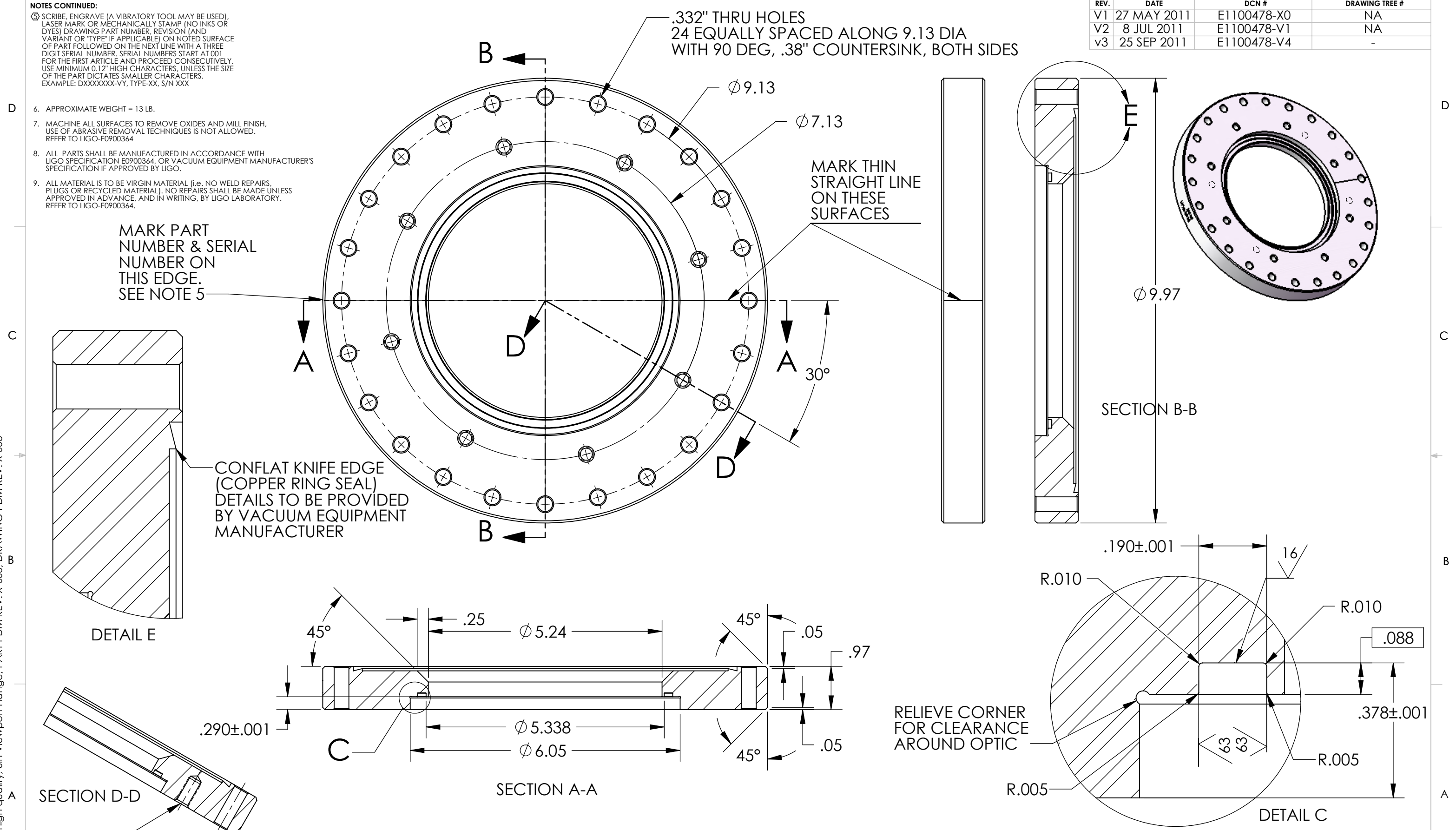


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- 6. APPROXIMATE WEIGHT = 13 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364, OR VACUUM EQUIPMENT MANUFACTURER'S SPECIFICATION IF APPROVED BY LIGO.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	27 MAY 2011	E1100478-X0	NA
V2	8 JUL 2011	E1100478-V1	NA
v3	25 SEP 2011	E1100478-V4	-



MARK PART NUMBER & SERIAL NUMBER ON THIS EDGE. SEE NOTE 5

CONFLAT KNIFE EDGE (COPPER RING SEAL) DETAILS TO BE PROVIDED BY VACUUM EQUIPMENT MANUFACTURER

MARK THIN STRAIGHT LINE ON THESE SURFACES

RELIEVE CORNER FOR CLEARANCE AROUND OPTIC

8X 5/16-24 TAP .6" DEEP
 DRILL .76" MAX DEPTH 8 EQUALLY SPACED
 ALONG 7.13 DIA WITH 90 DEG, .36" COUNTERSINK

DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR $\pm 1.0^\circ$		MATERIAL		FINISH		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		PART NAME	
.XX	$\pm .03$.XXX	$\pm .010$			ALUMINUM	63 Ra	ALUMINUM	63 Ra	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.	aLIGO High Quality, 6in Viewport FLANGE		
SYSTEM		SUB-SYSTEM		DESIGNER		DRAFTER		CHECKER		APPROVAL		SIZE DWG. NO.	
AOS		SLC		Dennis Coyne 27 May 2011		Dennis Coyne 27 May 2011		Mike Smith 8 Jun 2011		see DCN		B D1101001	
NEXT ASSY		SCALE: 1:2		PROJECTION:		SHEET 1 OF 1							
D1100999, D1101000													