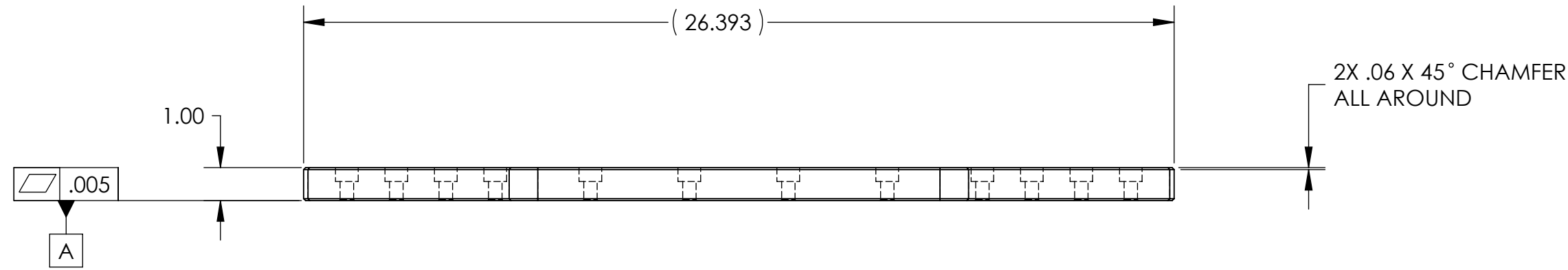
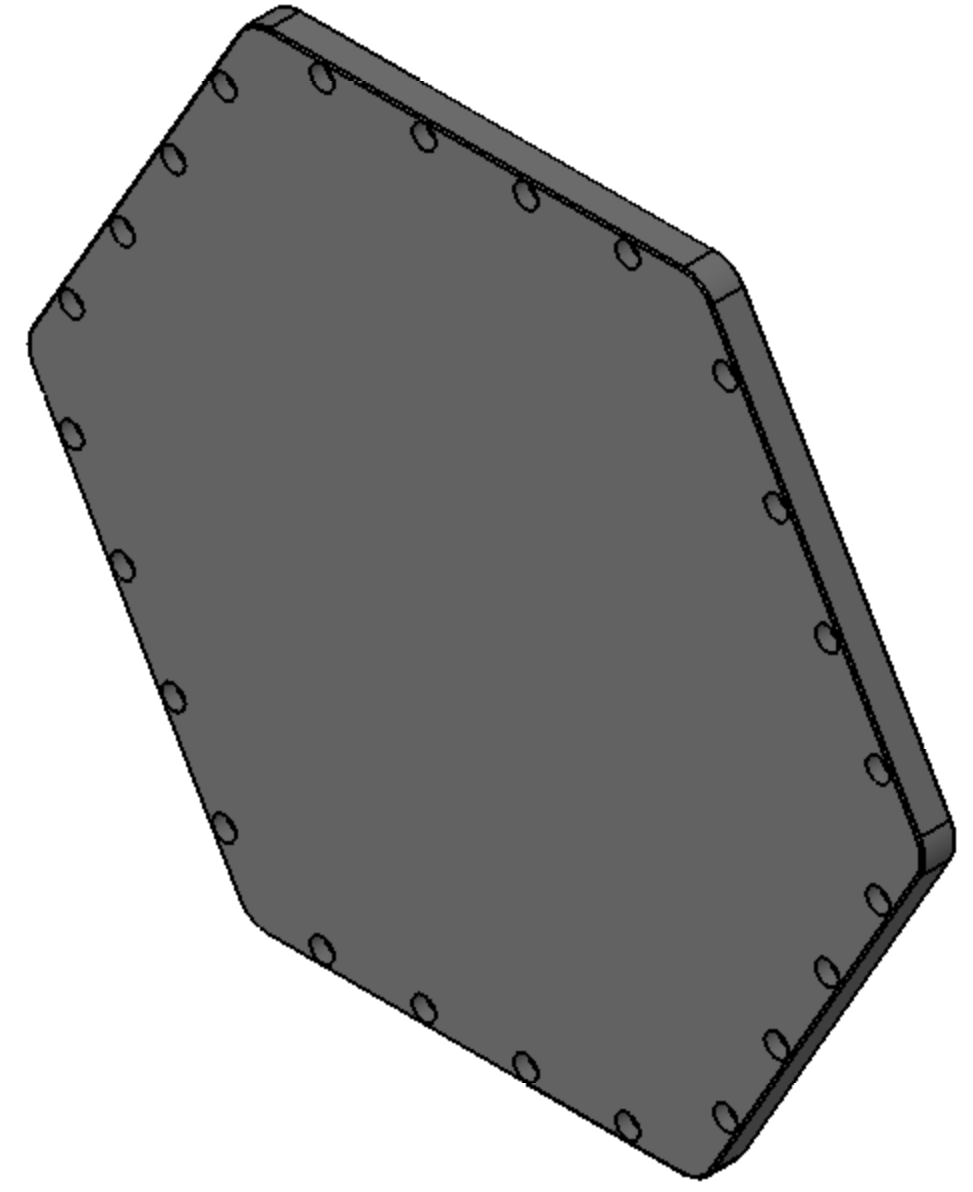
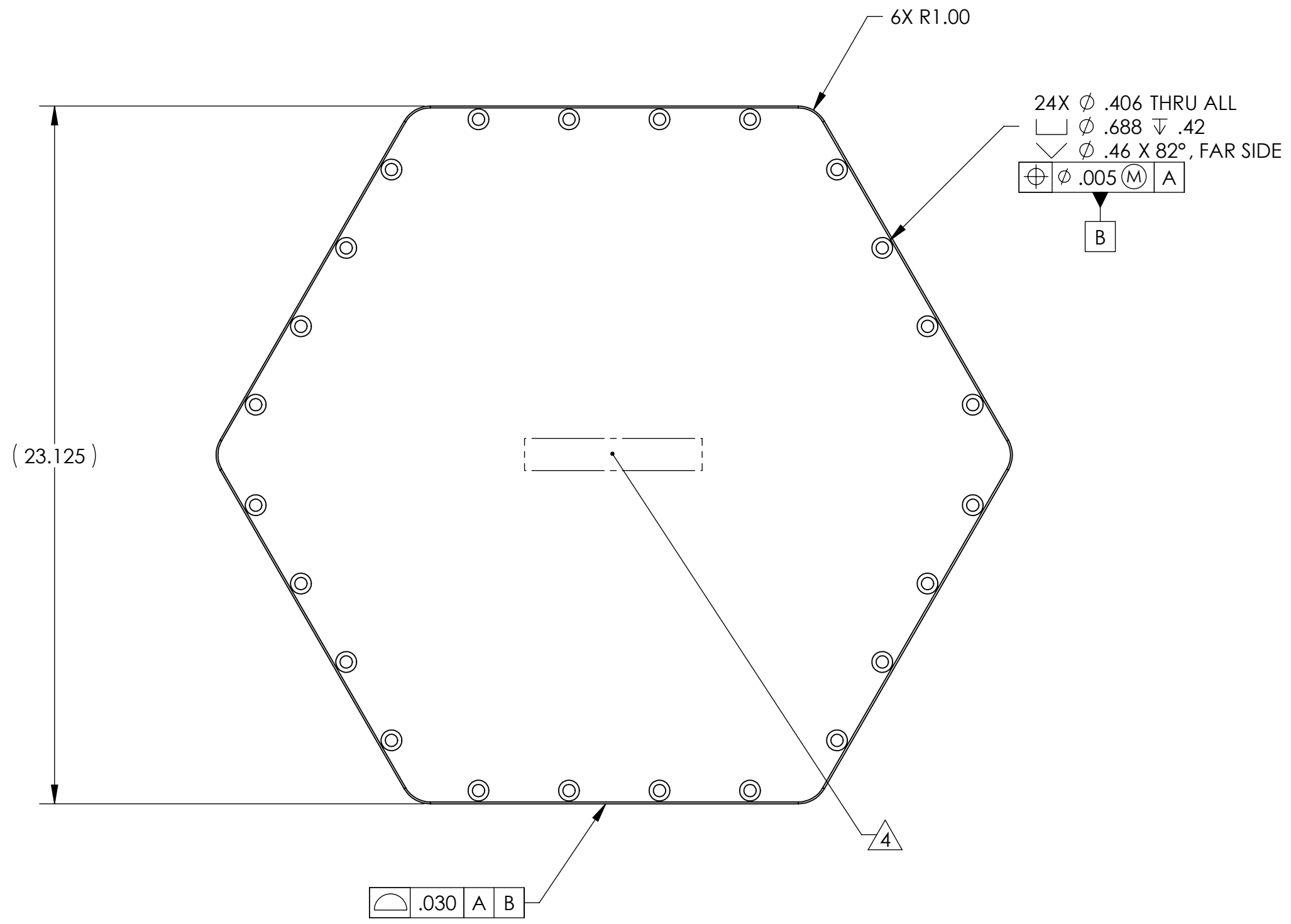


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	2 Jul 2007	1067	Dan Bryce	Release for Enhanced LIGO.
V2	13 Mar 2009		A. Stein	Release for Advanced LIGO. Added c'sinks to far-side of thru holes.



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.

D071065-V2
S/N - ###

POST-MACHINING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A.

UNLESS OTHERWISE SPECIFIED:	
DIMENSIONS ARE IN INCHES	
DECIMAL TOLERANCES:	
.XX ±.015	.XXX ±.005
ANG TOL: ± 1° SURFACE ROUGHNESS: 6.3	
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		MODIFIED BY:
	1448 Valtec Lane, Suite C, Boulder, Colorado 80301		
	Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		
DESCRIPTION:	Keel Base		
P/N:	D071065	CONFIG:	-
CAD FILE NAME:	D071065_Keel_Base		
PROJECT:	HAM ISI, Advanced LIGO		
SIZE	SCALE: 1:4	DRAWN BY: Jonas Waterman (HPD)	REV
C	SHEET 1 OF 1	DATE PRINTED: 3/27/2009	V2

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/29/2007
QUALITY (HPD): C. Danaher	5/29/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	44.6 lbs