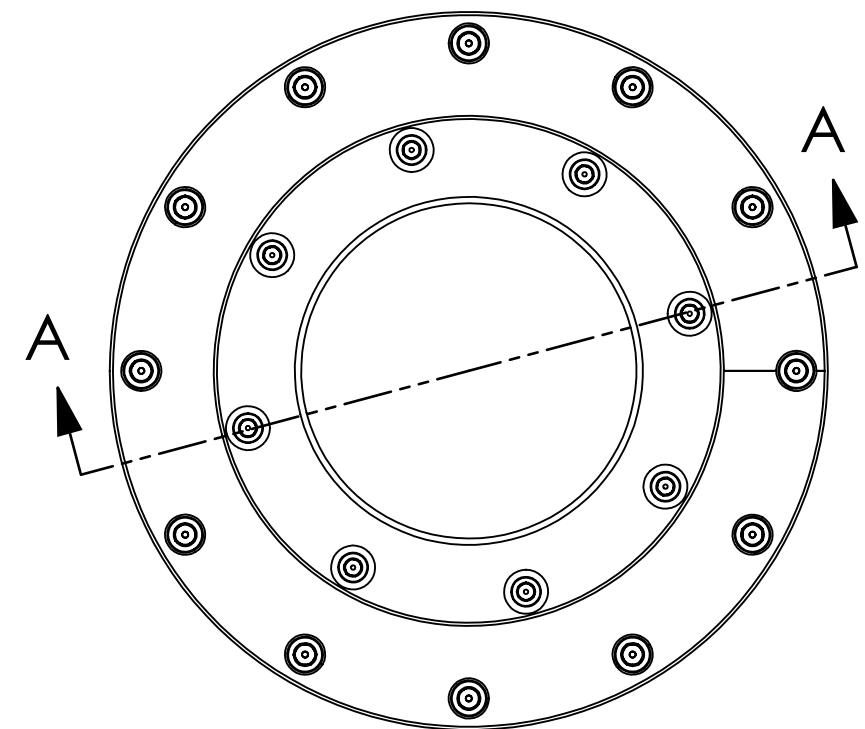


NOTES CONTINUED:  
 5. APPROXIMATE WEIGHT = 17 LB.  
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

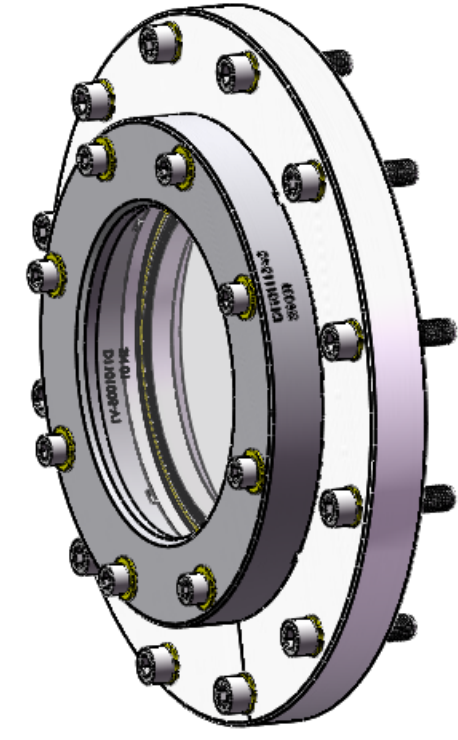
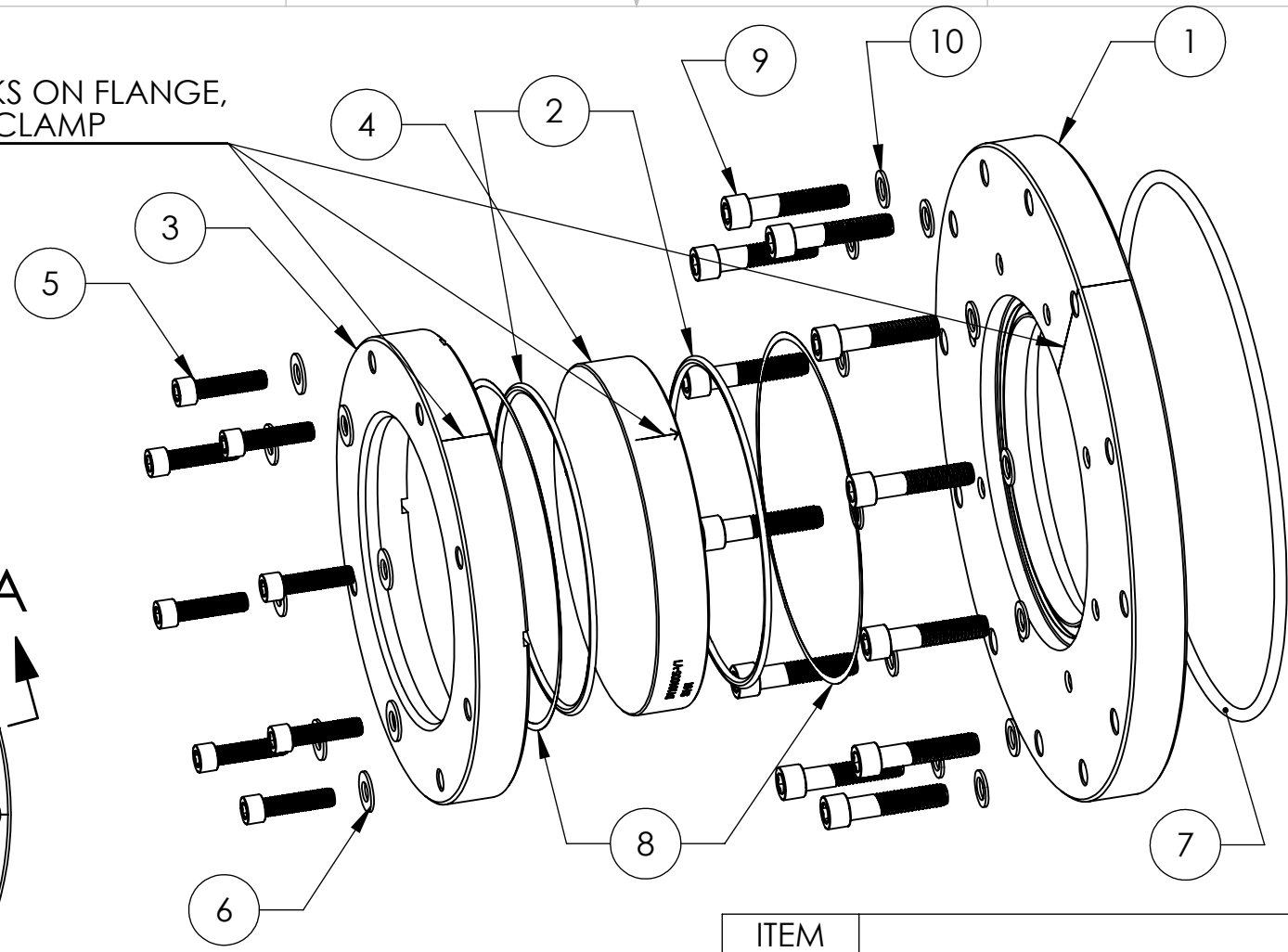
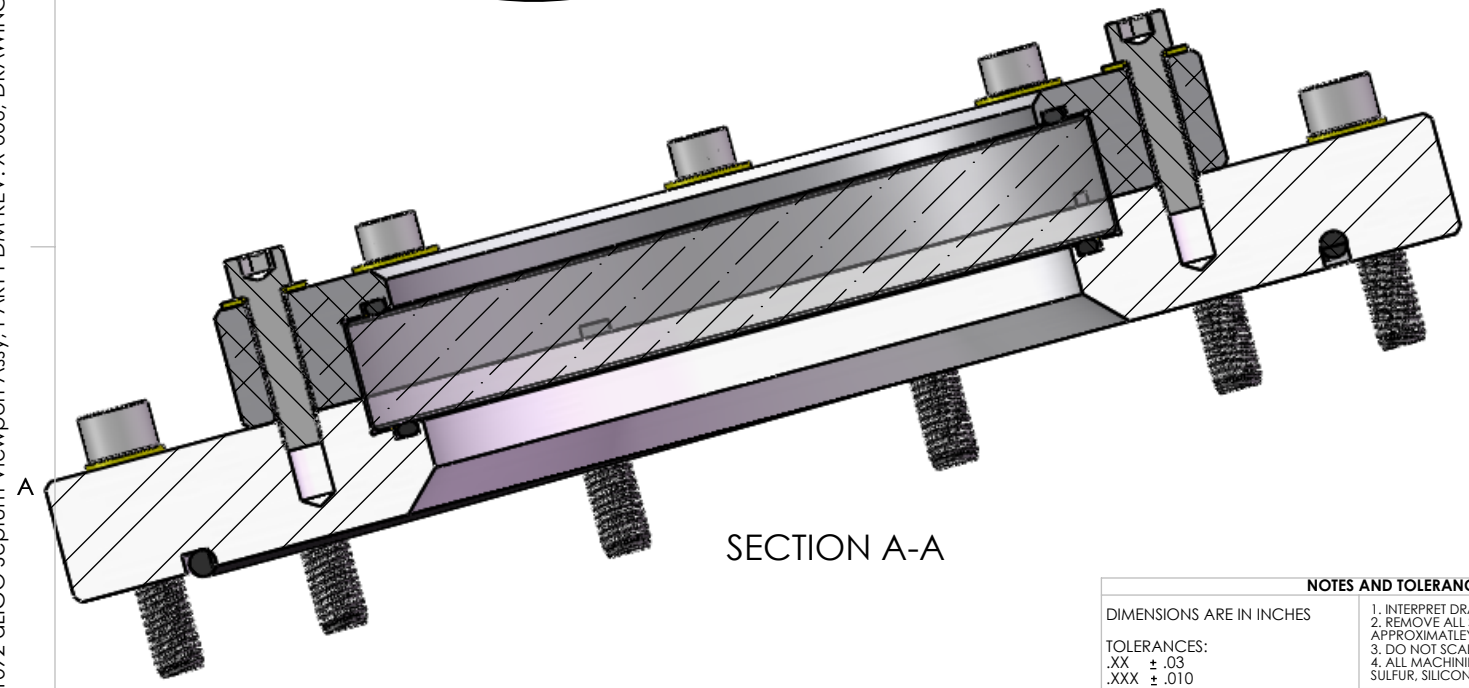
REV.	DATE	DCN #	DRAWING TREE #
v1	9 JUN 2011	E1100478-x0	E1100516
v2	8 JUL 2011	E1100478-v1	E1100516
v3	5 OCT 2011	E1100478-v4	-

ALIGN MARKS ON FLANGE,  
OPTIC AND CLAMP

D1101092 aLIGO Septum Viewport Assy, PART PDM REV: X-006, DRAWING PDM REV: X-004



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. O-Rings must match-must be from the same lot/batch.	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", Vented, Silver Plated SS, UC Components #C-3120-A or equivalent	8
6	5/16" FLAT WASHERS, NAS 1149-C0563R (OR EQUIV.)	8
7	Parker O-Ring #2-373, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent	1
8	D1003207 aLIGO, high quality, 6in Viewport, Viewport Spacer	2
9	3/8-16 UNC x 1.75", SHCS, vented, Silver plated SS, UC Components #C-1628-A or equivalent	12
10	3/8" Flat washer, NAS 1149-C0663R or equivalent	12

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

MATERIAL N/A FINISH N/A μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM AOS SUB-SYSTEM SLC

PART NAME aLIGO Septum Viewport Assy, wedged

DESIGNER Dennis Coyne 9 JUN 2011 SIZE DWG. NO. B D1101092 REV. v3  
 DRAFTER Dennis Coyne 9 JUN 2011  
 CHECKER Mike Smith 10 JUN 2011  
 APPROVAL See DCN See DCN SCALE: 1:4 PROJECTION: SHEET 1 OF 1