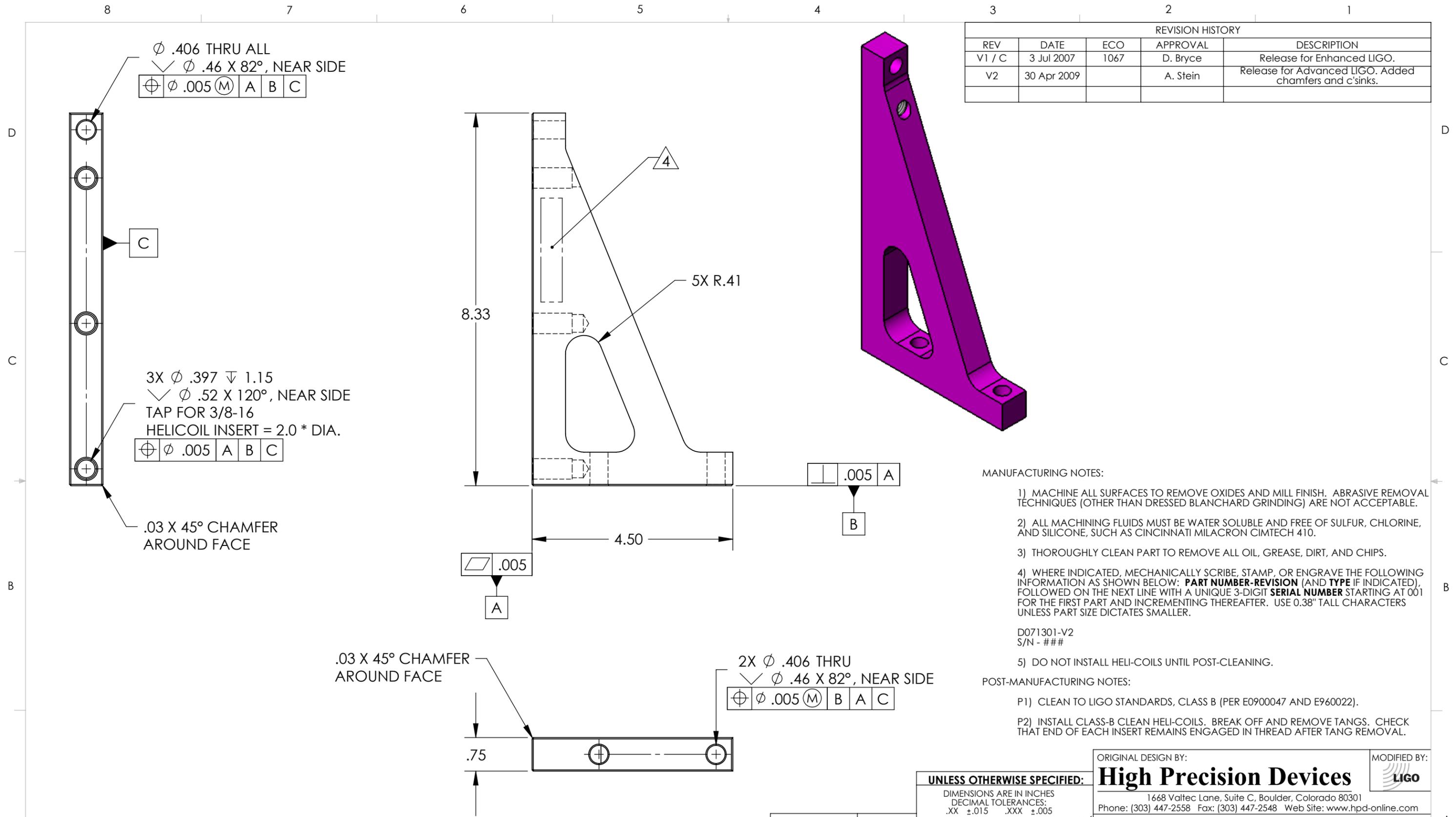


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	3 Jul 2007	1067	D. Bryce	Release for Enhanced LIGO.
V2	30 Apr 2009		A. Stein	Release for Advanced LIGO. Added chamfers and c'sinks.



MANUFACTURING NOTES:

- 1) 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 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.

D071301-V2
S/N - ###
- 5) DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.

POST-MANUFACTURING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS B (PER E0900047 AND E960022).
- P2) INSTALL CLASS-B 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 1185...	Qty.
1	3/8"-16 x .75"	Nitronic 60	-6EN750	3

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	6/15/2007
QUALITY (HPD): C. Danaher	6/15/2007
MATERIAL: 6061-T6 Al	
FINISH: None	
MASS: 1.0 lbs	

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:

ORIGINAL DESIGN BY:	High Precision Devices	MODIFIED BY:	LIGO
1668 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com			
DESCRIPTION: Angle Brace, Shipping			
P/N: D071301	CONFIG: -		
CAD FILE NAME: D071301_Angle_Brace-Shipping			
PROJECT: HAM ISI, Advanced LIGO			
SIZE B	SCALE: 1:2	DRAWN BY: Dan Bryce (HPD)	REV V2
SHEET 1 OF 1		DATE PRINTED: 4/30/2009	