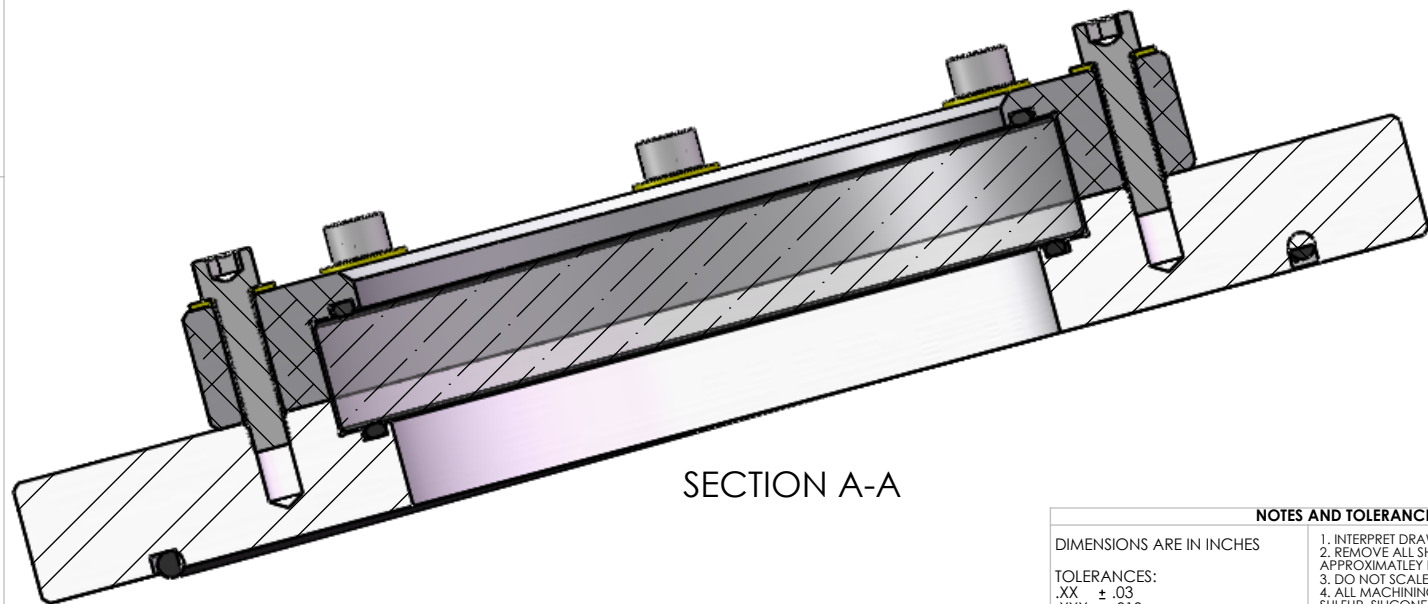
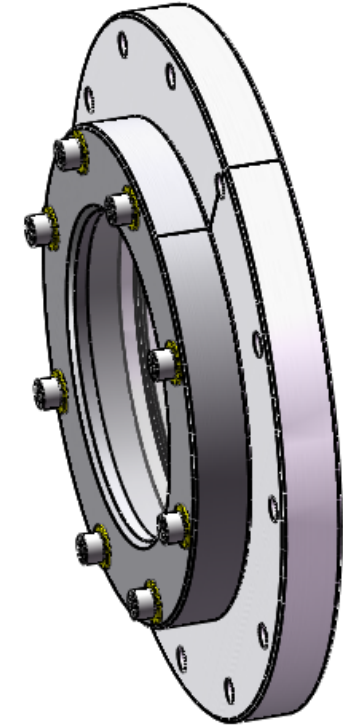
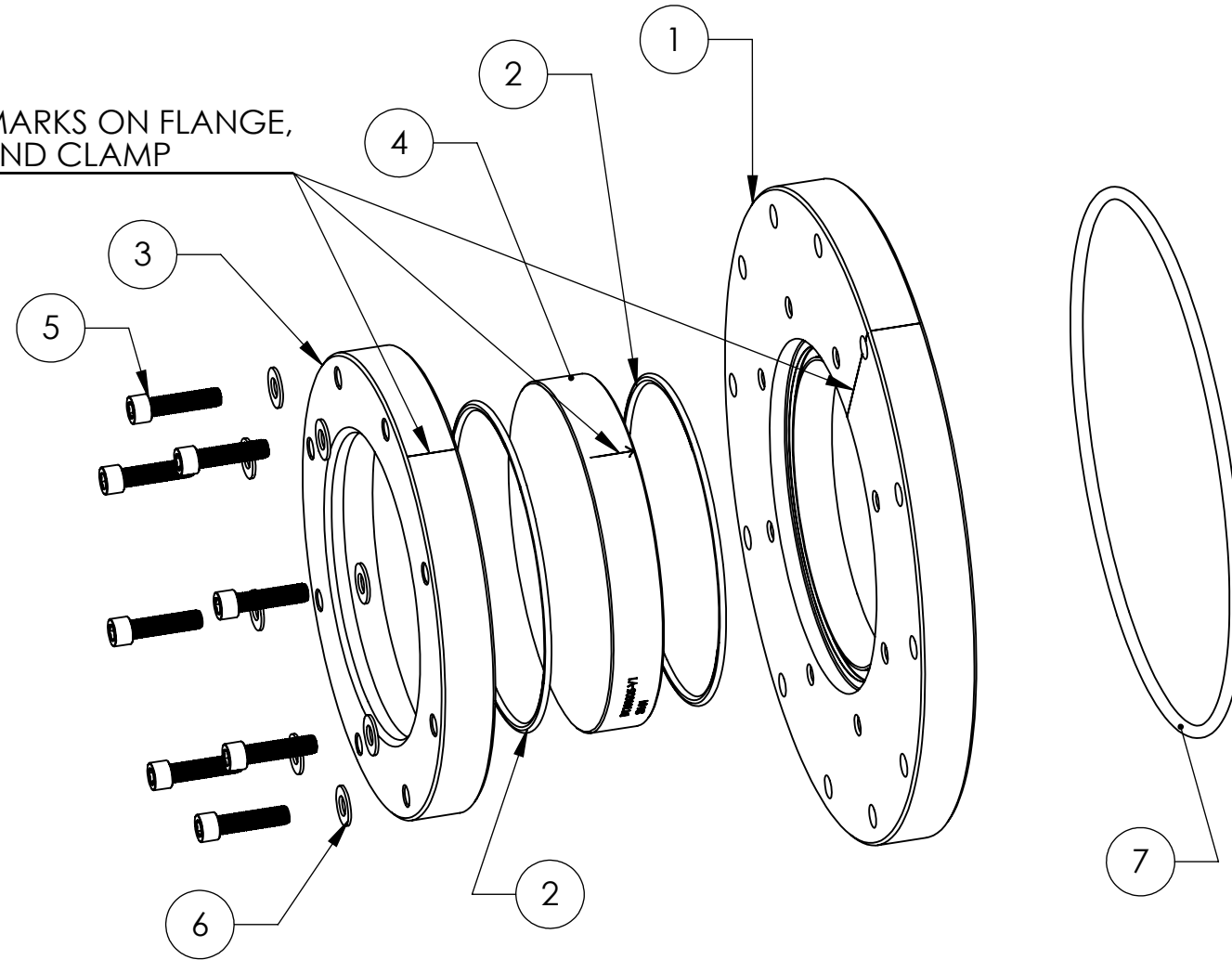
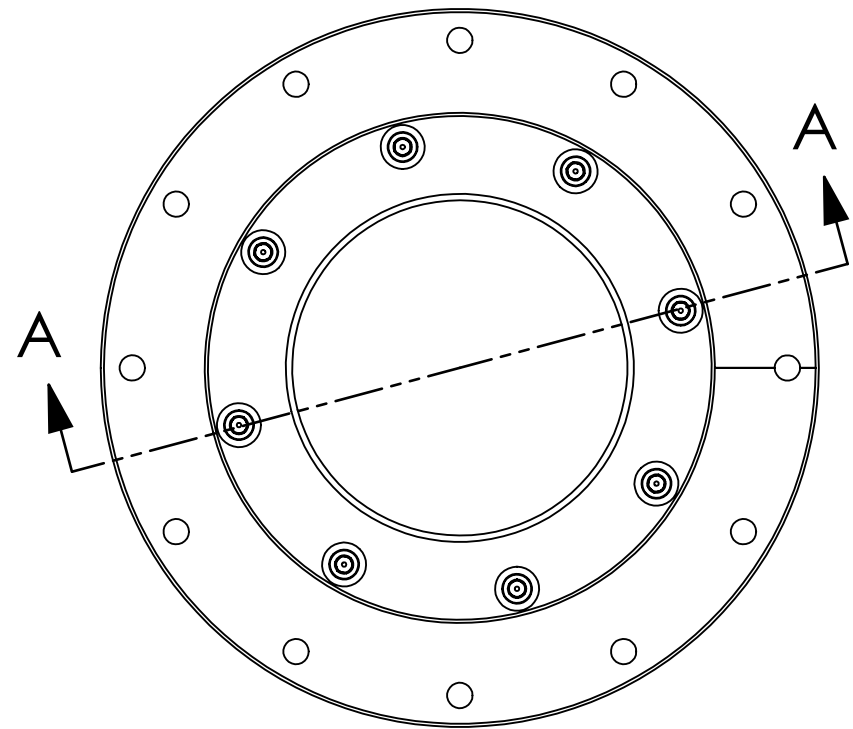


NOTES CONTINUED:
 5. APPROXIMATE WEIGHT = 17 LB.
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

REV.	DATE	DCN #	DRAWING TREE #
v1	9 JUN 2011	E1100478	E1100516
-	-	-	-
-	-	-	-

ALIGN MARKS ON FLANGE,
OPTIC AND CLAMP



SECTION A-A

ITEM NO.	PART NUMBER	QTY.
1	D1101117 aLIGO Septum Viewport Flange	1
2	Parker O-Ring #2-253, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent	2
3	D1101115 aLIGO, high quality, 6in Viewport Clamp, wedged	1
4	D1101005 aLIGO, high quality, wedged, 6in Viewport, Optic	1
5	5/16-24 UNF x 1.25", Silver Plated SS, UC Components #C-3120-NA or equivalent	8
6	_____ 0.3125in, MS 15795-812 FLAT WASHERS (OR EQUIV.)	8
7	Parker O-Ring #2-373, Viton(R) Fluorocarbon (KFM), 75 Shore A 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 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.

MATERIAL N/A FINISH N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		aLIGO Septum Viewport Assy	
	SYSTEM	SUB-SYSTEM	DESIGNER	DATE
AOS	SLC	Dennis Coyne	9 JUN 2011	SIZE DWG. NO.
NEXT ASSY		DRAFTER	9 JUN 2011	B
		CHECKER	10 JUN 2011	D1101092
		APPROVAL	See DCN	REV. v1
			See DCN	SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1101092 aLIGO Septum Viewport Assy, PART PDM REV: X-000, DRAWING PDM REV: X-000