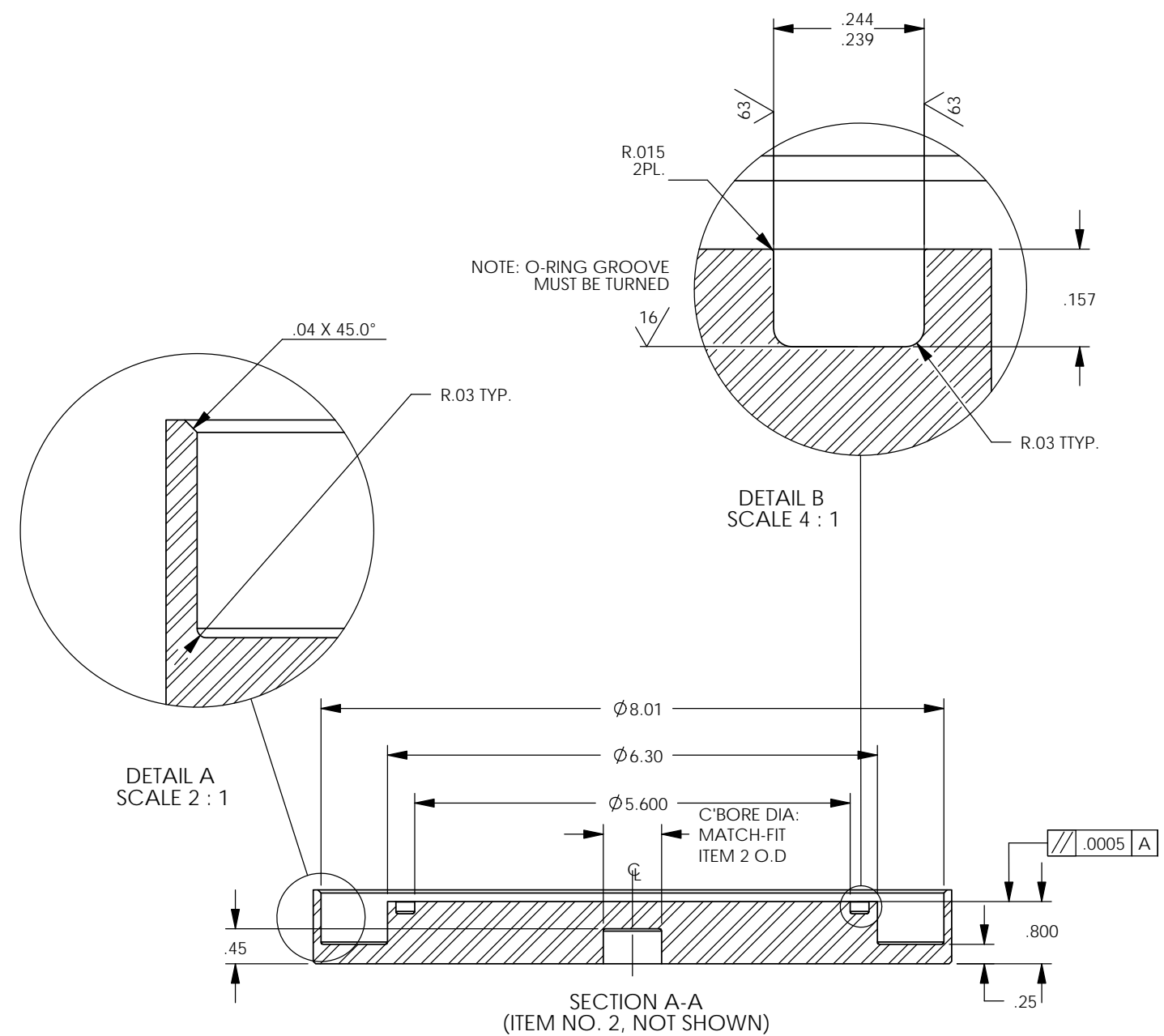
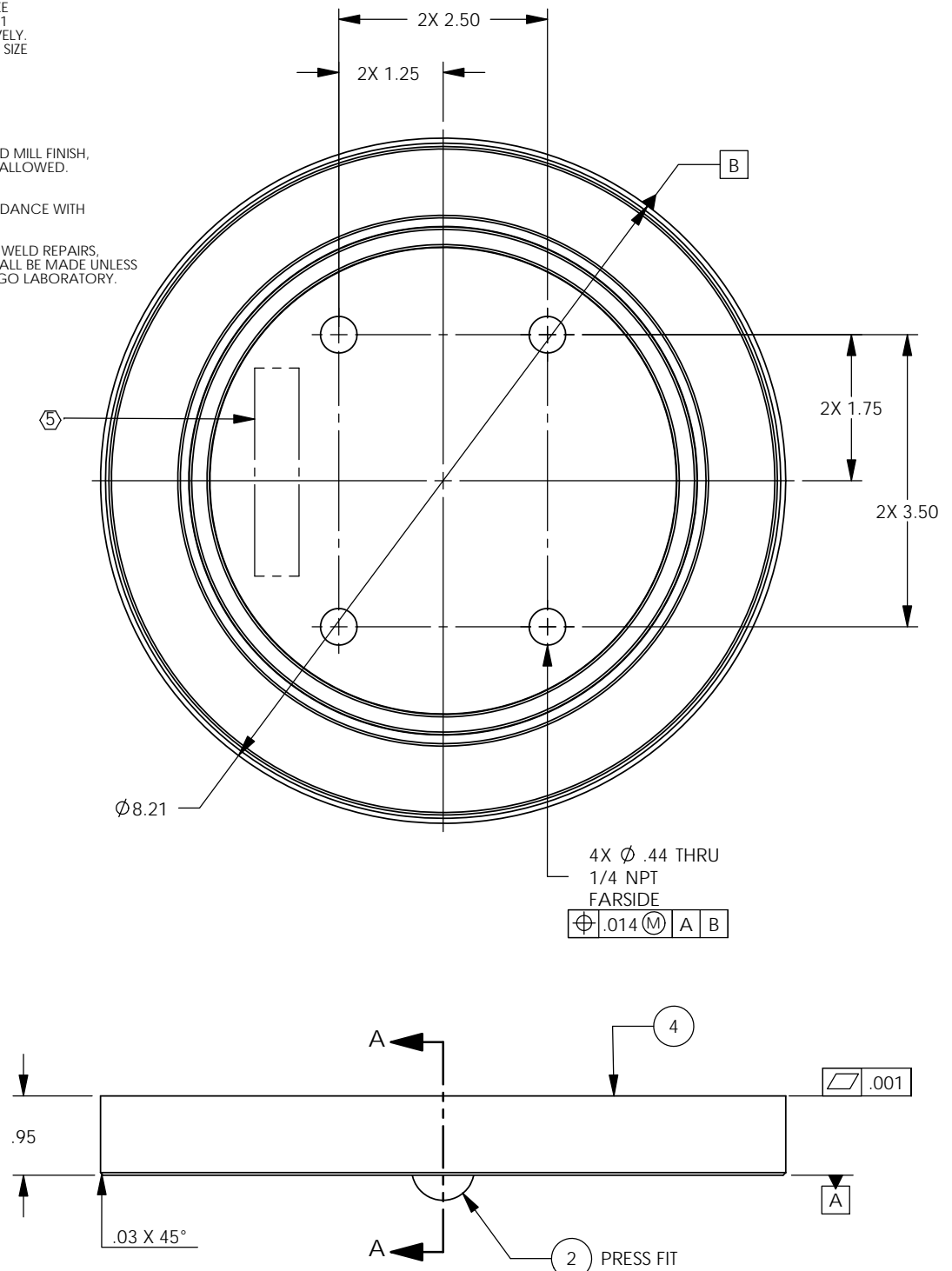


D1101936 aLIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (HQ V.P.), PART PDM REV: X-003, DRAWING PDM REV: X-001

**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 = 9.00 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.
- 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	11 OCT 2011	E1101031-x0	-
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
2	-	PRECISION BALL, .750 O.D, NITRONIC 60	Nitronic 60	1
4	D1101936-1	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (HQ V.P)	304 SSTL	1

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.5°

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 DRAWINGS.  
 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

PART NAME: ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (HQ V.P)

SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: J.LEWIS	DATE: 04 NOV 2011	SIZE: B	DWG. NO.: D1101936	REV.: v1
CHECKER: SEE DCC	SEE DCC	APPROVAL: SEE DCC	SEE DCC	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1