

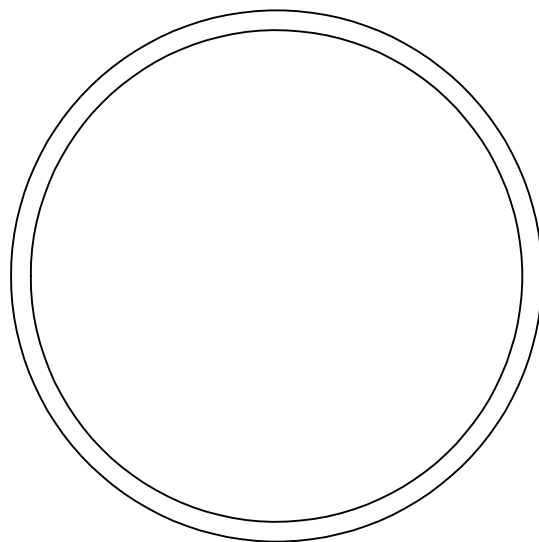
NOTES CONTINUED:

5 SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6 MATERIAL SPECIFICATION:
 AS568A AEROSPACE STANDARD UNIFORM DASH NUMBER: -146
 NOMINAL I.D.: $\varnothing 2.6250$
 NOMINAL O.D.: $\varnothing 2.8125$
 THICKNESS: 3/32
 MATERIAL: FLUOREL OR VITON (SEE LIGO-E960050, ITEMS I8-112)
 DUROMETER: 70 SHORE A

- 7 FINISHED PART TO BE CLEANED IN ACCORDANCE WITH LIGO-E960022
- 8 MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 9 ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 10 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.
- 11 SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 12 REFER TO LIGO-T1100346 FOR DESIGN GUIDELINES

REV.	DATE	DCN #	DRAWING TREE #
v3	26 JUL 2011	E1100655-v1	E1100656-v1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX \pm .01
 .XXX \pm .005

ANGULAR \pm 1.0°

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.

MATERIAL

SEE 6

FINISH

N/A



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

ADVANCED LIGO

SUB-SYSTEM

AOS

NEXT ASSY

D1003194, D1003204, D1100493, D1100494

PART NAME

O-RING, 3 IN VIEWPORTS

DESIGNER

D. COOK

2009

DRAFTER

A. LANGLEY

17 MAR 2011

CHECKER

M. JACOBSON

25 JUL 2011

APPROVAL

P. WILLEMS

30 MAR 2011

SIZE

A

DWG. NO.

D080631

REV.

v3

SCALE: 2:1

PROJECTION:



SHEET 1 OF 1