

D1200845- v3 aLigo_Ham_ViewPort_Target_Tool_Assembly., PART PDM REV: X-006, DRAWING PDM REV: X-003

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
- 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	06-13-12	TO FOLLOW	-
V2	06-29-12	TO FOLLOW	-
v3	07-05-12	TO FOLLOW	-

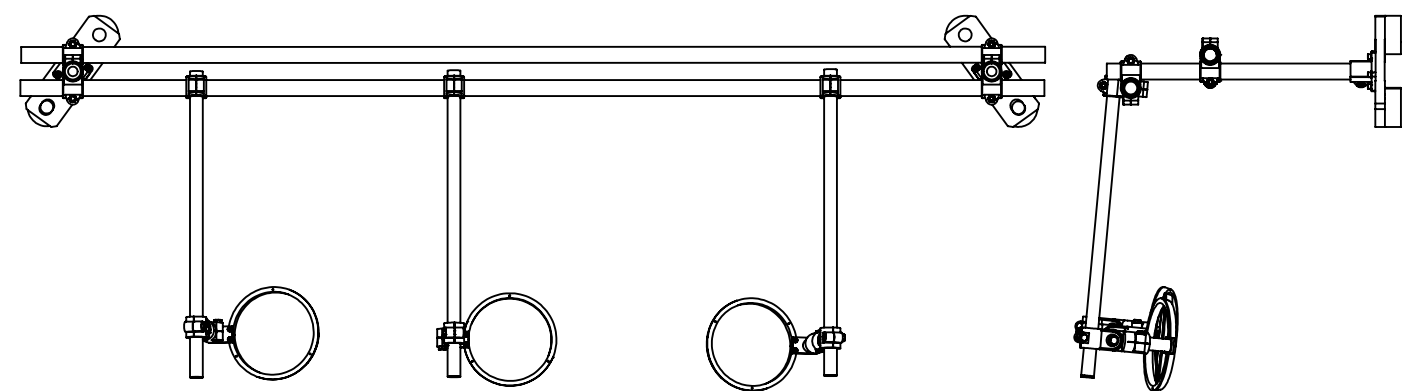
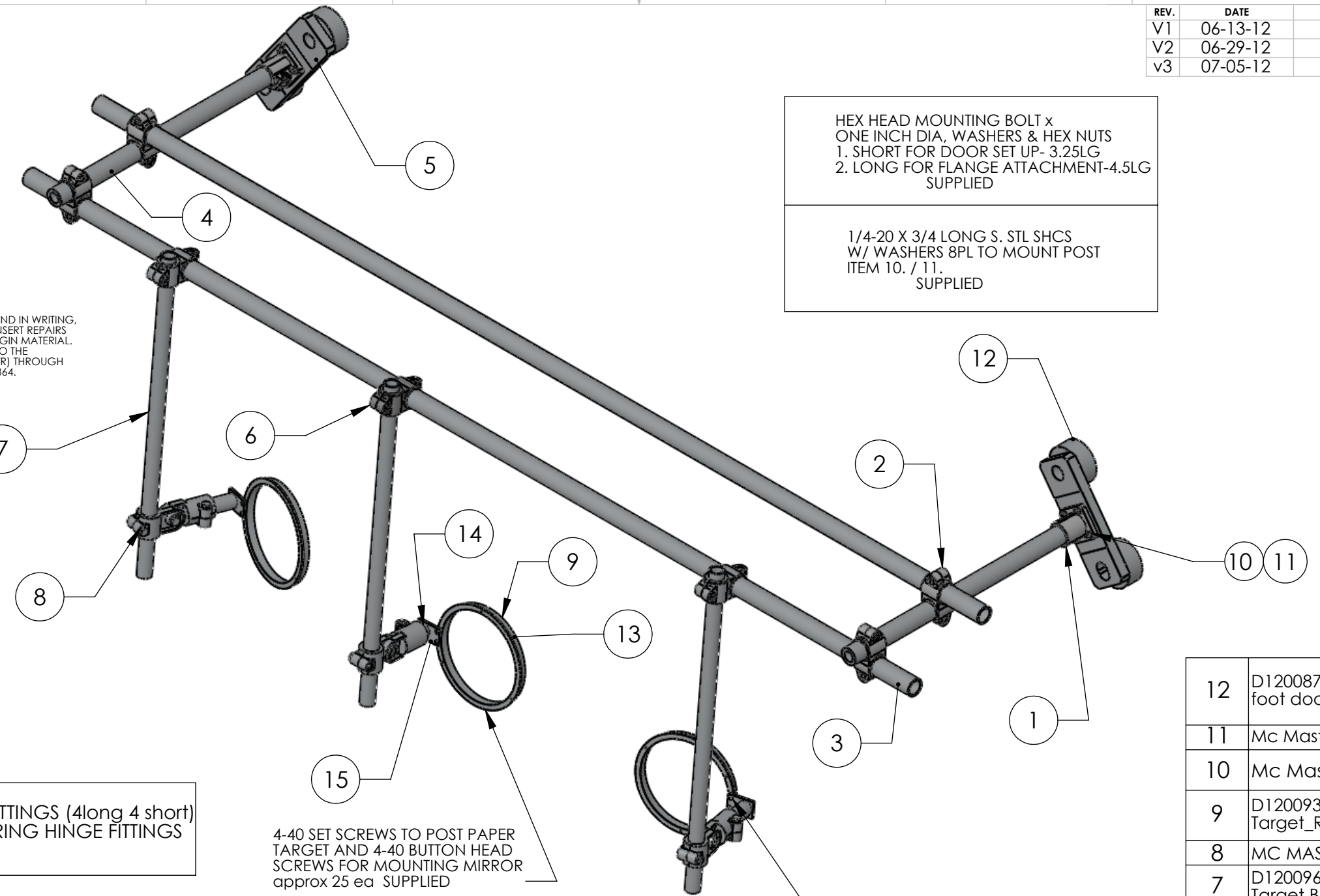
HEX HEAD MOUNTING BOLT x ONE INCH DIA, WASHERS & HEX NUTS
 1. SHORT FOR DOOR SET UP- 3.25LG
 2. LONG FOR FLANGE ATTACHMENT-4.5LG
 SUPPLIED

1/4-20 X 3/4 LONG S. STL SHCS W/ WASHERS 8PL TO MOUNT POST ITEM 10. / 11.
 SUPPLIED

6MM HEX WRENCH FOR CLAMP FITTINGS (4long 4 short)
 15MM WRENCH (2) FOR ITEM 11 RING HINGE FITTINGS
 SUPPLIED

4-40 SET SCREWS TO POST PAPER TARGET AND 4-40 BUTTON HEAD SCREWS FOR MOUNTING MIRROR approx 25 ea SUPPLIED

8-32 FLAT HD X 3/8LONG S. STL TYP SUPPLIED



12	D1200870 aligo viewport target post foot door spacer. SLDprt	4
11	Mc Master part #92141A013	8
10	Mc Master Part# 92196A540	8
9	D1200935aLigo_HamViewPort Target_Ring_Sub Assem. ref	3
8	MC MASTER PART# 9578T41	3
7	D1200968 aLigo HAM viewport Target Bar	3
6	D1200932-V1 MODIFIED MCMaster #9578T21	3
5	D1200868-v1 aligo viewport target post foot	2
4	D1200969-v1 aLigo HAM viewport Target flange Bar	2
3	D1200967-v1 aLigo HAM viewport Target Long Bar	2
2	MC MASTER PART# 9578T22	4
1	MC MASTER PART# 9578T62	2
ITEM NO.	PART NUMBER	Qty

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 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 ± .02
 .XXX ± .005

ANGULAR ± 1.0°

MATERIAL: -- FINISH: -- μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

PART NAME: **aLigo_Ham_ViewPort_Target_Tool_Assembly**

DESIGNER: KEN MAILAND 6-6-2012
 DRAFTER: KEN MAILAND 06-08-12
 CHECKER: KEN MAILAND 06-08-12
 APPROVAL: _____

SIZE DWG. NO. **B** **D1200845** REV. **v3**

SCALE: 1:24 PROJECTION: SHEET 1 OF 1