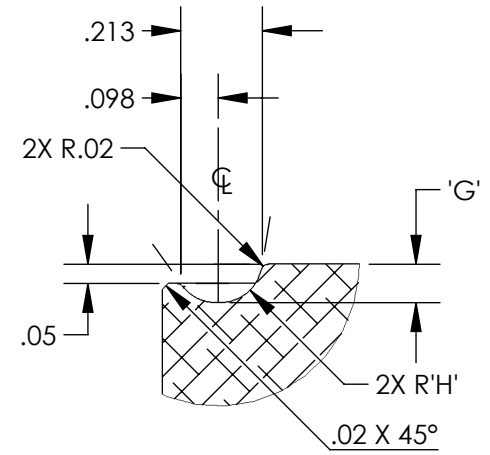
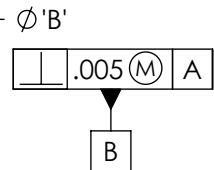
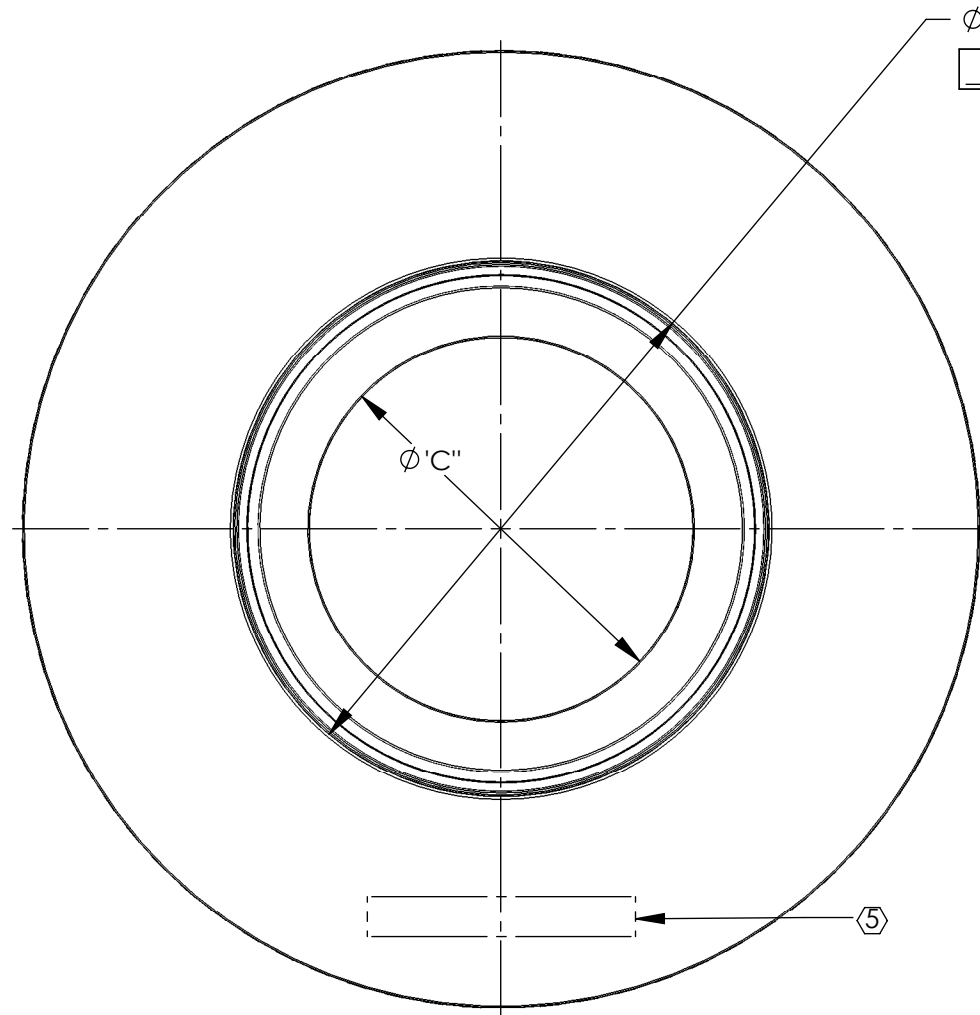


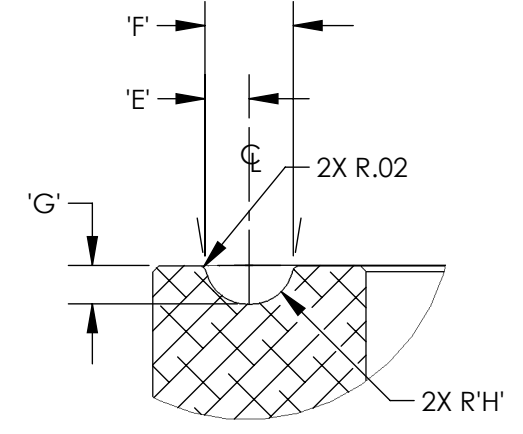
D1200399_ALIGO_AOS_VIEWPORT LEAK TEST FIXTURE, INTERNAL SUPPORT RING, PART PDM REV: X-004, DRAWING PDM REV: X-009

- 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 = 9.24 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.
 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.
 10. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 -.030.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 MAR 2012	E1200271-x0	-
-	-	-	-
-	-	-	-

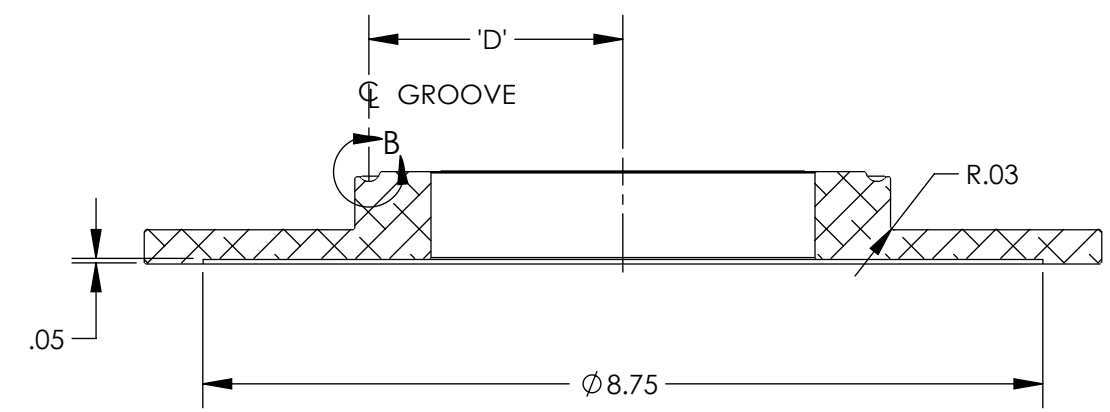
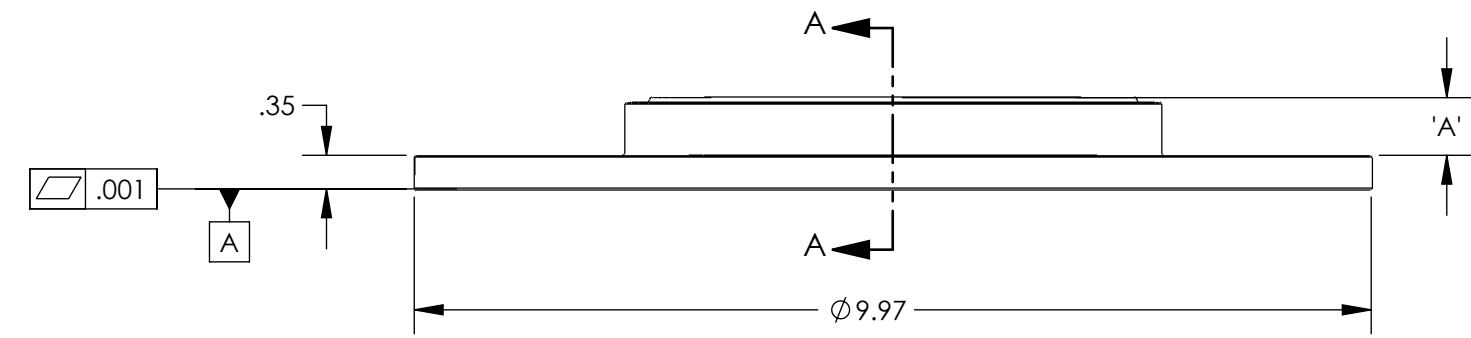


GROOVE DETAIL B
(-1 ONLY)
SCALE 2:1



GROOVE DETAIL B
(-2 AND -3 ONLY)
SCALE 2:1

SECTION A-A



PART NUMBER	'A'	'B'	'C'	'D'	'E'	'F'	'G'	'H'
D1200399-1	.600	5.580	4.000	2.645	.115	.230	.100	.110
D1200399-2	.750	7.687	6.576	3.593				
D1200399--3	1.625	2.469	2.000	1.124	.079	.159	.063	.074

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

MATERIAL: 304 SSSL
 FINISH: 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, INTERNAL SUPPORT RING

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS
 NEXT ASSY: D1101939

DESIGNER	J.LEWIS	06 MAR 2012	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	06 MAR 2012	B	D1200399	v1
CHECKER	SEE DCC	SEE DCC	SCALE:	1:2	PROJECTION:
APPROVAL	SEE DCC	SEE DCC	SHEET 1 OF 1		