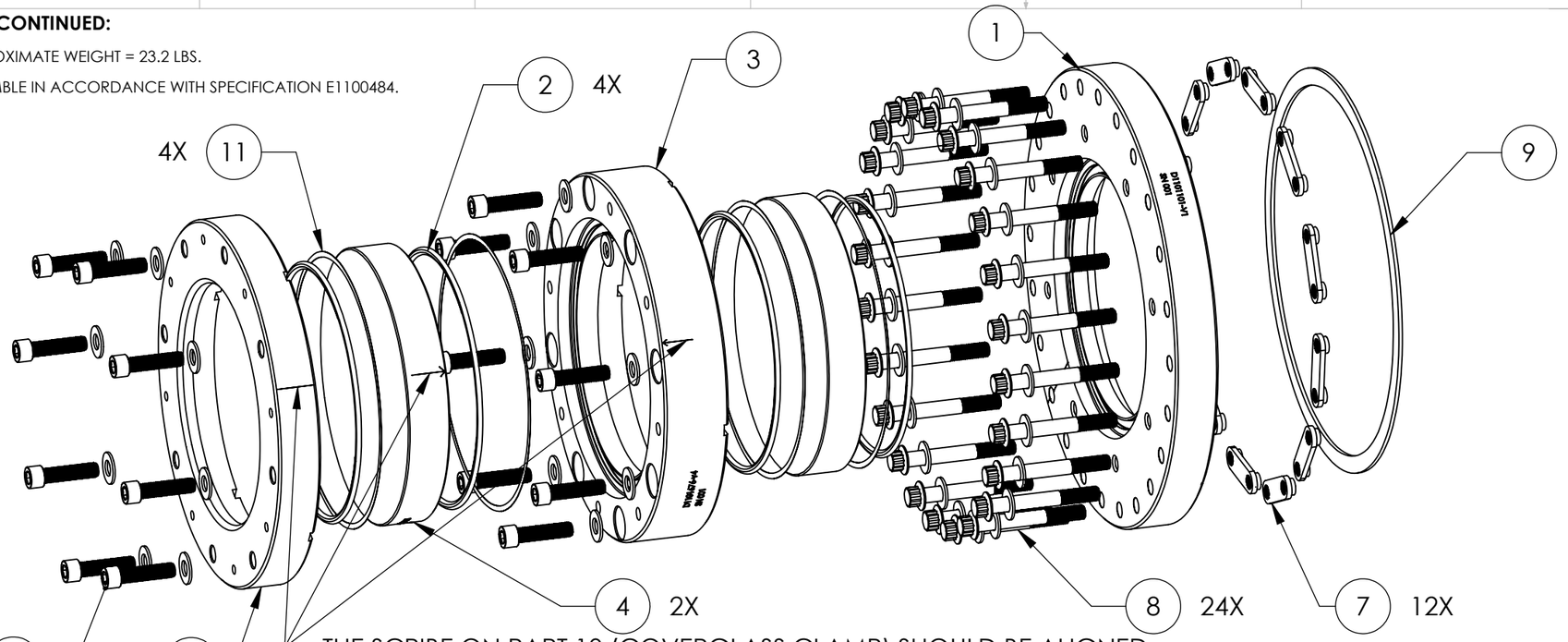
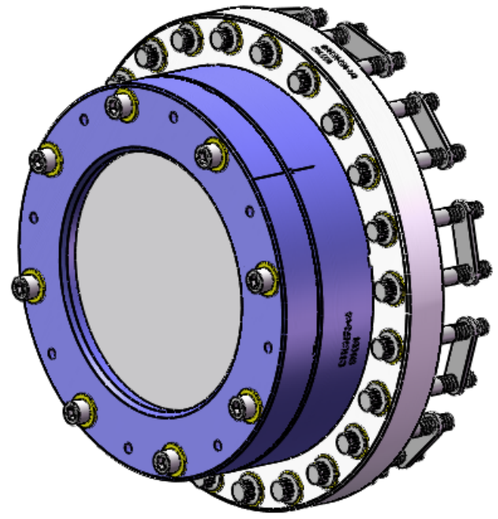
NOTES CONTINUED:

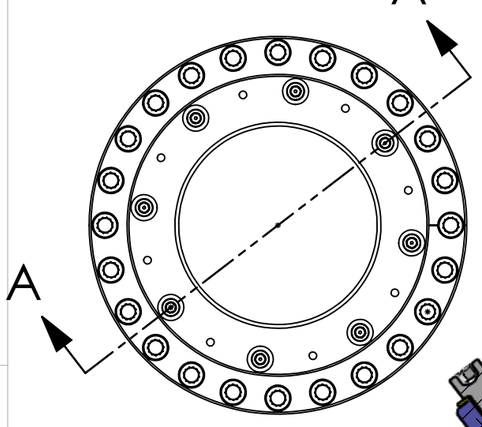
5. APPROXIMATE WEIGHT = 23.2 LBS.
6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

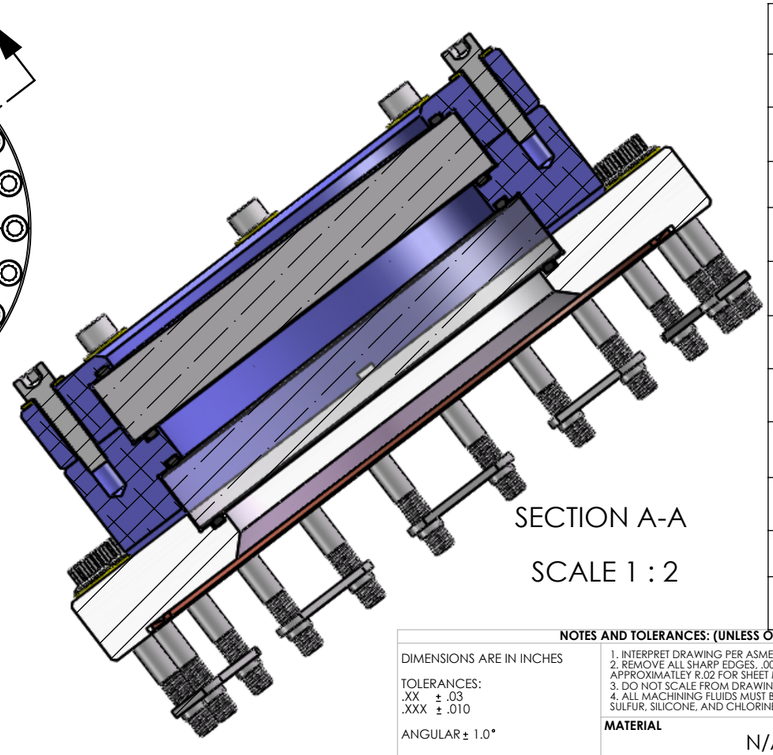
REV.	DATE	DCN #	DRAWING TREE #
v1	30 NOV 2011	E1100478-v4	-
-	-	-	
-	-	-	-





THE SCRIBE ON PART 10 (COVERGLASS CLAMP) SHOULD BE ALIGNED WITH THE ARROW ON PART 3 (VIEWPORT CLAMP) THAT IS POINTING TOWARD PART 10. THE ARROW ON PART 4 (COVERGLASS) SHOULD BE ALIGNED WITH AND POINTING TOWARDS THE ARROW ON PART 3.





SECTION A-A

SCALE 1 : 2

ITEM NO.	PART NUMBER	QTY.
1	D1101001 aLIGO, High quality, 6in Viewport Flange	1
2	Parker O-Ring #2-253 Viton(R) Flourocarbon (KFM), 75 shore A or equivalent. O-Rings must match-must be from the same lot/batch.	4
3	D1101676, ALIGO, high power, Wedged, 6in Clamp	1
4	D1101005 ALIGO, High quality, Wedged 6in viewport, Optics	2
5	5/16-24 UNF x 1.25", Silver Plated, UC Components, #C-3120-NA (or Equivalent)	16
6	5/16" FLAT WASHER, NAS 11149-C0563R (or Equivalent)	16
7	Nut Plate, 10" Conflat, NOR-Cal NP-800 (or Equivalent)	12
8	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt, and Washers MDC Kit #190067 (qty 25) or equivalent, discard nut.	24
9	Copper Gasket, 10" Conflat, MDC #19019 (or Equivalent)	1
10	D1101710 ALIGO, High power, Wedged, 6in Coverglass Clamp	1
11	D1003207 aLIGO, High quality, 6in viewport, Viewport spacer	4

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

NEXT ASSY:

LIGO — UNIVERSITY OF FLORIDA, CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SLC

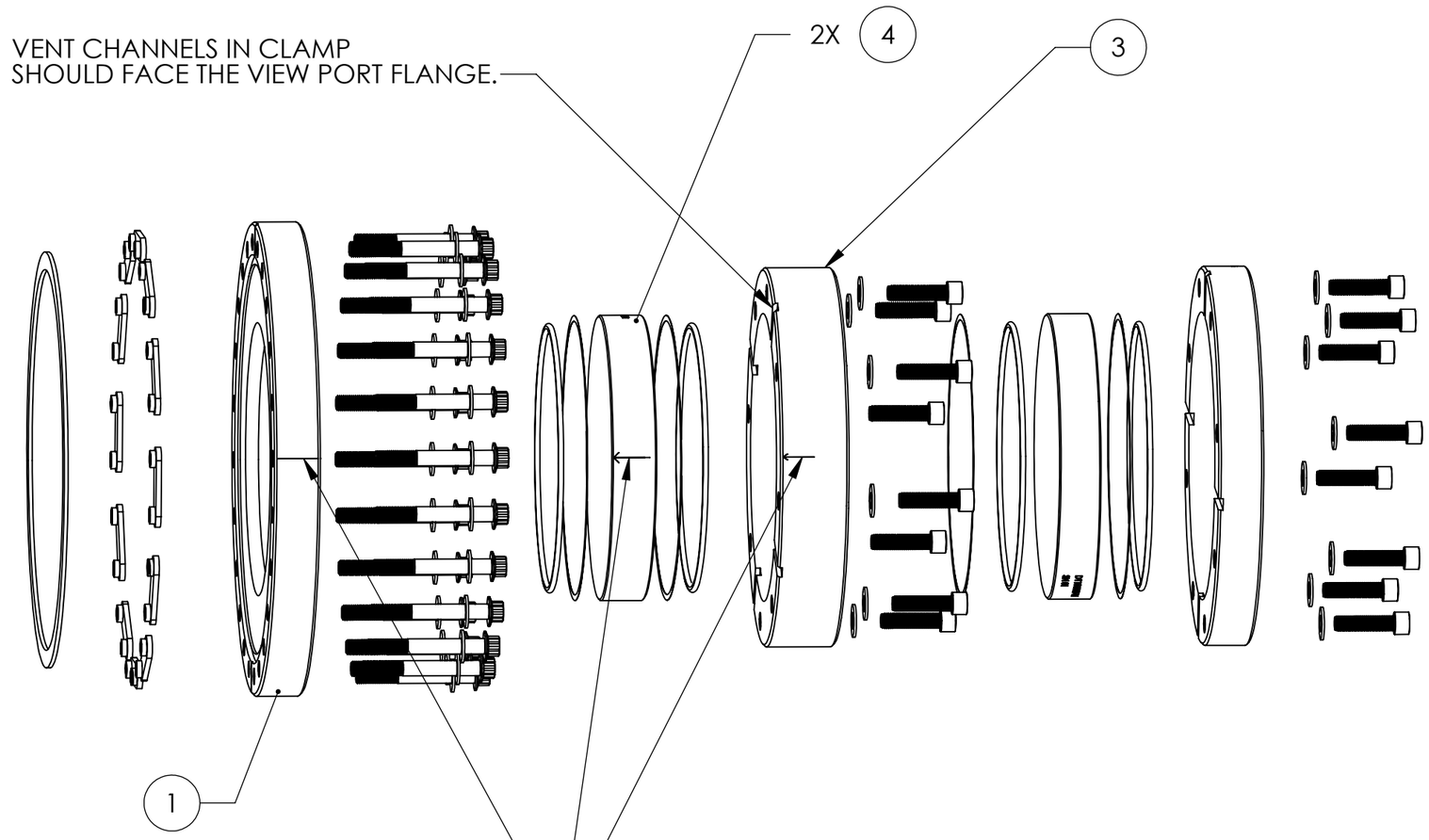
PART NAME: High Quality, Wedged, 6in Viewport Assy

DESIGNER	J. GLEASON	30 May 2011
DRAFTER	D. KUMAR	28 OCT 2011
CHECKER	L. AUSTIN	
APPROVAL	M. SMITH	

SIZE: B — DWG. NO.: D1101714 — REV.: v1

SCALE: 1:3 — PROJECTION: — SHEET 1 OF 2

D1101714 ALIGO HIGH POWER WEDGED 6IN VIEWPORT ASSY, PART PDM REV: X-014, DRAWING PDM REV: X-013



THE ARROWS ON PARTS 3 AND 4 INDICATED (VIEWPORT CLAMP AND VIEWPORT OPTIC) ALIGNED WITH THE SCRIBE ON PART 1 (VIEWPORT FLANGE)SHOULD POINT TOWARD THE FLANGE.

D1101714 ALIGO HIGH POWER WEDGED 6IN VIEWPORT ASSY, PART PDM REV: X-014, DRAWING PDM REV: X-013

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1101714	REV. v1	
SCALE: 1:3	PROJECTION:	SHEET 2 OF 2	