REV.	DATE	DCN #	DRAWING TREE #
V1	8 JUN 2011	E1100478	NA
-	-	-	-
-	-	-	-

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

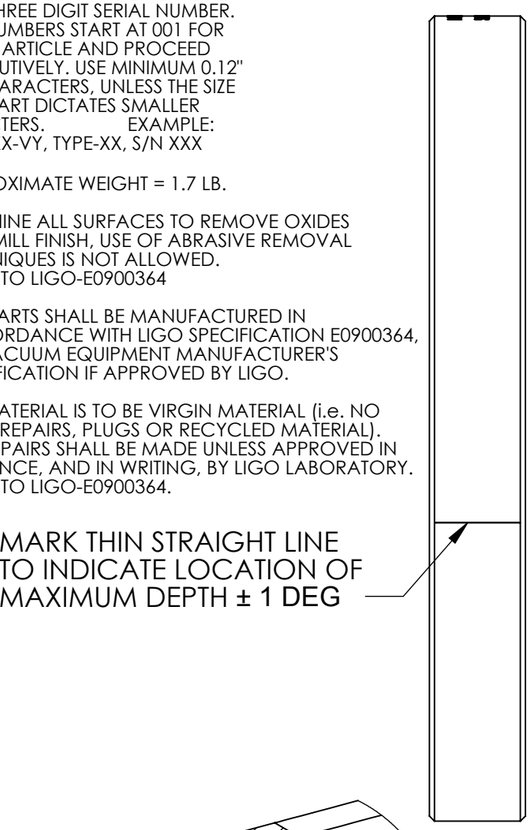
6. APPROXIMATE WEIGHT = 1.7 LB.

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.

MARK THIN STRAIGHT LINE TO INDICATE LOCATION OF MAXIMUM DEPTH ± 1 DEG

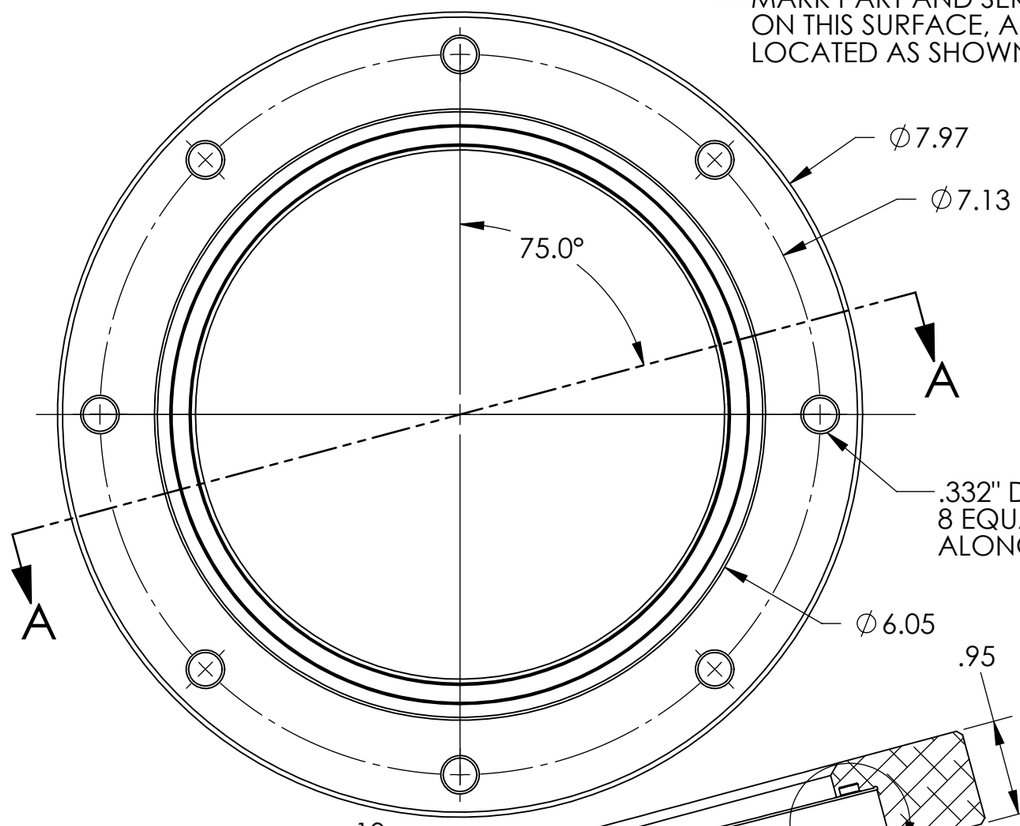


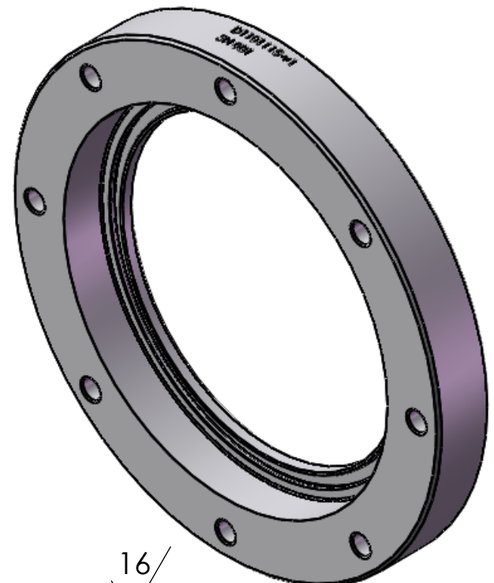
.698

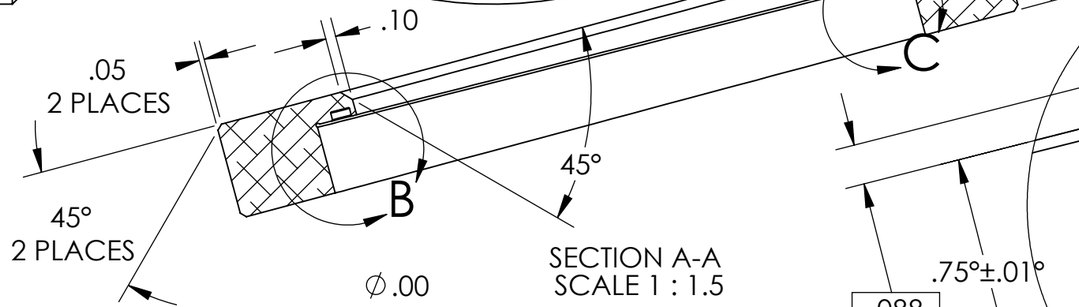
DETAIL B
SCALE 2 : 1.5

D1101115-v1
SN 001

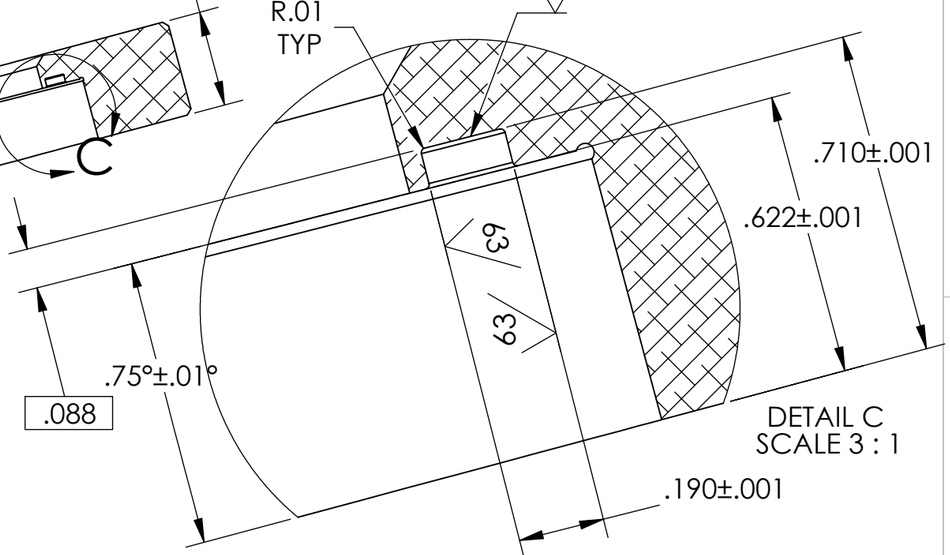
MARK PART AND SERIAL NUMBERS ON THIS SURFACE, APPROXIMATELY LOCATED AS SHOWN







SECTION A-A
SCALE 1 : 1.5



DETAIL C
SCALE 3 : 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: 6061 Alloy	FINISH: 63 Raμinch	NEXT ASSY: D1101000		

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: AOS | SUB-SYSTEM: SLC

PART NAME: High Quality, 6" Viewport CLAMP, wedged

			SIZE	DWG. NO.	REV.
DESIGNER	Dennis Coyne	27 May 2011	B	D1101115	v1
DRAFTER	Dennis Coyne	27 May 2011			
CHECKER	Mike Smith	27 May 2011			
APPROVAL	See DCN	See DCN	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1101115 aLIGO, high quality, 6in Viewport Clamp, wedged, PART PDM REV: X-002, DRAWING PDM REV: X-002