

NOTES: UNLESS OTHERWISE SPECIFIED

1. INTERPRET DRAWING PER ASME Y14.5-1994.

2. REMOVE ALL SHARP EDGES AND BURRS AND ROUND EDGES APPROXIMATELY R.02.

3. DO NOT SCALE FROM DRAWING.

4. ALL MACHINE FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.

5. MECHANICALLY STAMP (NO INKS OR DYES) PART NUMBER, REVISION AND SERIAL NUMBER .020 DEEP WITH MINIMUM CHARACTER HEIGHT .156 APPROXIMATELY WHERE SHOWN. SERIAL NUMBER WILL START AT 001 AND PROCEED CONSECUTIVELY. EXAMPLE: D100XXX-V1 S/N 001

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.

7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.

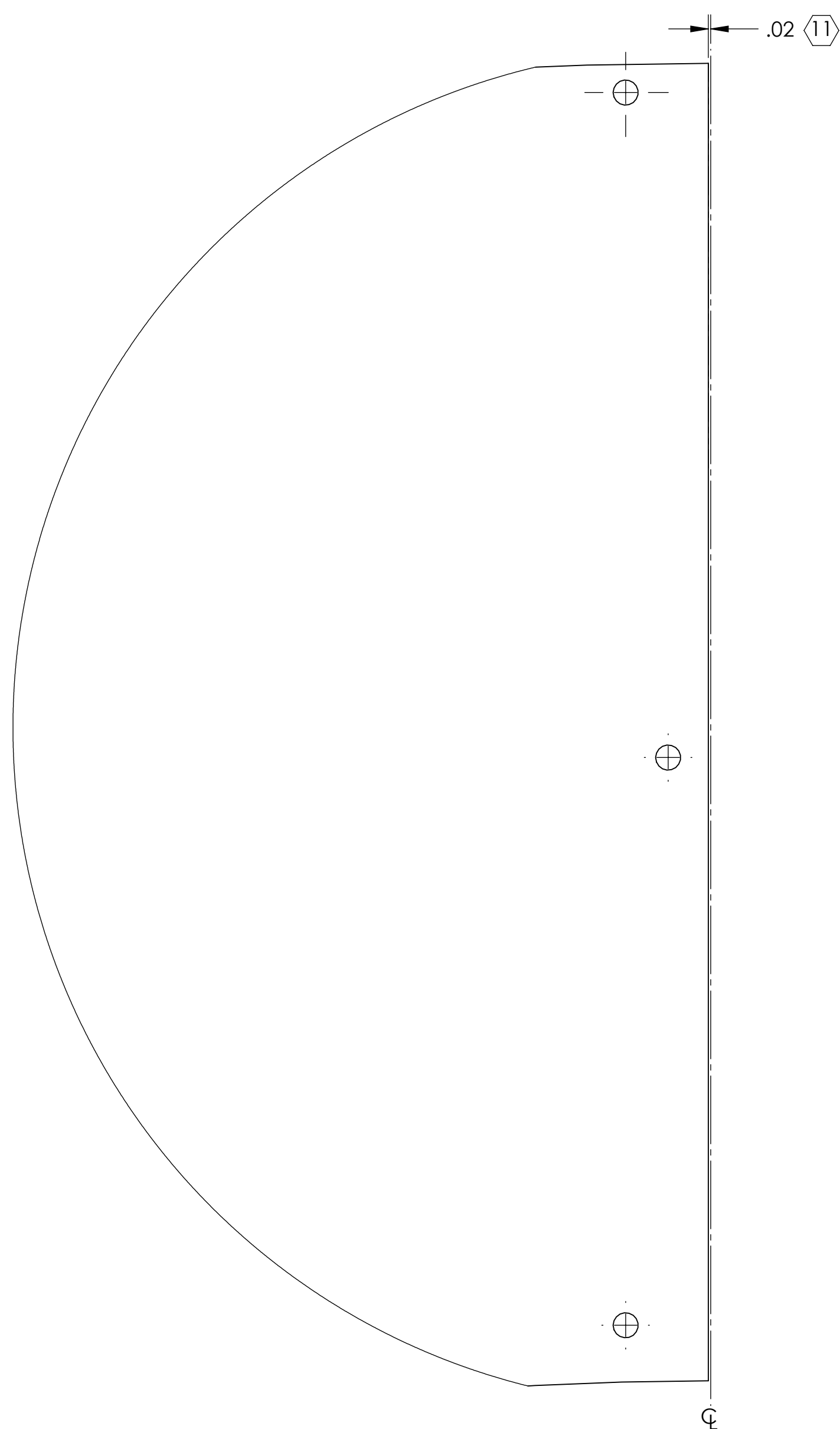
8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

9. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.

10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

11. PART IS NOT TRUE HALF CIRCLE.

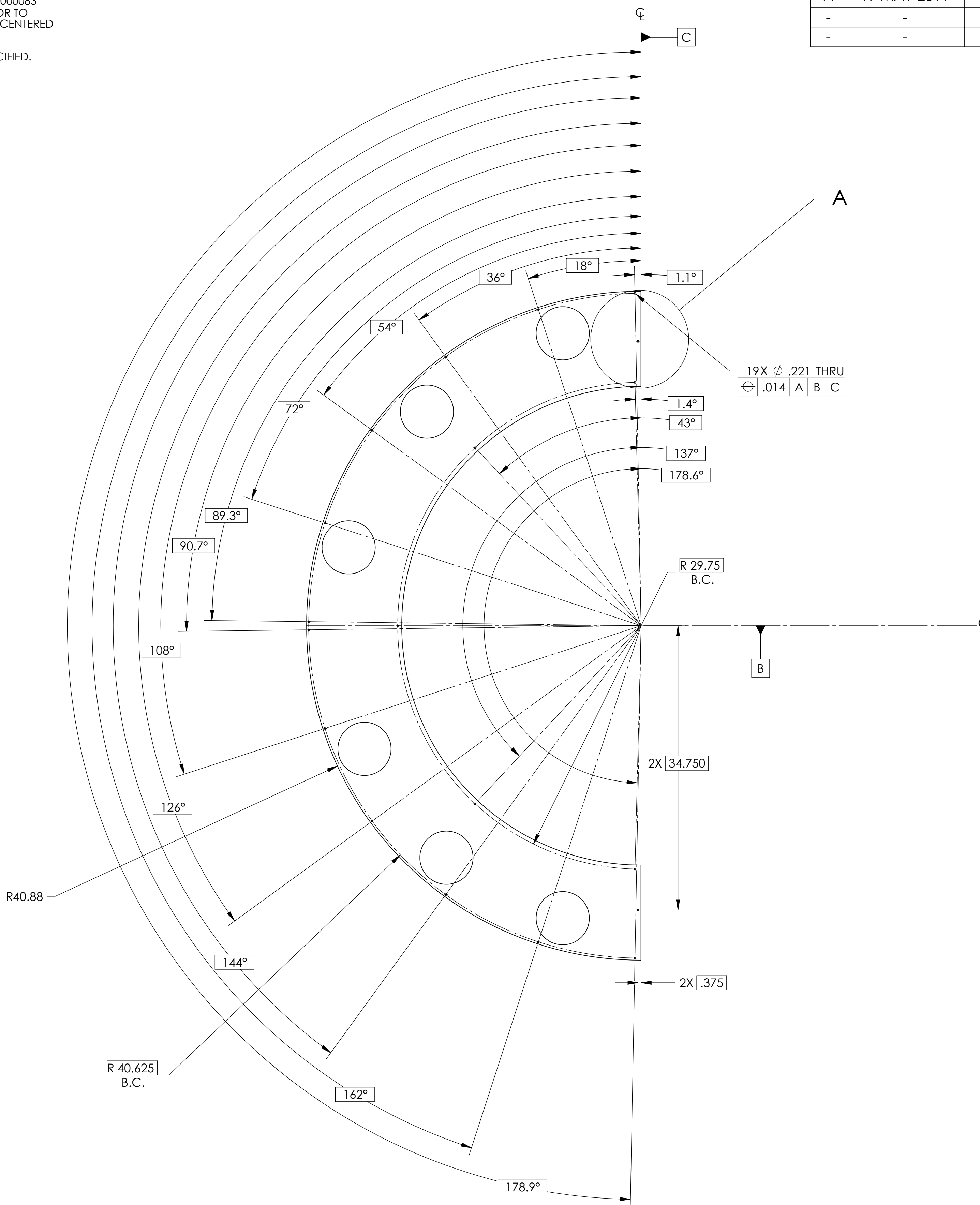
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
-	-	-	-
-	-	-	-



DETAIL A
SCALE 1 : 1
2 PLACES

\square .06

A



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				SYSTEM		MODE CLEANER BAFFLE VIEWPORT PLATE, LOWER					
TOLERANCES: .XX ± .03 .XXX ± .005				NEXT ASSY		ADVANCED LIGO		SUB-SYSTEM		AOS	
ANGULAR ± 0.1°				MATERIAL		D1002864		DESIGNER		TQ. NGUYEN 28 OCT 2010	
				FINISH				DRAFTER		N. KILPATRICK 29 NOV 2010	
								CHECKER		M. SMITH	
								APPROVAL		D. COYNE	
								SCALE: 1:8		PROJECTION:	
								DWG. NO.		D1003119	
								REV.		v1	
								SHEET 1 OF 2			

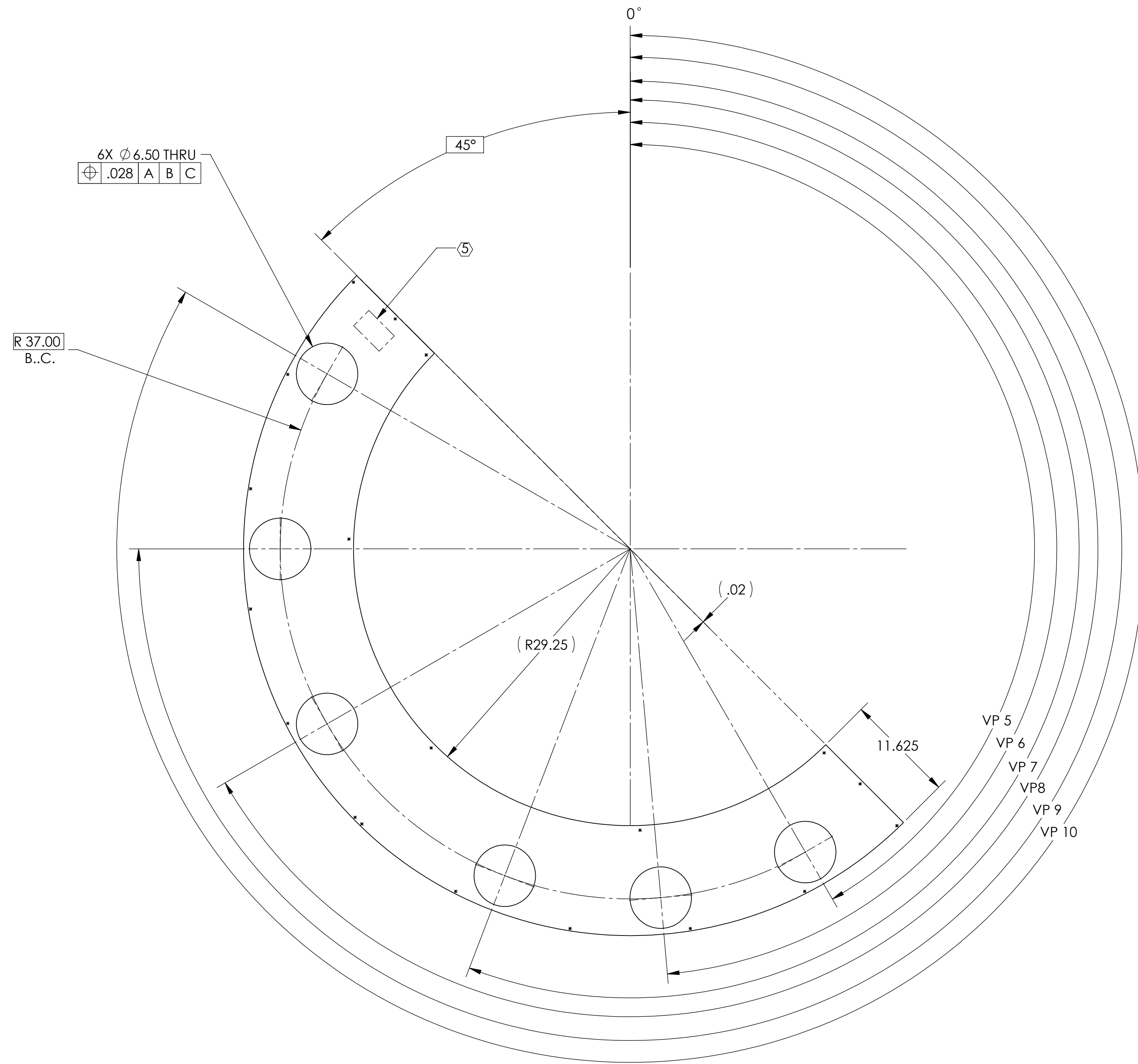


TABLE I: VIEWPORT LOCATIONS

VIEWPORT No.	MCA -00	MCB1 -01	MCB2 -02	MCB3 -03	MCB4 -04
VP 5	150°	150°	157°	150°	146°
VP 6	180°	175°	180°	190°	172°
VP 7	210°	201°	210°	215°	194°
VP 8	240°	240°	240°	240°	240°
VP 9	270°	270°	270°	270°	270°
VP 10	300°	300°	300°	300°	300°