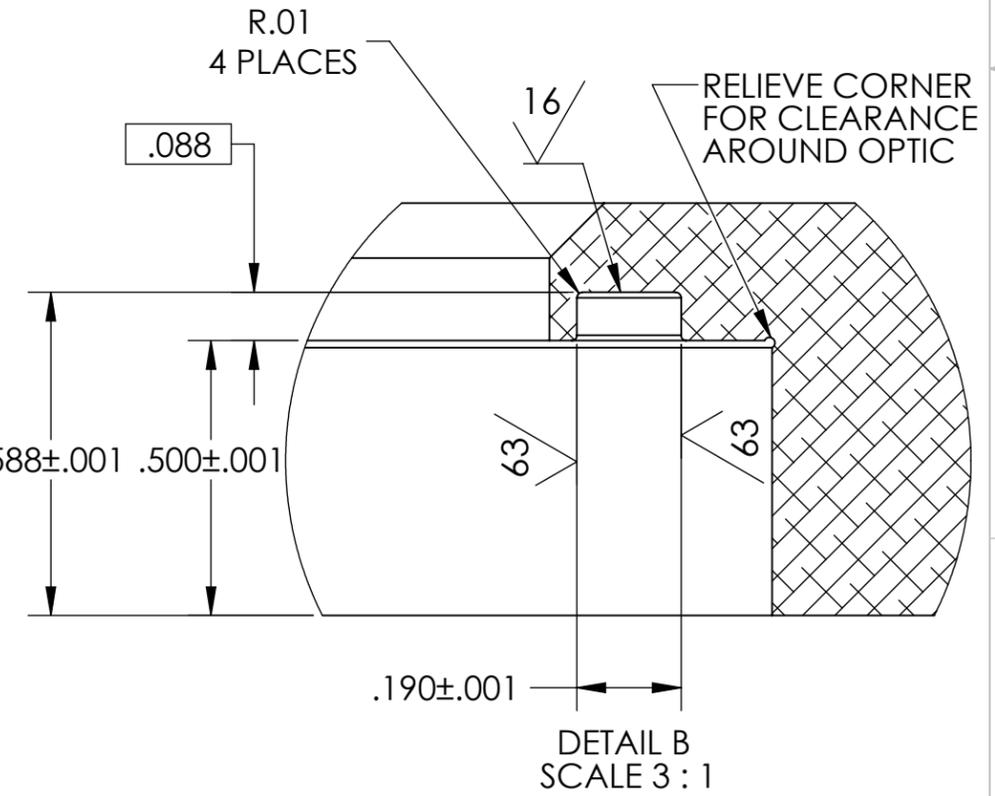
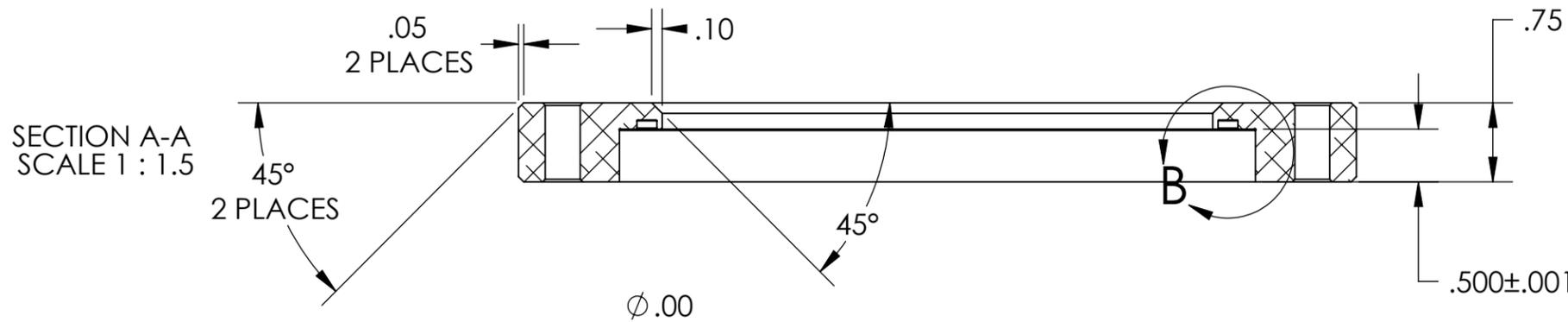
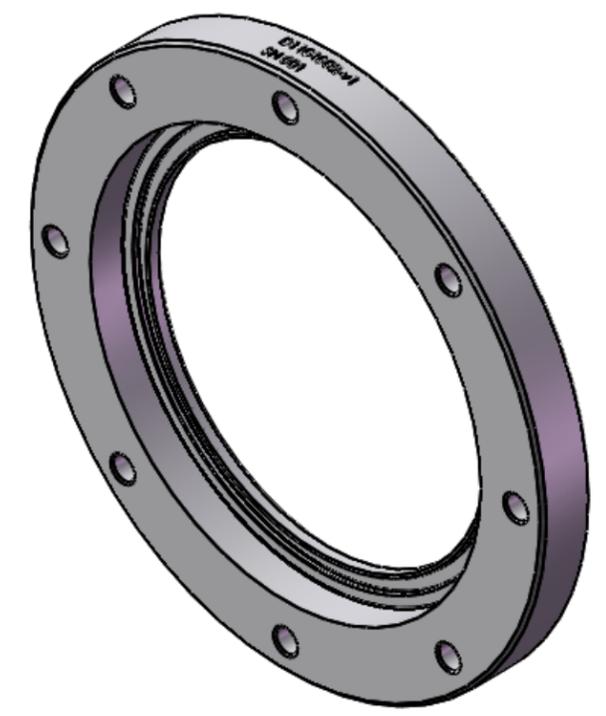
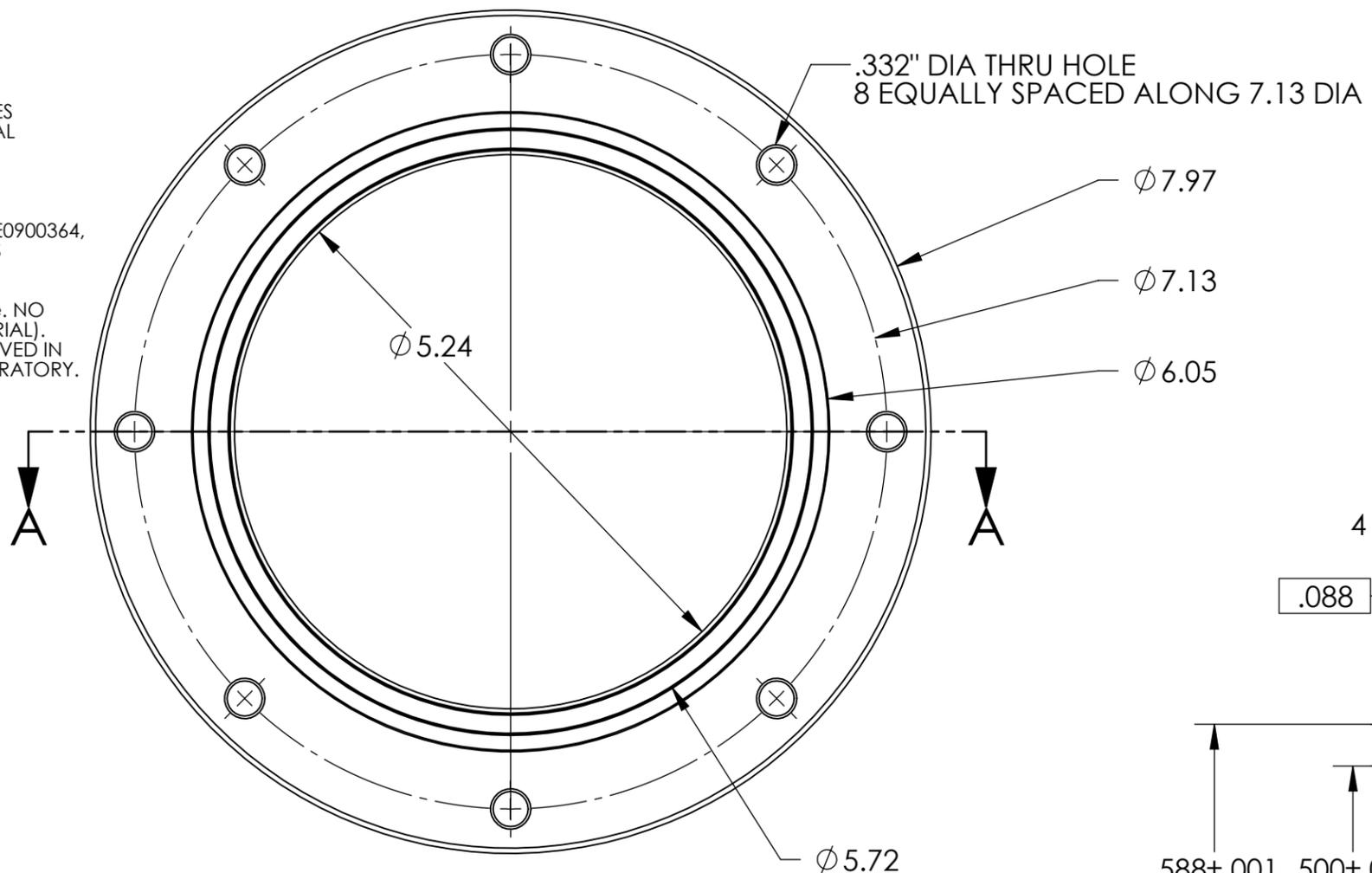


NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 1.7 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.

D1101002-v1  
 SN 001

MARK PART AND SERIAL NUMBERS ON THIS SURFACE, APPROXIMATELY LOCATED AS SHOWN



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

|                          |   |                      |
|--------------------------|---|----------------------|
| DIMENSIONS ARE IN INCHES | TOLERANCES:<br>.XX ± .03<br>.XXX ± .010 | ANGULAR ± 1.0°       |
| MATERIAL                 | 6061 Alloy                              | FINISH<br>63 Raμinch |

|   |                          |  |            |
|---|--------------------------|--|------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY |                          | PART NAME<br><b>aLIGO, High Quality, 6" Viewport CLAMP</b> |            |
| SYSTEM  | AOS                      | SUB-SYSTEM   | SLC        |
| DESIGNER  | Dennis Coyne 27 May 2011 | SIZE   | DWG. NO. B |
| DRAFTER   | Dennis Coyne 27 May 2011 | <b>D1101002</b>  |            |
| CHECKER   | Mike Smith 27 May 2011   | REV.   | v1         |
| APPROVAL  | See DCN                  | SCALE:   | 1:2        |
|   | See DCN                  | PROJECTION:  |            |
|   |                          | SHEET 1 OF 1   |            |

D1101002 aLIGO, high quality, 6in Viewport Clamp, PART PDM REV: X-002, DRAWING PDM REV: X-002