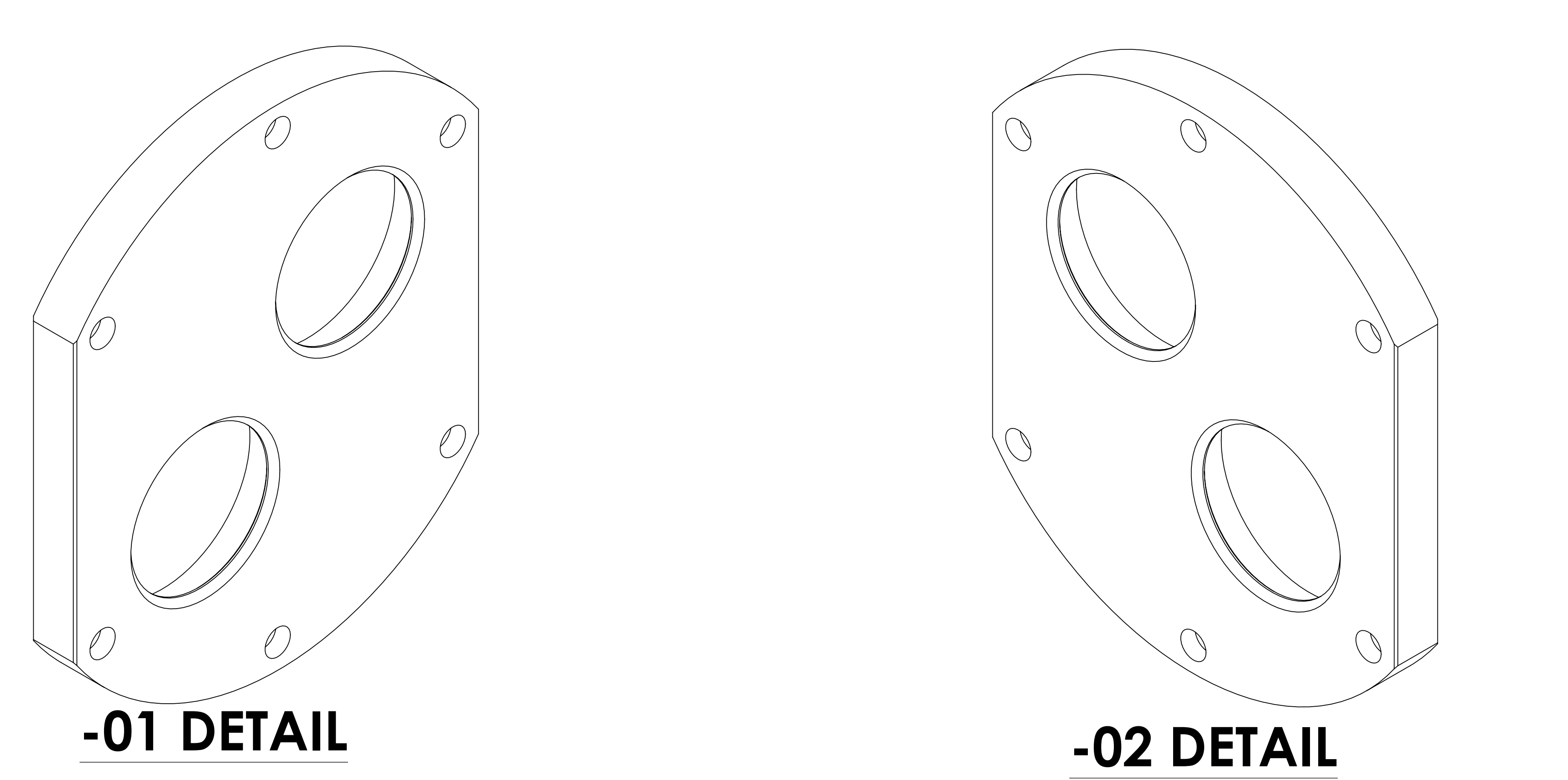
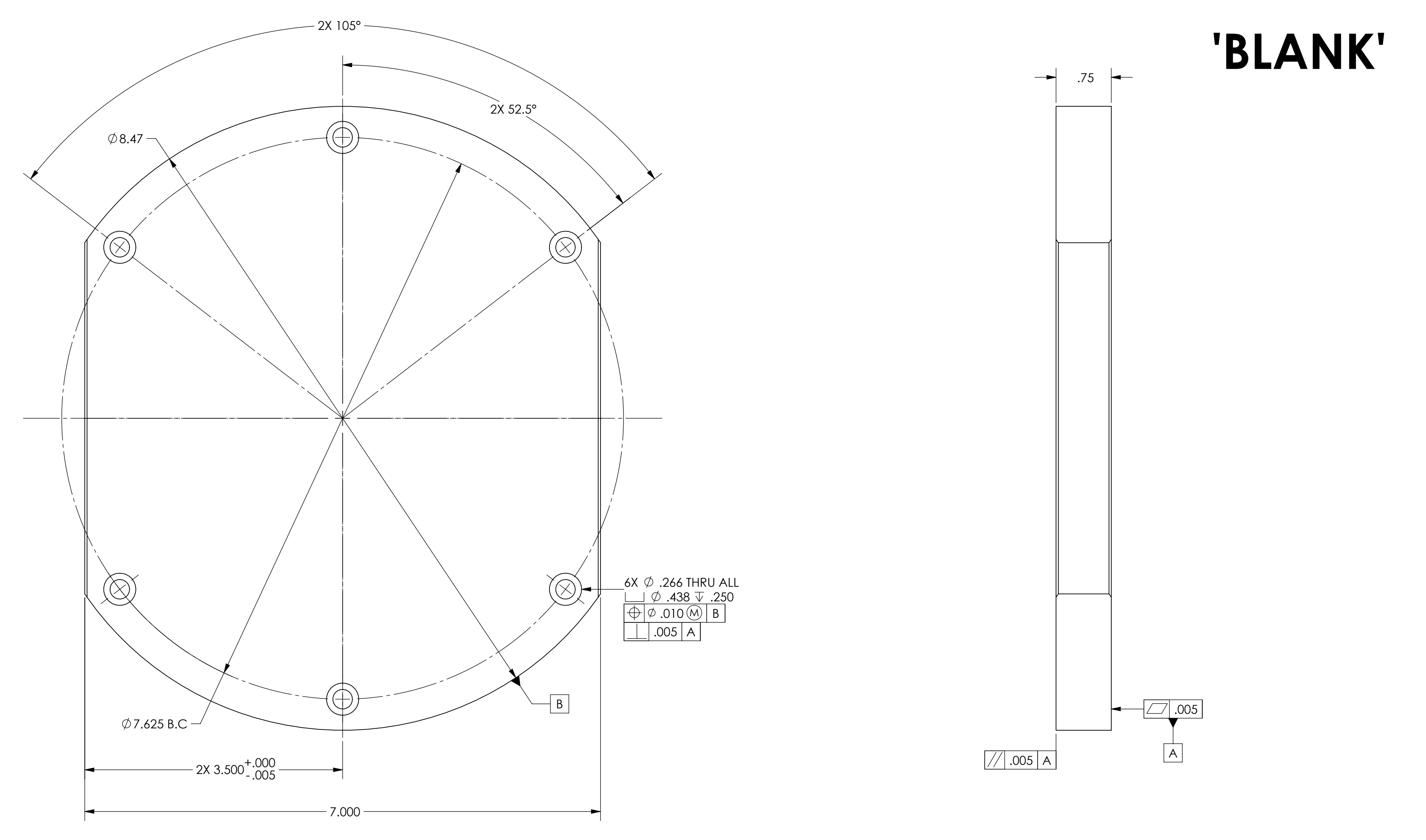
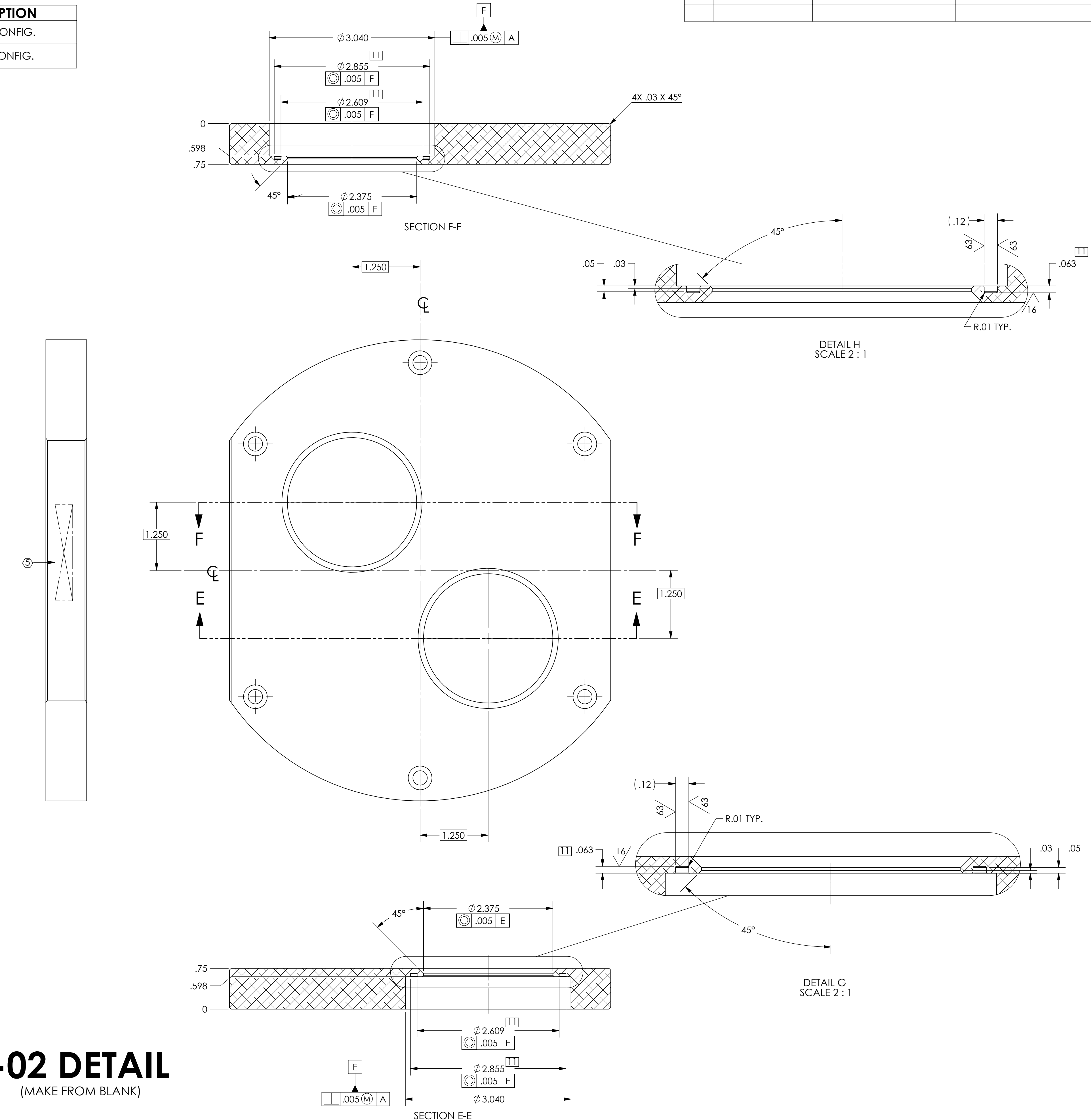
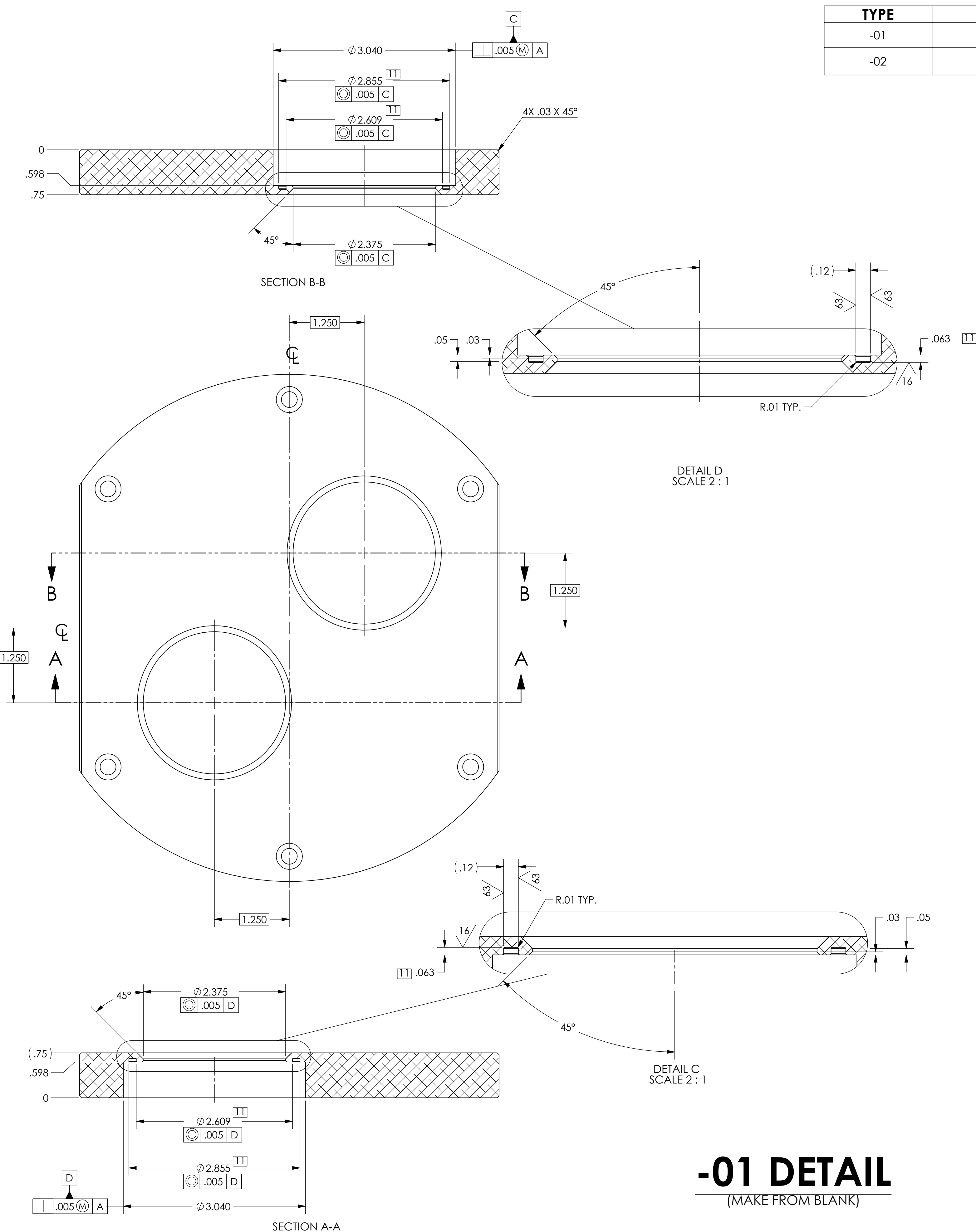


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.17" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 6. APPROXIMATE WEIGHT = 2.74 LB.
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-EP00364
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION EP00364.
 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-EP00364.
 10. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 11. REFER TO LIGO T1100346 FOR FEATURE DESIGN GUIDELINES.

REV.	DATE	DCN #	DRAWING TREE #
v1	05 DEC 2012	E1200247-x0	E1200248-v1
-	-	-	-

TYPE	DESCRIPTION
-01	X-ARM CONFIG.
-02	Y-ARM CONFIG.



DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME PRIMARY VIEWPORT CLAMP, H1-L1 BSC 1 AND 3	
1. INTERPRET DRAWING PER ASME Y14.5-1994		2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS, ROUND ALL EDGES APPROXIMATELY R.02.		3. DO NOT SCALE FROM DRAWING.		4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL 6061 Alloy		FINISH 63 μin		NEXT ASSY	
ANGULAR ± 1.0°		DESIGNER M. JACOBSON		DRAFTER E. SANCHEZ		CHECKER M. JACOBSON	
APPROVAL M. JACOBSON		DATE 05 DEC 2012		SCALE 1:1		PROJECTION FIRST ANGLE	
DWG. NO. E		SIZE D1201303		REV. v1		SHEET 1 OF 1	