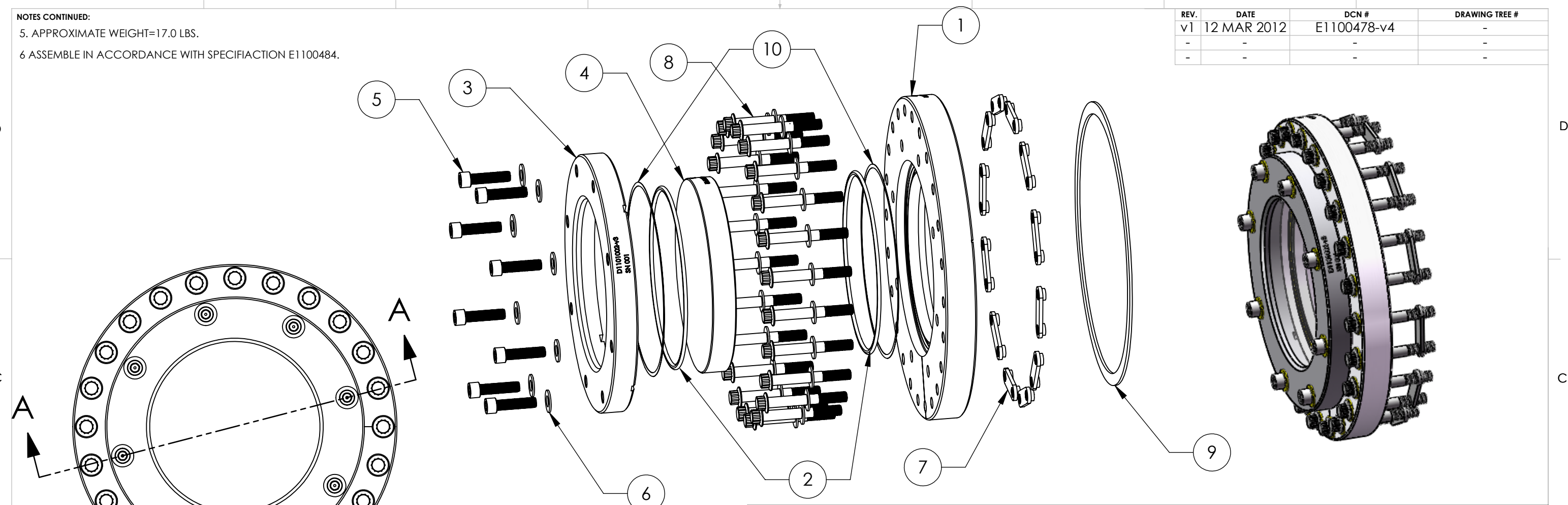


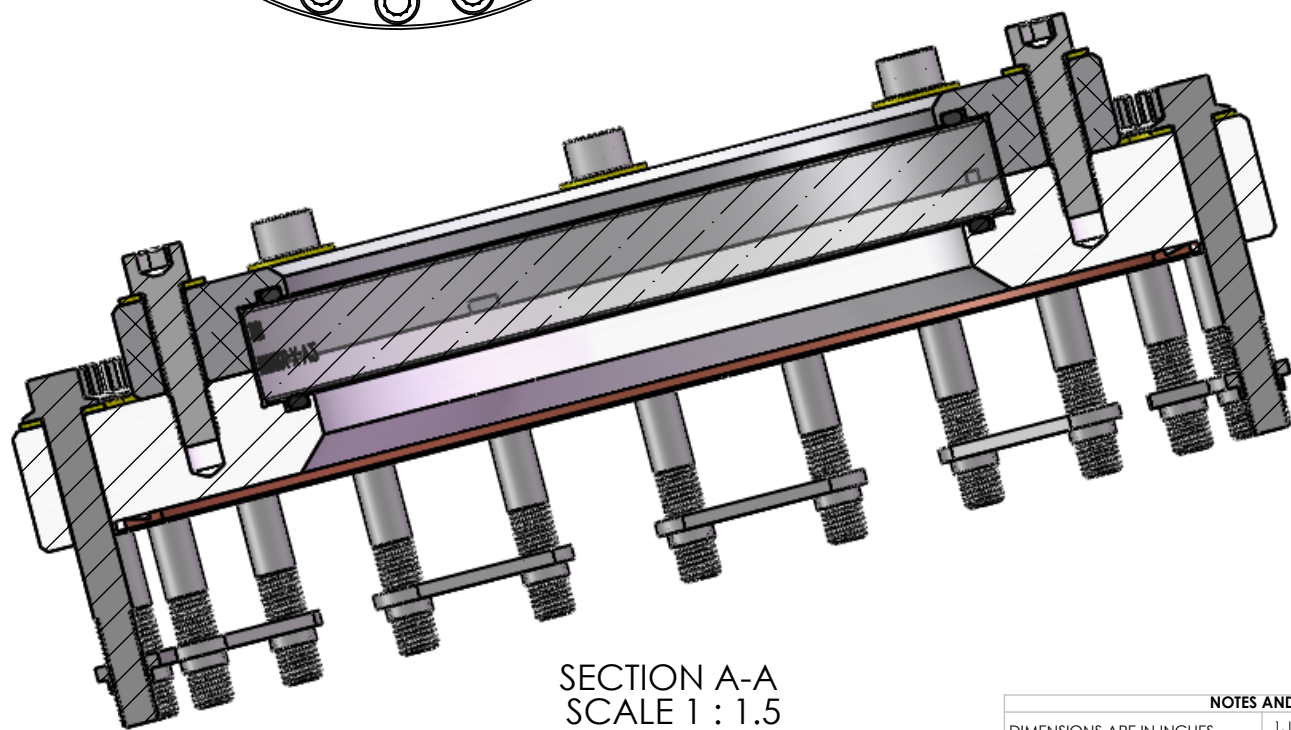
D1200441 aLIGO, high quality, non-wedged, 6in Viewport Assy_uncoated, PART PDM REV: X-004, DRAWING PDM REV: X-004

NOTES CONTINUED:
 5. APPROXIMATE WEIGHT=17.0 LBS.
 6 ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 12 MAR 2012 | E1100478-v4 | - |
| - | - | - | - |
| - | - | - | - |



| PARTS LIST | | |
|------------|--|------|
| ITEM NO. | PART NUMBER | QTY. |
| 1 | D1101001 aLIGO, High quality, 6in Viewport Flange | 1 |
| 2 | Parker O-Ring #2-253, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent. O-Rings must match-must be from the same lot/batch. | 2 |
| 3 | D1101002 aLIGO, high quality, 6in Viewport Clamp | 1 |
| 4 | D1101006-3 aLIGO, high quality, non-wedged, 6in Viewport optic_uncoated | 1 |
| 5 | 5/16-24 UNF x 1.25", Silver Plated, UC Components, #C-3120-NA (or Equivalent) | 8 |
| 6 | 5/16" Flat washer, NAS 1149-C0563R (or Equivalent) | 8 |
| 7 | Nut plates, 10" Cnflat, 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 #191019 (or Equivalent) | 1 |
| 10 | D1003207 aLIGO, High quality, 6in viewport, Viewport spacer | 2 |



SECTION A-A
SCALE 1 : 1.5

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.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .03
 .XXX ± .010
 ANGULAR ± 1.0°

MATERIAL N/A FINISH N/A μinch

| | | | | |
|---|-----------|-------------|--|------------------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | PART NAME | | High Quality, Non-Wedged, 6in Viewport Assy_uncoated | |
| | SYSTEM | SUB-SYSTEM | DESIGNER | TQ. NGUYEN 12 MAR 2012 |
| ADVANCED LIGO | SLC | DRAFTER | TQ. NGUYEN 12 MAR 2012 | |
| NEXT ASSY | | CHECKER | L. AUSTIN | |
| | | APPROVAL | M. SMITH | |
| SIZE DWG. NO. | | B D1200441 | | |
| SCALE: 1:3 | | PROJECTION: | | |
| SHEET 1 OF 1 | | REV. v1 | | |