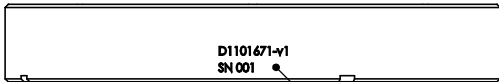


D1101671 ALIGO HIGH POWER NON WEDGED 6IN VIEWPORT CLAMP - PART PDM REV: X-001 - DRAWING PDM REV: X-007

8 7 6 5 4 3 2 1

NOTES CONTINUED:
 Ⓞ 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

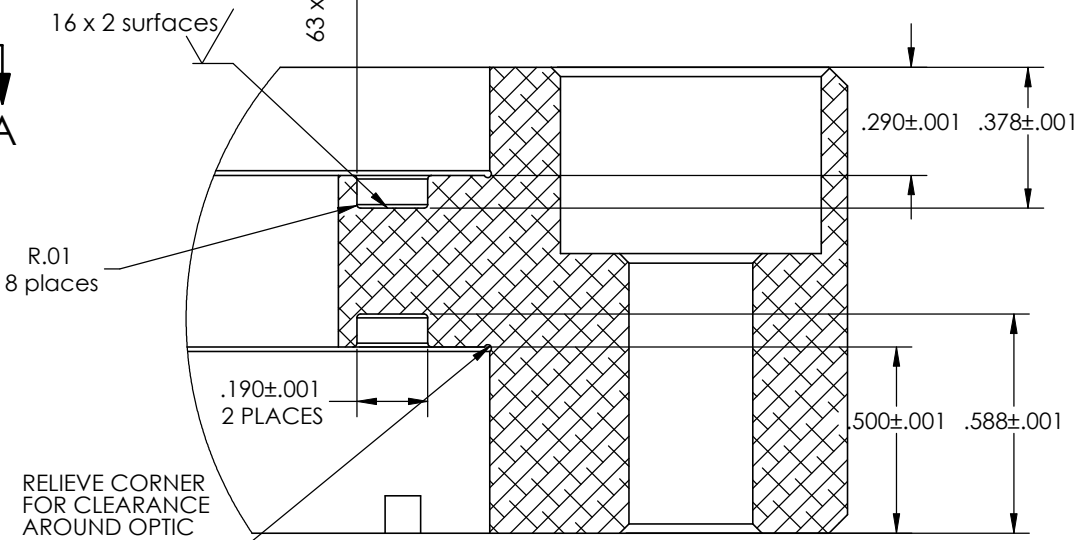
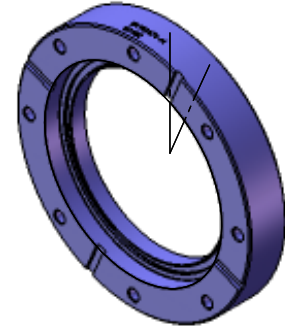
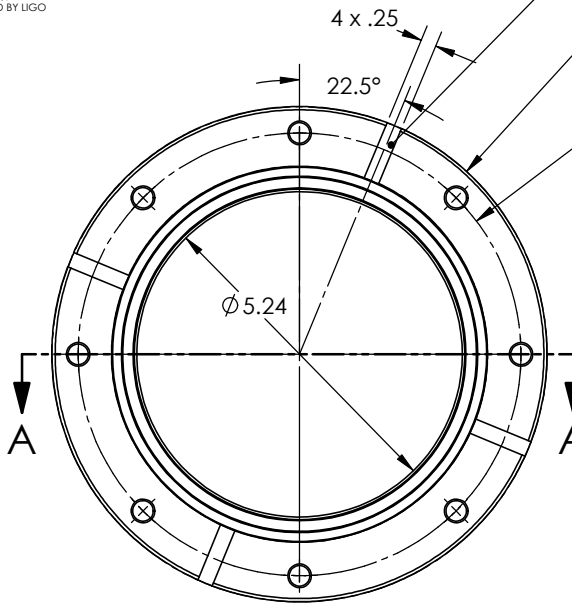


REV.	DATE	DCN #	DRAWING TREE #
-	-	E1100478-v4	-
-	-	-	-
-	-	-	-

- 6. APPROXIMATE WEIGHT = X.XXX 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

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

4 SLOTS EQUALLY SPACED .1" DEEP



DETAIL C SCALE 3 : 1

SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN TOLERANCES: .XX ± .005 .XXX ± .001 ANGULAR ± °				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 POWER NON WEDGED 6IN VIEWPORT CLAMP	
MATERIAL 6061 Alloy		FINISH 63 μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM 100	
NEXT ASSY D1101670		DESIGNER J. GLEASON		23 AUG 2011		SIZE DWG. NO. B D1101671	
		DRAWN J. GLEASON				REV. v3	
		CHECKER				SCALE: 1:2	
		APPROVAL				PROJECTION: SHEET 1 OF 2	

8 7 6 5 4 3 2 1

D1101671 ALIGO HIGH POWER NON WEDGED 6IN VIEWPORT CLAMP, PART PDM REV: X-001, DRAWING PDM REV: X-007

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

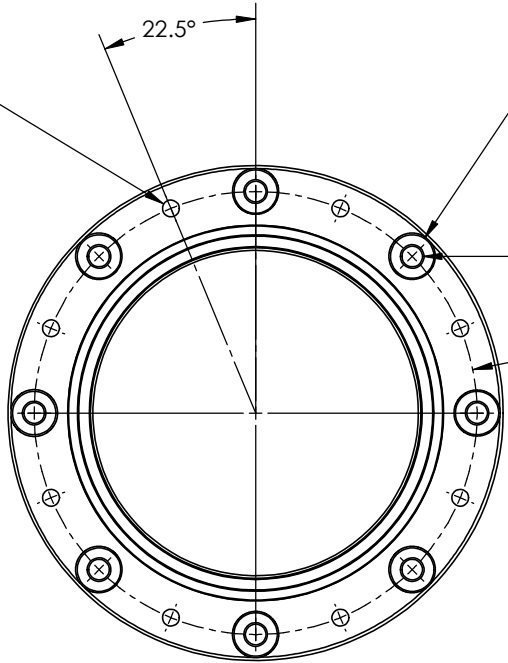
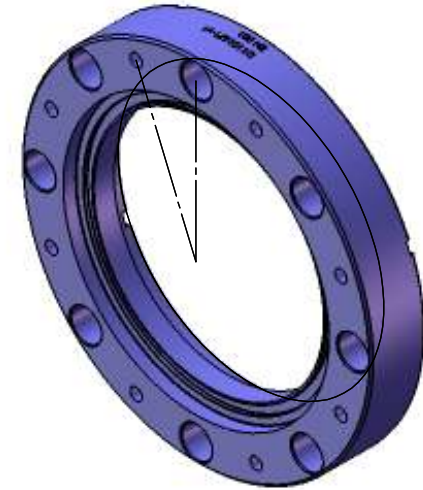
8 X 5/16-24 TAP .60" DEEP
DRILL .65" MAX DEPTH
8 EQUALLY SPACED
ALONG 7.13 DIA



22.5°

Ø.70 COUNTERBORE
.50" DEEP 8 PLACES

8 X Ø.332 THRU
EQUALLY SPACED ALONG 7.13 DIA
WITH 90 DEG .38" COUNTERSINK BOTH SIDES

Ø7.13



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D1101671
SCALE: 1:2	PROJECTION:  SHEET 2 OF 2
REV. v3	

8 7 6 5 4 3 2 1