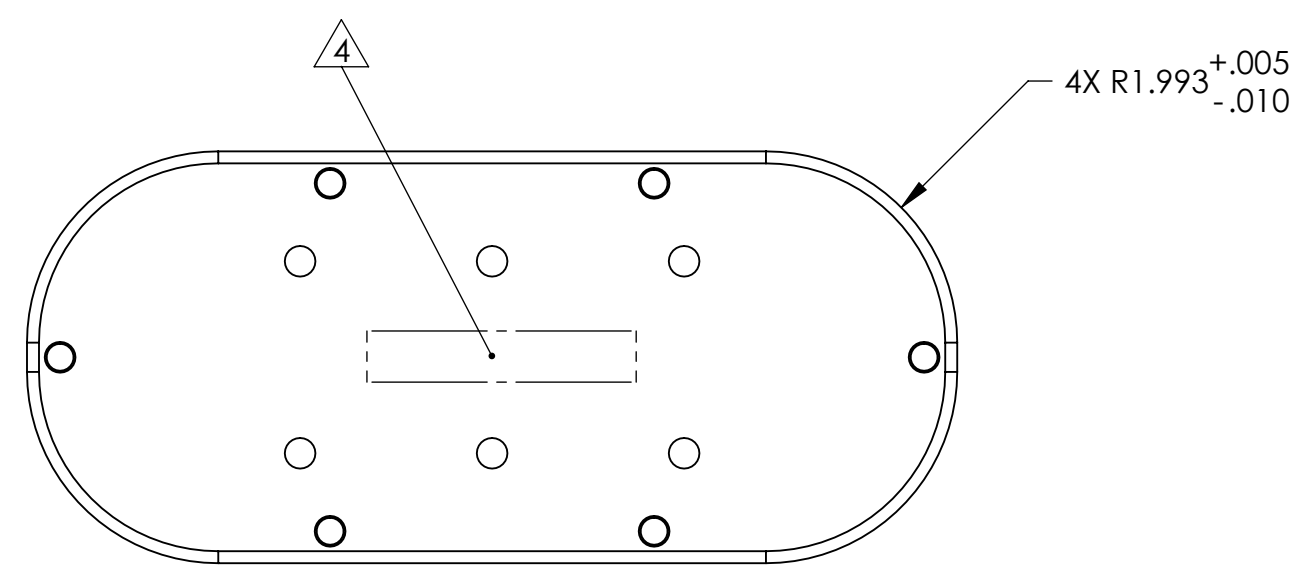
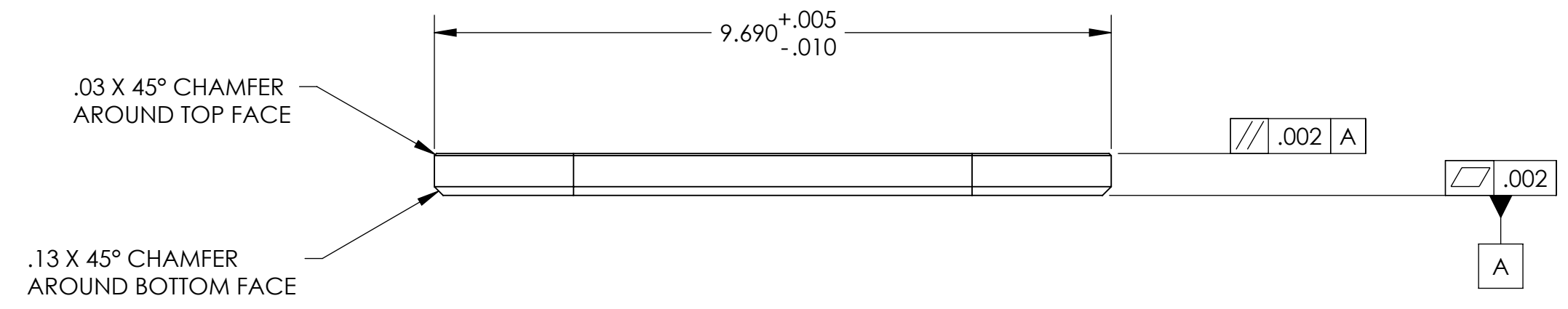
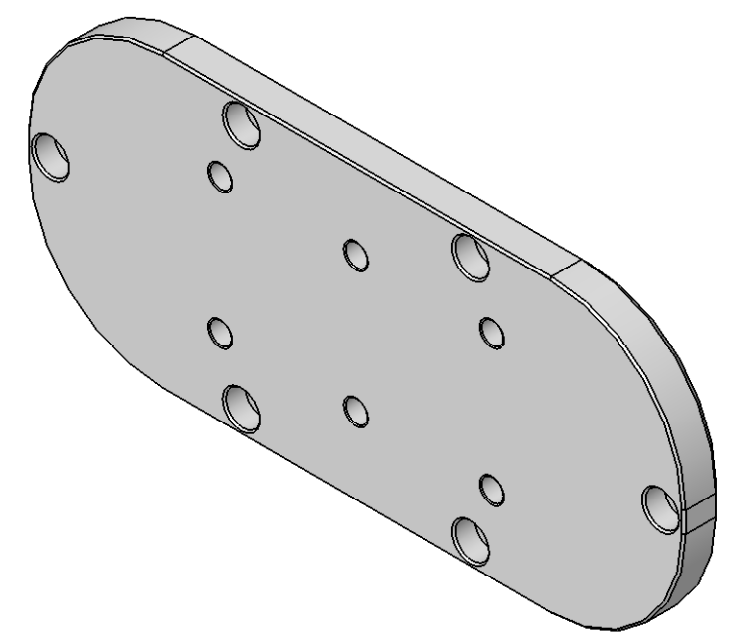
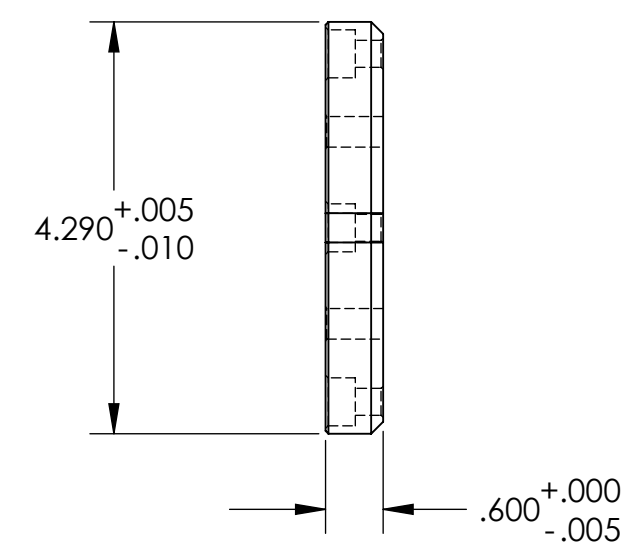
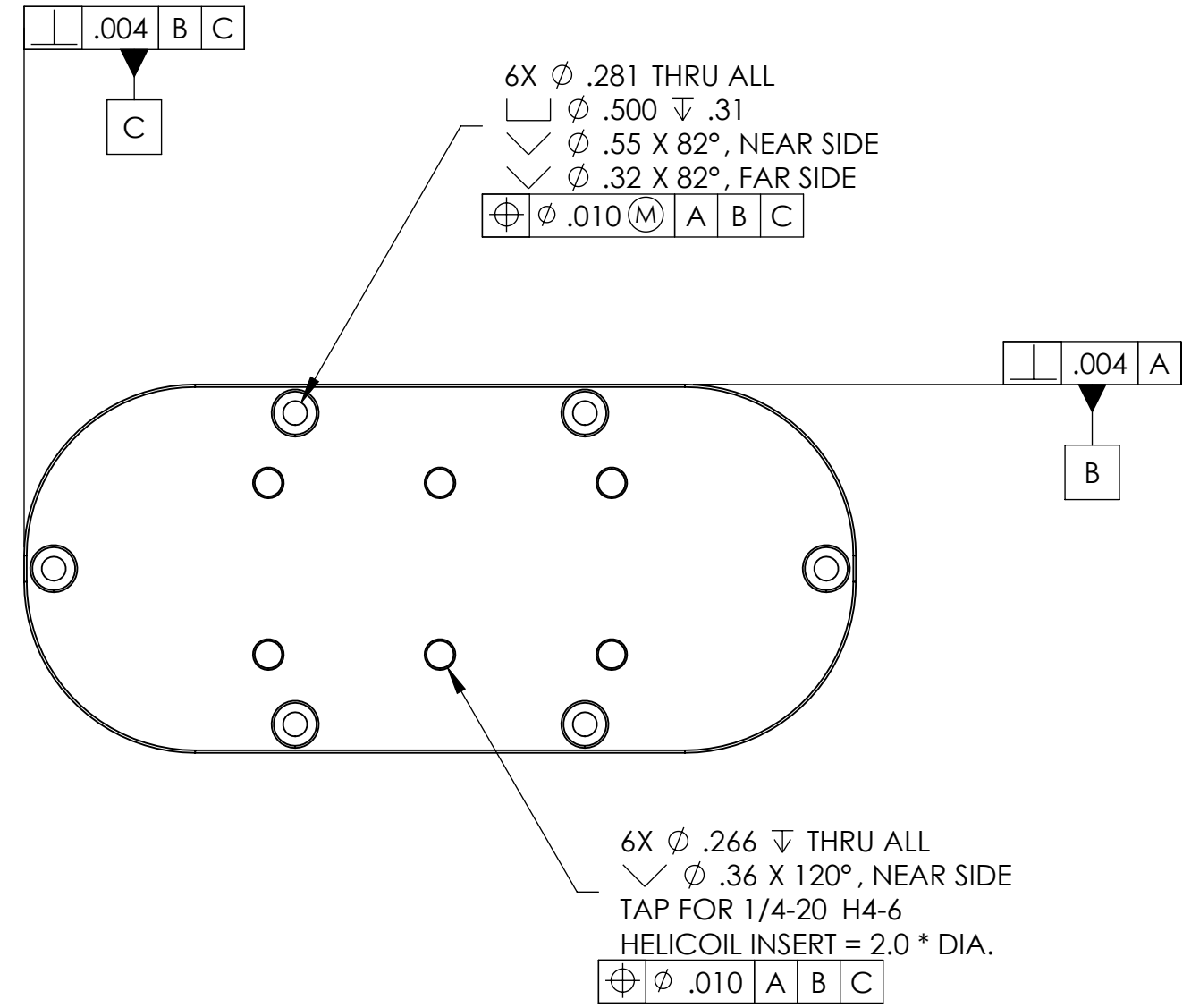


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	3 Jul 2007	1067	D. Senders	Release for Enhanced LIGO.
V2	25 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfer around top face. Added c'sinks.



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.

D071067-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	Qty.
1	1/4"-20 x .50"	Nitronic 60	-4EN500	6

APPROVALS	DATE
ENGINEERING (HPD): D. Senders	6/15/2007
QUALITY (HPD): C. Danaher	6/15/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	2.1 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:

\oplus ϕ .010 A B C

ORIGINAL DESIGN BY:	MODIFIED BY:
High Precision Devices	
1468 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
DESCRIPTION:	Spring Hatch, Optics Table
P/N:	D071067
CAD FILE NAME:	D071067_Spring_Hatch-Optics_Table
PROJECT:	HAM ISI, Advanced LIGO
SIZE	SCALE: 1:2
DATE PRINTED:	3/25/2009
REV	V2