

5

4

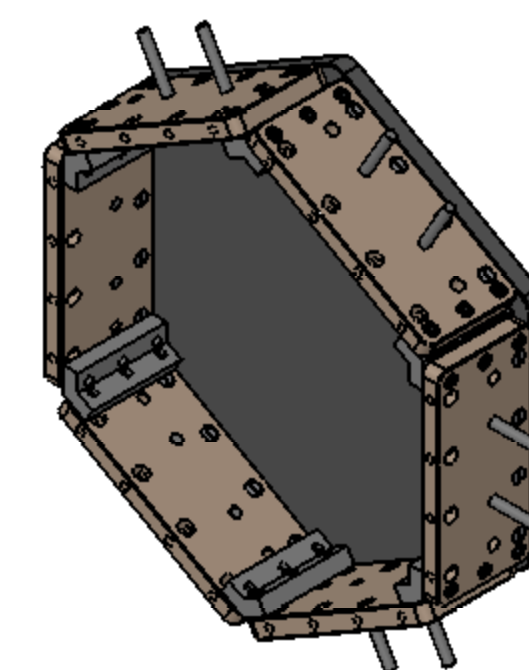
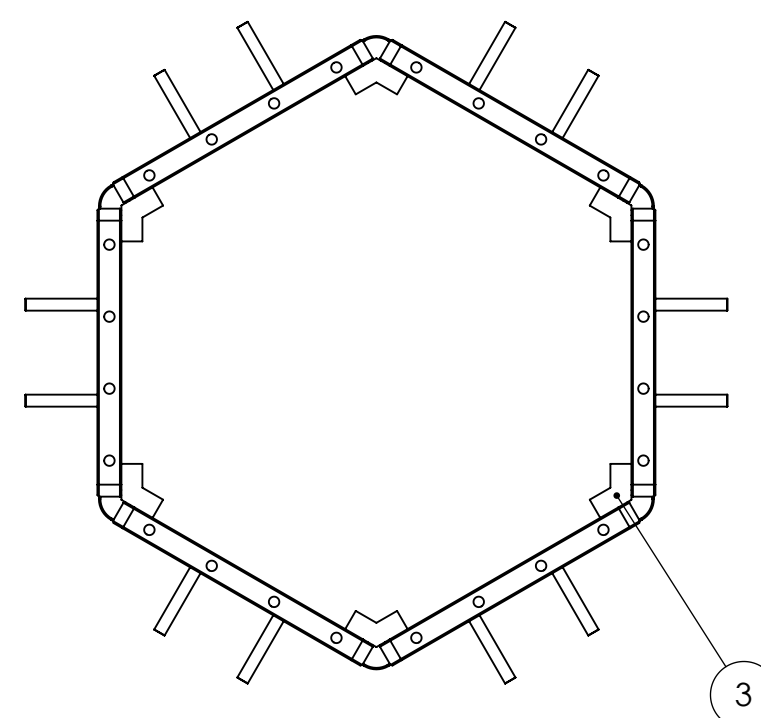
3

2

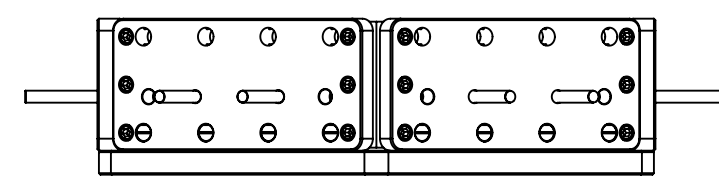
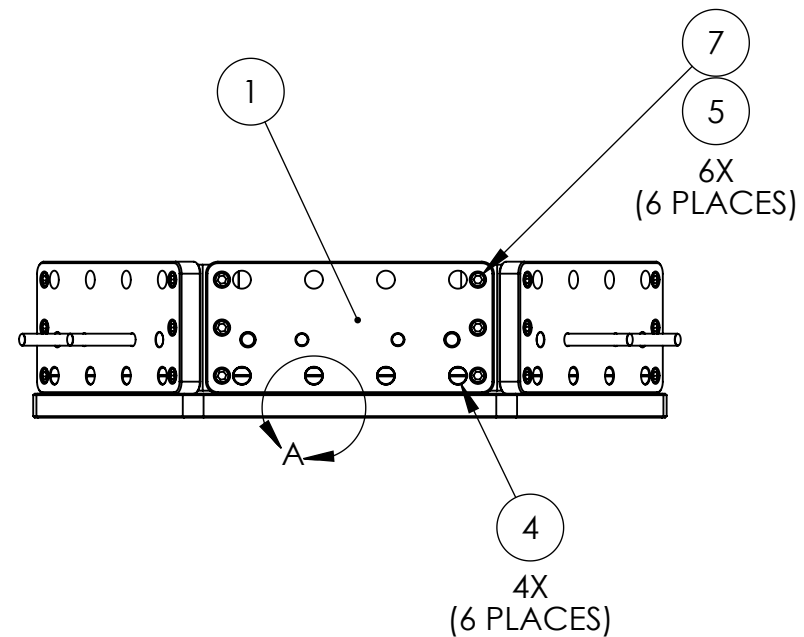
1

REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	6-1-07	1062	Dan Bryce	Manufacturing Release
C	01-08-08	-	A. STEIN	Added detail. Updated BOM.

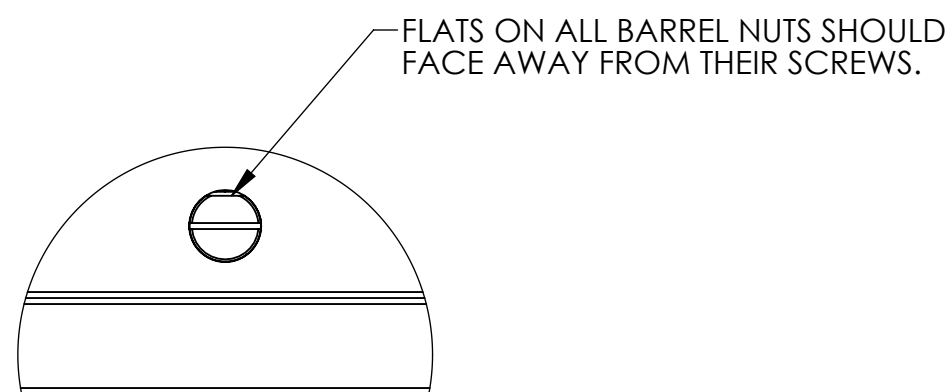
D



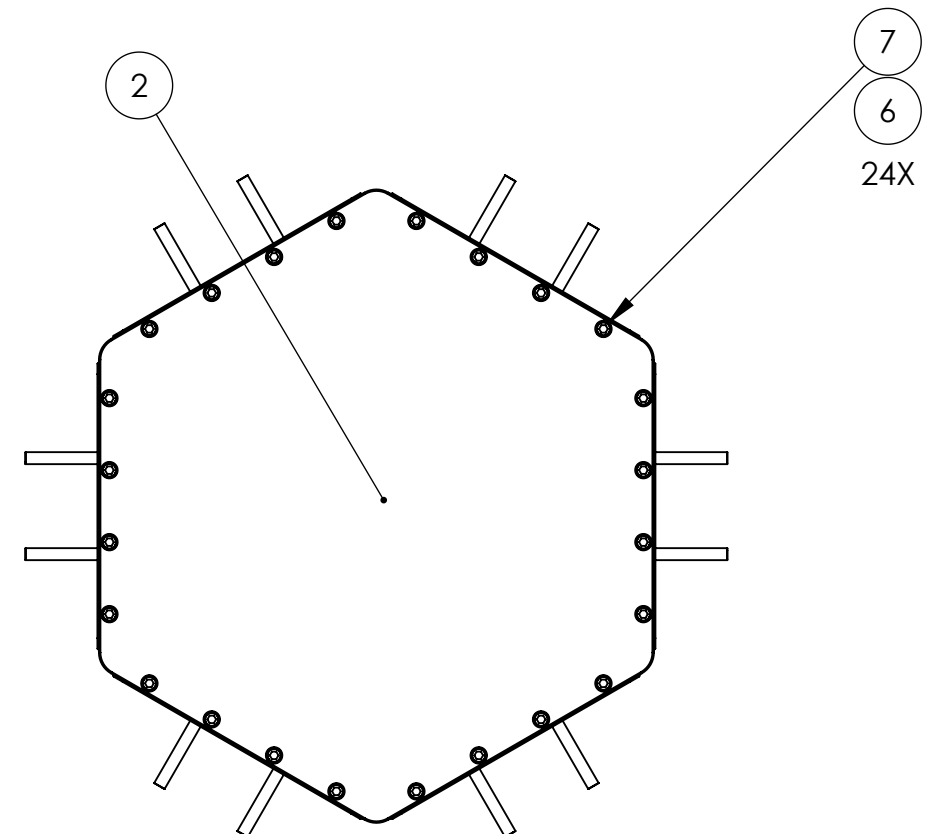
C



B



DETAIL A
SCALE 1 : 2



A

- NOTES:
- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
 - ASSEMBLE DIRECTLY TO D071051 (STAGE 1 FLOOR), WHILE SUPPORTED ON D070350 (PRE-ASSEMBLY STAND).

BILL OF MATERIALS					
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	6	D071425	ASM, KEEL WALL	-	See BOM
2	1	D071065	KEEL BASE	-	6061-T6
3	6	D071060	OUTER WALL, BRACKET 120	KEEL BRACKET (SHORT)	6061-T6
4	24	D071250	BARREL NUT	3/8"-1.6x1.0"L	6061-T6
5	36	HOLOKROME 78100	SHCS	3/8"-1.6x1.25"	18-8 SS
6	24	HOLOKROME 78104	SHCS	3/8"-1.6x1.75"	18-8 SS
7	60	UCC WFV-38	VENTED WASHER	.39"IDx.625"OD	18-8 SS

PRIOR P/N: p06109-424-0 APPROVALS: Dan Bryce DATE: 6-1-07 MANUFACTURING:		DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX ±.015 .XXX ±.005 ANG TOL: ± 1° SURFACE ROUGHNESS: 63 INTERNAL AND EXTERNAL INTERSECTIONS SHALL BE UNIFORMLY FINISHED WITH A CHAMFER .005/.010 X 45° OR RADIUS .005/.010. CHAMFER ALL THREADED HOLES 110% OF MAJOR DIAMETER X 45°		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	
QUALITY: C. Danaher DATE: 6-1-07 MATL: See BOM FINISH: See BOM		DESCRIPTION: ASM, KEEL P/N: D071424 CONFIG DESC: - FILE NAME: D071424-C Asm, Keel		FOLDER: SIZE: C SCALE: 1:8 DRAWN BY: Dan Bryce REV: C SHEET 1 OF 1 DATE PRINTED: 1/10/2008	