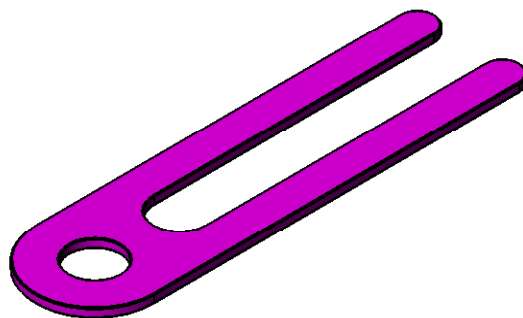
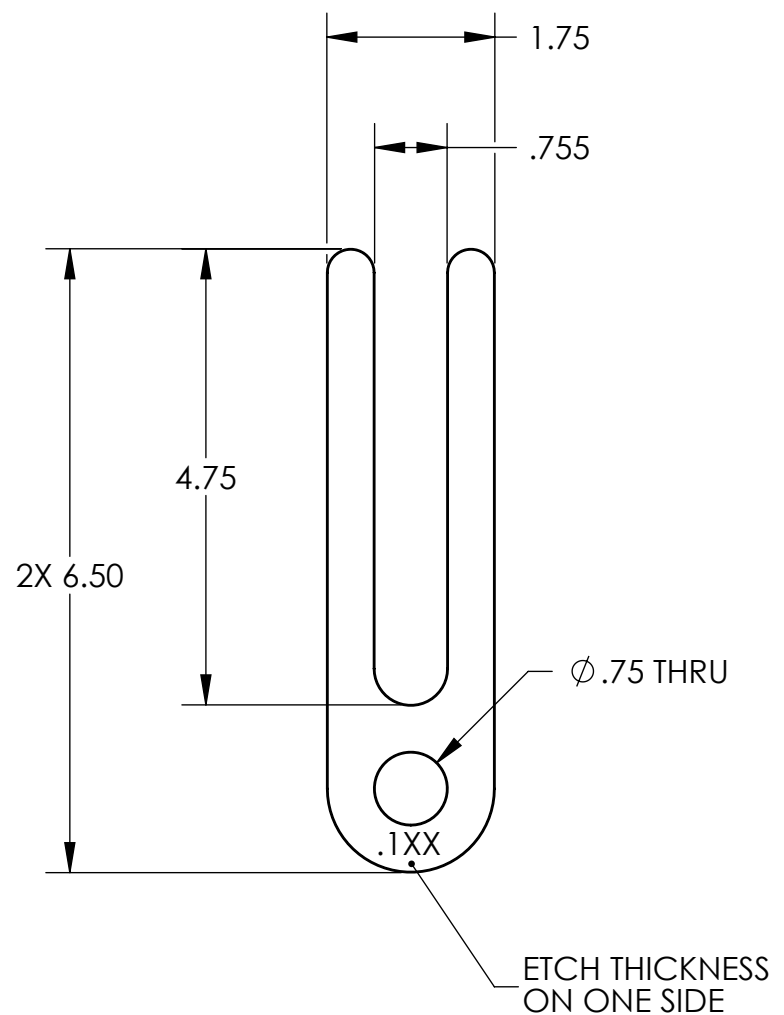


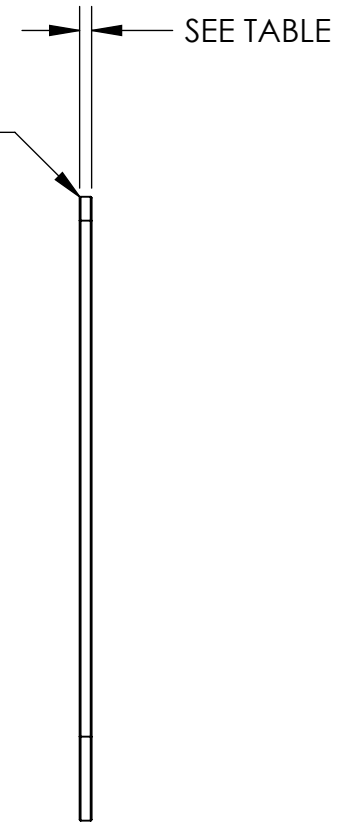
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	3 Jul 2007	1067	D. Bryce	Release for Enhanced LIGO.
V2	25 Mar 2009		A. Stein	Release for Advanced LIGO. Added min chamfer/radius call-out.



CONFIGURATION TABLE	
LIGO Type	THICKNESS
-00	.120
-01	.121
-02	.122
-03	.123
-04	.124
-05	.125
-06	.126
-07	.127
-08	.128
-09	.129
-10	.130



.01 X 45° MIN CHAMFER, OR  
.01 MIN RADIUS  
AROUND ALL EDGES



MACHINING NOTES:

- 1) UNLESS MANUFACTURED FROM SHEET WITH FINISH OF 2B OR EQUIVALENT, 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 **THICKNESS** OF THE SHIM.
- 5) THICKNESS TOLERANCE IS +/- .0005, FOR ALL PARTS. TOLERANCE APPLIES BEFORE ELECTROPOLISH.

POST-MACHINING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES  
DECIMAL TOLERANCES:  
.XX ±.015 .XXX ±.005  
ANG TOL: ± 1° SURFACE ROUGHNESS: 63

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:

	.010	A	B	C
--	------	---	---	---

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/24/2007
QUALITY (HPD): C. Danaher	5/24/2007
MATERIAL:	<b>304 SS</b>
FINISH:	<b>ELECTROPOLISH</b>
MASS:	<b>0.25 lbs</b>

ORIGINAL DESIGN BY:		<b>High Precision Devices</b>		MODIFIED BY:
		1668 Valtec Lane, Suite C, Boulder, Colorado 80301		
		Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com		
DESCRIPTION:		<b>Locker Spacer</b>		
P/N:	<b>D071141</b>	CONFIG:	<b>See Table</b>	
CAD FILE NAME:		D071141_Shim		
PROJECT:		HAM ISI, Advanced LIGO		
SIZE	SCALE: <b>1:2</b>	DRAWN BY:	<b>Dan Bryce (HPD)</b>	REV
<b>B</b>	SHEET <b>1</b> OF <b>1</b>	DATE PRINTED:	<b>3/25/2009</b>	<b>V2</b>