NOTES CONTINUED:

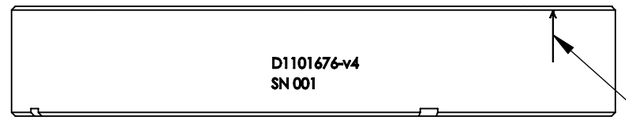
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE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

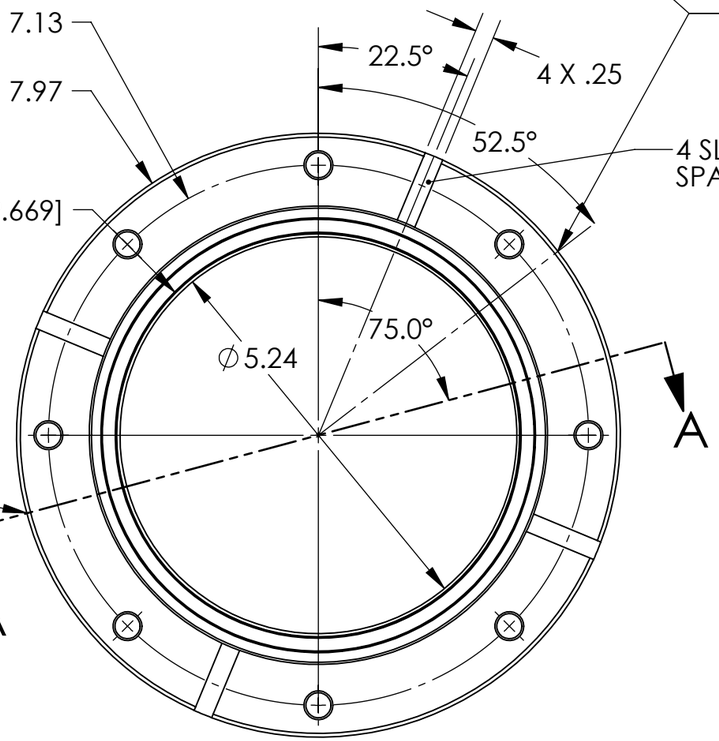
6. APPROXIMATE WEIGHT = X.XXX LB.

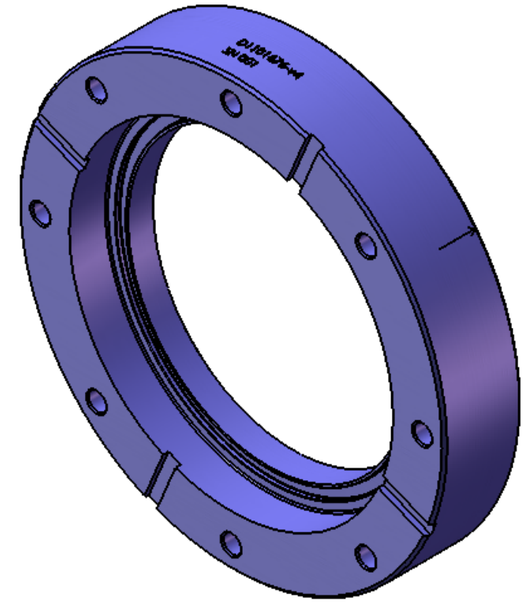
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

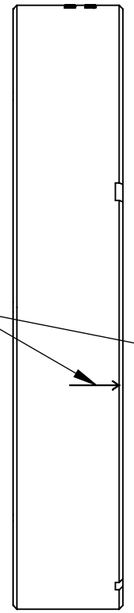
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364 OR VACUUM EQUIPMENT MANUFACTURER'S SPECIFICATION IF APPROVED BY LIGO

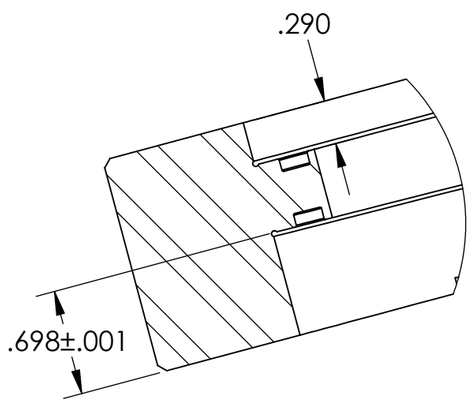
REV.	DATE	DCN #	DRAWING TREE #
-	-	E1100478-v4	-
v4	15 DEC 2011	E1100478-v4	-
-	-	-	-



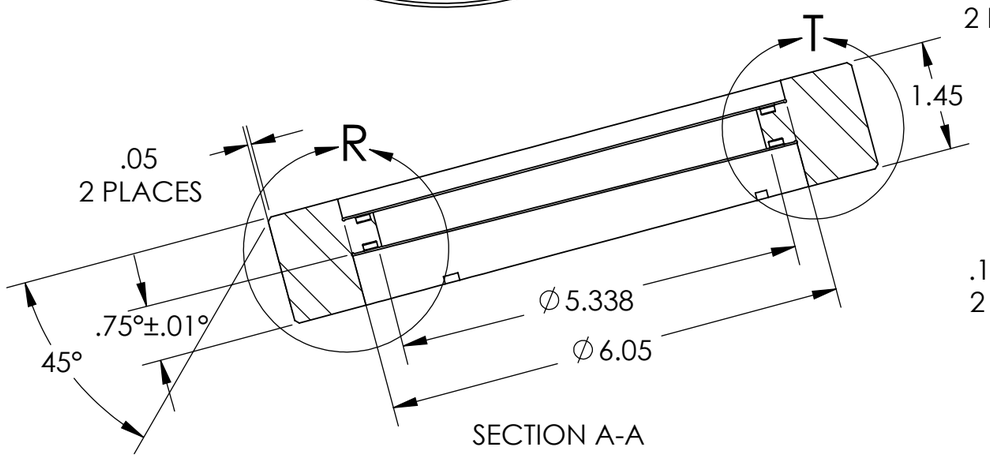




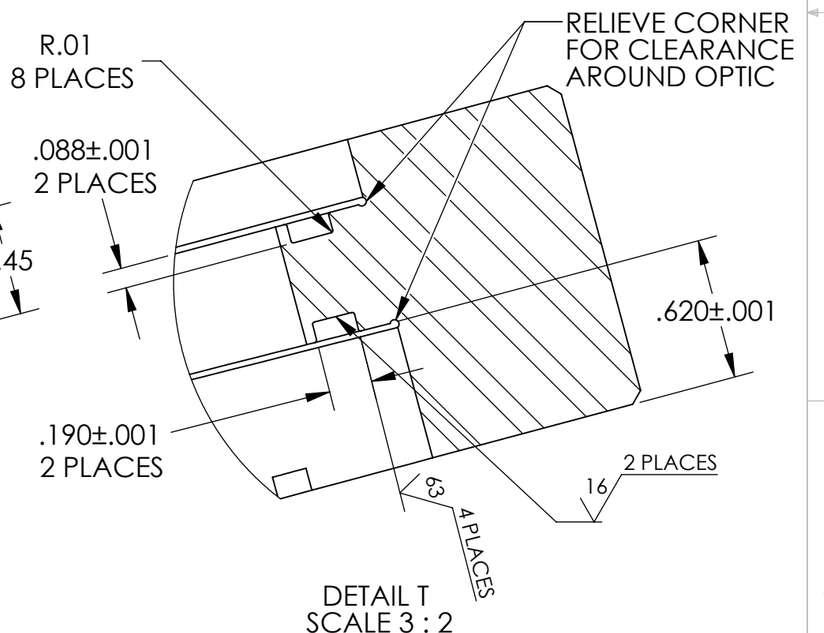




DETAIL R
SCALE 1 : 1



SECTION A-A



DETAIL T
SCALE 3 : 2

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 APPROXIMATLEY 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: 6061 Alloy	FINISH: 63 µinch	NEXT ASSY	

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: HIGH POWER WEDGED VIEWPORT CLAMP

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	IOO

DESIGNER	J. GLEASON	26 AUG 2011
DRAFTER	J. GLEASON	27 AUG 2011
CHECKER	L. AUSTIN	
APPROVAL	M. SMITH	

SIZE: B | DWG. NO.: D1101676 | REV.: v4

SCALE: 1:2 | PROJECTION: | SHEET 1 OF 2

D1101676 ALIGO HIGH POWER WEDGED 6IN VIEWPORT CLAMP, PART PDM REV: X-010, DRAWING PDM REV: X-020

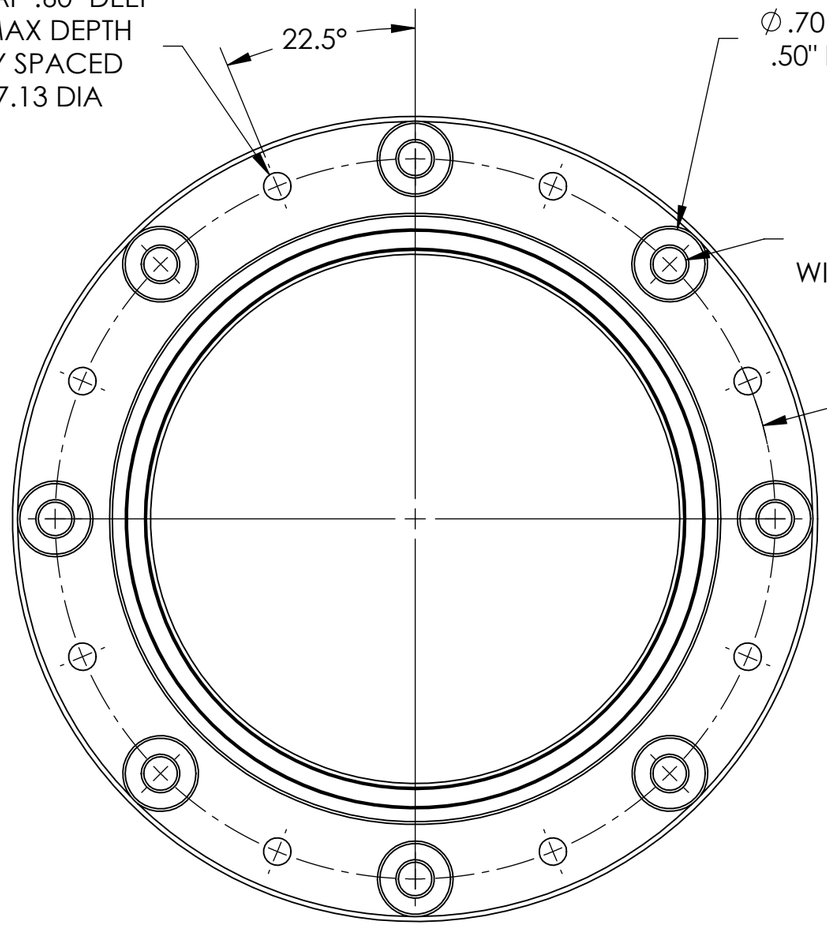
8 X 5/16-24 TAP .60" DEEP
DRILL .65" MAX DEPTH
8 EQUALLY SPACED
ALONG 7.13 DIA

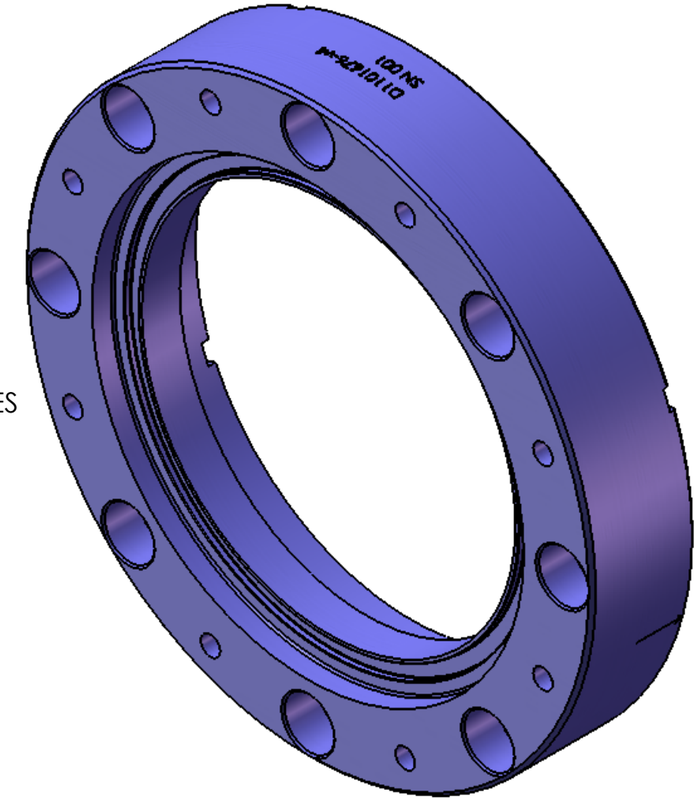
22.5°

∅.70 COUNTERBORE
.50" DEEP 8 PLACES

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

∅7.13





D1101676 ALIGO HIGH POWER WEDGED 6IN VIEWPORT CLAMP, PART PDM REV: X-010, DRAWING PDM REV: X-020

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1101676	v4

SCALE: 2:3 | PROJECTION: | SHEET 2 OF 2