

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

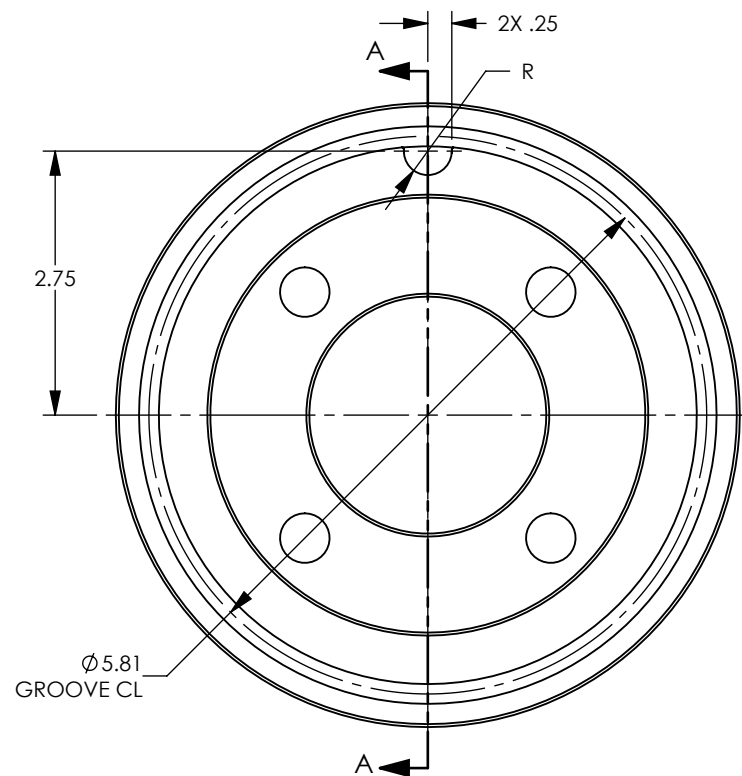
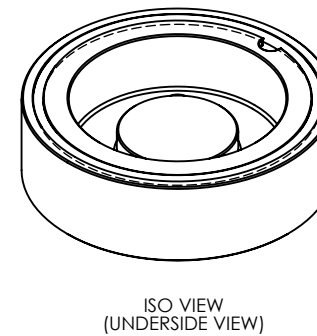
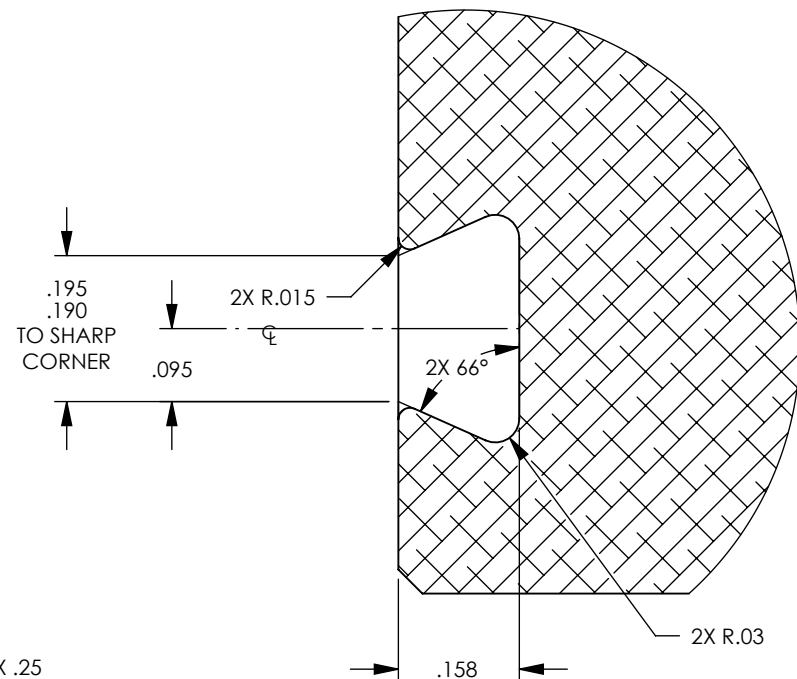
6. APPROXIMATE WEIGHT = 12.11 LB.

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

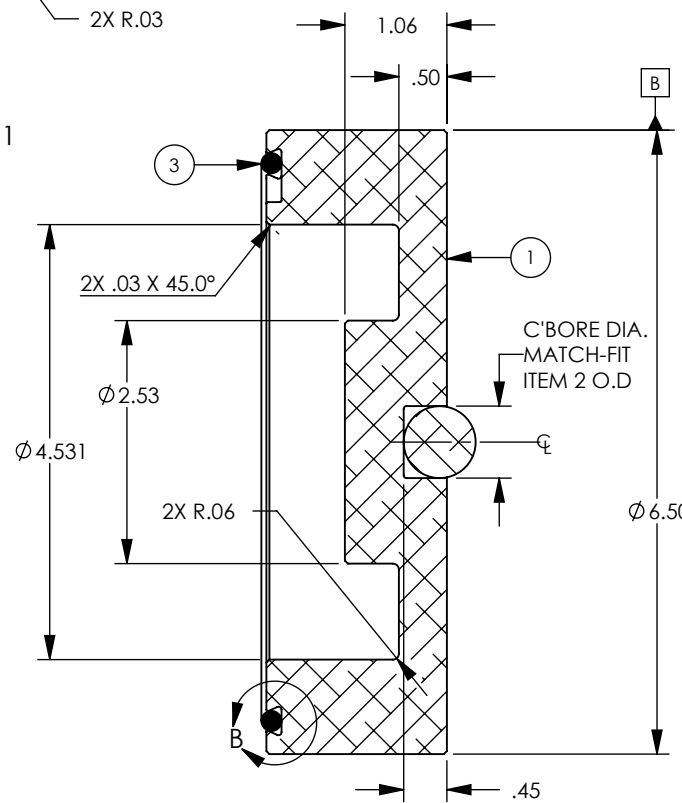
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATIONS E0900364.

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.

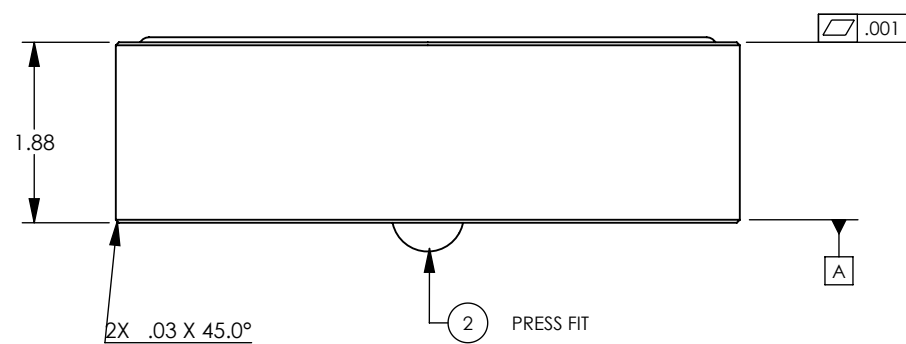
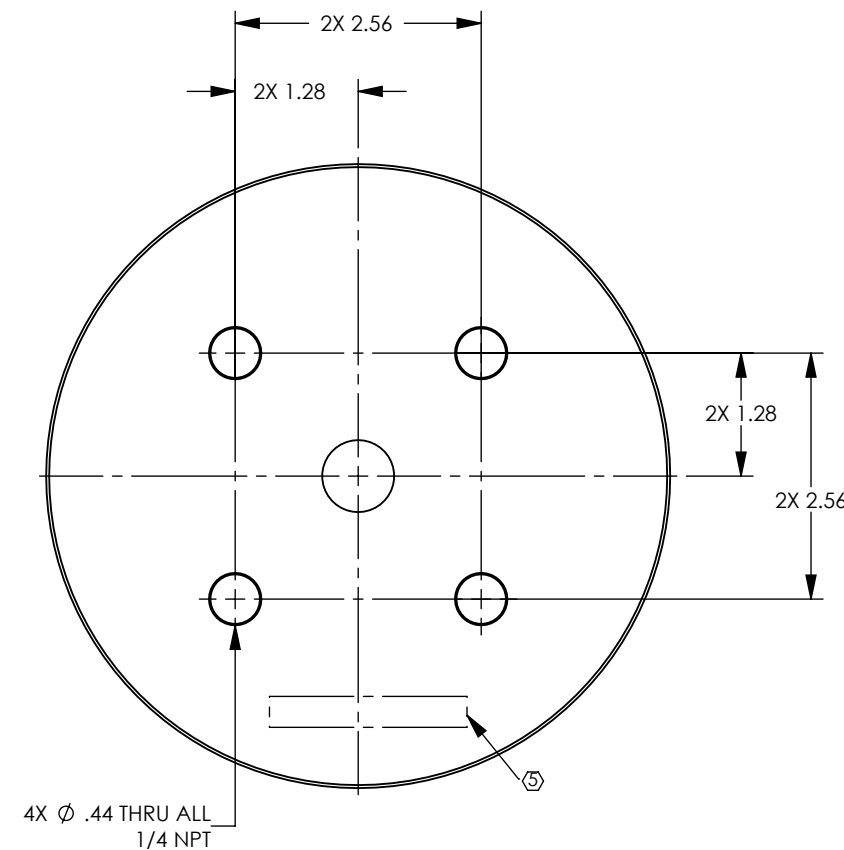
REV.	DATE	DCN #	DRAWING TREE #
v1	01 DEC 2011	E1101137-x0	-
-	-	-	-
-	-	-	-



DETAIL B  
SCALE 4 : 1



SECTION A-A  
SCALE 1 : 2



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
3	PARKER NO.: 2-358	O-RING, 3/16 WIDE	VITON	1
2	-	PRECISION BALL, .750 O.D, NITRONIC 60	NITRONIC 60	1
1	D1102284-1	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (MDC450004)	304 SSSL	1

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	
MATERIAL	N/A
FINISH	N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (MDC450004)	
DESIGNER	J.LEWIS	07 OCT 2011	SIZE DWG. NO.
DRAFTER	E.SANCHEZ	11 NOV 2011	B D1102284
CHECKER	SEE DCC	SEE DCC	REV.
APPROVAL	SEE DCC	SEE DCC	v1
NEXT ASSY		D1101939	SCALE: 1:2
PROJECTION:		1st Angle	SHEET 1 OF 1

D1102284-1 ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (MDC450004), PART PDM REV: X-001, DRAWING PDM REV: X-004