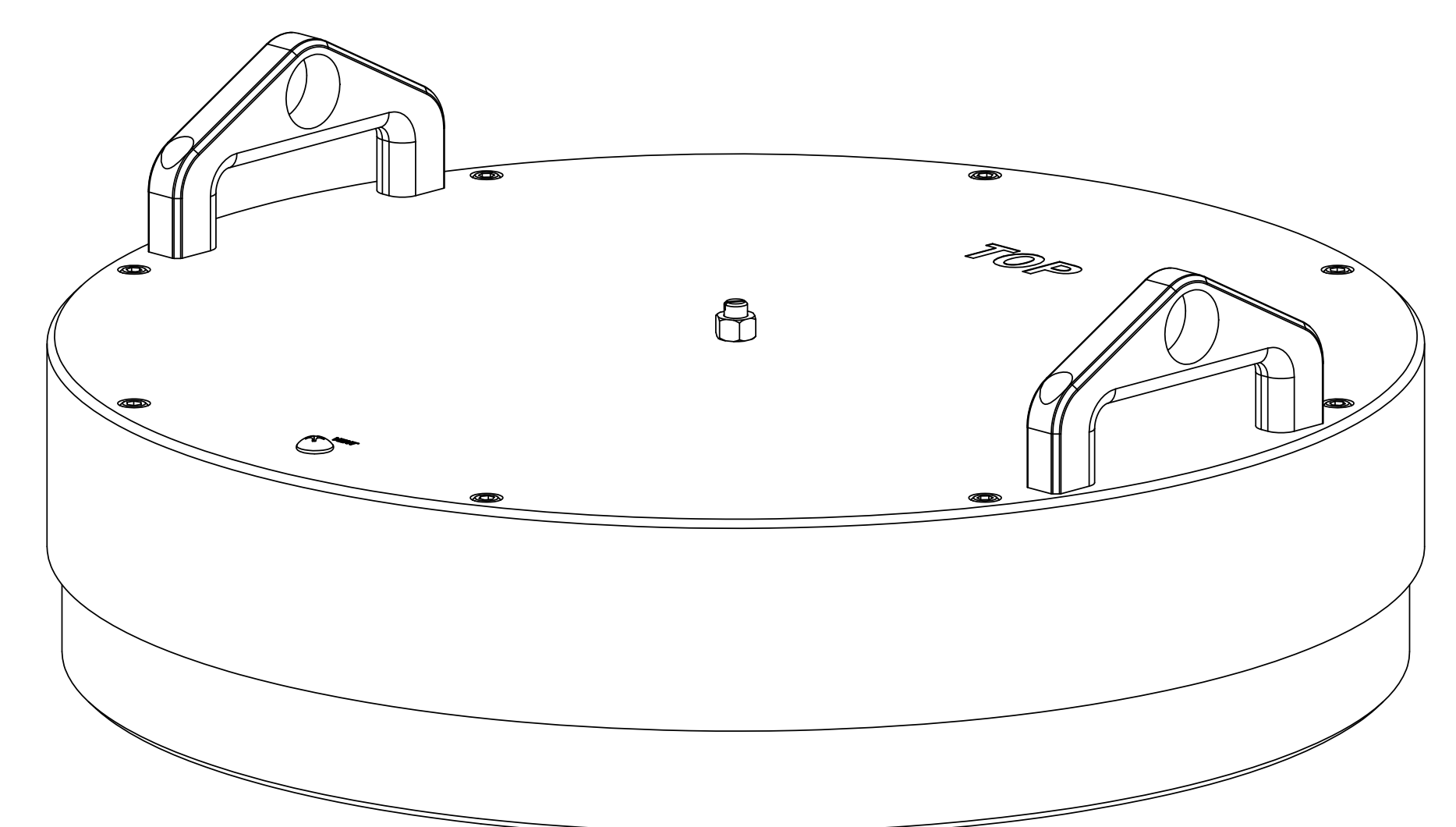
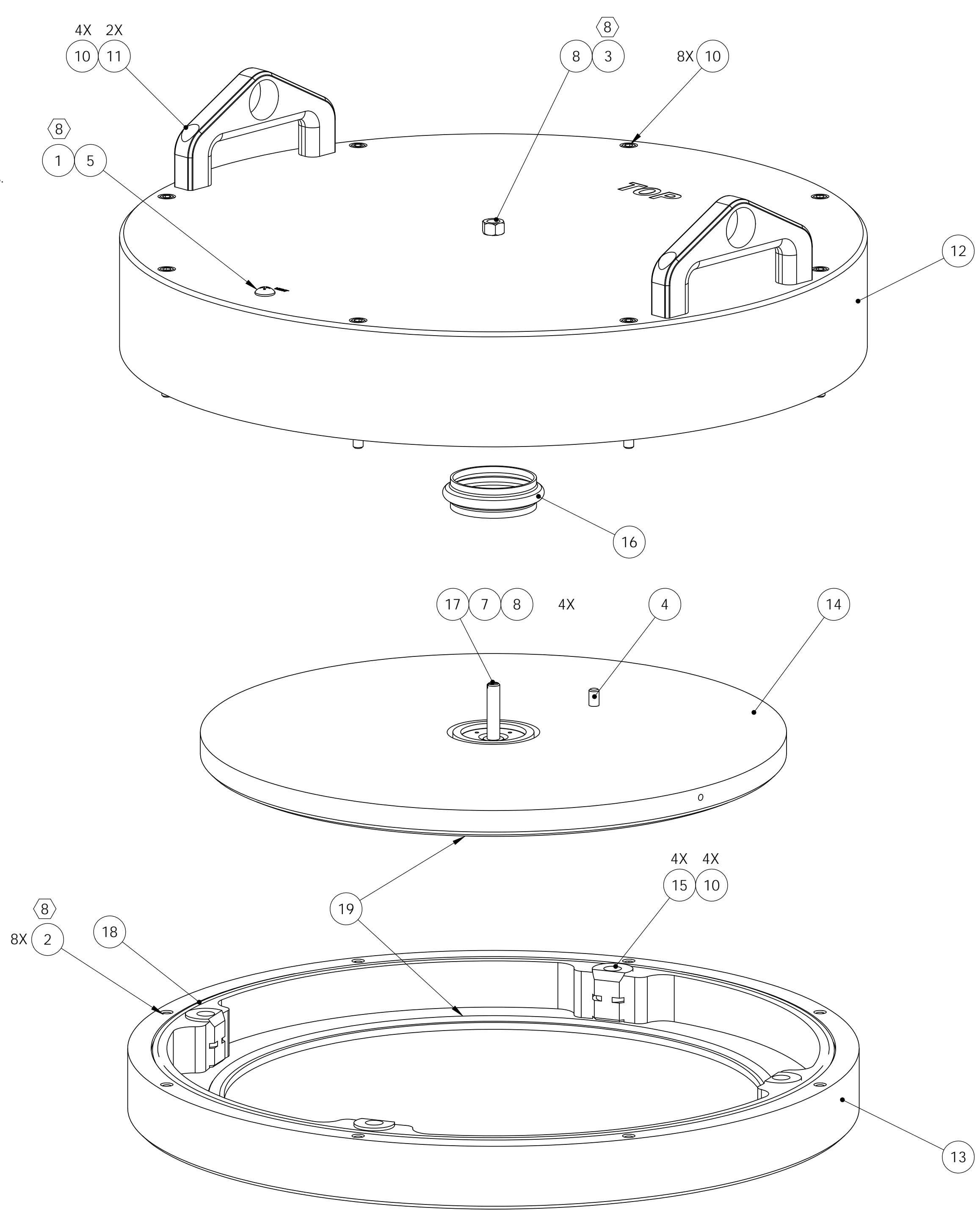


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED. ESTIMATE.
- 6. ESTIMATED WEIGHT FROM CAD MODEL: 51.2 lbs (23.2 kg).
- 7. THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS WITH SOAP AND WATER. FOLLOW WITH SOLVENT (ACETONE) WIPE. PAY CLOSE ATTENTION TO THE TAPPED HOLES.
- 8. THE CONTRACTOR IS RESPONSIBLE FOR INSERTION OF HELI-COILS (HELI-COILS ITEMS NO. 1, 2 & 3 TO BE INSTALLED INTO BASE RING, ITEM NO. 15, & COVER LID, ITEM NO. 14). EXTRA CARE SHOULD BE TAKEN ON CLEANING THE HELI-COILS AND THE HOLES PRIOR TO THE INSERTING THE HELI-COILS. (LIGO STAFF CAN HELP WITH THIS STAGE.)
 - a. AFTER CLEANING THE HOLE AND HELI-COIL WITH SOAP AND WATER, AS ABOVE
 - b. CLEAN THE HELI-COIL IN ACETONE AND CLEAN THE HOLE WITH ACETONE AND A BRUSH
 - c. LASTLY RINSE BOTH THE HELI-COIL AND THE HOLE WITH DE-IONIZED WATER
 - d. PLEASE WEAR LATEX GLOVES WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)
- 9. ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND CHIPS.



REV.	DATE	DCN #	DRAWING TREE #
-	-	REFER TO E0900200-v1	-
-	-	-	-
-	-	-	-

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
19	ROW Inc.	O-Ring, Supporting Optic, FM, .275 Thick X 13.475 ID	PFA Encapsulated Viton	2	0	2
18	ROW Inc.	O-Ring, Base FM, .139 Thick X 16.500 ID	Rubbber Viton	1	0	1
17	D0901320	Screw, Retaining, End Slot 5/16-18 x 1.41	17-4 SS	1	0	1
16	D0901311	Bellow, Single Convolution, Molded, Viton	Rubbber Viton	1	0	1
15	D0901270	Plastic Insert, Base, FM Optic Container	PFA 440 HP	4	0	4
14	D0901268	Wedge Plate, FM Optic Container	6061-T6 Alum	1	0	1
13	D0901267	Base, Bottom, FM Optic Container	6061-T6 Alum	1	0	1
12	D0901266	Cover, Top, FM Optic Container	6061-T6 Alum	1	0	1
11	D0901064	Handle, Cover Lid, Optic Container	6061-T6 Alum	2	0	2
10	C-2048-N	Screw, Soc Hd Cap, 1/4-20 x 3.00 (UC Comp #C-2048-N)	18-8 SS	8	0	8
9	C-2016-N	Screw, Soc Hd Cap, 1/4-20 x 1.00 (UC Comp #C-2016-N)	18-8 SS	8	0	8
8	94252A706	Nut, Hex, SS, 5/16-18 X 19/64, McM #94252A706	18-8 SS	1	0	1
7	91944A401	Washer, Self-Aligning, Female, 1/4-20 Screw Size, McM #91944A401	316 SSSL	1	0	1
6	91944A301	Washer, Self-Aligning, Male, 1/4-20 Screw Size, McM #91944A301	316 SSSL	1	0	1
5	91770A537	Screw, Rnd Head Phillips, 1/4-20 x .500, McM #91770A537	18-8 SS	1	0	1
4	90145A540	Pin, Dowel, Stop, Cover Lid, .25 Dia x .75, McM #90145A540	18-8 SS	1	0	1
3	1185-5EN469	#5/16-18 X .469 HELICOIL (Emhart P/N 1185-5EN469)	Nitronic 60	1	0	1
2	1185-4EN500	#1/4-20 X .500 HELICOIL (Emhart P/N 1185-4EN500)	Nitronic 60	8	0	8
1	1185-4EN375	#1/4-20 X .375 HELICOIL (Emhart P/N 1185-4EN375)	Nitronic 60	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± 0.01
 .XXX ± 0.005

ANGULAR ± 0.5°

MATERIAL: N/A FINISH: N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: COC

PART NAME: FM Optic Container

DESIGNER: ED CHAVEZ 25 JUN 2009 SIZE: D DWG. NO.: D0901299 REV.: v1

DRAFTER: ED CHAVEZ 15 JUL 2009

CHECKER: REFER TO E0900200-v1

APPROVAL: REFER TO E0900200-v1

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

D0901299 FM Optic Container, Cover Lin, PART PDM REV. X:001, DRAWING PDM REV. X:001