

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = X.XXX LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

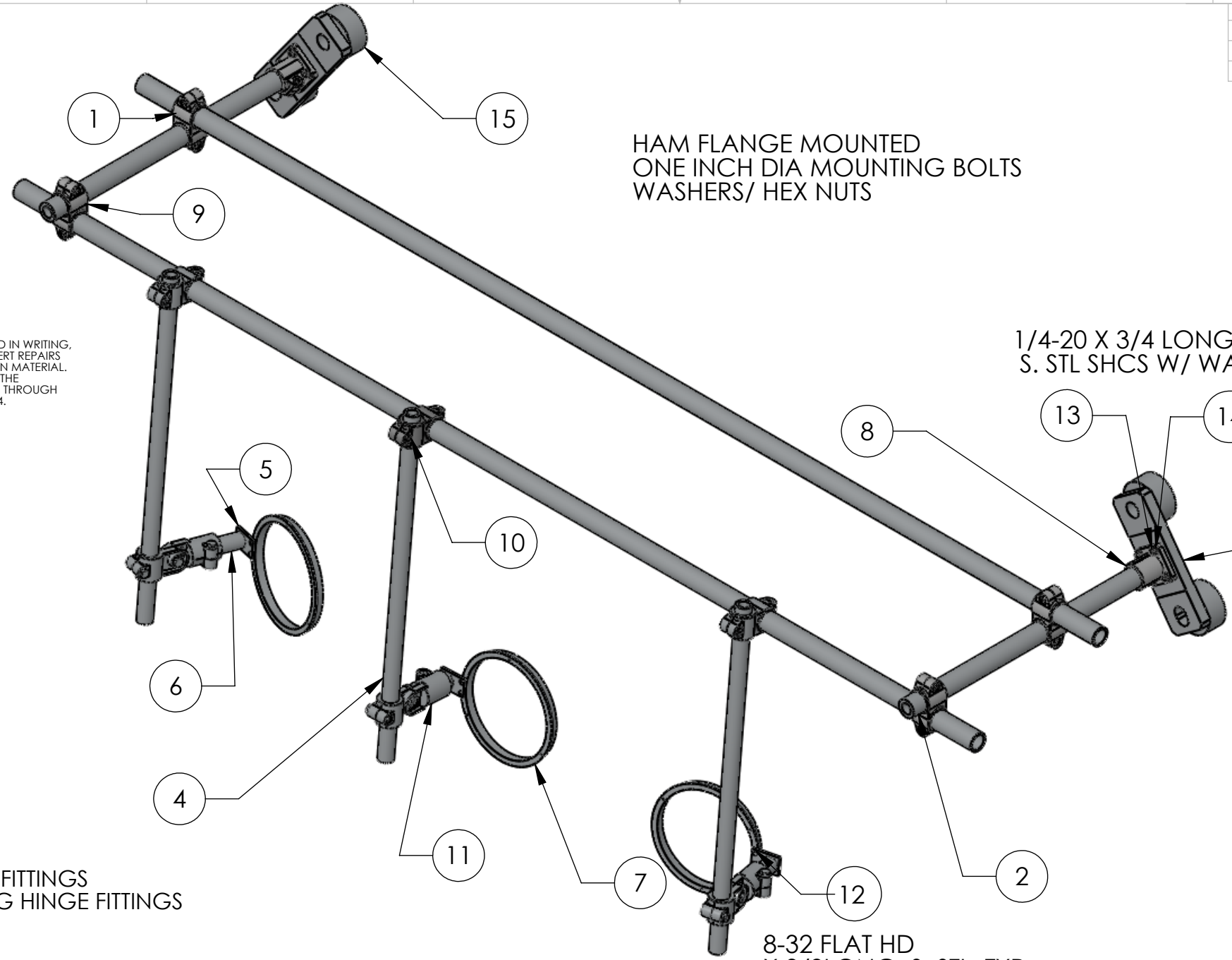
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	06-13-12	TO FOLLOW	-
v2	06-15-12	TO FOLLOW	-
-	-	-	-

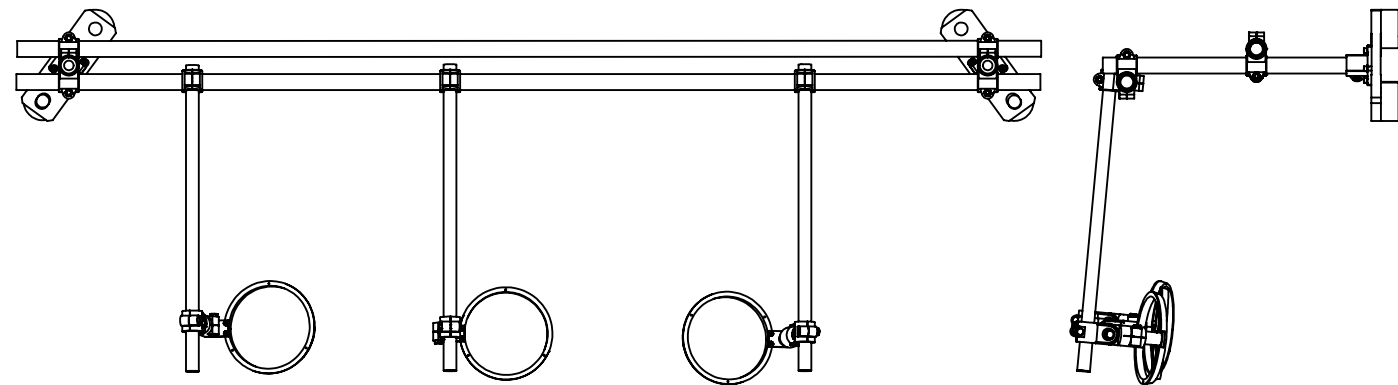


HAM FLANGE MOUNTED
ONE INCH DIA MOUNTING BOLTS
WASHERS/ HEX NUTS

1/4-20 X 3/4 LONG
S. STL SHCS W/ WASHER TYP

8-32 FLAT HD
X 3/8LONG S. STL TYP

6MM HEX WRENCH FOR CLAMP FITTINGS
15MM WRENCH FOR ITEM 11 RING HINGE FITTINGS



15	D1200870 aligo viewport target post foot door spacer. SLDPRT	4
14	90107A013	8
13	92196A540	8
12	90585A226	12
11	9578T41	3
10	9578T21	3
9	9578T22	4
8	9578T62	2
7	D1200872 aLigo viewport target ring	3
6	D1200906 aligo viewport target ring shaft	3
5	D1200904 aLigo viewport target ring bracket	3
4	aligo viewport target tube 1inch	3
3	aligo viewport target post foot	2
2	aligo viewport target mount 1.25 x .12 wall alum tube flange.	2
1	aligo viewport target mount 1.25 x .12 wall alum tube horiz.	2
ITEM NO.	PART NUMBER	Req'd QTY.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .02 .XXX ± .005	
ANGULAR ± 1.0°	
MATERIAL	FINISH
--	-- μinch

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

PART NAME: **aLigo_Ham_ViewPort_Target_Tool_Assembly**

DESIGNER: KEN MAILAND 6-6-2012
DRAFTER: KEN MAILAND 06-08-12
CHECKER: KEN MAILAND 06-08-12
APPROVAL: _____

SIZE DWG. NO. **B**
D1200845

REVISION: **v2**

SCALE: 1:24 PROJECTION: SHEET 1 OF 1