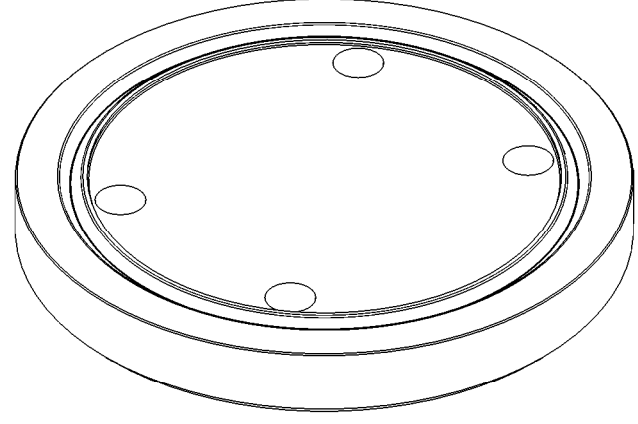
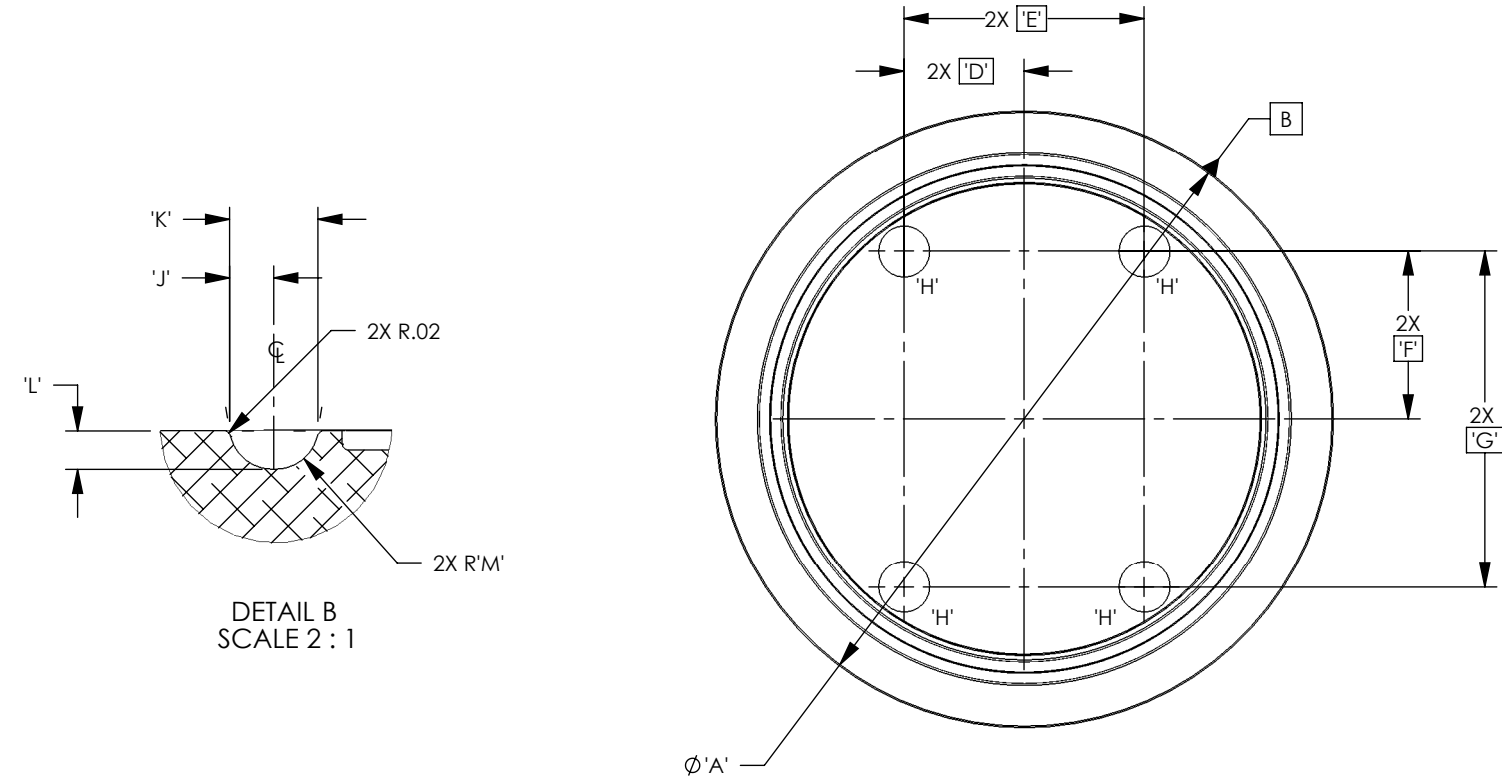


D1101938 Q.LIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (COML V.P.), PART PDM REV: X-007, DRAWING PDM REV: X-005

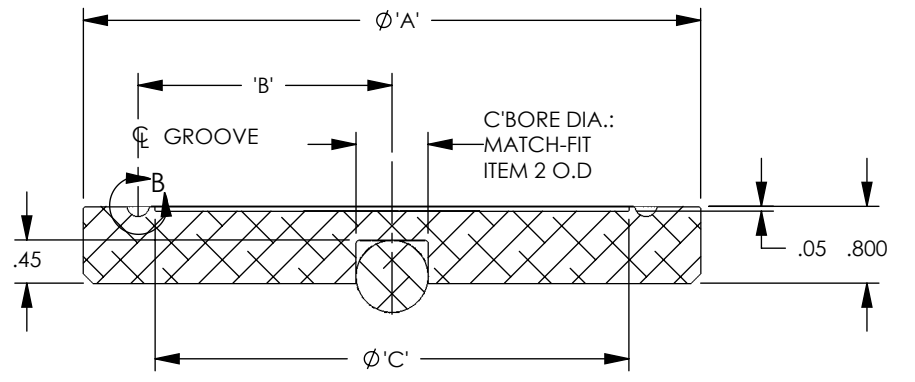
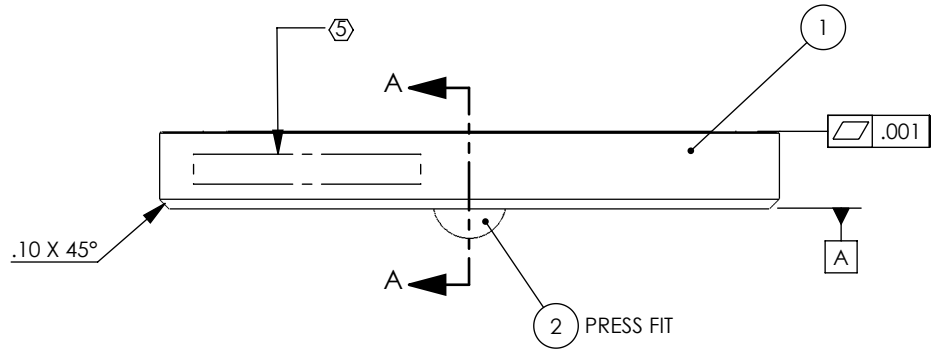
TABLE 1

PART NUMBER	Ø 'A'	'B'	Ø 'C'	'D'	'E'	'F'	'G'	'H'	'J'	'K'	'L'	'M'
D1101938-1	6.430	2.645	4.935	1.250	2.500	1.750	3.500	.438 THRU ALL 1/4 NPT FS	.115	.230	.100	.110
D1101938-2	7.687	3.593	6.830									
D1101938-3	2.469	1.124	2.000	.516	1.031	.516	1.031	.332 THRU ALL 1/8 NPT FS	.079	.159	.063	.074

REV.	DATE	DCN #	DRAWING TREE #
v1	11 OCT 2011	E1101031-x0	-
v2	09 MAR 2012	E1200271-x0	-
-	-	-	-



ISO VIEW  
(-1 SHOWN)



SECTION A-A

- 10. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 -.030.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
- 6. APPROXIMATE WEIGHT = 11.98 LB.
- 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

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1101938-1/QTY.	D1101938-2/QTY.	D1101938-3/QTY.
2	-	PRECISION BALL, .750 O.D, NITRONIC 60	NITRONIC 60	1	1	1
1	D1101938-103	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (MDC450004)	304 SSTL	-	-	1
1	D1101938-102	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (MDC9722012)	304 SSTL	-	1	-
1	D1101938-101	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (ZV-800)	304 SSTL	1	-	-

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:  
.XX ± .01  
.XXX ± .005

ANGULAR ± 0.5°

FINISH 63 μinch

MATERIAL SEE PARTS LIST

**PARTS LIST**

**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.

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

**ADVANCED LIGO** SUB-SYSTEM AOS

**PART NAME**  
ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (COML V.P.)

**DESIGNER** J.LEWIS 07 OCT 2011  
**DRAFTER** E.SANCHEZ 11 OCT 2011  
**CHECKER** SEE DCC SEE DCC  
**APPROVAL** SEE DCC SEE DCC

**SIZE DWG. NO.**  
B D1101938

**REV.**  
v2

**SCALE:** 1:2 **PROJECTION:** **SHEET 1 OF 1**

NOTES CONTINUED: