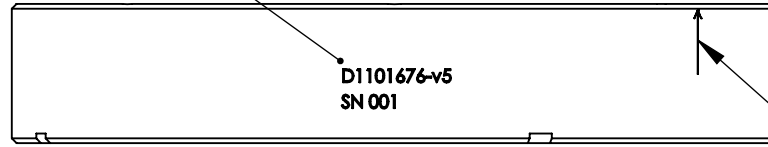


NOTES CONTINUED:

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

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

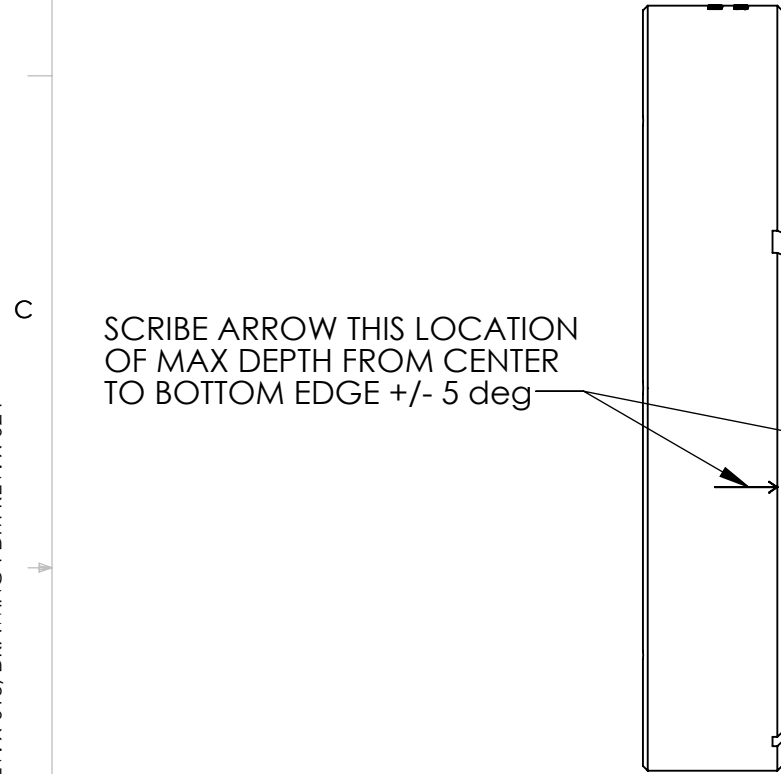


REV.	DATE	DCN #	DRAWING TREE #
-	-	E1100478-v4	-
v4	15 DEC 2011	E1100478-v4	-
v5	21 JUN 2012	-	-

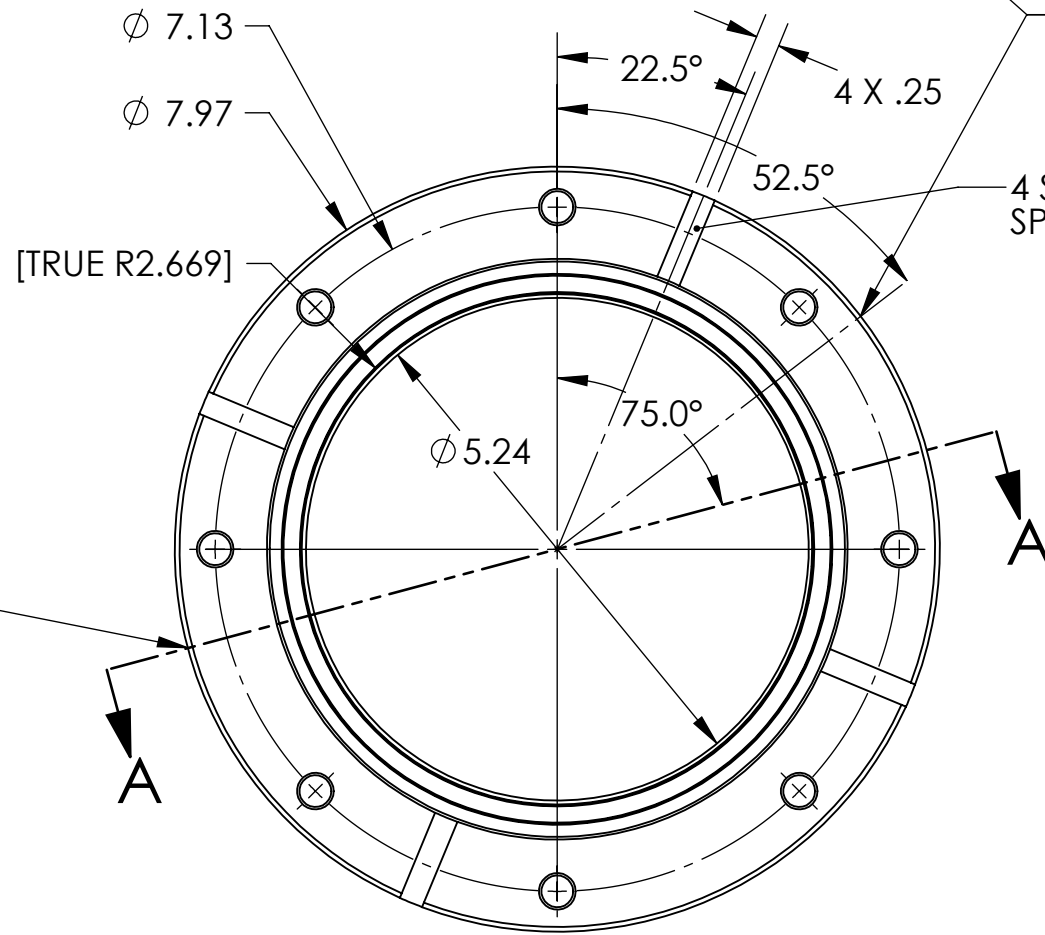
6. APPROXIMATE WEIGHT = X.XXX LB.

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

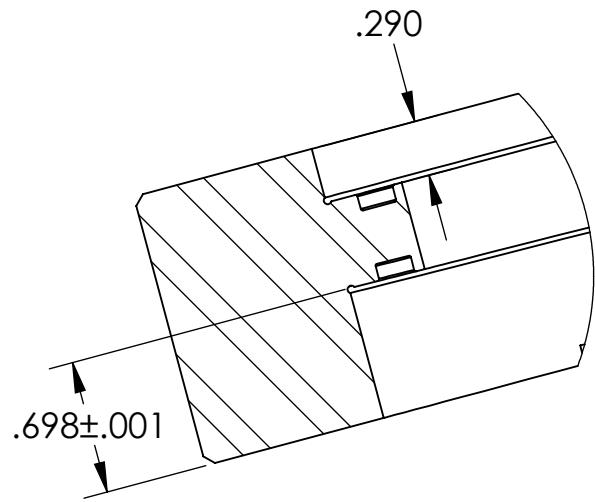
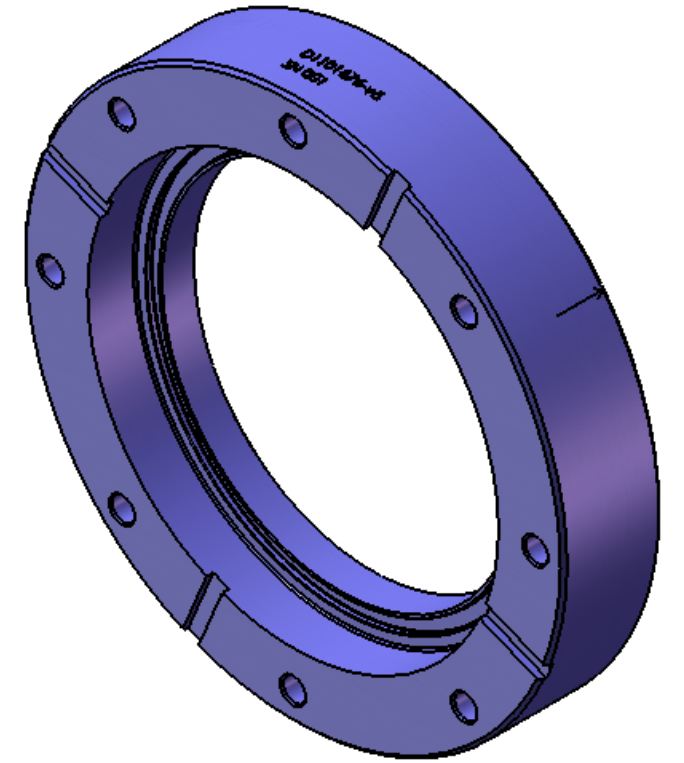


SCRIBE ARROW THIS LOCATION OF MAX DEPTH FROM CENTER TO BOTTOM EDGE +/- 5 deg

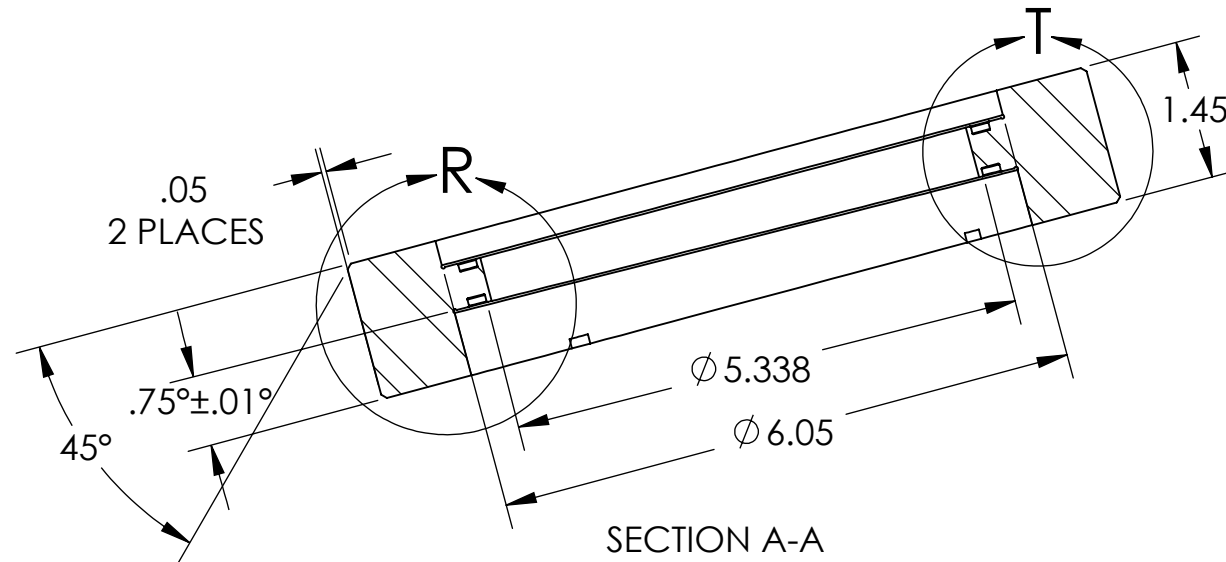


SCRIBE ARROW THIS LOCATION FROM CENTER TO TOP EDGE +/- 1 DEG

4 SLOTS EQUALLY SPACED .10" DEEP



DETAIL R
SCALE 1 : 1



SECTION A-A

R.01
8 PLACES

.088 +/- .001
2 PLACES

.190 +/- .001
2 PLACES

RELIEVE CORNER FOR CLEARANCE AROUND OPTIC

1.45

.620 +/- .001

63
4 PLACES

16
2 PLACES

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 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	6061 Alloy
FINISH	63 μinch

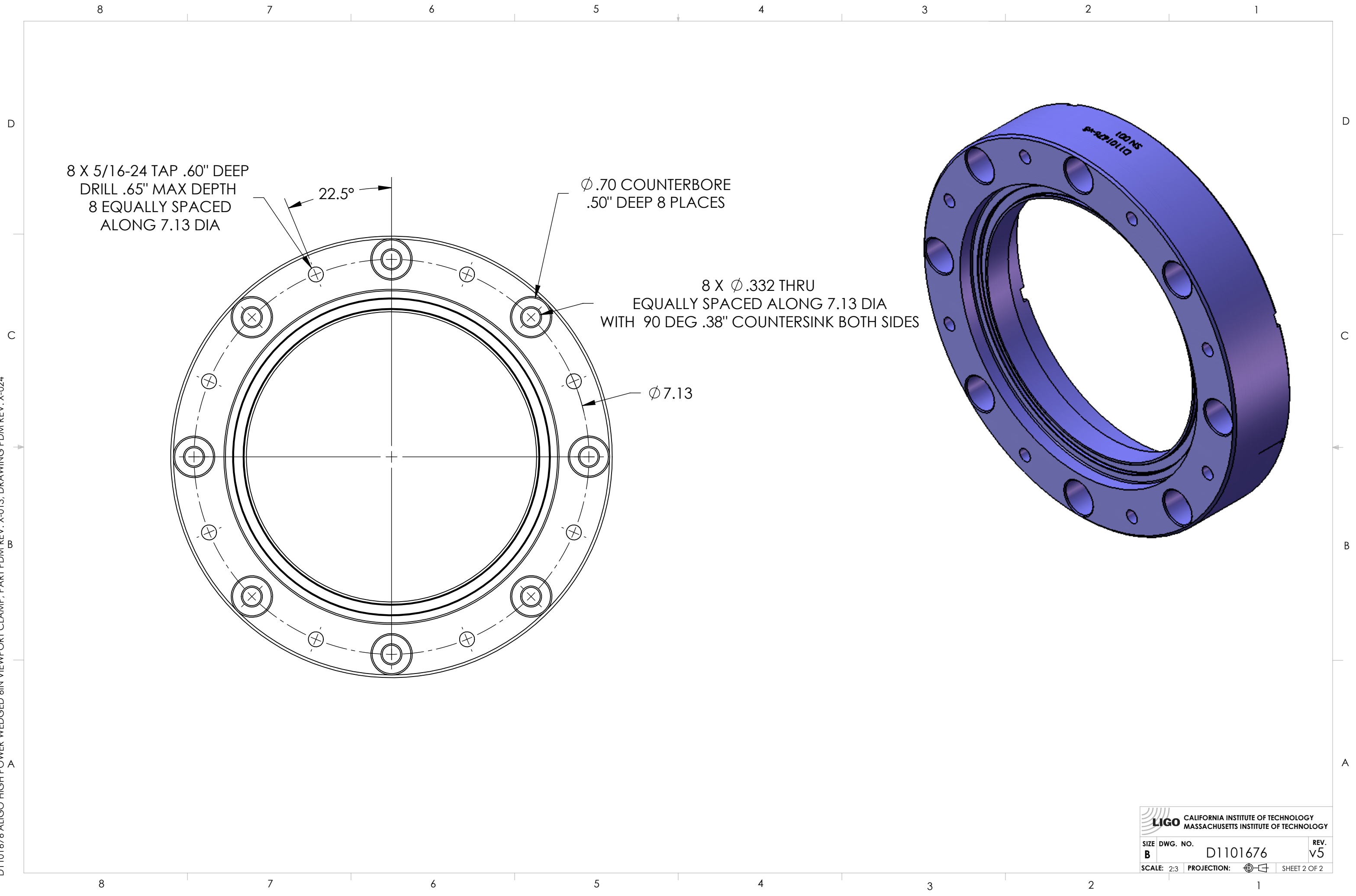
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY


SYSTEM: ADVANCED LIGO SUB-SYSTEM: 100
NEXT ASSY: D1101714

PART NAME: HIGH POWER WEDGED VIEWPORT CLAMP

DESIGNER	J. GLEASON	26 AUG 2011	SIZE DWG. NO.	B	REV.	v5
DRAFTER	J. GLEASON	27 AUG 2011				
CHECKER	L. AUSTIN					
APPROVAL	M. SMITH		SCALE: 1:2	PROJECTION:		SHEET 1 OF 2

D1101676 ALIGO HIGH POWER WEDGED 6IN VIEWPORT CLAMP, PART PDM REV: X-013, DRAWING PDM REV: X-024



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1101676	v5
SCALE: 2:3	PROJECTION:	SHEET 2 OF 2