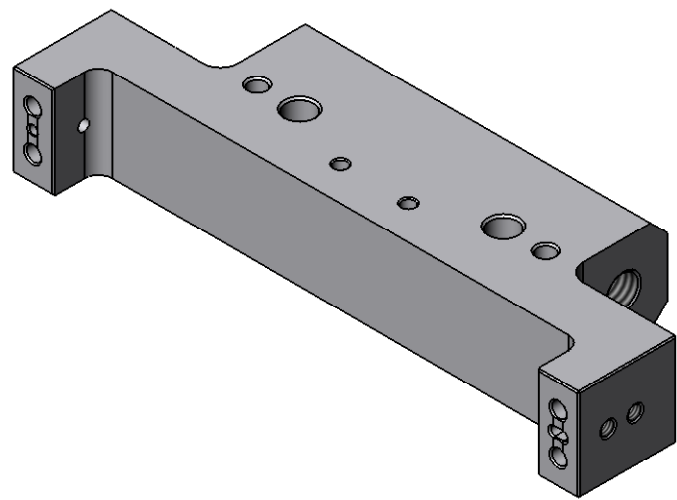


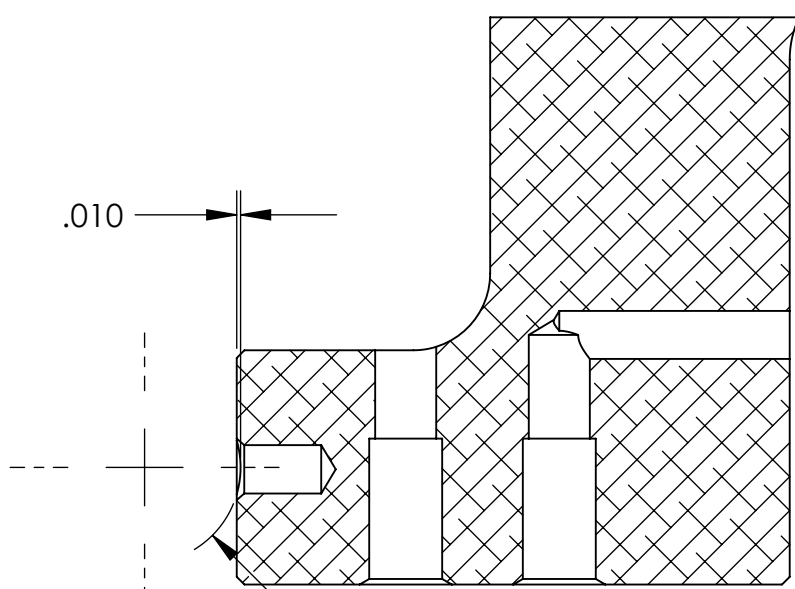
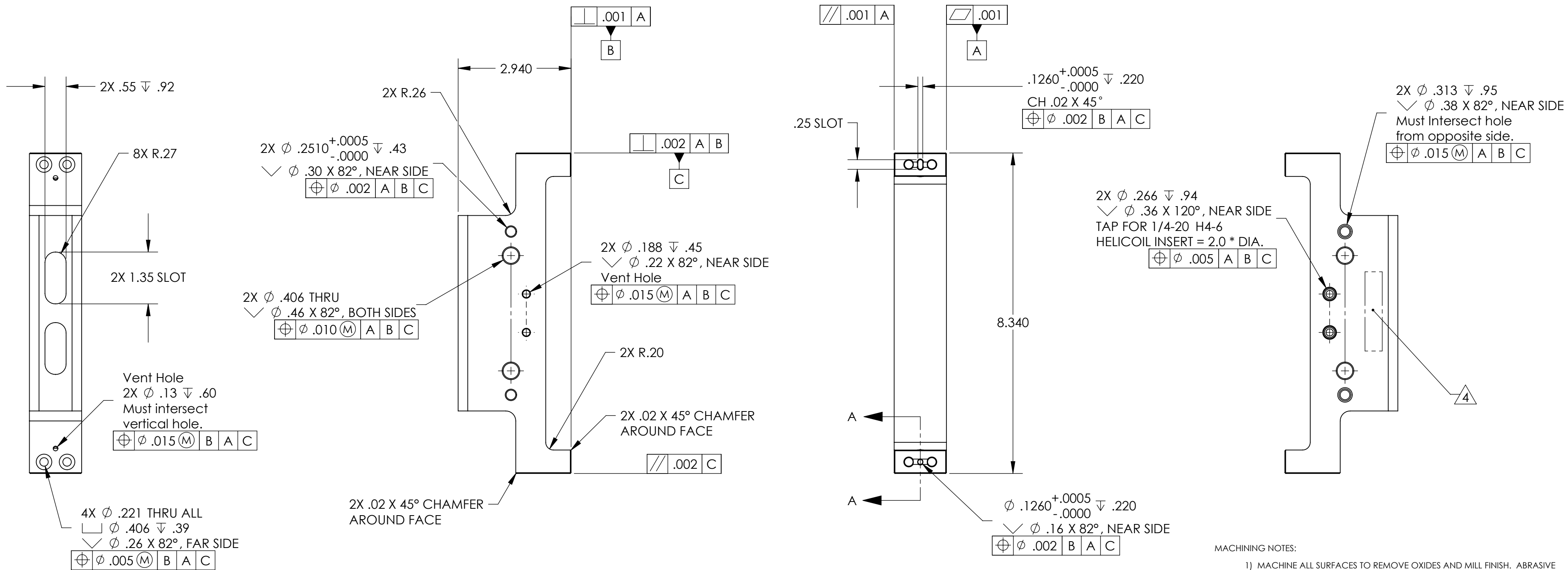
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	21 Aug 2007	1071	D. Senders	Release for Enhanced LIGO.
V2	1 Apr 2009		A. Stein	Release for Advanced LIGO. Changed venting details. Added chamfers and c/sinks. Replaced 2x c bores with straight thru holes.



$\phi .397 \downarrow 1.15$   
 $\sphericalangle \phi .52 \times 120^\circ$ , NEAR SIDE  
 TAP FOR 3/8-16 H4-6  
 HELICOIL INSERT = 2.0 \* DIA.  
 Must be fully tapped THRU  
 intersection with pocket.

$\phi .010$	C	A	B
-------------	---	---	---

2X  $\phi .159 \downarrow .65$   
 10-32 UNF H7-11  $\downarrow .38$   
 $\sphericalangle \phi .24 \times 120^\circ$ , NEAR SIDE  
 $\phi .005$  C A B



$\phi .397 \downarrow 1.15$   
 $\sphericalangle \phi .52 \times 120^\circ$ , NEAR SIDE  
 TAP FOR 3/8-16 H4-6  
 HELICOIL INSERT = 2.0 \* DIA.  
 Must be fully tapped THRU  
 intersection with pocket.

$\phi .010$	C	A	B
-------------	---	---	---

2X  $\phi .159 \downarrow .65$   
 10-32 UNF H7-11  $\downarrow .38$   
 $\sphericalangle \phi .24 \times 120^\circ$ , NEAR SIDE  
 $\phi .005$  C A B

- 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.
- D071121-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	2
2	3/8"-16 x .75"	Nitronic 60	-6EN750	2

APPROVALS	DATE	ANG TOL: ± 1" SURFACE ROUGHNESS: 63
ENGINEERING (HPD): D. Senders	7/31/2007	
QUALITY (HPD): C. Danaher	7/31/2007	
MATERIAL: <b>6061-T6 Al</b>		
FINISH: <b>None</b>		
MASS: <b>1.7 lbs</b>		

UNLESS OTHERWISE SPECIFIED:		
DIMENSIONS ARE IN INCHES		
DECIMAL TOLERANCES:		
.XX ±.015	.XXX ±.005	
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:		
$\phi .010$	A	B C

ORIGINAL DESIGN BY:	MODIFIED BY:
<b>High Precision Devices</b>	<b>LIGO</b>
1468 Valtrec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
DESCRIPTION:	<b>Actuator Coil Support</b>
P/N: <b>D071121</b>	CONFIG: -
CAD FILE NAME: D071121_Actuator_Coil_Support	
PROJECT: HAM ISI, Advanced LIGO	
SIZE	REV
SCALE: <b>1:2</b>	DRAWN BY: <b>Dave Senders (HPD)</b>
<b>C</b>	<b>V2</b>
SHEET 1 OF 1	DATE PRINTED: <b>4/2/2009</b>