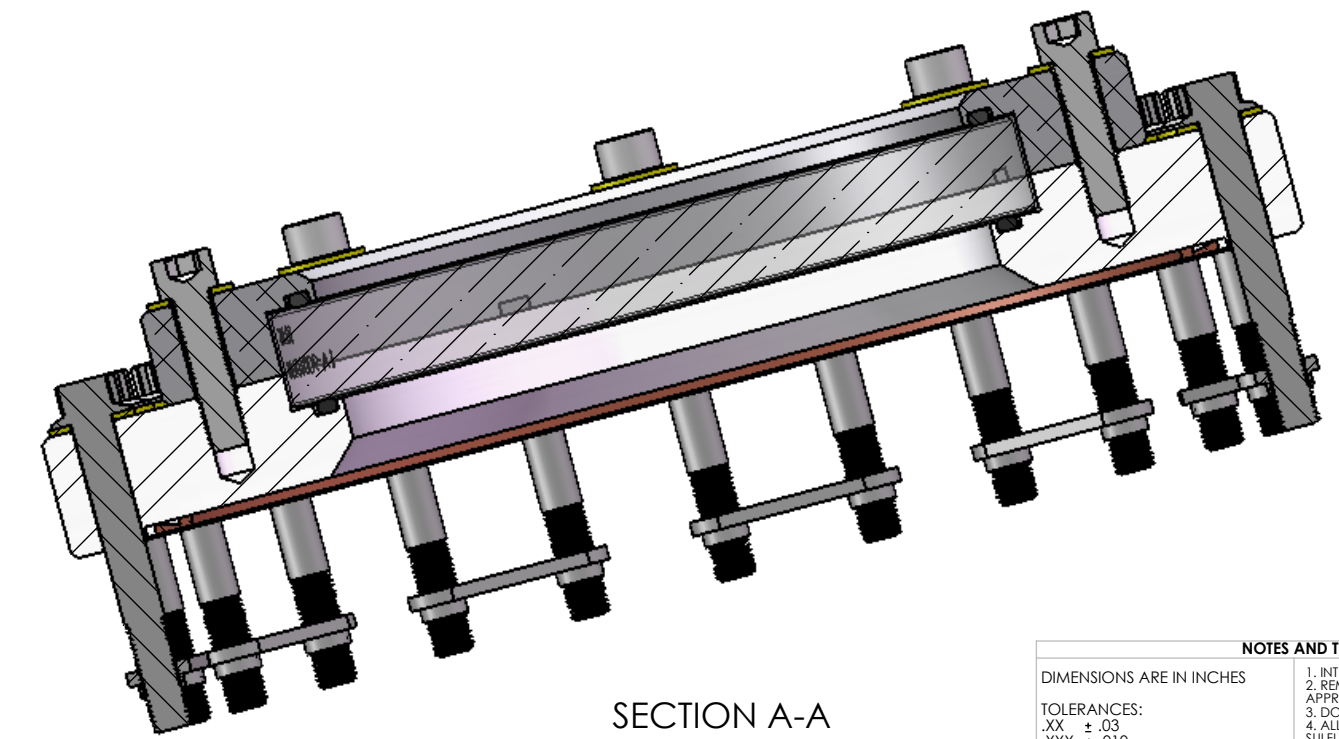
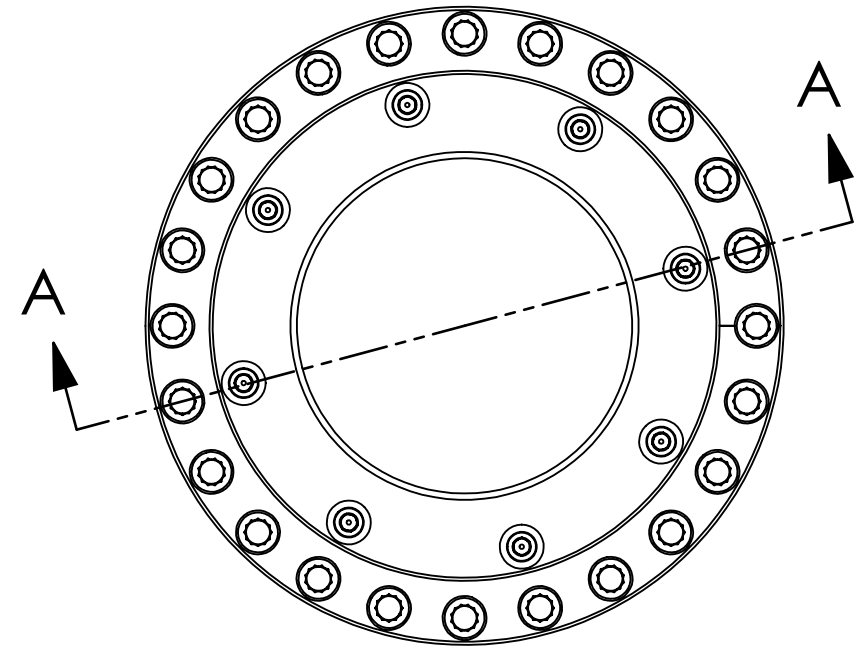
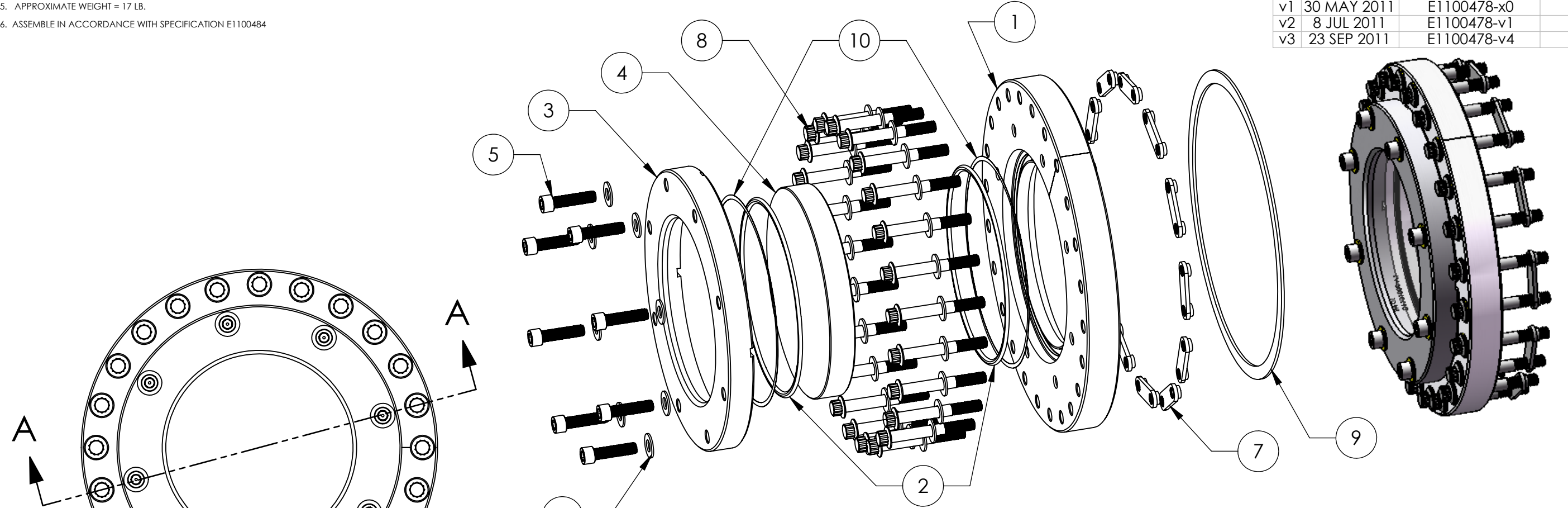


8 7 6 5 4 3 2 1

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

REV.	DATE	DCN #	DRAWING TREE #
v1	30 MAY 2011	E1100478-x0	E1100479
v2	8 JUL 2011	E1100478-v1	E1100479
v3	23 SEP 2011	E1100478-v4	-

D1100999 aLIGO, high quality, non-wedged, 6in Viewport Assy, PART PDM REV: X-009, DRAWING PDM REV: X-006



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	5/16" FLAT WASHERS, NAS 1149-C0563R (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, and Washers MDC Kit #190067 (qty 25) or equivalent, discard nut.	24
9	Copper Gasket, 10" Conflat, MDC #191019 or equivalent	1
10	D1003207 aLIGO, high quality, 6in Viewport, Viewport Spacer	2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .03
 .XXX ± .010
 ANGULAR ± 1.0°

MATERIAL N/A

FINISH N/A μinch

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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.

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		High Quality, Non-Wedged, 6in Viewport Assy	
	DESIGNER	Dennis Coyne	30 May 2011	SIZE DWG. NO.
DRAFTER	Dennis Coyne	30 May 2011	B	D1100999
CHECKER	Mike Smith	31 May 2011		
APPROVAL	See DCN			v3
SCALE: 1:4		PROJECTION:		SHEET 1 OF 1

8 7 6 5 4 3 2 1