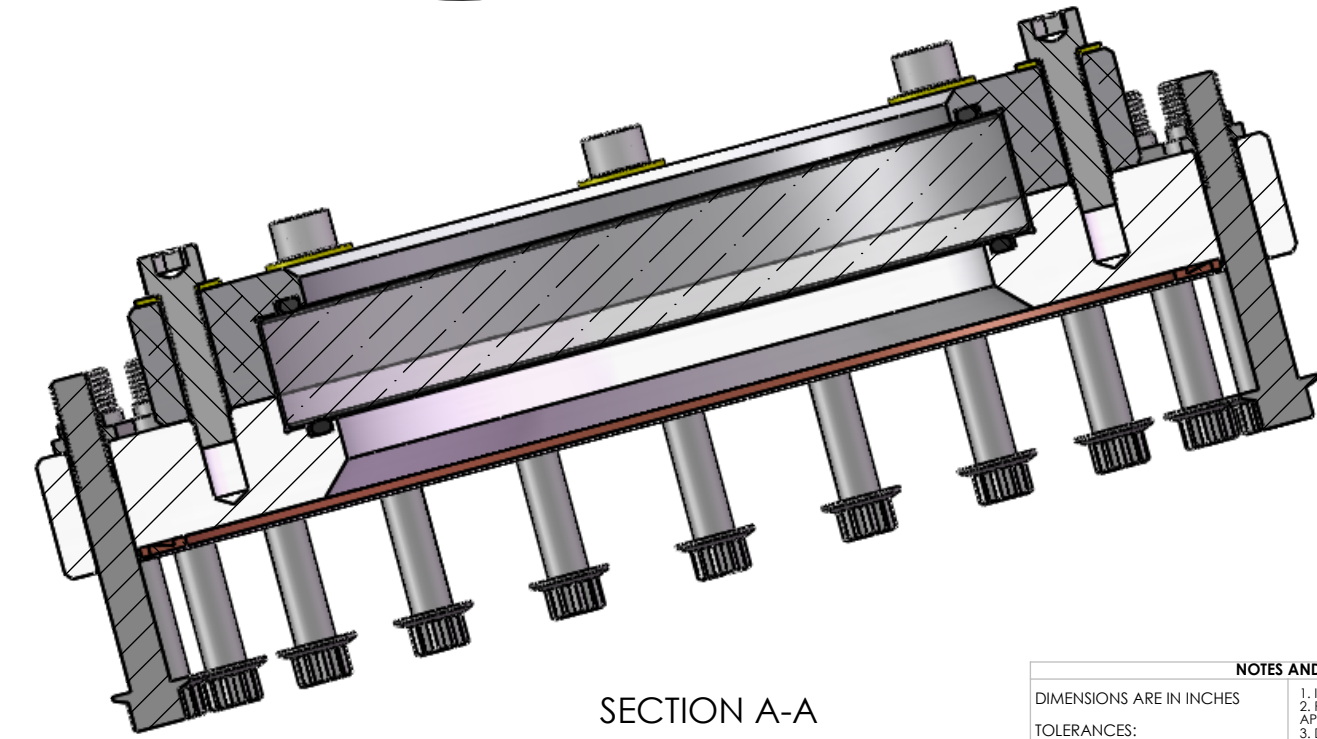
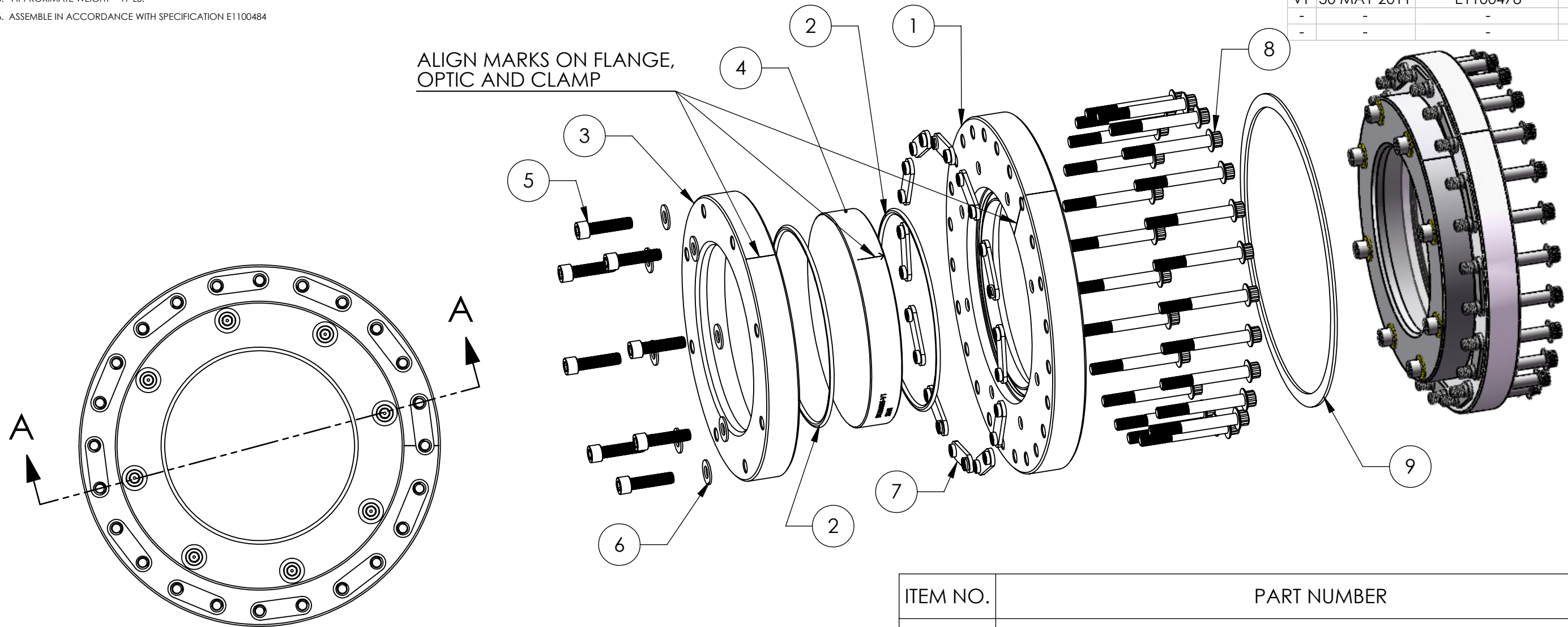


NOTES CONTINUED:  
 5. APPROXIMATE WEIGHT = 17 LB.  
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

REV.	DATE	DCN #	DRAWING TREE #
v1	30 MAY 2011	E1100478	E1100479
-	-	-	-
-	-	-	-

ALIGN MARKS ON FLANGE,  
OPTIC AND CLAMP



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	2
3	D1101115 aLIGO, high quality, 6in Viewport Clamp, wedged	1
4	D1101005 aLIGO, high quality, wedged, 6in Viewport, Optic	1
5	5/16-24 UNF x 1.25", Silver Plated SS, UC Components #C-3120-NA or equivalent	8
6	_____ 0.3125in, MS 15795-812 FLAT WASHERS (OR EQUIV.)	8
7	Nut Plate, 10" Conflat, Nor-Cal NP-800 or equivalent	12
8	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt, MDC #190067 (qty 25) or equivalent	24
9	Copper Gasket, 10" Conflat, MDC #191019 or equivalent	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .03  
 .XXX ± .010  
 ANGULAR ± 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 N/A FINISH N/A μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM AOS SUB-SYSTEM SLC

PART NAME High Quality, Wedged, 6in Viewport Assy

DESIGNER Dennis Coyne 30 May 2011 SIZE DWG. NO. B D1101000 REV. v1  
 DRAFTER Dennis Coyne 30 May 2011  
 CHECKER Mike Smith 31 May 2011  
 APPROVAL See DCN

SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1101000 aLIGO, high quality, Wedged, 6in Viewport Assy, PART PDM REV: X-000, DRAWING PDM REV: X-000