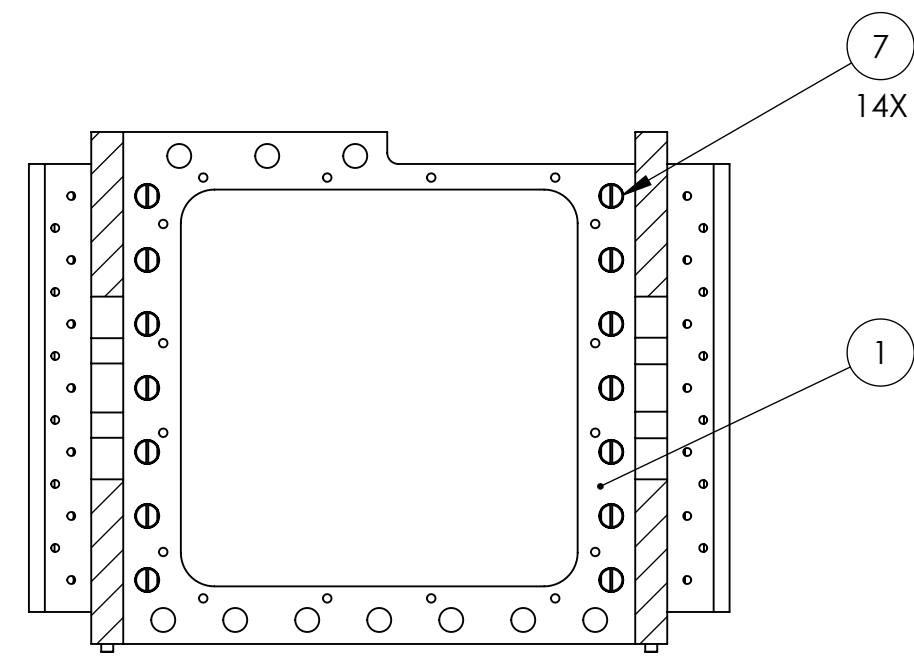
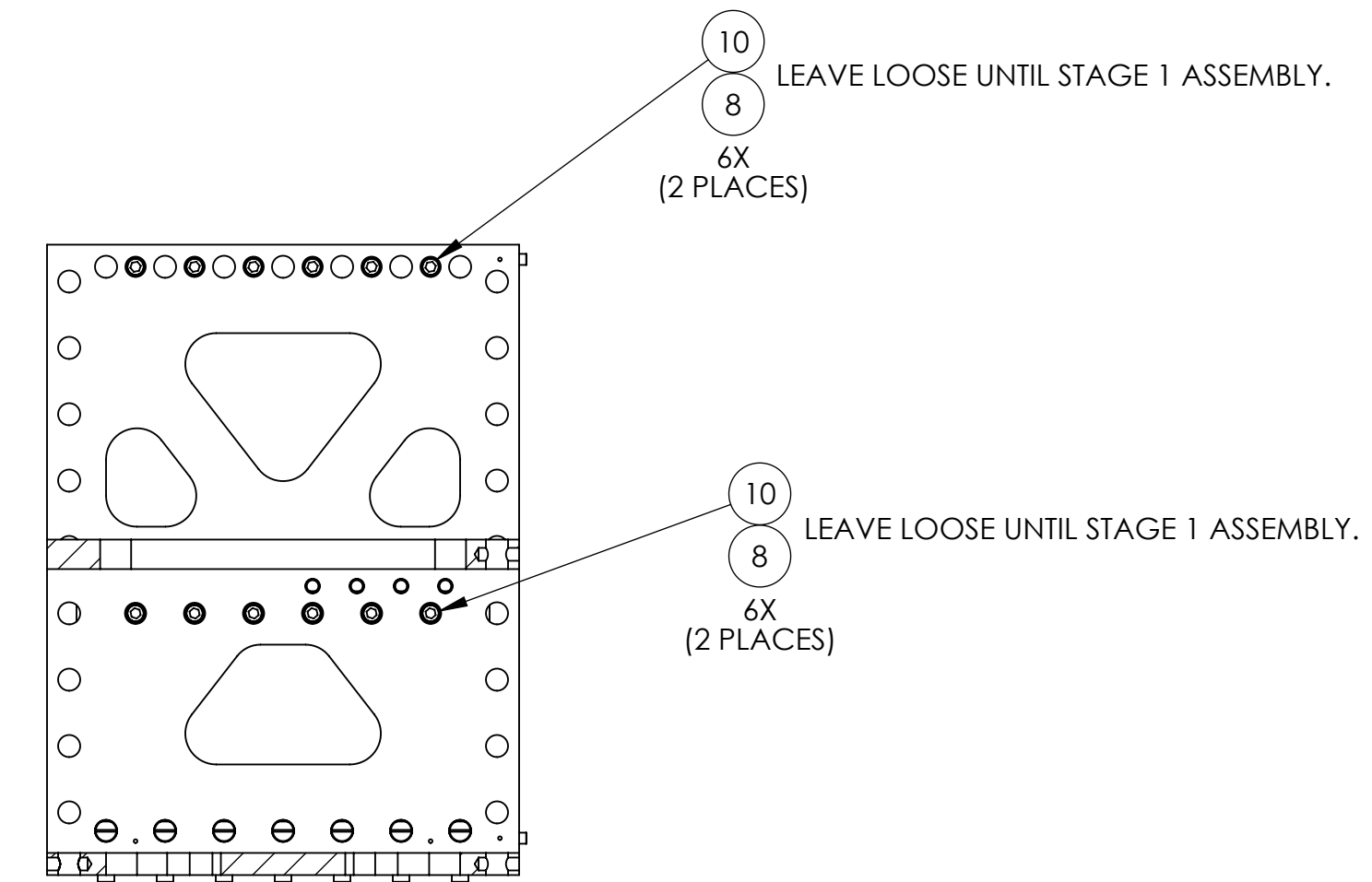
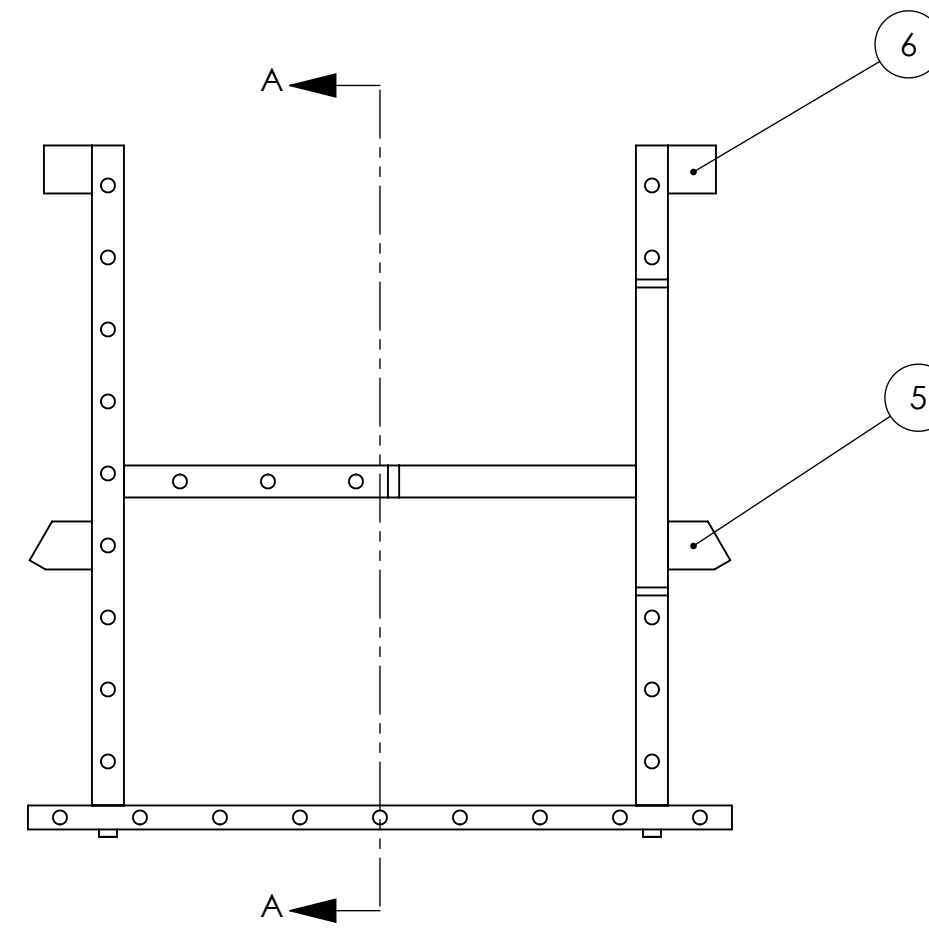
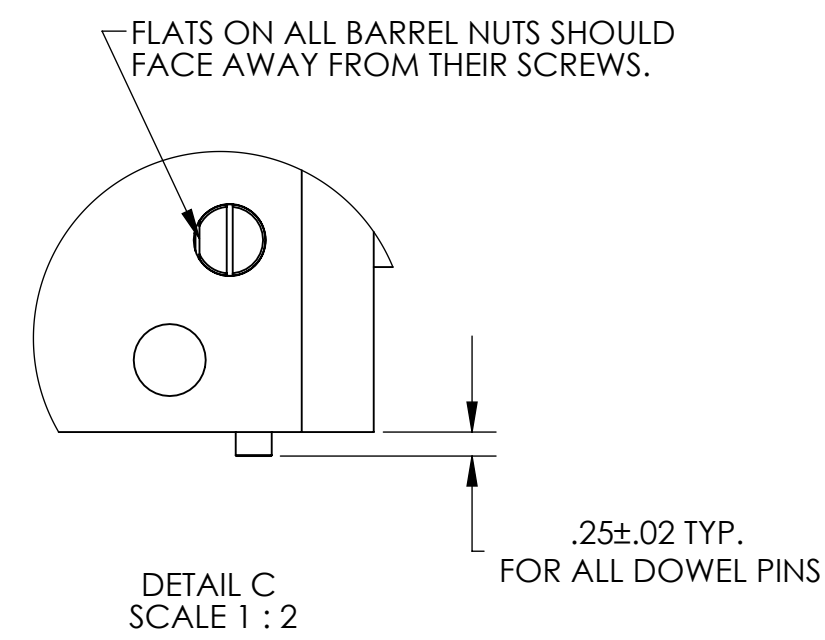
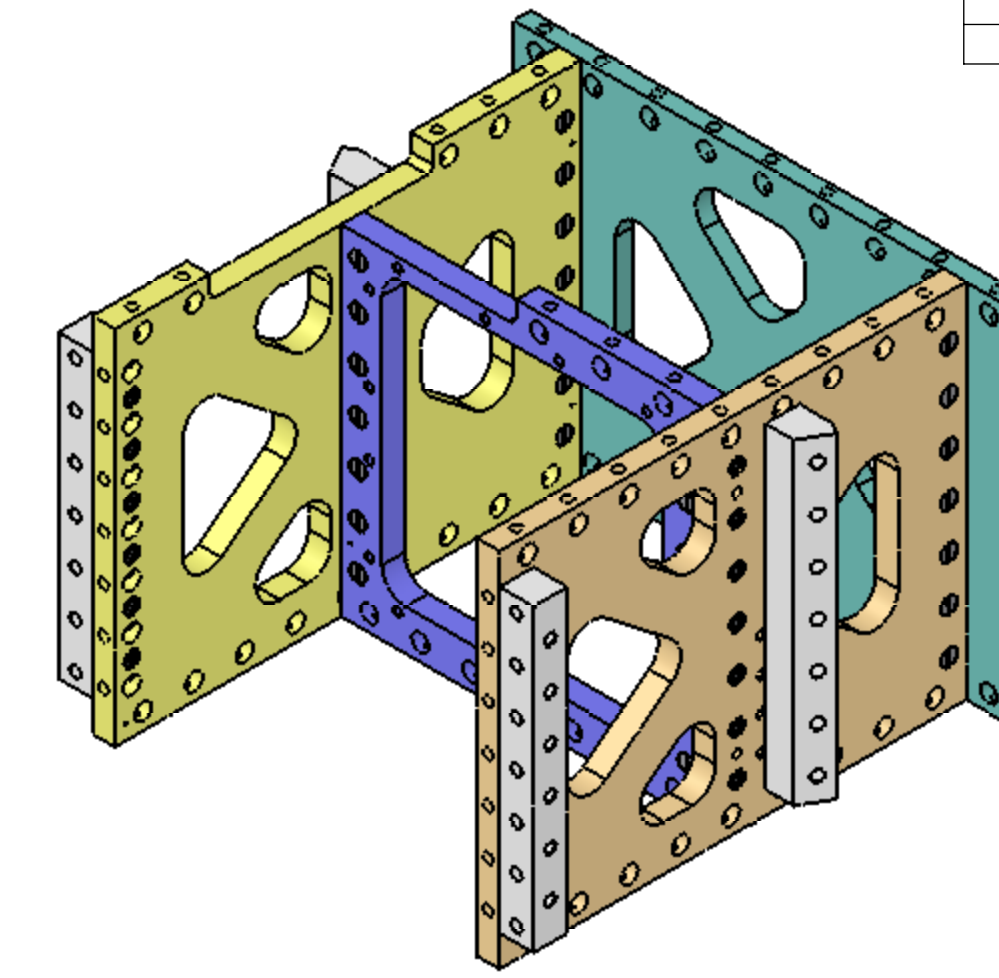
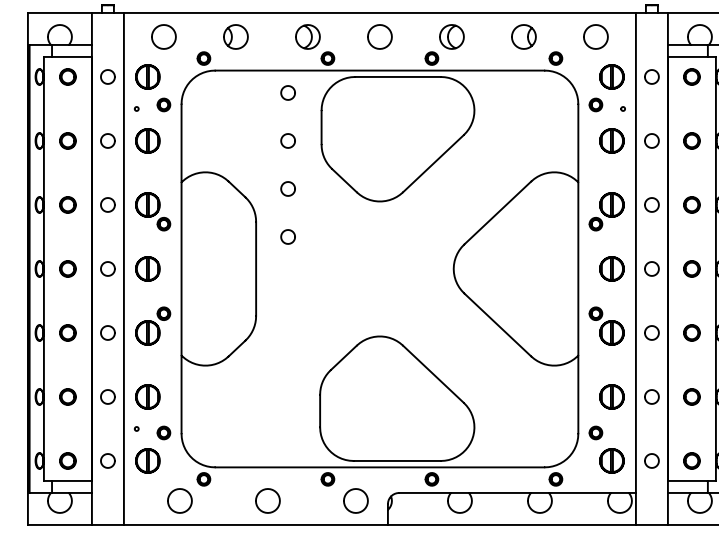


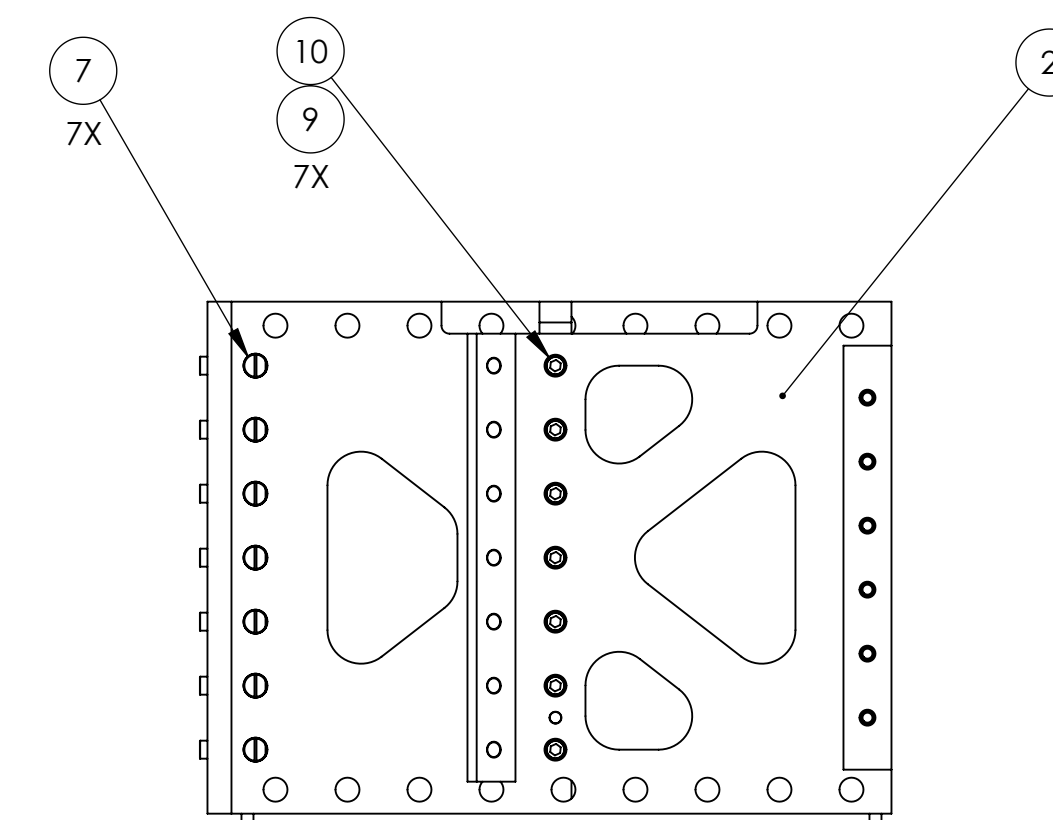
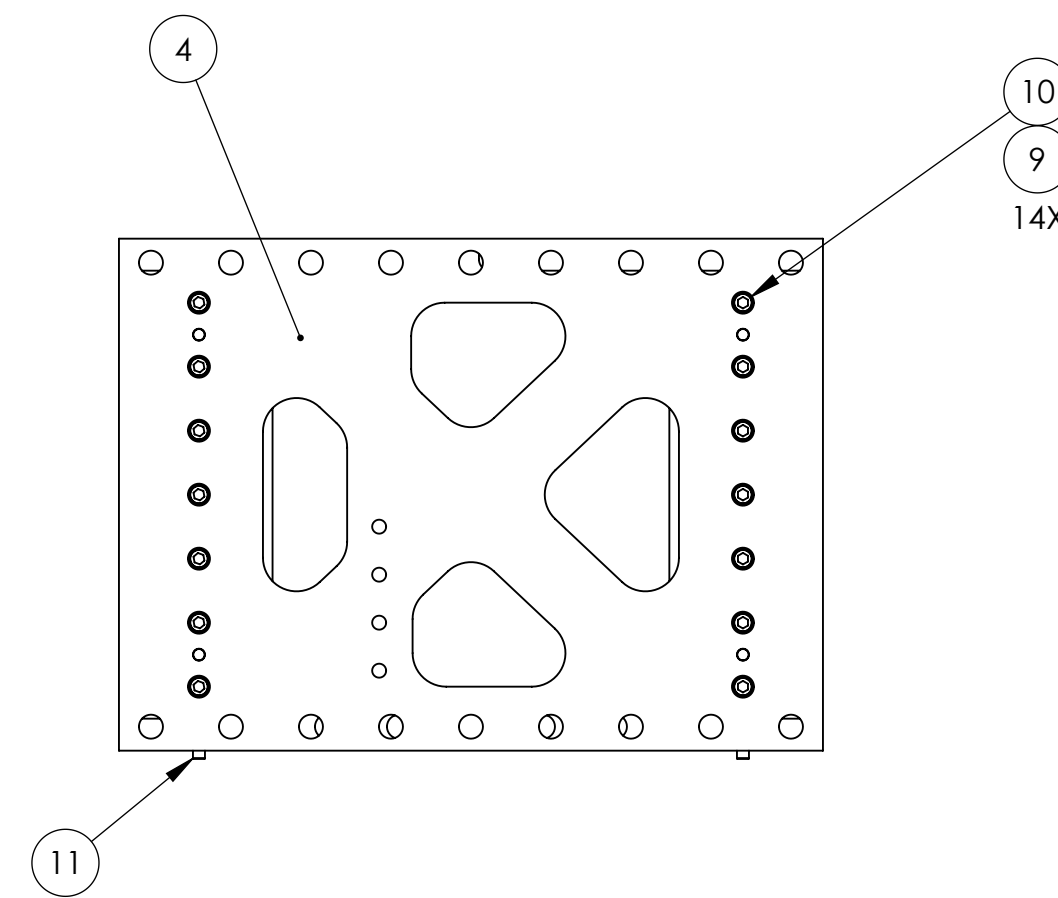
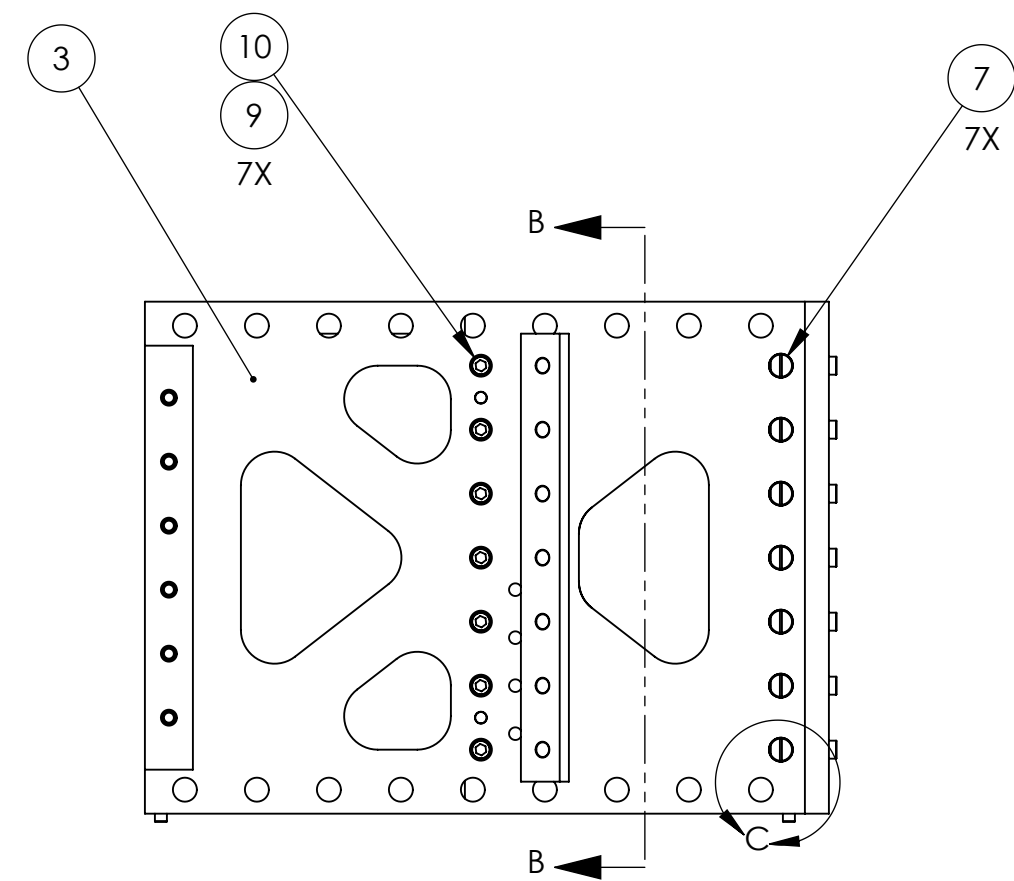
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	5/22/2007	1060	J. Waterman	Manufacturing Release
C	7/3/2007	1067	D. Senders	Added Notes, parts, changed BOM
D	01/07/2008	-	A. STEIN	Added detail. Updated BOM.
E	02/26/2008	-	A. STEIN	Removed upper-level parts. Updated BOM.



SECTION B-B



SECTION A-A



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. ALL DOWEL PINS USED TO LOCATE THE PLATES WITHIN THE ASSEMBLY SHOULD ALREADY BE INSTALLED. HOWEVER, DO NOT PRESS THE LAST (3) DOWEL PINS INTO THE BOTTOM OF THE ASSEMBLY UNTIL AFTER THE PLATES ARE BOLTED TOGETHER, AS DESCRIBED IN E070154.

BILL OF MATERIALS					
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D071071	RIB, TAN, FLEXURE MID	-	6061-T6
2	1	D071068	RIB, RAD, FLEXURE OUT 1	-	6061-T6
3	1	D071069	RIB, RAD, FLEXURE OUT 2	-	6061-T6
4	1	D071070	RIB, TAN, FLEXURE CEN	-	6061-T6
5	2	D071073	RIB BRACKET, 60 DEG	-	6061-T6
6	2	D071061	OUTER WALL, BRACKET 90	-	6061-T6
7	28	D071250	BARREL NUT	3/8"-1.6x1.0"L	6061-T6
8	24	HOLOKROME 78102	SHCS	3/8"-1.6x1.5"	18-8 SS
9	28	HOLOKROME 78104	SHCS	3/8"-1.6x1.75"	18-8 SS
10	52	UCC WFV-38	VENTED WASHER	.39"IDx.625"OD	18-8 SS
11	10	MCMASTER 90145A422	DOWEL PIN	3/8"x.75"	18-8 SS

PRIOR P/N: **p06109-422-0**
 APPROVALS: DATE: 7/03/07
 ENGINEER: D. Senders
 MANUFACTURING: C. Danaher
 QUALITY: See BOM
 MATL: See BOM
 FINISH: See BOM

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 DECIMAL TOLERANCES:
 XX ±.015 XXX ±.005
 ANG TOL: ± 1° SURFACE ROUGHNESS: 43
 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°

THIS PRINT & ITS RELATED MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL FEATURES MUST CONFORM TO 010 TOTAL WIDE PROFILE OF A SURFACE. INTERPRET DWG PER ASME Y14.5M 1994

High Precision Devices
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 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

DESCRIPTION: **ASM, BOXWORK**
 P/N: **D071422** CONFIG: -
 FILE NAME: D071422-E Asm, Boxwork

FOLDER: D
 SIZE: 1 OF 1
 SCALE: 1:6
 DRAWN BY: Jonas Waterman
 DATE PRINTED: 2/26/2008
 REV: E