

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 = 1.7 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.

REV.	DATE	DCN #	DRAWING TREE #
V1	8 JUN 2011	E1100478-X0	NA
V2	8 JUL 2011	E1100478-V1	NA
V3	25 SEP 2011	E1100478-v4	-

D1101002-v3
 SN 001

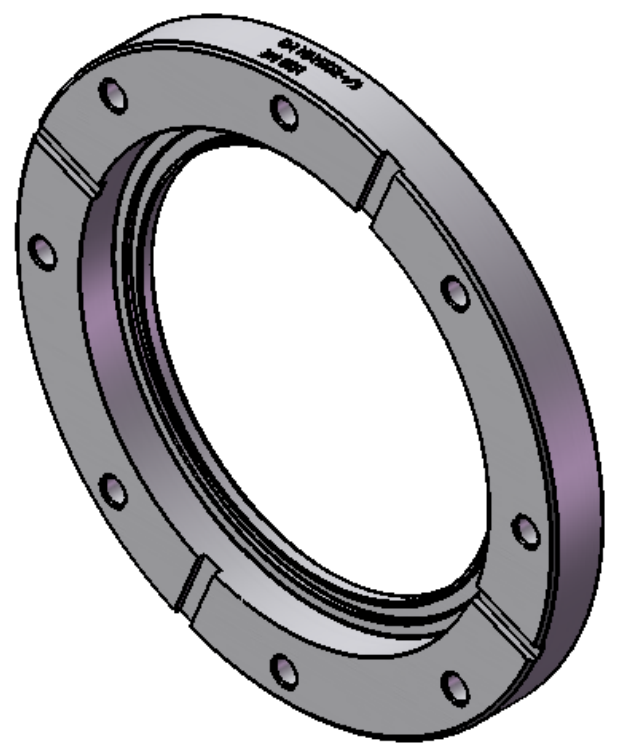
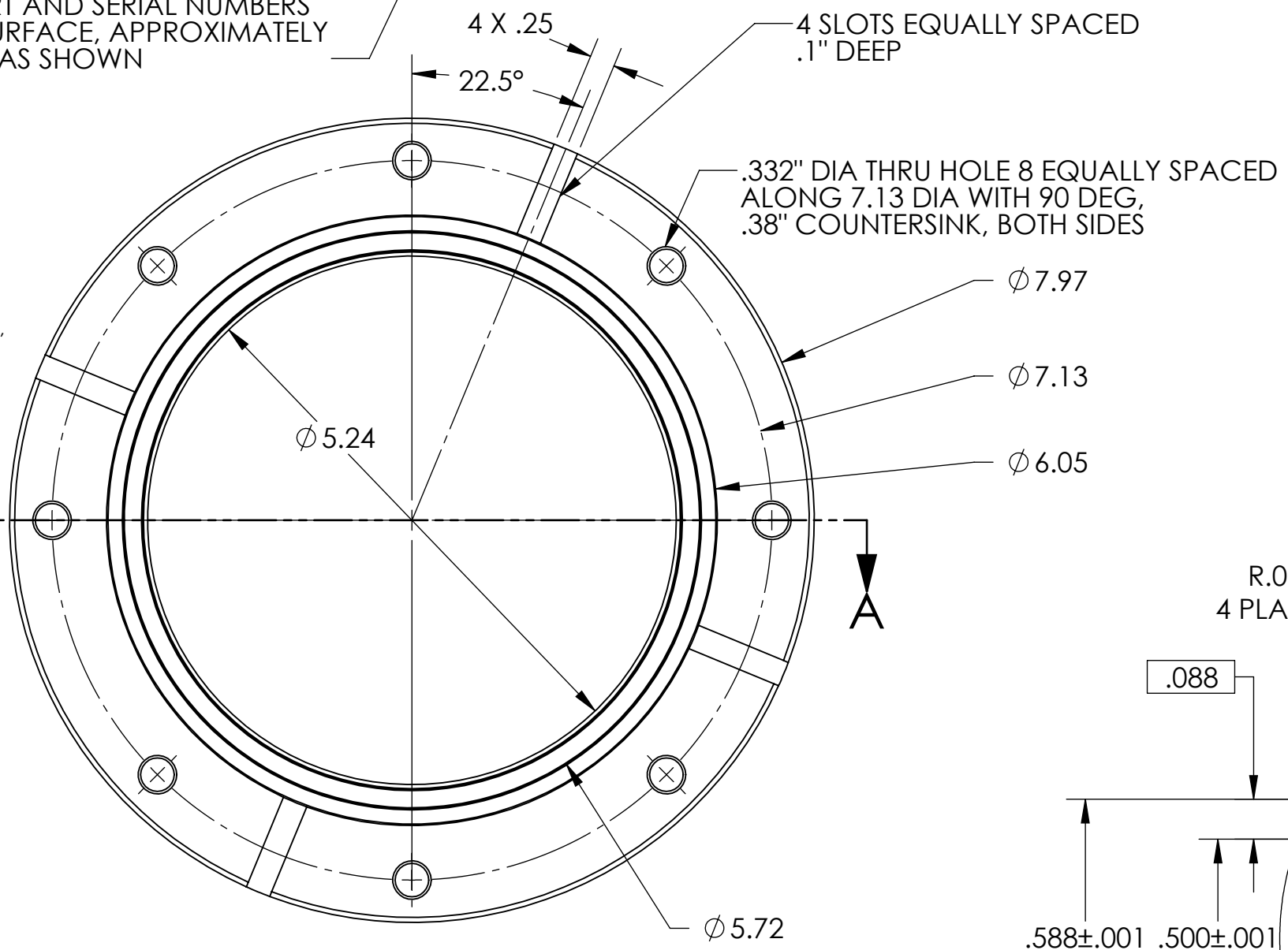
MARK PART AND SERIAL NUMBERS ON THIS SURFACE, APPROXIMATELY LOCATED AS SHOWN

D

C

B

A

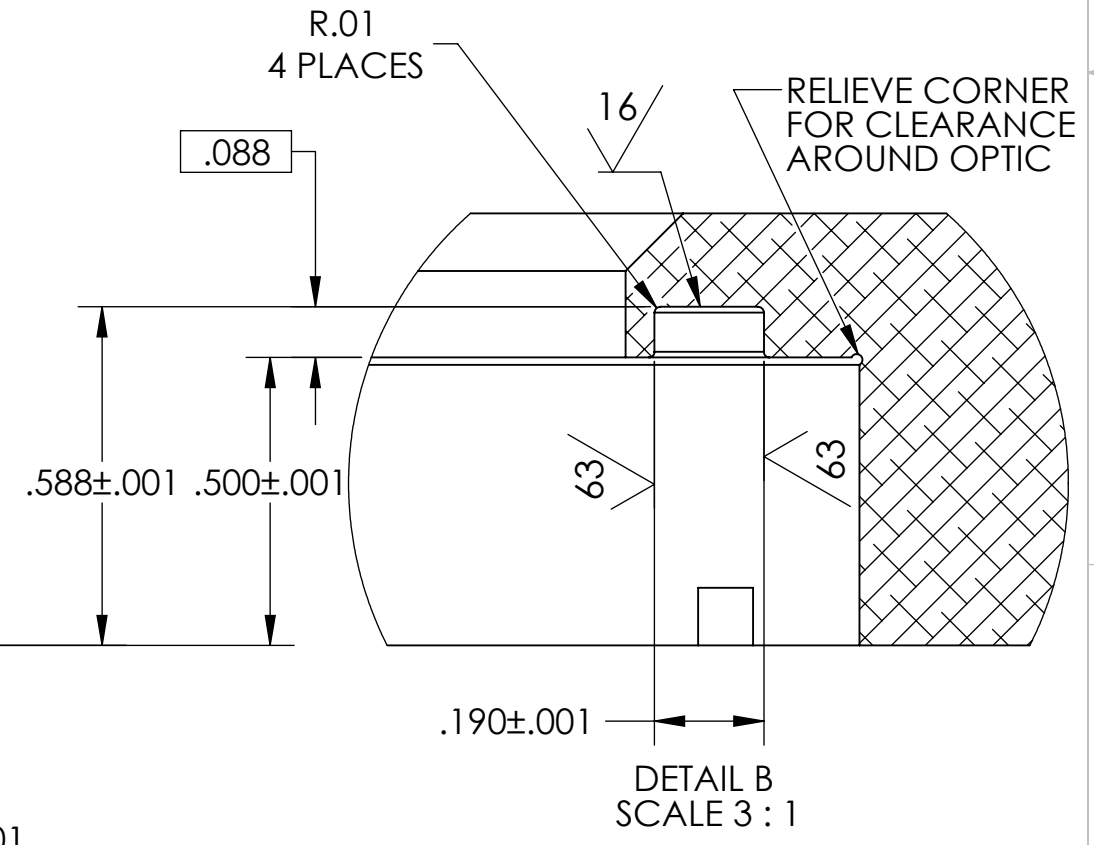
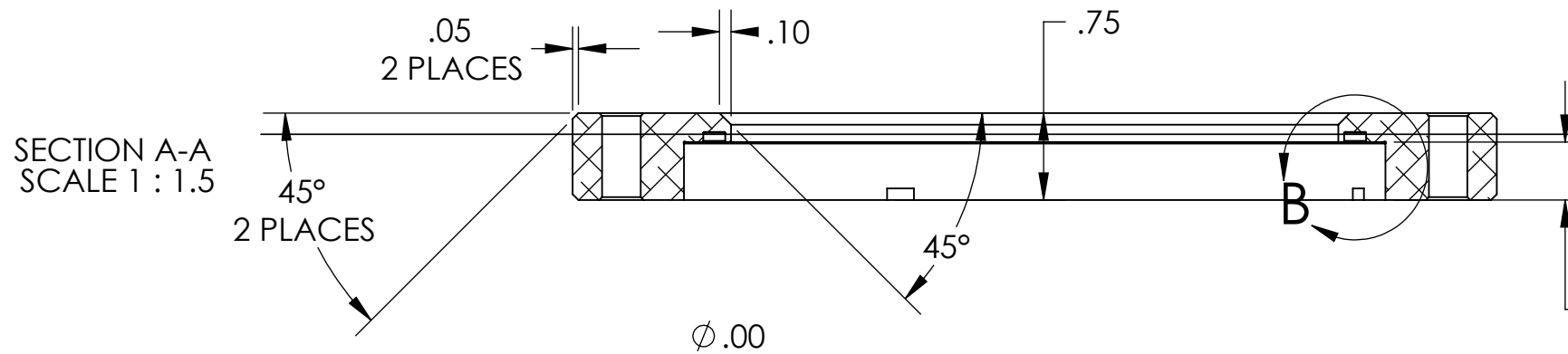


D

C

B

A



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 6061 Alloy FINISH 63 Raqinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO, High Quality, 6" Viewport CLAMP	
SYSTEM	AOS	SUB-SYSTEM	SLC
DESIGNER	Dennis Coyne 27 May 2011	SIZE DWG. NO.	B
DRAFTER	Dennis Coyne 27 May 2011	D1101002	
CHECKER	Mike Smith 27 May 2011	REV.	v3
APPROVAL	See DCN	SCALE: 1:2	PROJECTION:
NEXT ASSY	D1100999	SHEET 1 OF 1	

D1101002 aLIGO, high quality, 6in Viewport Clamp, PART PDM REV: X-008, DRAWING PDM REV: X-006