

5

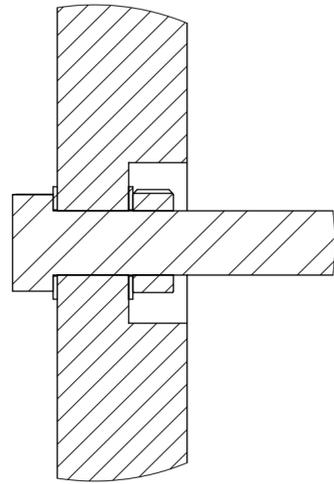
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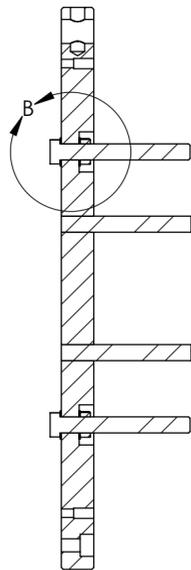
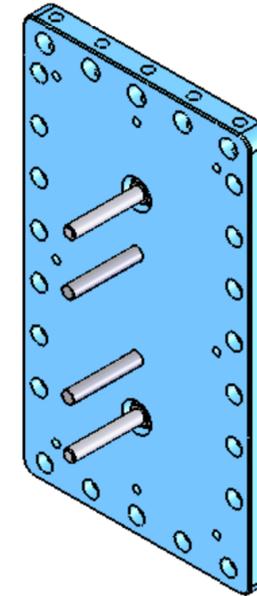
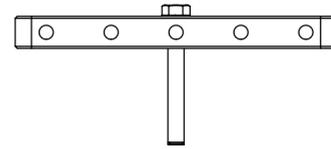
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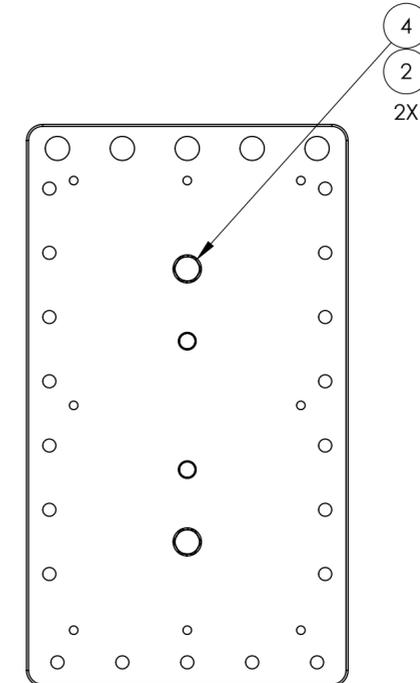
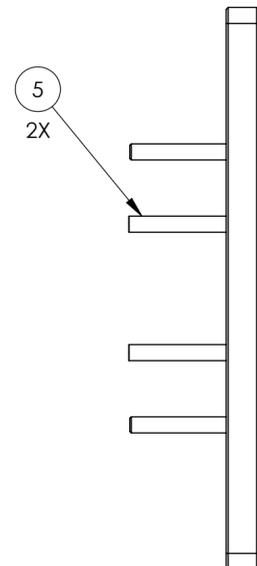
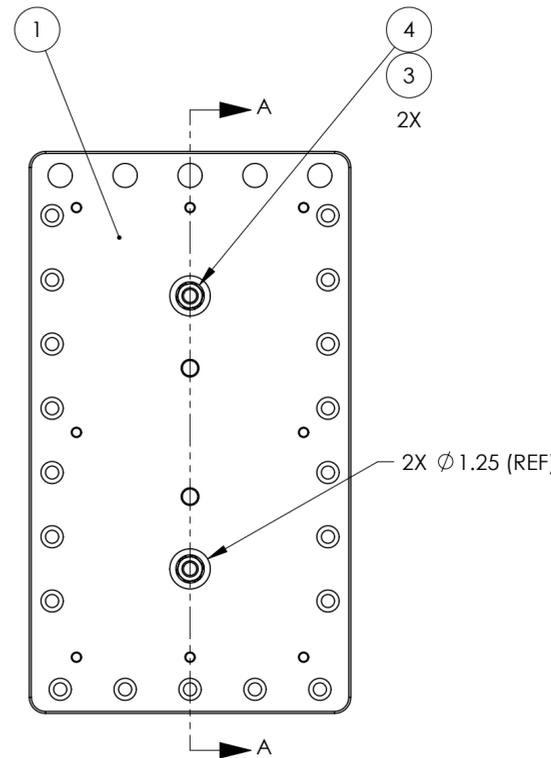
REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	5-29-07	1061	Bryce/Waterman	Manufacturing Release
C	01-08-08	-	A. STEIN	Added detail. Updated BOM.



DETAIL B
SCALE 1 : 1



SECTION A-A



NOTES:

- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
- PRESS THE (2) DOWEL PINS IN UNTIL THEIR ENDS ARE FLUSH WITH BACK SURFACE OF WALL.
- THREAD IN (2) HHCS, AND TORQUE TO SPEC. NEXT, THREAD ON (2) HEX JAM NUTS, AND TORQUE TO SPEC.

BILL OF MATERIALS					
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D071059	OUTER WALL, SMALL PANEL	-	6061-T6
2	2	MCMMASTER 92240A728	HHCS	1/2"-13x4.0", FULL THREAD	18-8 SS
3	2	MCMMASTER 91847A520	HEX JAM NUT	1/2"-13	18-8 SS
4	4	UCC WFW-50	VENTED WASHER	.515"IDx.875"OD	18-8 SS
5	2	MCMMASTER 90145A729	DOWEL PIN	1/2"x4.0"	18-8 SS

PRIOR P/N:	p06109-427-0
APPROVALS ENGINEERING	DATE
Dan Bryce	5-29-07
MANUFACTURING	
QUALITY	
C. Danaher	5-29-07
MATL:	See BOM
FINISH:	See BOM

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

DESCRIPTION: **ASM, OUTER WALL, SMALL PANEL**

P/N: **D071427** CONFIG DESC: -

FILE NAME: D071427-C Asm, Outer Wall, Small Panel

FOLDER:

SIZE SCALE: **1:4** DRAWN BY: **Jonas Waterman** REV

C SHEET 1 OF 1 DATE PRINTED: **1/8/2008** **C**