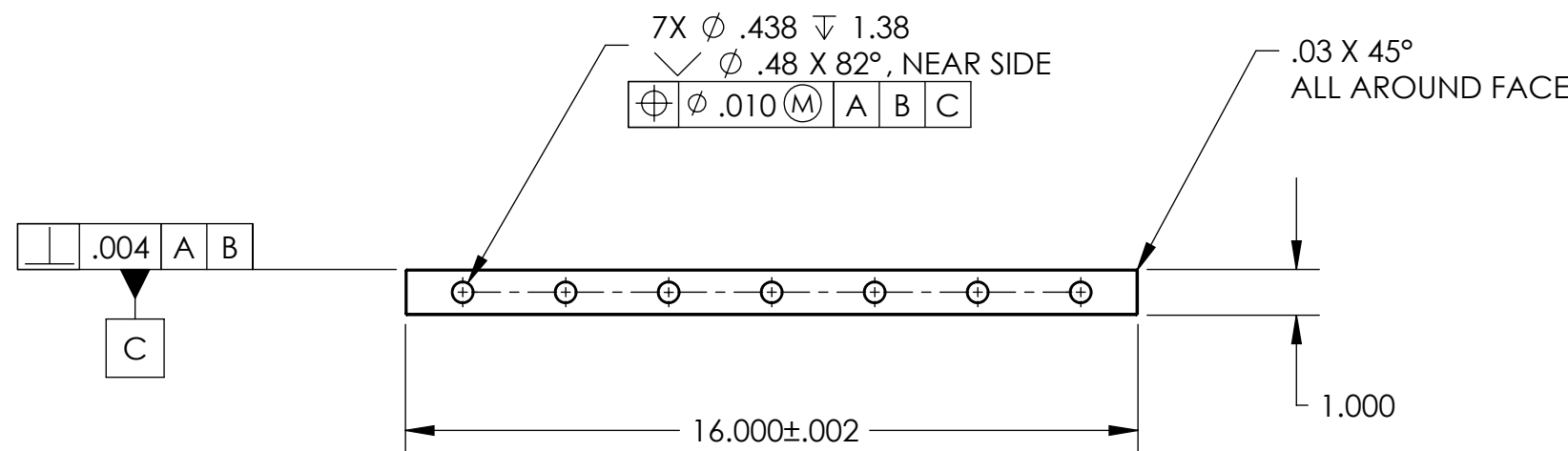
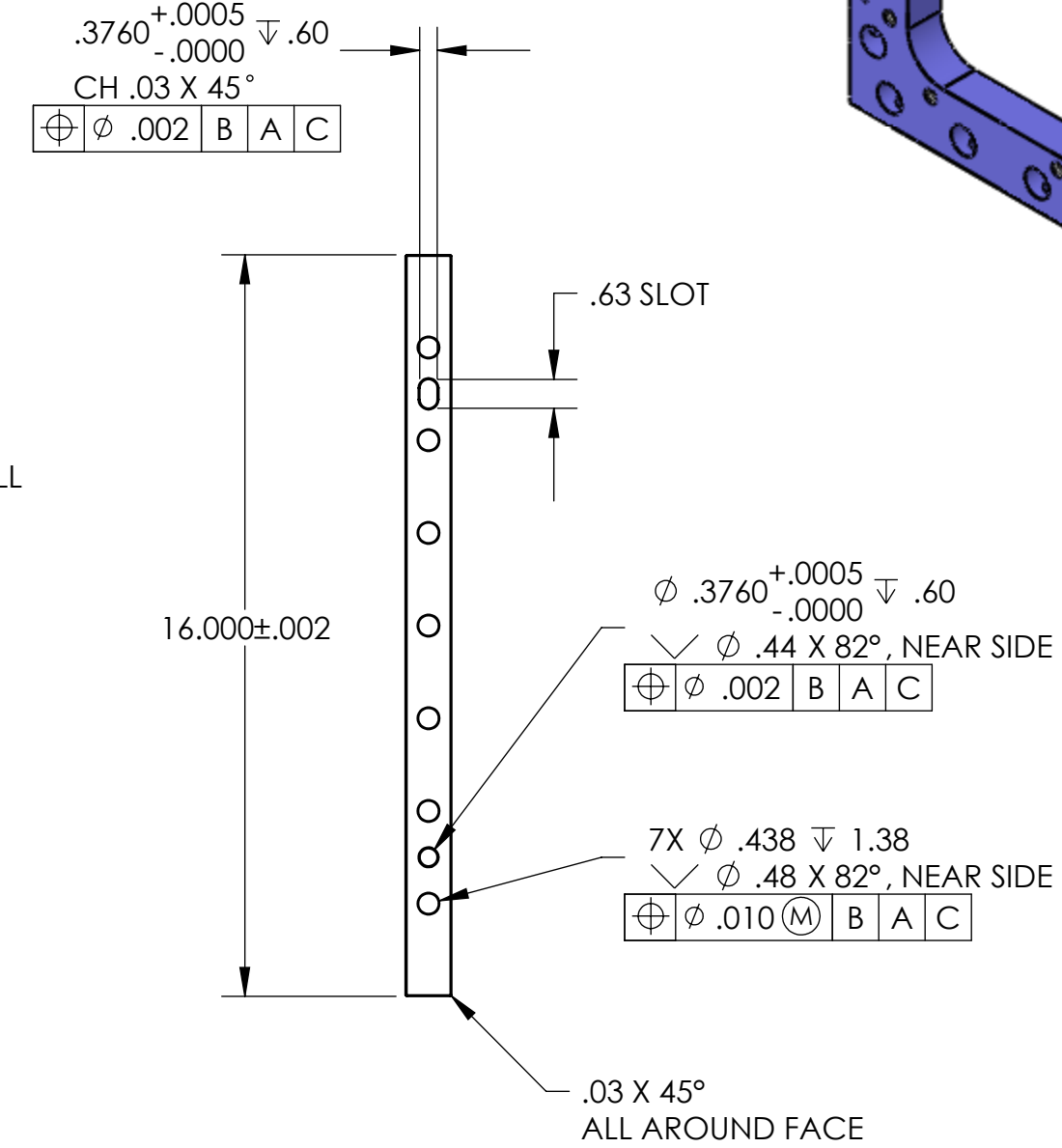
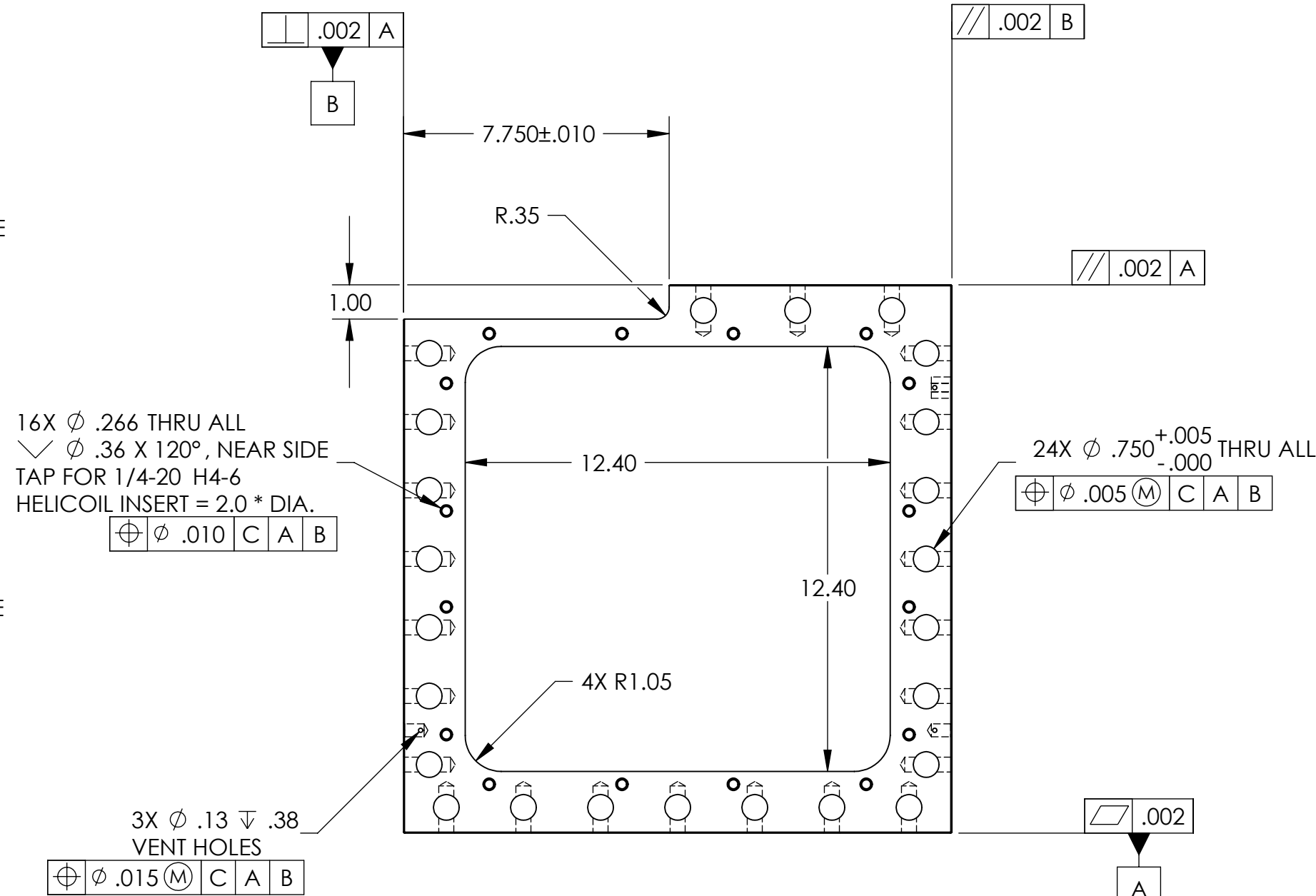
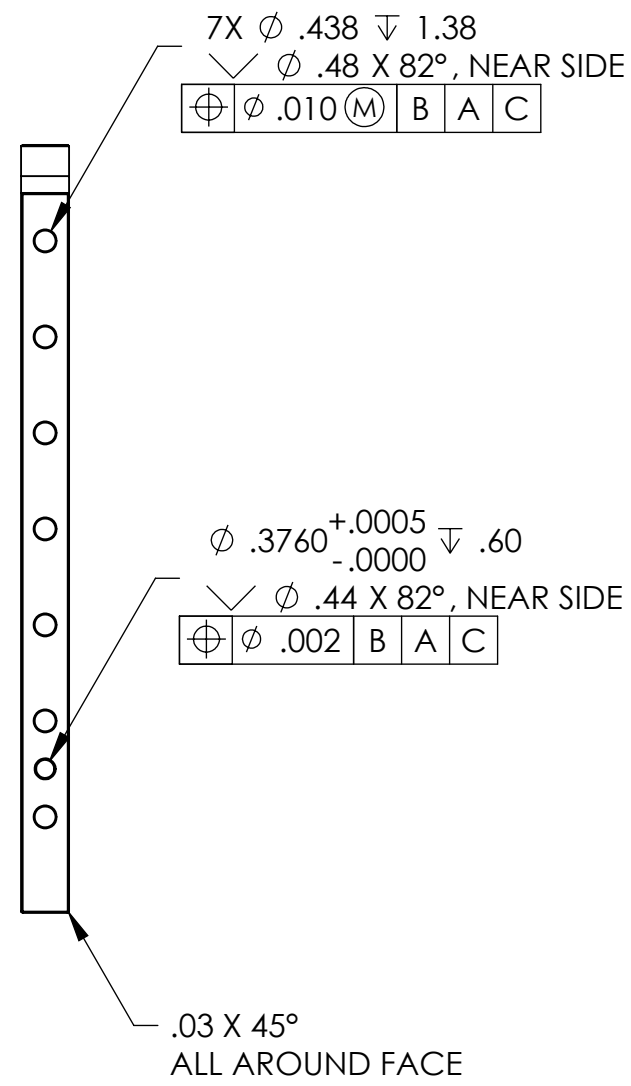
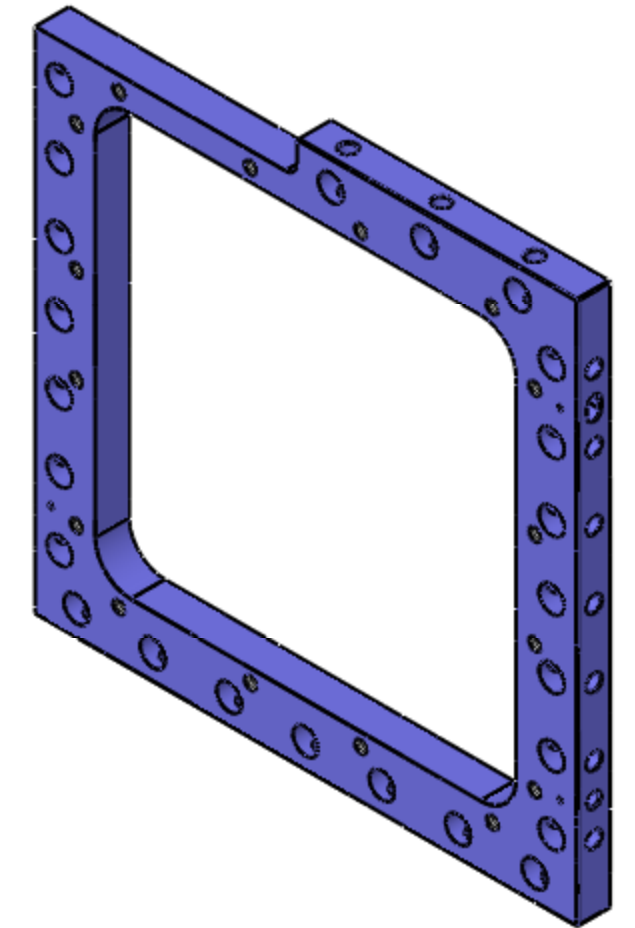
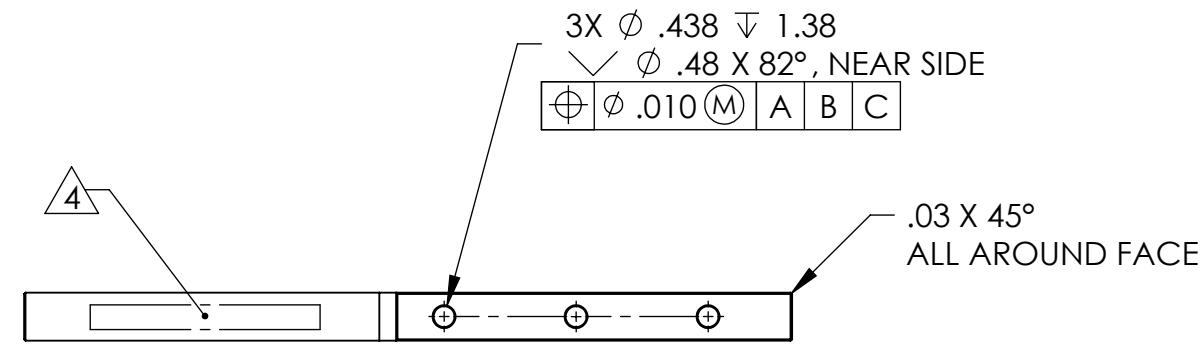


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / D	27 Jun 2007	1066	D. Senders	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Chamfers added to interface surfaces. Minor changes to hole details.



MACHINING NOTES:

- MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES (OTHER THAN DRESSED BLANCHARD GRINDING) ARE NOT ACCEPTABLE.
- ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.
- THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
- 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.  
D071071-V2  
S/N - ###
- DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.

POST-MACHINING NOTES:

- CLEAN TO LIGO STANDARDS, CLASS A.
- 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	16

APPROVALS	DATE
ENGINEERING (HPD): D. Senders	5/22/2007
QUALITY (HPD): C. Danaher	5/22/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	7.9 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:  
Ø .010 A B C

ORIGINAL DESIGN BY:	<b>High Precision Devices</b>		MODIFIED BY:
	1448 Valtrec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		LIGO
DESCRIPTION:	Rib, Tan, Flexure Mid		
P/N:	D071071	CONFIG:	-
CAD FILE NAME:	D071071_Rib-Tan-Flexure_Mid		
PROJECT:	HAM ISI, Advanced LIGO		
SIZE	SCALE: 1:4	DRAWN BY:	Dave Senders (HPD)
SHEET 1 OF 1	DATE PRINTED:	3/17/2009	REV V2