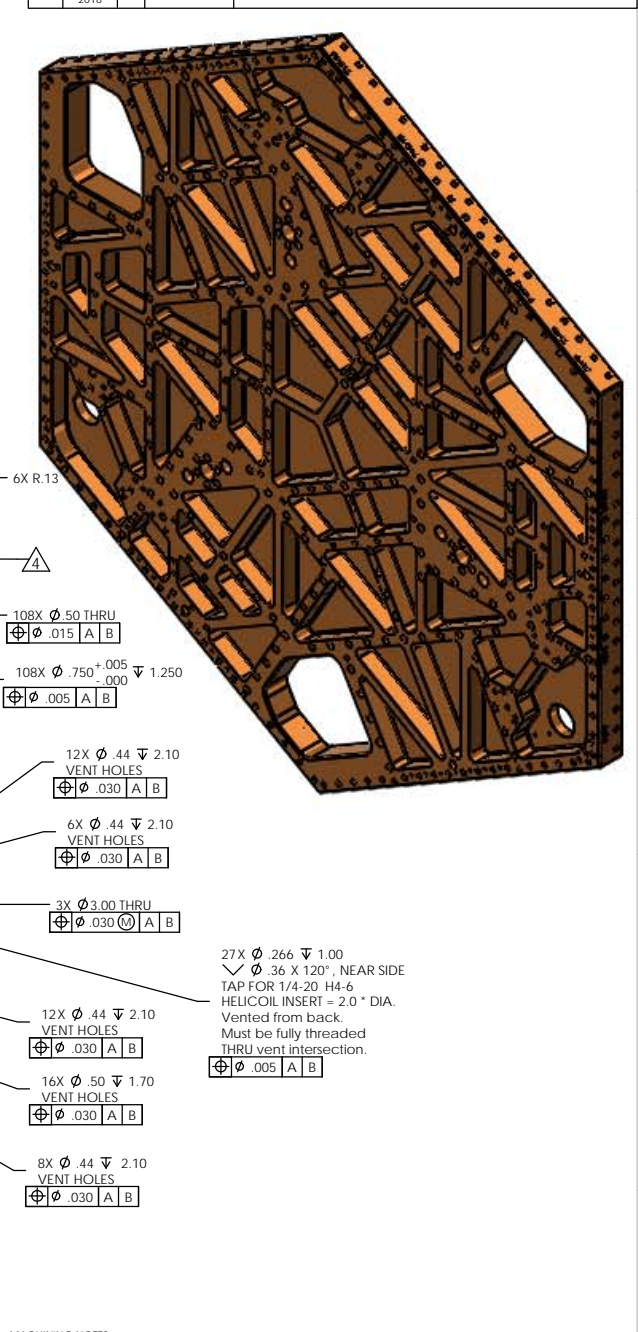
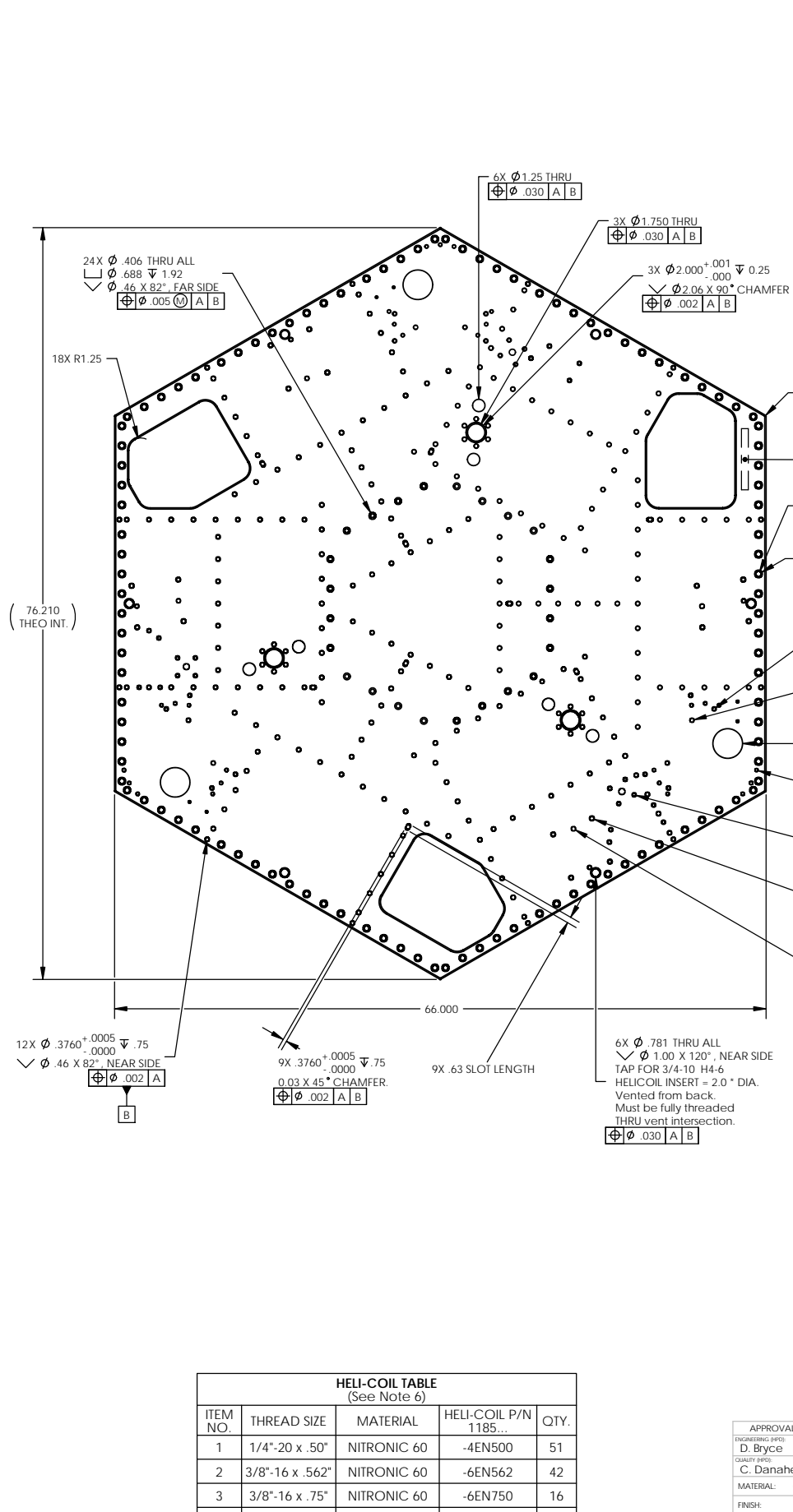
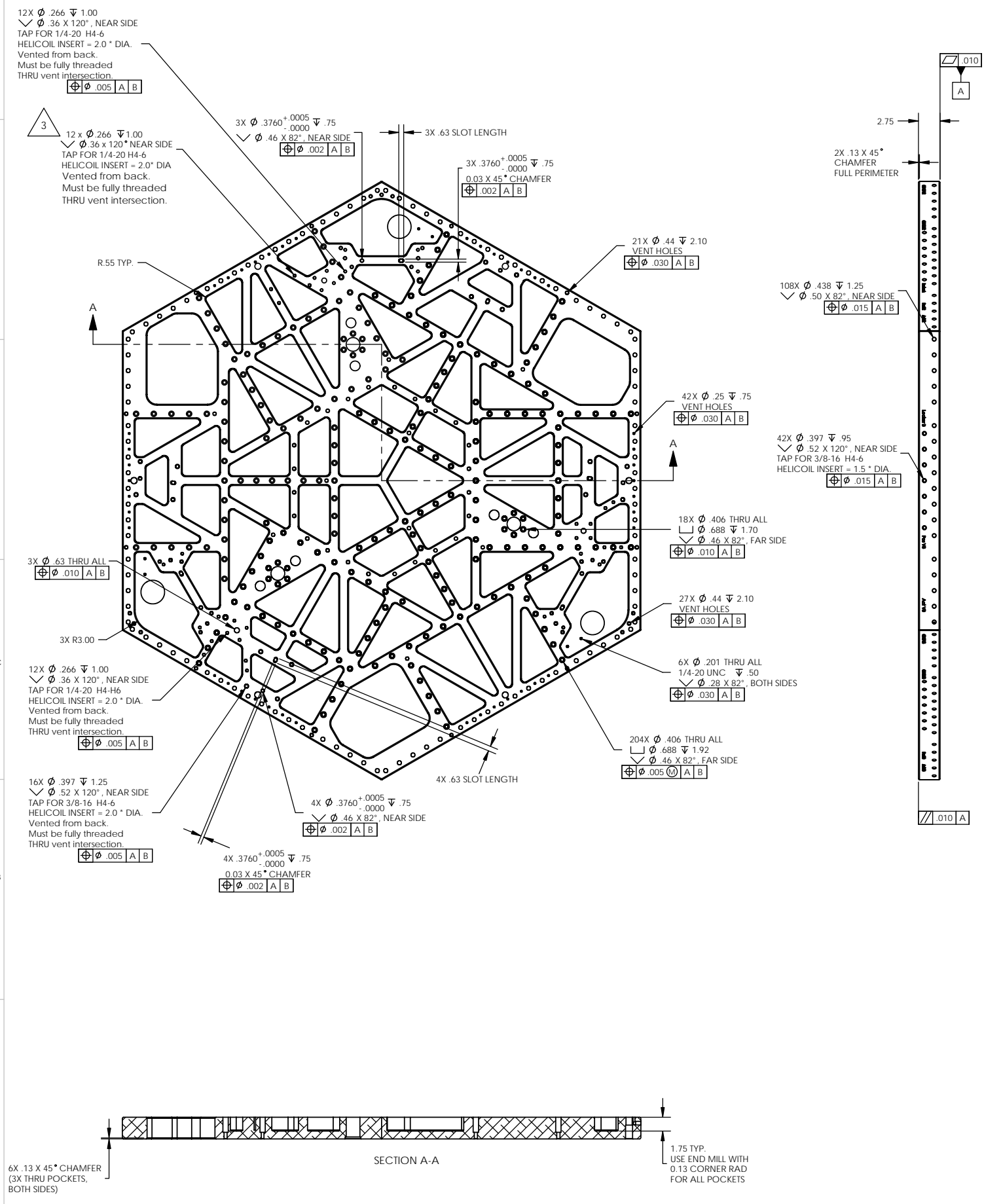


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
B	5/22/07	1060	Daniel Bryce	Manufacturing Release
C	6/07/07	1063	Daniel Bryce	Multiple Minor Changes
D	6/19/07	1065	Daniel Bryce	Multiple Minor Changes
3	6/27/07	1066	Daniel Bryce	Multiple Minor Changes
V2	3/6/2009		Andy Stein	Added 3/8"-16 x 1.5" Dia Heli-Coil patterns to 2 sides. Moved 3x 3.0" Dia thru holes. Added 1/4"-20 holes for Vert GS-13 cable clamps. Added component labels. Changed cham details. Changed some cham and vent hole depths.
V3	19 NOV 2018		KMASON	Added 12 1/4"-20 helicoils for future sensor.



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.
D071051-V2
S/N - ###
5) WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE LABELS SHOWN ON SHEET 2. USE .38" TALL CHARACTERS. LOCATION TOLERANCE +/- .10".
6) 6X 3/4"-10 HELI-COILS MAY BE INSTALLED FOR HANDLING. NO OTHER HELI-COILS SHOULD BE INSTALLED UNTIL POST-CLEANING. SEE TABLE FOR FULL LIST OF HELI-COILS REQUIRED.

POST-MACHINING NOTES:
P1) CLEAN ACCORDING TO LIGO-E0810022.
P2) INSTALL CLASS-A CLEAN HELI-COILS. BREAK OFF AND REMOVE TANGS. CHECK THAT END OF EACH INSERT REMAINS ENGAGED IN THREAD AFTER TANG REMOVAL.

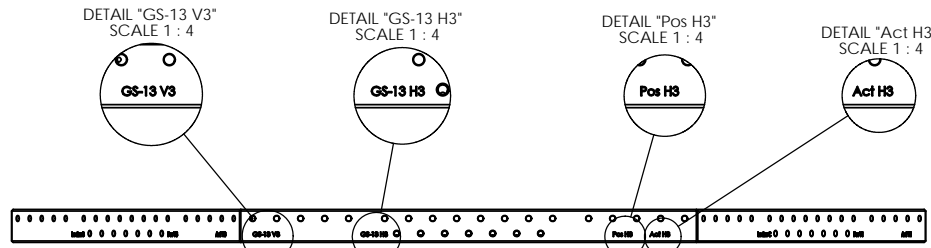
APPROVALS			
ENGINEER	DATE	DATE	
D. Bryce	5/22/07		
C. Danaher	5/22/07		

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
XXX ±.015 XXX ±.005
XXX ±.015 XXX ±.005
ANG TOL ± 1° SURFACE ROUGHNESS Ra
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:
0.10 | A | B

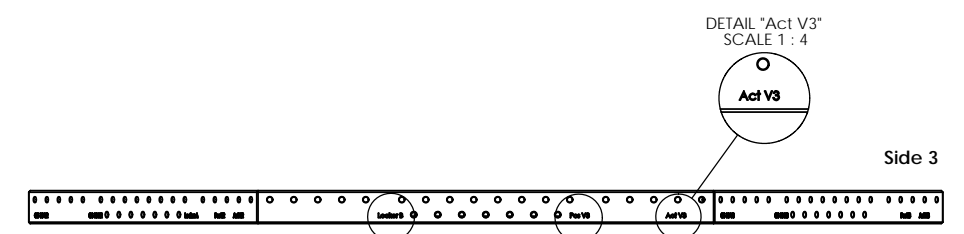
ORIGINAL DESIGN BY: **High Precision Devices** (LIGO)
1668 Vallée Lane, Suite C, Boulder, Colorado 80301
Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com

DESCRIPTION: **Stage 1 Floor**
P/N: **D071051** CONFID: -
CAD FILE NAME: D071051_Stage_1_Floor
PROJECT: HAM ISI, Advanced LIGO
SIZE: SCALE: **1:8** DRAWN BY: **HPD** REV
D SHEET **1** OF **2** DATE PRINTED: **11/19/2018** V3

HELI-COIL TABLE (See Note 6)				
ITEM NO.	THREAD SIZE	MATERIAL	HELI-COIL P/N	QTY.
1	1/4"-20 x .50"	NITRONIC 60	-4EN500	51
2	3/8"-16 x .562"	NITRONIC 60	-6EN562	42
3	3/8"-16 x .75"	NITRONIC 60	-6EN750	16
4	3/4"-10 x 1.50"	STAINLESS STEEL	-12CN1500	6

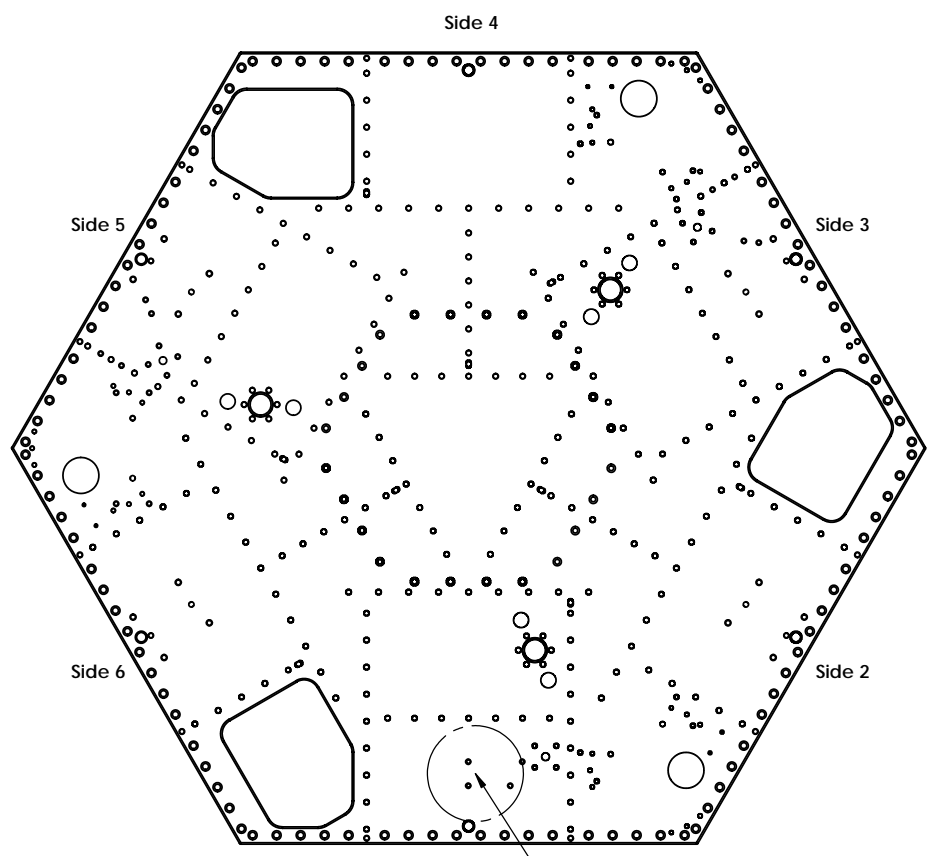


Side 4
(Note left/right orientation.
Not projected from Top View!)

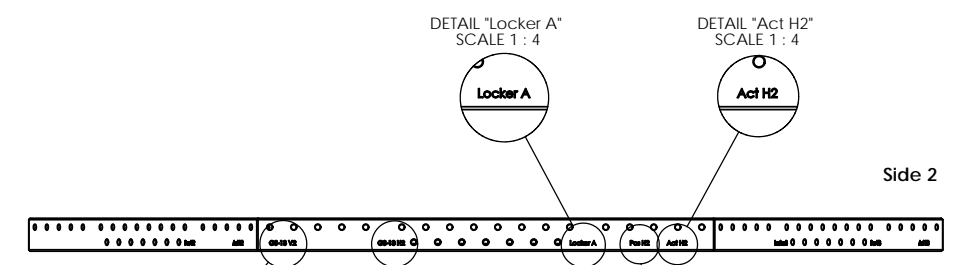


DETAIL "Locker B"
SCALE 1 : 4

DETAIL "Pos V3"
SCALE 1 : 4



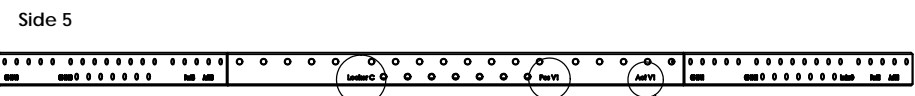
Side 1
To identify Side 1:
No holes in this area,
as opposed to Sides 3 and 5.



DETAIL "GS-13 V2"
SCALE 1 : 4

DETAIL "GS-13 H2"
SCALE 1 : 4

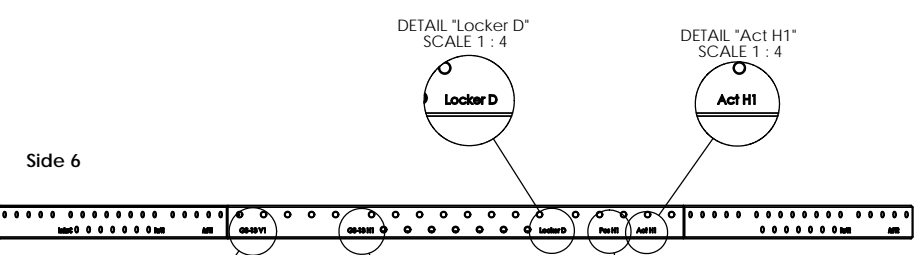
DETAIL "Pos H2"
SCALE 1 : 4



DETAIL "Locker C"
SCALE 1 : 4

DETAIL "Pos V1"
SCALE 1 : 4

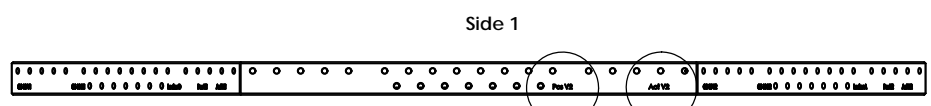
DETAIL "Act V1"
SCALE 1 : 4



DETAIL "GS-13 V1"
SCALE 1 : 4

DETAIL "GS-13 H1"
SCALE 1 : 4

DETAIL "Pos H1"
SCALE 1 : 4



DETAIL "Pos V2"
SCALE 1 : 4

DETAIL "Act V2"
SCALE 1 : 4

APPROVALS	DATE
D. Bryce	5/22/07
C. Danaher	5/22/07

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
DECIMAL TOLERANCES:
XX ±.015 XXX ±.005
ANG TOL: ±1° SURFACE ROUGHNESS:
REMOVED ALL SHARP EDGES.
LEAVE .005 X .45° MIN CHAMFER
OR .005 MIN RADIUS.

ORIGINAL DESIGN BY:	High Precision Devices	MODIFIED BY:	LIGO
1668 Vailtec Lane, Suite C, Boulder, Colorado 80301	Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	DESCRIPTION: Stage 1 Floor	
P/N: D071051	CONFIG: -	CAD FILE NAME: D071051_Stage_1_Floor	
PROJECT: HAM ISI, Advanced LIGO	SCALE: 1:8	DRAWN BY: HPD	REV
SHEET 2 OF 2	DATE PRINTED: 11/19/2018		V2