

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

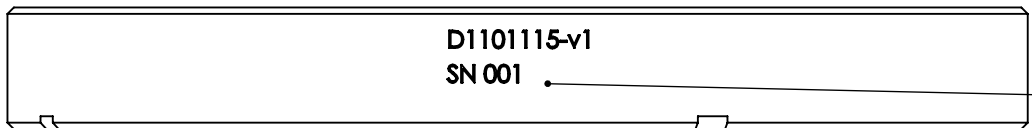
6. APPROXIMATE WEIGHT = 1.7 LB.

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.

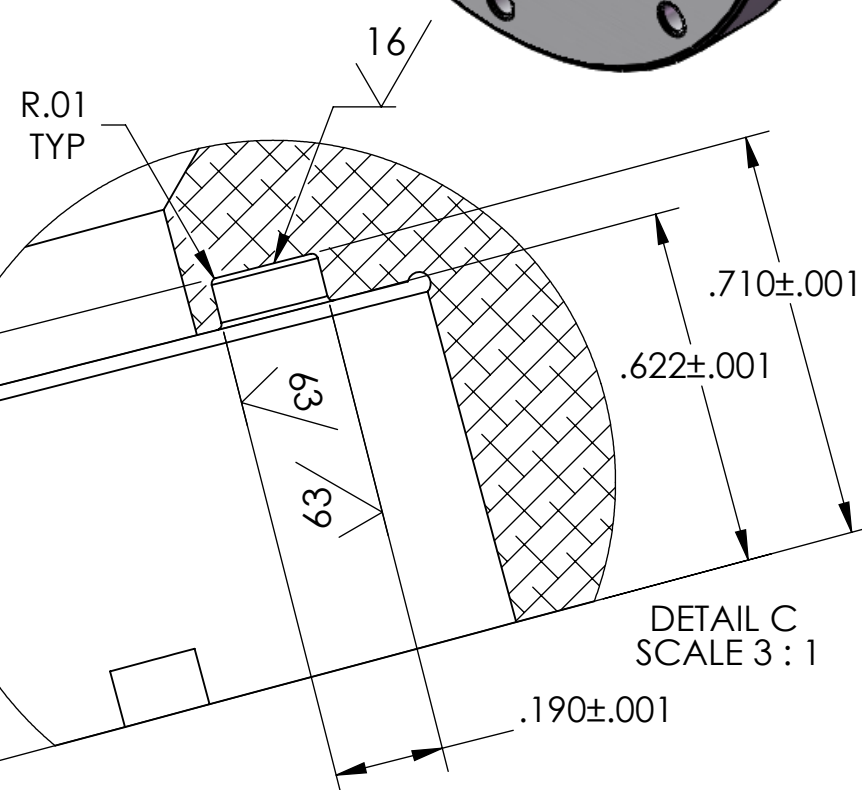
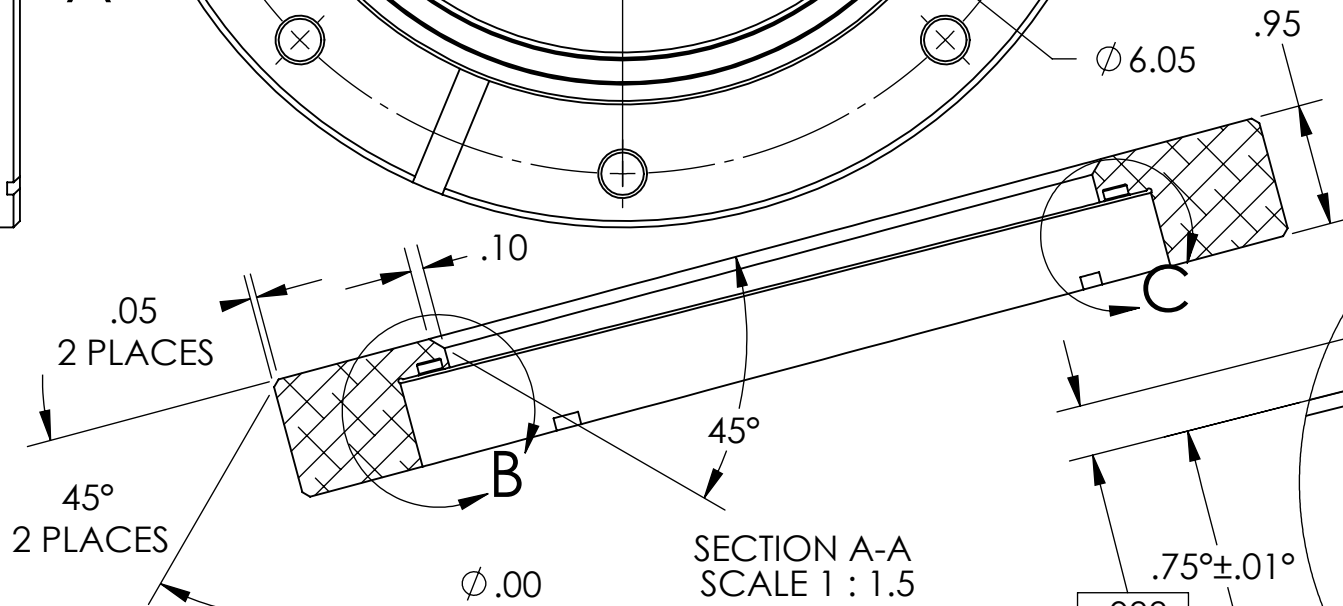
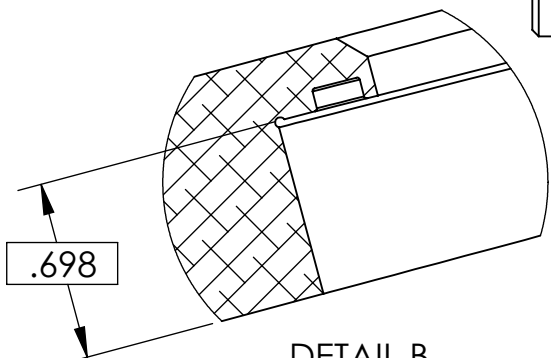
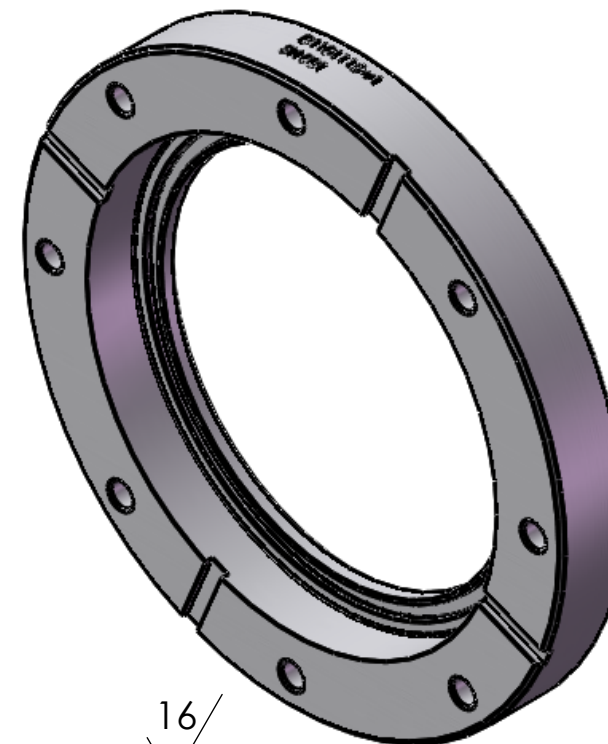
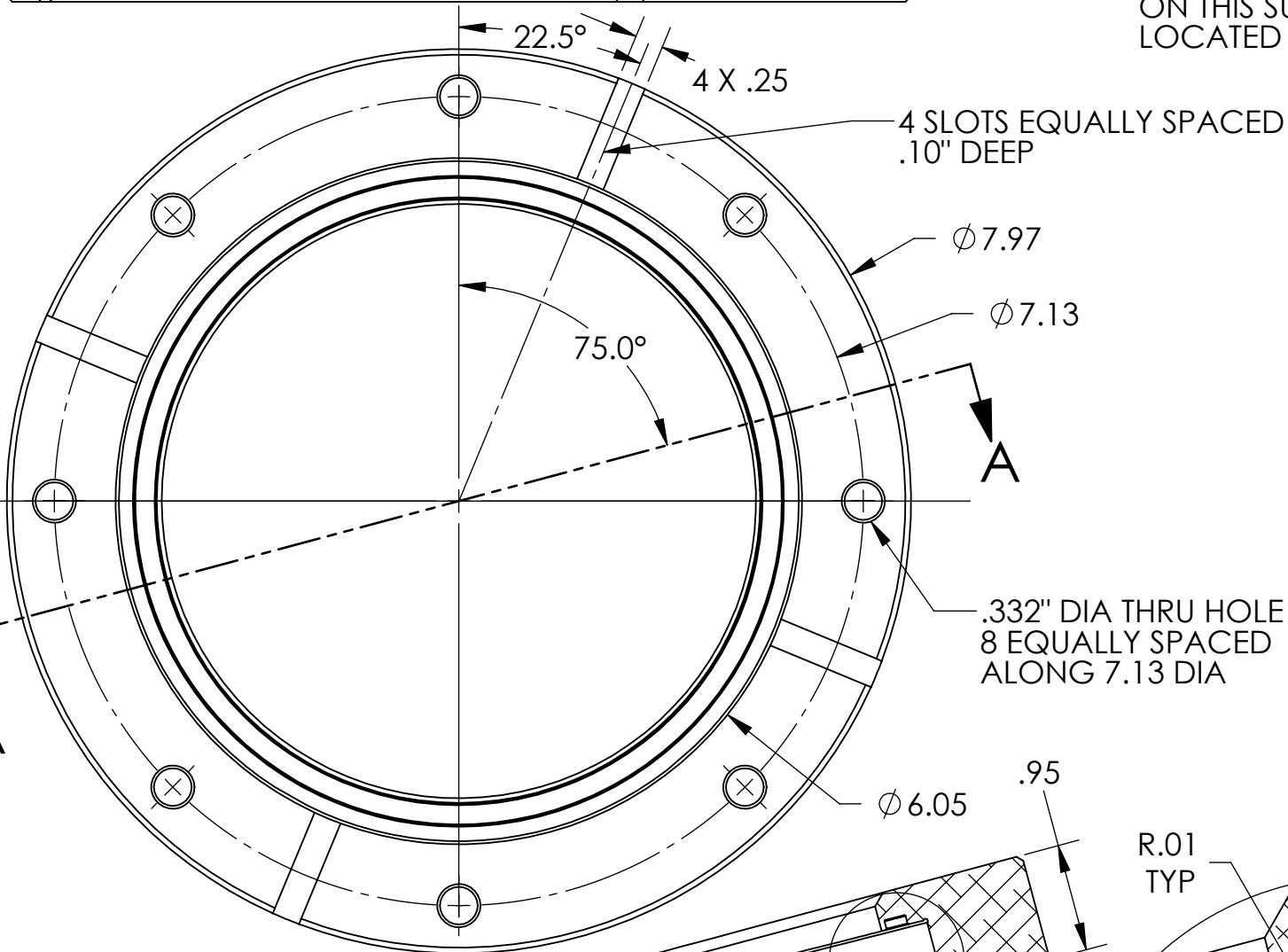
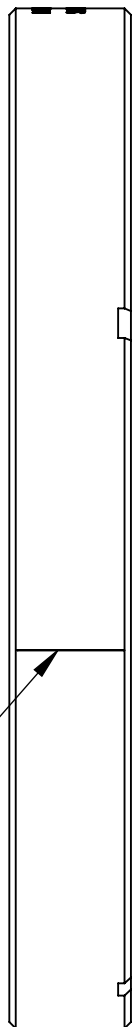
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

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



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

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



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± .03
.XXX ± .010
ANGULAR ± 1.0°
MATERIAL 6061 Alloy
FINISH 63 Raqinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM AOS
NEXT ASSY D1101000

PART NAME High Quality, 6" Viewport CLAMP, wedged
DESIGNER Dennis Coyne 27 May 2011
DRAFTER Dennis Coyne 27 May 2011
CHECKER Mike Smith 27 May 2011
APPROVAL See DCN See DCN
SIZE DWG. NO. B D1101115
REV. v2
SCALE: 1:2 PROJECTION: SHEET 1 OF 1