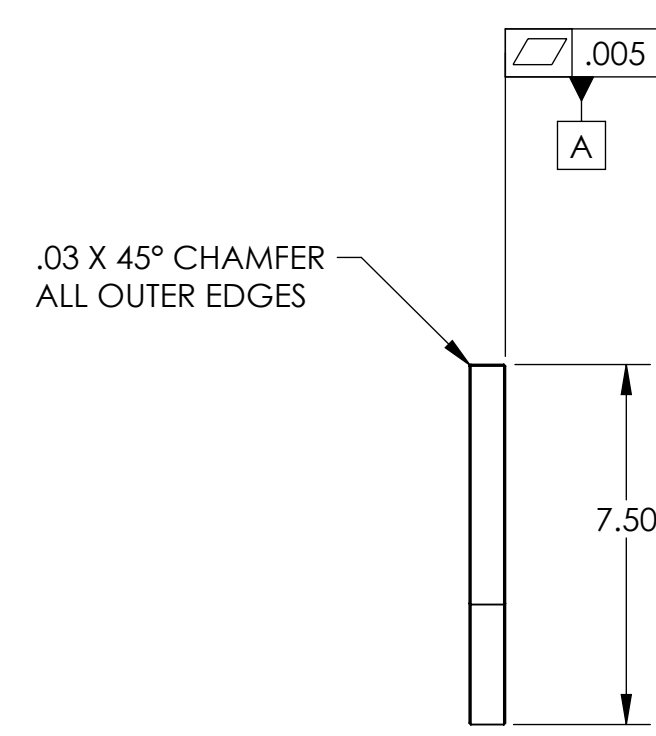
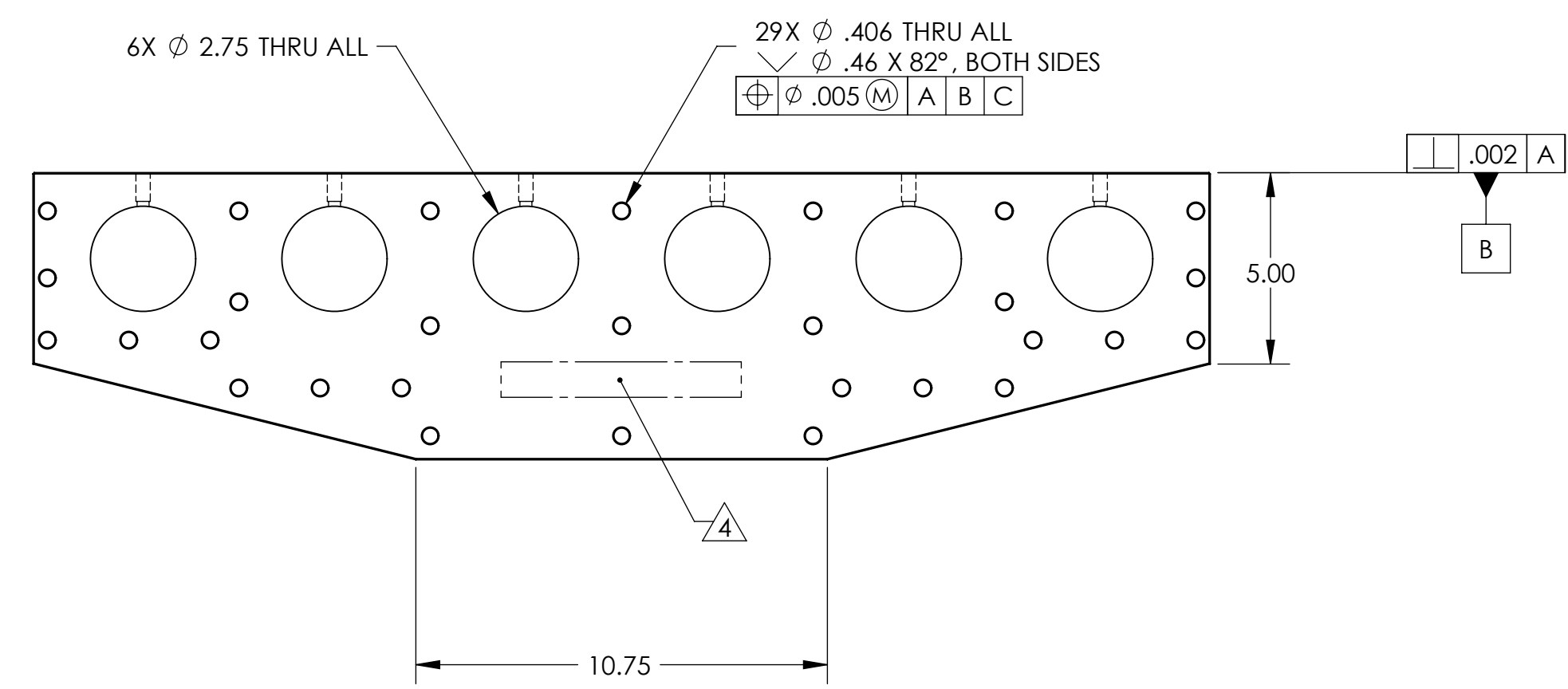
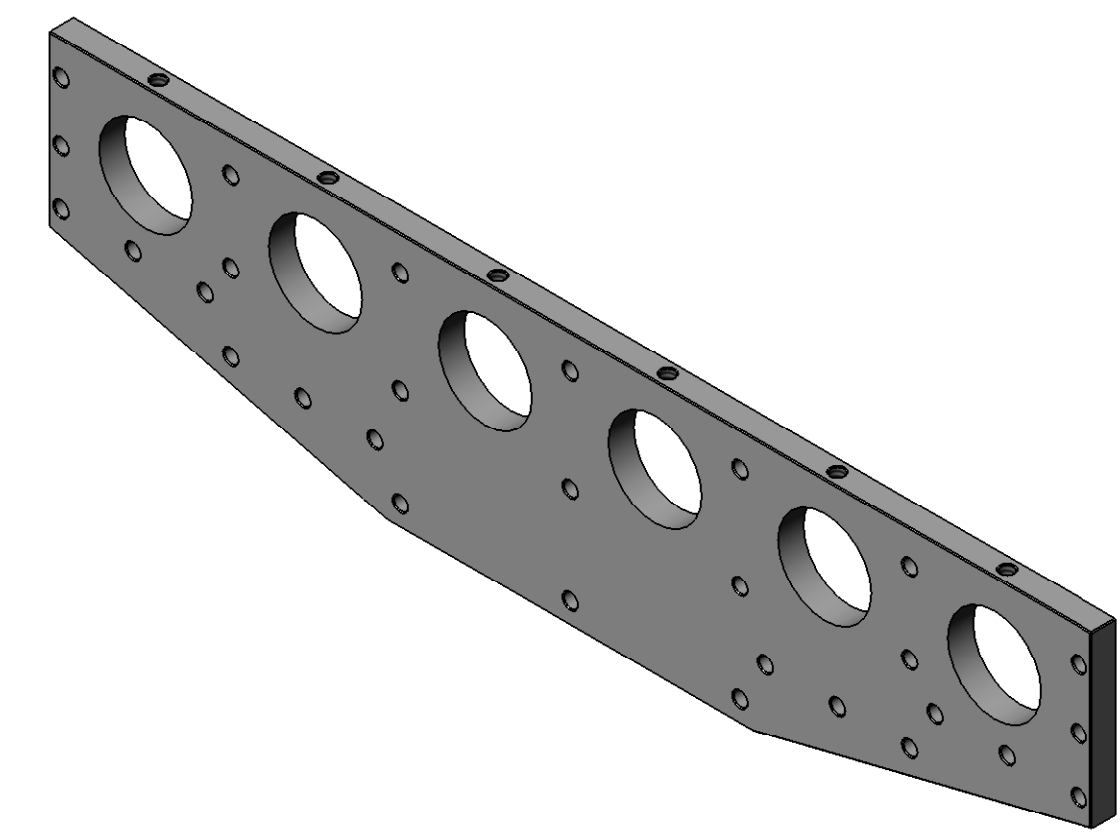
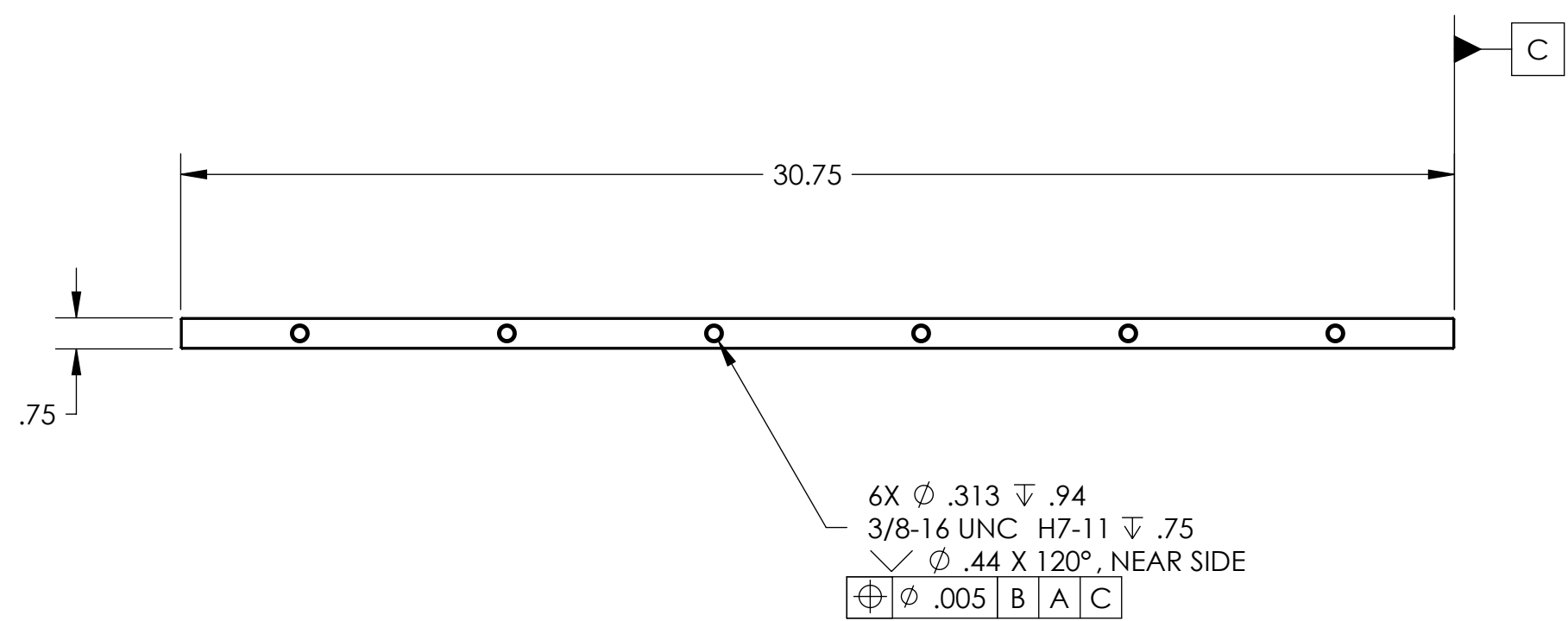


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / E	17 Oct 2007	1072	D. Senders	Release for Enhanced LIGO.
V2	26 Mar 2009		A. Stein	Release for Advanced LIGO. Added chamfers. Added c/sinks.



MACHINING 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.

D071008-V2
 S/N - ###

POST-MACHINING NOTES:
 P1) CLEAN TO LIGO STANDARDS, CLASS A.

APPROVALS		DATE	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX ±.015 .XXX ±.005 ANG TOL: ± 1° SURFACE ROUGHNESS: $\sqrt{32}$ 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 1448 Valtec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
ENGINEERING (HPD): D. Bryce 5/22/2007 QUALITY (HPD): C. Danaher 5/22/2007 MATERIAL: 6061-T6 Al FINISH: None MASS: 12.1 lbs		DESCRIPTION: Stage 0 Stiffener End Cap P/N: D071008 CONFIG: - CAD FILE NAME: D071008_Stage_0_Stiffener_End_Cap PROJECT: HAM ISI, Advanced LIGO		MODIFIED BY: 	
SIZE SCALE: 1:4 DRAWN BY: Dan Bryce (HPD) REV C SHEET 1 OF 1 DATE PRINTED: 3/26/2009 V2					