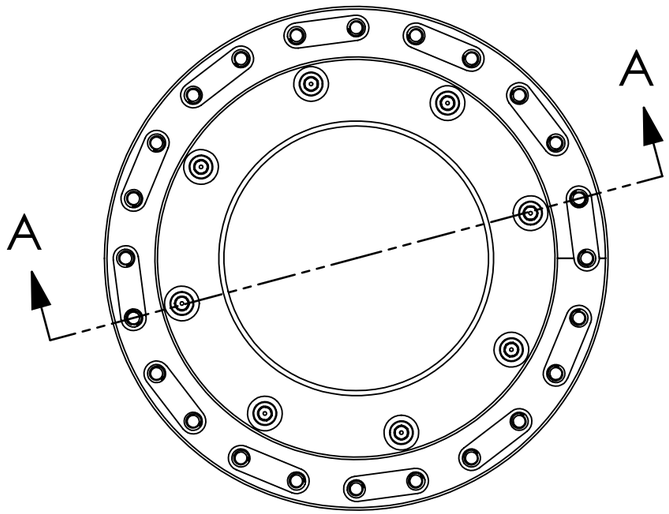
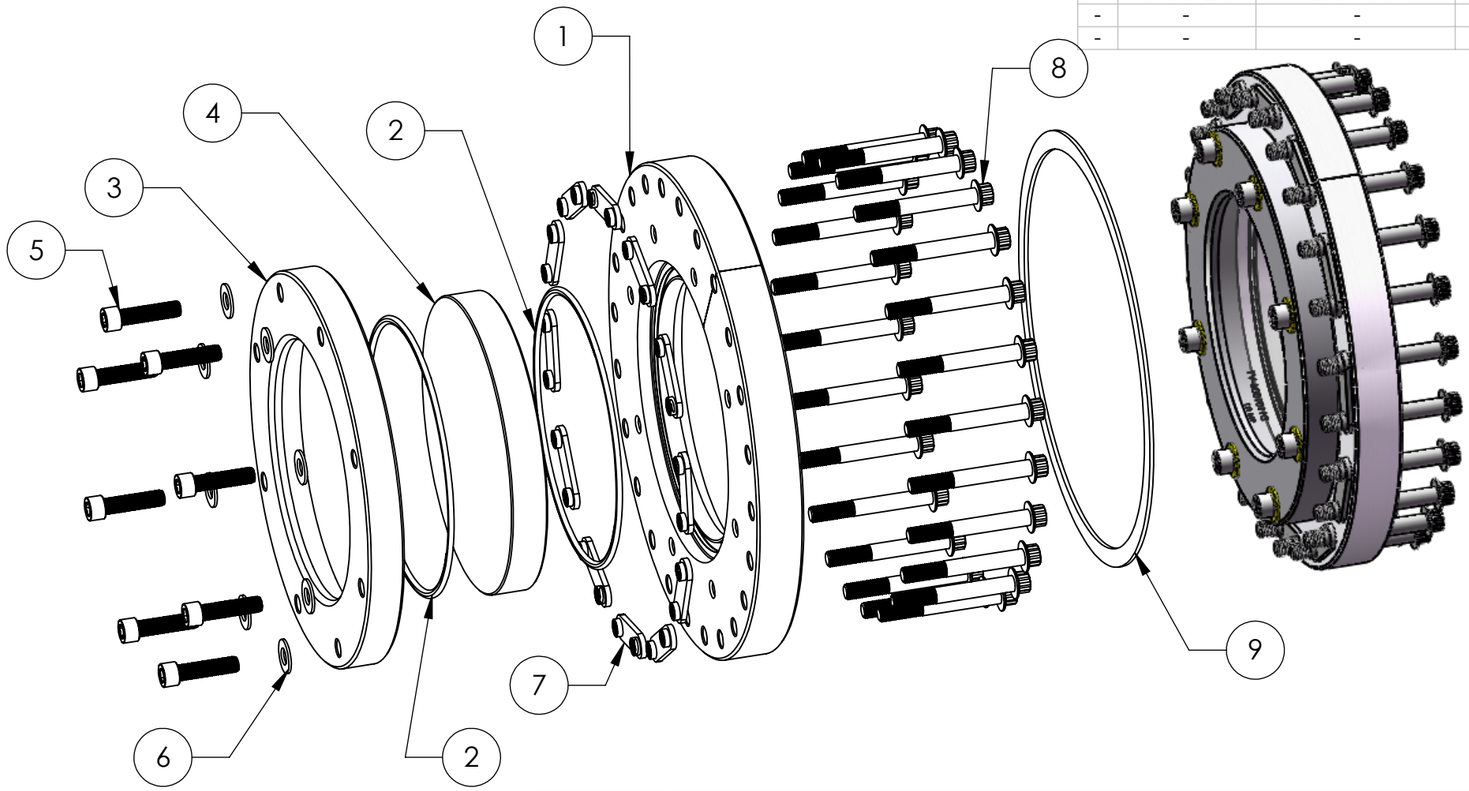
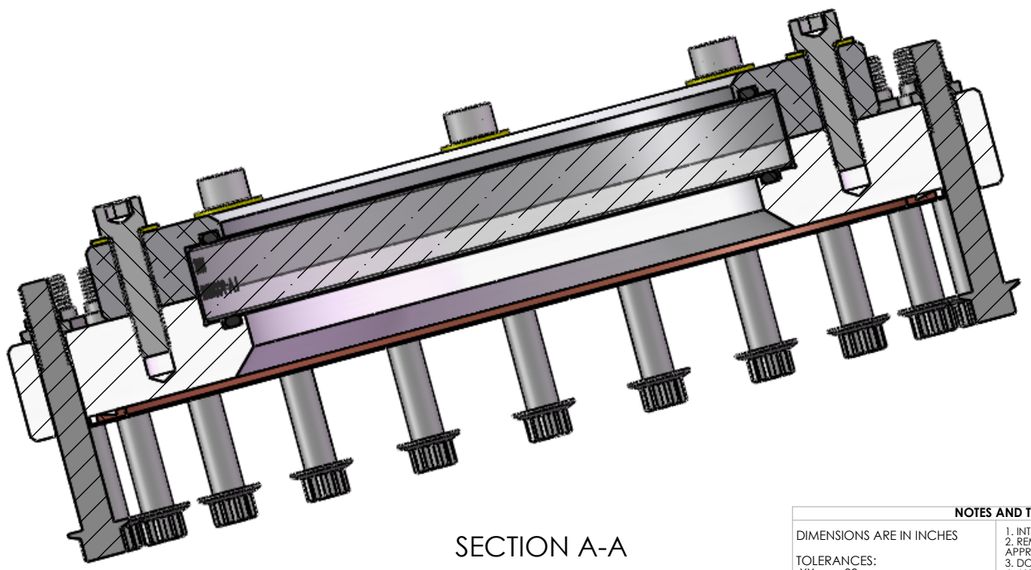
NOTES CONTINUED:

5. APPROXIMATE WEIGHT = 17 LB.
6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

REV.	DATE	DCN #	DRAWING TREE #
v1	30 MAY 2011	E1100478	E1100479
-	-	-	-
-	-	-	-







SECTION A-A

ITEM NO.	PART NUMBER	QTY.
1	D1101001 aLIGO, high quality, 6in Viewport Flange	1
2	Parker O-Ring #2-253, Viton (R) Fluorocarbon (KFM), 75 Shore A or equivalent. O-rings must match-- must be from the same lot/batch	2
3	D1101002 aLIGO, high quality, 6in Viewport Clamp	1
4	D1101006 aLIGO, high quality, non-wedged, 6in Viewport, Optic	1
5	5/16-24 UNF x 1.25", Silver Plated, UC Components #C-3120-NA or equivalent	8
6	_____ 0.3125in, MS 15795-812 FLAT WASHERS (OR EQUIV.)	8
7	Nut Plate, 10" Conflat, Nor-Cal NP-800 or equivalent	12
8	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt, MDC #190067 (qty 25) or equivalent	24
9	Copper Gasket, 10" Conflat, MDC #191019 or equivalent	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .03
.XXX ± .010

ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY R.02 FOR SHEET METAL PARTS.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL N/A

FINISH N/A µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME High Quality, Non-Wedged, 6in Viewport Assy

SYSTEM AOS

SUB-SYSTEM SLC

NEXT ASSY

DESIGNER	Dennis Coyne	30 May 2011	
DRAFTER	Dennis Coyne	30 May 2011	
CHECKER	Mike Smith	31 May 2011	
APPROVAL	See DCN		

SIZE B **DWG. NO.** D1100999 **REV.** v1

SCALE: 1:4 **PROJECTION:** SHEET 1 OF 1

D1100999 aLIGO, high quality, non-wedged, 6in Viewport Assy, PART PDM REV: X-001, DRAWING PDM REV: X-000