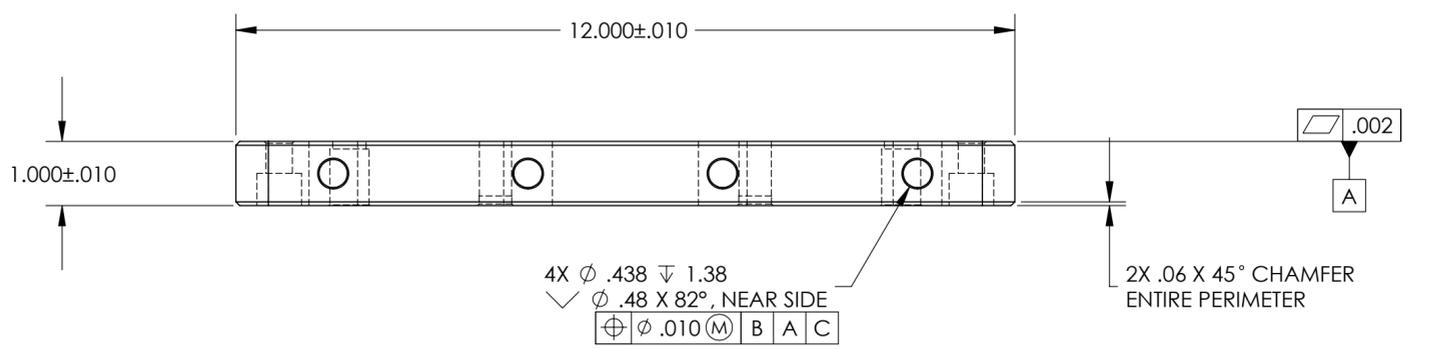


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	2 Jul 2007	1067	D. Bryce	Release for Enhanced LIGO.
V2	13 Mar 2009		A. Stein	Release for Advanced LIGO. Added lead-in sections to press-fit pin holes. Changed depth of c'bores. Added/changed c'sinks.



- 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.  
D071063-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	1/2"-13 x .75"	Nitronic 60	-8EN750	2

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/29/2007
QUALITY (HPD): C. Danaher	5/29/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	5.7 lbs

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 C

ORIGINAL DESIGN BY:	<b>High Precision Devices</b>		MODIFIED BY:
	1468 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		
DESCRIPTION:	Keel Wall		
P/N:	D071063	CONFIG:	-
CAD FILE NAME:	D071063_Keel_Wall		
PROJECT:	HAM ISI, Advanced LIGO		
SIZE	SCALE: 1:2	DRAWN BY:	Senders/Bryce (HPD)
C	SHEET 1 OF 1	DATE PRINTED:	3/27/2009
			REV V2