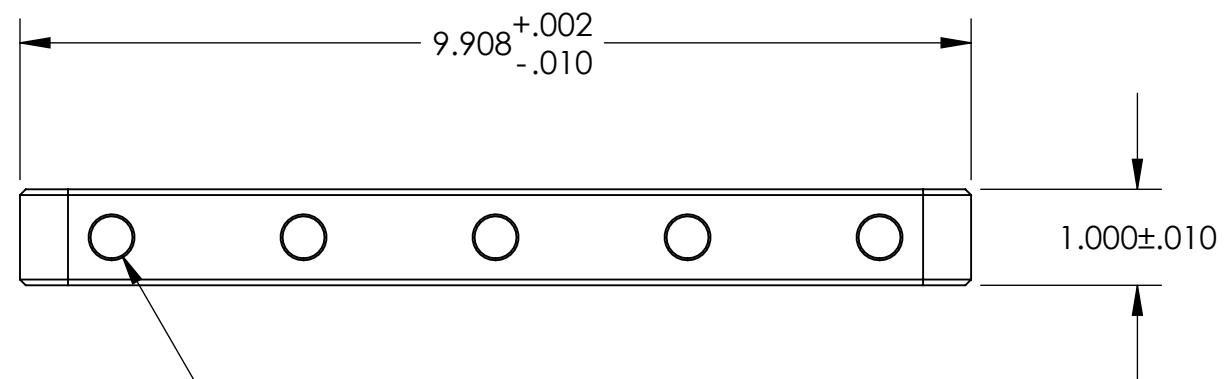


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / C	11 Jun 2007	1064	D. Senders	Release for Enhanced LIGO.
V2	10 Mar 2009		A. Stein	Release for Advanced LIGO. Changed 1/4"-20 holes from Heli-Coil to regular taps. Increased jam nut c'bore dia. Added/modified c'sinks.



5X ϕ .438 ∇ 1.38
 ∇ ϕ .48 X 82°, NEAR SIDE
 \oplus ϕ .010 (M) B A C

\parallel .004 A B
 C

5X ϕ .750 \pm .005 THRU ALL
 \oplus ϕ .005 (M) A B C

\parallel .002 A
 B

2X .06 X 45°
 AROUND OUTER
 EDGES

∇ .002
 A

2X ϕ .422 THRU ALL
 1/2-13 UNC H7-11 THRU ALL
 ∇ ϕ .60 X 120°, NEAR SIDE
 ∇ ϕ .70 X 120°, FAR SIDE
 \oplus ϕ .010 A B C

2X ∇ ϕ 1.50 ∇ .45
 \oplus ϕ .015 (M) A B C

8X ϕ .201 THRU ALL
 1/4-20 UNC ∇ .50
 ∇ ϕ .30 X 120°, NEAR SIDE
 \oplus ϕ .030 A B C

19X ϕ .406 THRU ALL
 ∇ ϕ .688 ∇ .42
 ∇ ϕ .46 X 82°, FAR SIDE
 \oplus ϕ .005 (M) A B C

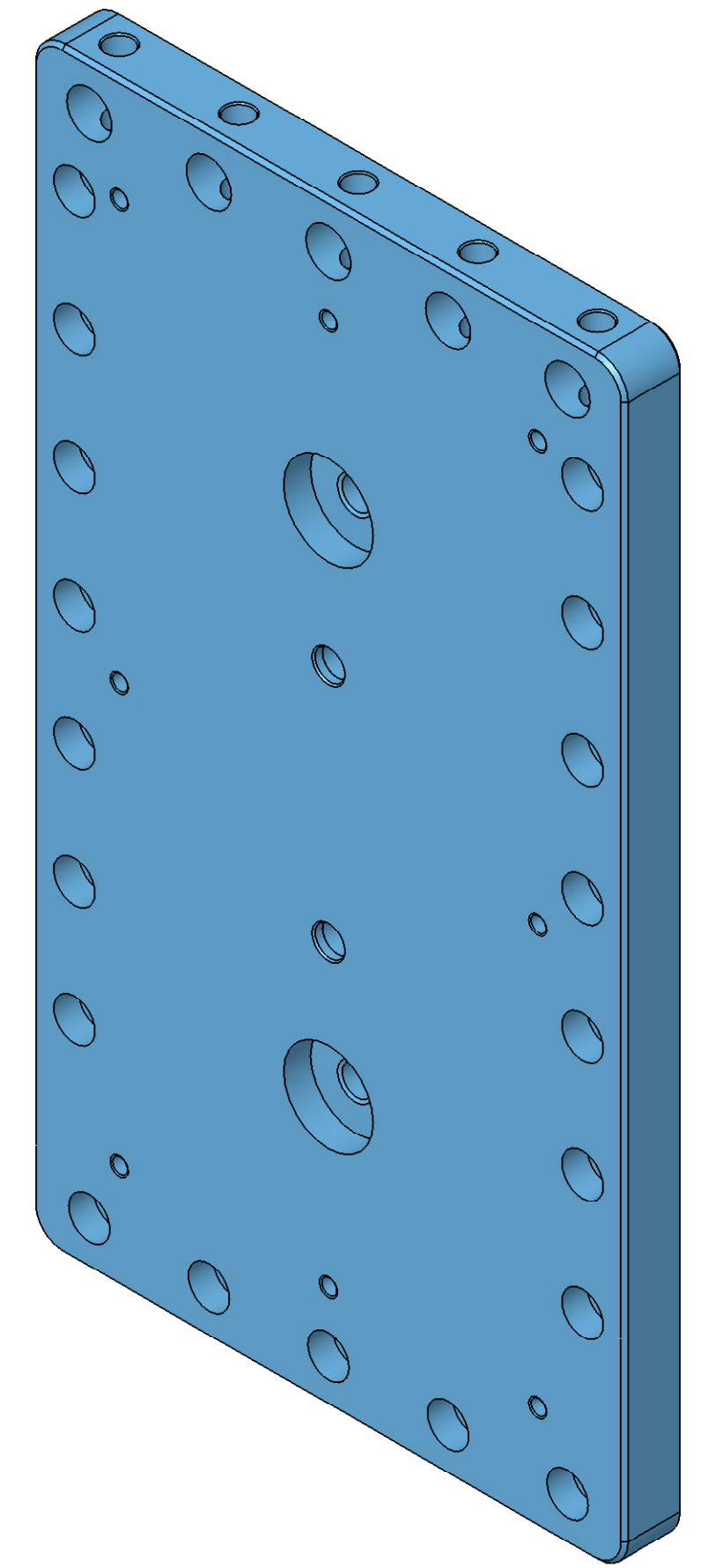
2X ϕ .4998 \pm .0000 THRU ALL
 ∇ ϕ .502 \pm .001 ∇ .15
 ∇ ϕ .55 X 82°, NEAR SIDE
 \oplus ϕ .005 A B C

4

4X R.50

17.500 \pm .010

\parallel .004 A



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.

D071059-V2
 S/N - ###

POST-MACHINING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 DECIMAL TOLERANCES:
 .XX \pm .015 .XXX \pm .005
 ANG TOL: \pm 1" SURFACE ROUGHNESS: \sqrt{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:

APPROVALS	DATE
ENGINEERING (HPD): D. Bryce	5/29/2007
QUALITY (HPD): C. Danaher	5/29/2007
MATERIAL:	6061-T6 Al
FINISH:	None
MASS:	15.9 lbs

ORIGINAL DESIGN BY:	MODIFIED BY:
High Precision Devices	
1468 Valtrec Lane, Suite C, Boulder, Colorado 80301 Phone: (303) 447-2558 Fax: (303) 447-2548 Web Site: www.hpd-online.com	
DESCRIPTION:	Outer Wall, Small Panel
P/N:	D071059
CAD FILE NAME:	D071059_Outer_Wall-Small_Panel
PROJECT:	HAM ISI, Advanced LIGO
SIZE	SCALE: 1:2
DATE PRINTED:	3/20/2009
REV	V2