



REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	7/03/07	1067	D. Senders	Manufacturing Release
C	8/9/07	1071	D. Senders	Changed dowel pin lengths, added two pin and collar sets
D	9/7/2007			
E	01/08/2008	-	A. STEIN	Removed upper-level parts. Added detail. Updated BOM.

NOTES:

- SEE E070154 (ADVANCED LIGO SINGLE STAGE HAM VIBRATION ISOLATION TABLE ASSEMBLY PROCEDURE) FOR ADDITIONAL ASSEMBLY NOTES AND REQUIREMENTS.
- BEFORE ASSEMBLY, PRESS (2) PINS INTO THE LOCKER BASE AND (2) PINS INTO THE KINEMATIC LOCK.
- USE SPECIAL PLIERS TO INSTALL EXTERNAL RETAINING RING.
- WHEN (2) CAPS ON KINEMATIC LOCK ARE INSTALLED, THERE WILL BE A SMALL GAP THAT CANNOT BE CLOSED. TRY TO MAKE THE GAPS ON BOTH SIDES OF THE SPHERICAL PIN EQUAL.

BILL OF MATERIALS					
ITEM NO.	QTY/ASM	PART NUMBER	PART DESCRIPTION	CONFIG DESCRIPTION	MATERIAL
1	1	D071140	LOCKER BASE	-	6061-T6
2	1	D047932	LOCKER SLEEVE HOUSING (ASI)	-	2024-T6
3	1	D070270	LOCKER SLEEVE (ASI)	-	440C SS
4	1	D047935	SPHERICAL PIN (ASI)	-	440C SS
5	1	D047936	KINEMATIC LOCK (ASI)	-	2024-T6
6	1	SMALLEY FSE-0175	EXTERNAL SNAP RING	1.75"DIAX.067"THICK	302 SS
7	4	HOLOKROME 78104	SHCS	3/8"-16x1.75"	18-8 SS
8	4	MCMMASTER 92196A633	SHCS	3/8"-16x2.25"	18-8 SS
9	8	UCC WFV-38	VENTED WASHER	.39"IDx.625"OD	18-8 SS
10	4	MCMMASTER 90145A624	DOWEL PIN	3/8"x1.0"	18-8 SS

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

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PRIOR P/N: **p06109-450-0**

APPROVALS: **C. Danaher** DATE: **7/03/07**

MANUFACTURING: **D. Senders**

QUALITY: **C. Danaher** DATE: **7/03/07**

MATL: **See BOM**

FINISH: **See BOM**

DESCRIPTION: **ASM, LOCKER**

P/N: **D071450** CONFIG DESC: **-**

FILE NAME: **D071450-E Asm, Locker**

FOLDER:

SIZE: **C** SCALE: **1:2** DRAWN BY: **Dan Bryce** REV: **E**

SHEET **1** OF **1** DATE PRINTED: **1/9/2008**