

**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- 6. APPROXIMATE WEIGHT = 13 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364, OR VACUUM EQUIPMENT MANUFACTURER'S SPECIFICATION IF APPROVED BY LIGO.
- 9. 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.

MARK PART NUMBER & SERIAL NUMBER ON THIS EDGE. SEE NOTE 5

.397" THRU HOLES  
 12 EQUALLY SPACED ALONG 9.13 DIA  
 WITH 90 DEG, .38" COUNTERSINK, BOTH SIDES

REV.	DATE	DCN #	DRAWING TREE #
V1	27 MAY 2011	E1100478-X0	NA
-	-	-	-
-	-	-	-

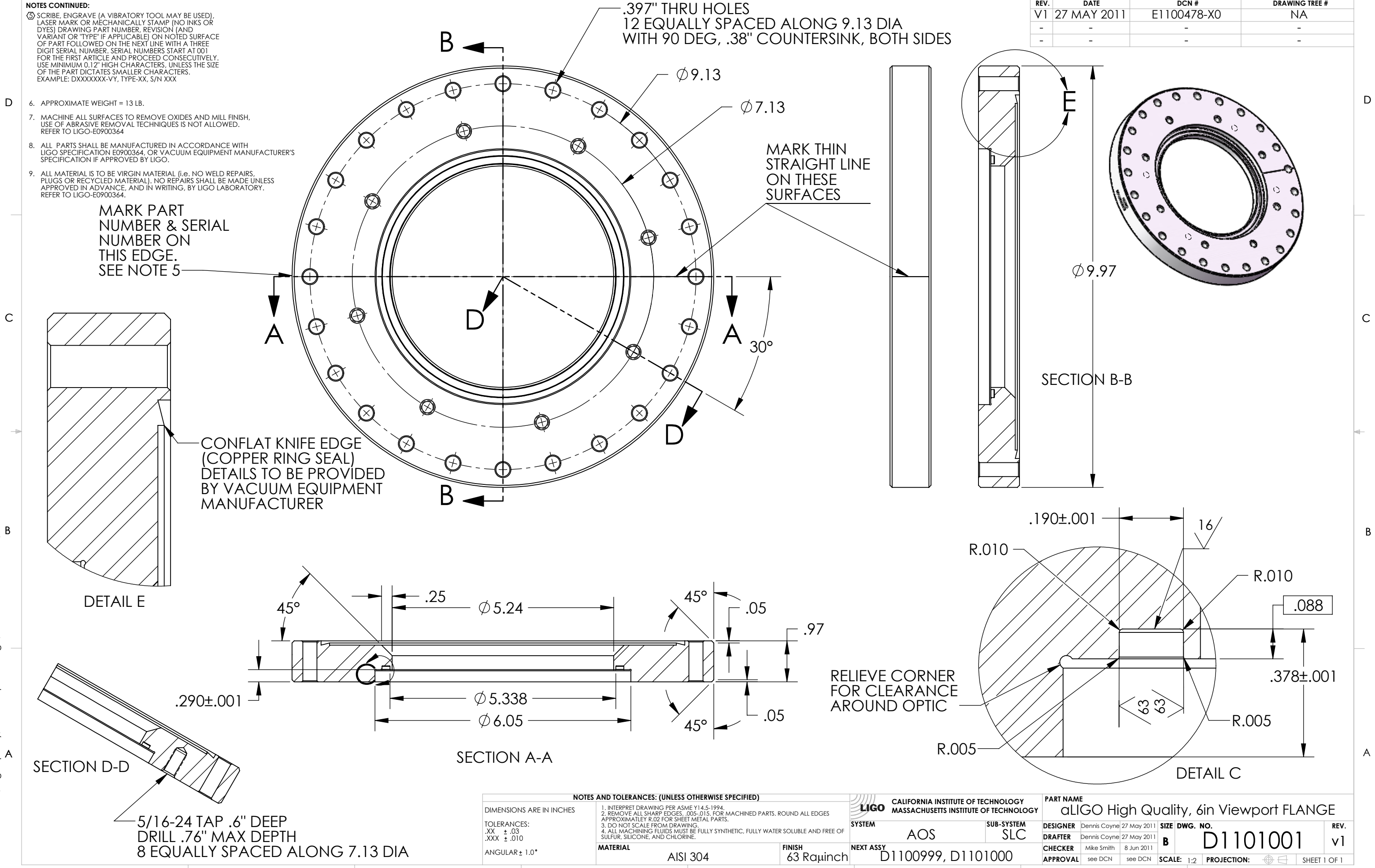
D

C

B

A

D1101001 aLIGO, high quality, 6in Viewport Flange, PART PDM REV: X-001, DRAWING PDM REV: X-001



CONFLAT KNIFE EDGE  
 (COPPER RING SEAL)  
 DETAILS TO BE PROVIDED  
 BY VACUUM EQUIPMENT  
 MANUFACTURER

MARK THIN  
 STRAIGHT LINE  
 ON THESE  
 SURFACES

RELIEVE CORNER  
 FOR CLEARANCE  
 AROUND OPTIC

5/16-24 TAP .6" DEEP  
 DRILL .76" MAX DEPTH  
 8 EQUALLY SPACED ALONG 7.13 DIA

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .03  
 .XXX ± .010  
 ANGULAR ± 1.0°

MATERIAL: AISI 304  
 FINISH: 63 Ra pinch

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <b>aLIGO High Quality, 6in Viewport FLANGE</b>	
SYSTEM	AOS	SUB-SYSTEM	SLC
DESIGNER	Dennis Coyne	DATE	27 May 2011
DRAFTER	Dennis Coyne	DATE	27 May 2011
CHECKER	Mike Smith	DATE	8 Jun 2011
APPROVAL	see DCN	DATE	see DCN
SIZE	DWG. NO.	<b>B D1101001</b>	
SCALE	1:2	PROJECTION	
NEXT ASSY			D1100999, D1101000
REVISION			v1
SHEET 1 OF 1			