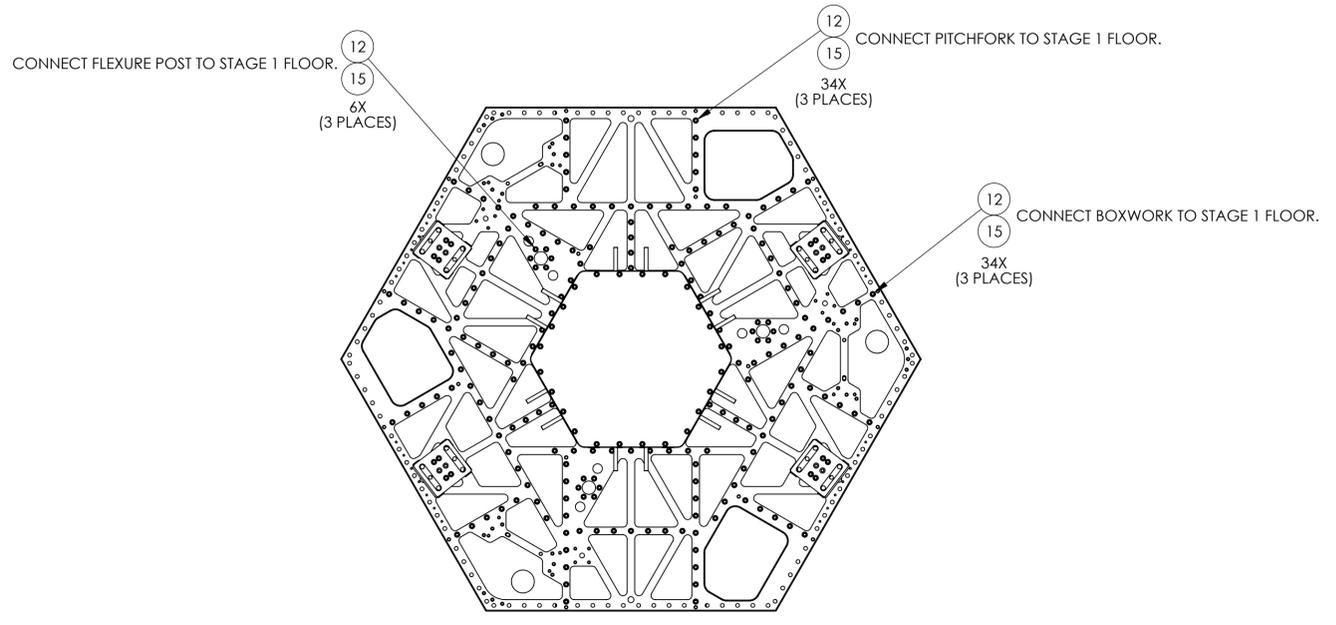
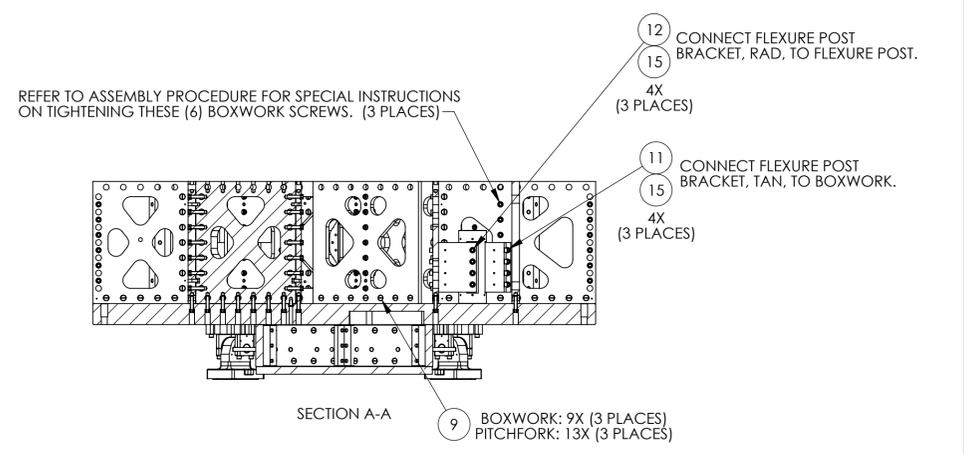
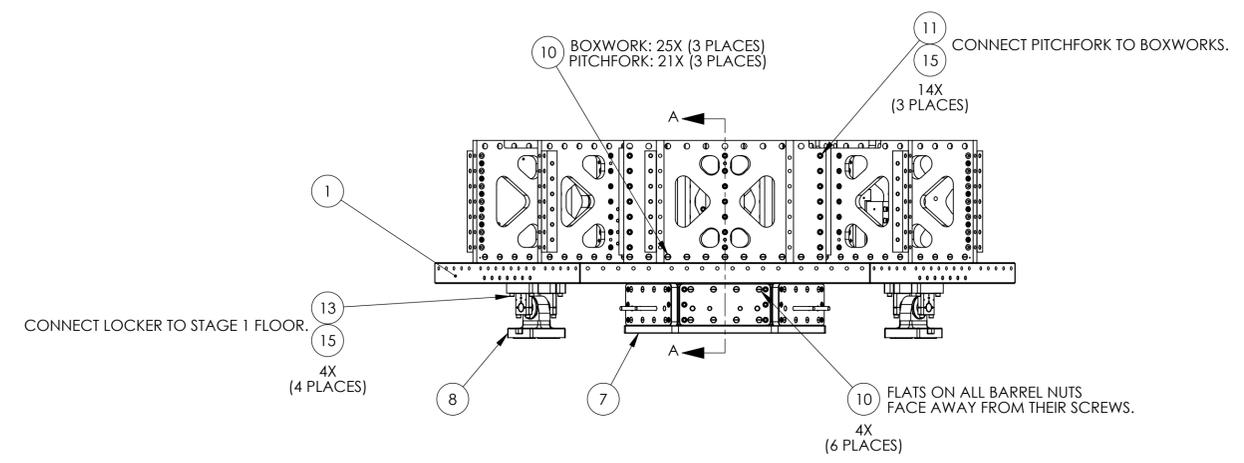
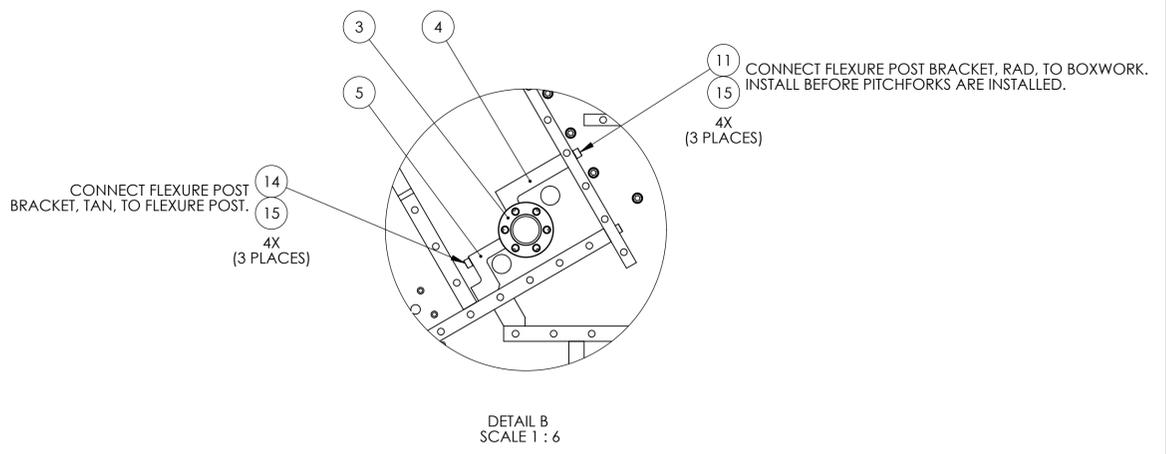
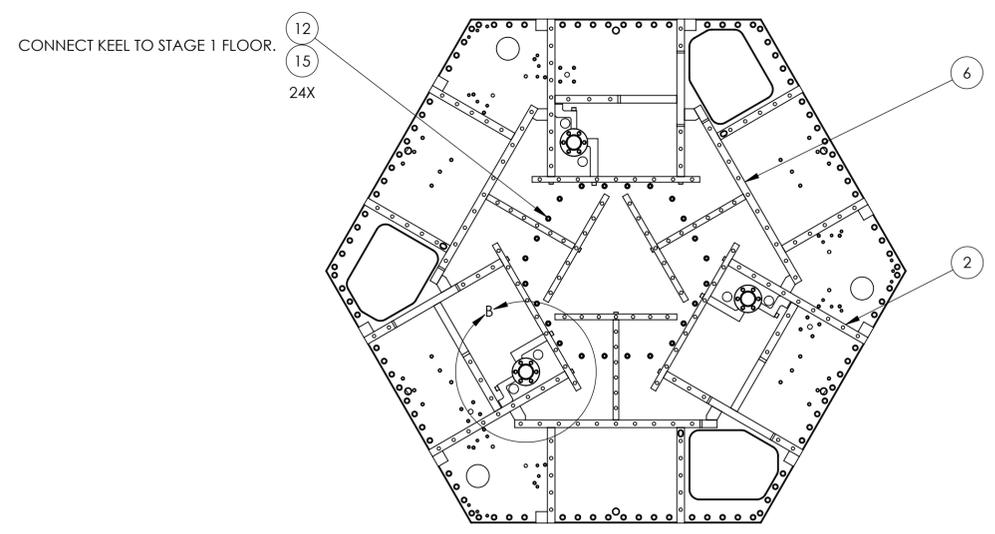
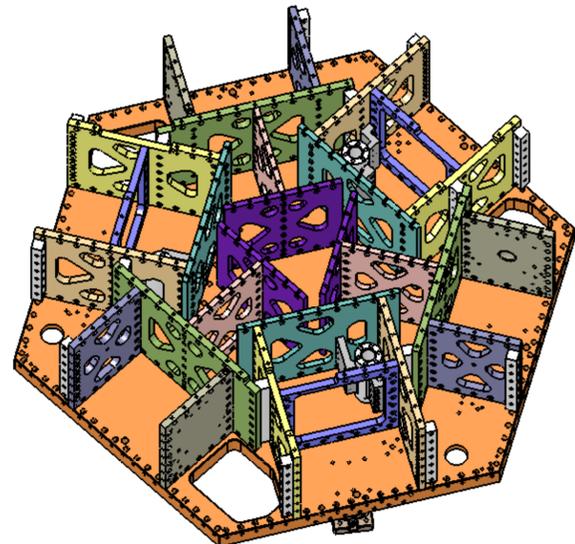


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	5/16/2007	1060	J. Waterman	Manufacturing Release
C	01/09/2008	-	A. STEIN	Removed upper-level parts, Added detail. Updated BOM.



- NOTES:
- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
 - BEFORE ASSEMBLY, ALL HELI-COIL INSERTS SHOULD ALREADY BE INSTALLED IN STAGE 1 FLOOR.
 - THIS SYSTEM SHOULD BE BUILT ON D070350 (PRE-ASSEMBLY STAND), OR SOMETHING SIMILAR.

BILL OF MATERIALS				
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	MATERIAL
1	1	D071051	STAGE 1 FLOOR	6061-T6
2	3	D071422	ASM, BOXWORK	See BOM
3	3	D071074	FLEXURE POST	6061-T6
4	3	D071075	FLEXURE POST BRACKET, RAD	6061-T6
5	3	D071076	FLEXURE POST BRACKET, TAN	6061-T6
6	3	D071423	ASM, PITCHFORK	See BOM
7	1	D071424	ASM, KEEL	See BOM
8	4	D071450	ASM, LOCKER	See BOM
9	66	D071250	BARREL NUT	3/8"-16x1.07L 6061-T6
10	162	D071250	BARREL NUT	3/8"-16x1.57L 6061-T6
11	66	HOLOKROME 78102	SHCS	3/8"-16x1.5" 18-8 SS
12	258	HOLOKROME 78104	SHCS	3/8"-16x1.75" 18-8 SS
13	16	MICMASTER 9219A6633	SHCS	3/8"-16x3.25" 18-8 SS
14	12	MICMASTER 9219A6637	SHCS	3/8"-16x3.25" 18-8 SS
15	352	UCC WFV-38	VENTED WASHER	.39"IDx.625"OD 18-8 SS

PRIOR APPROVALS: p06109-421-0

DATE:

MANUFACTURING:

QUALITY:

MATL: See BOM

FINISH: See BOM

High Precision Devices

1668 Valtec Lane, Suite C, Boulder, Colorado 80301
Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

DESCRIPTION: **ASM, STAGE 1 PRE-ASM**

P/N: **D071421** CONFIG: -

FILE NAME: D071421-C Asm, Stage 1 Pre-Asm

FOLDER:

SIZE: **D** SCALE: **1:12** DRAWN BY: **Jonas Waterman** REV: **C**

SHEET **1** OF **1** DATE PRINTED: **2/27/2008**