REV.	DATE	DCN #	DRAWING TREE #
v1	11 OCT 2011	-	-
v2	20 OCT 2011	E1101031-x0	-
-	-	-	-

NOTES CONTINUED:

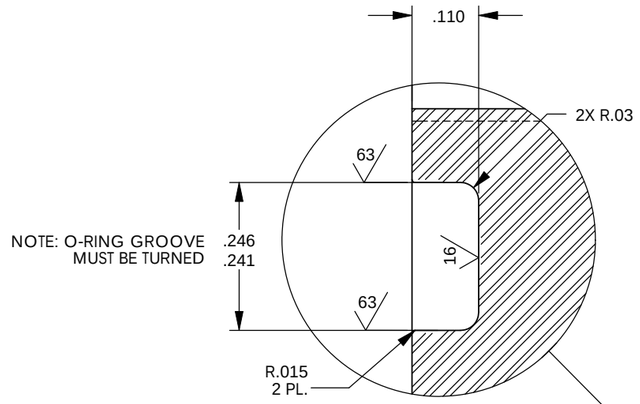
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = 33.28 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

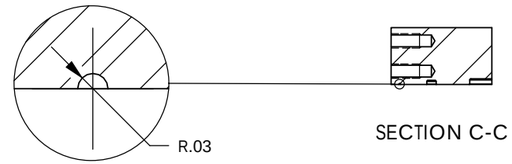
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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.



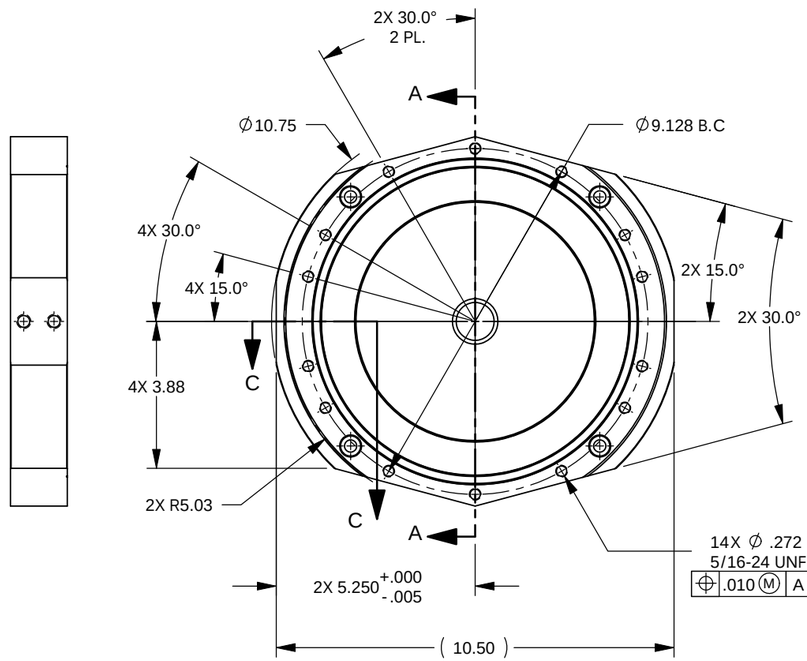
NOTE: O-RING GROOVE MUST BE TURNED

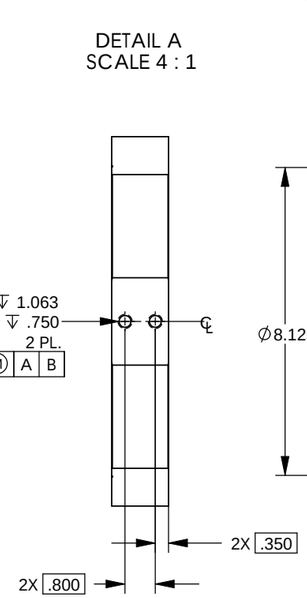
DETAIL A
SCALE 4 : 1

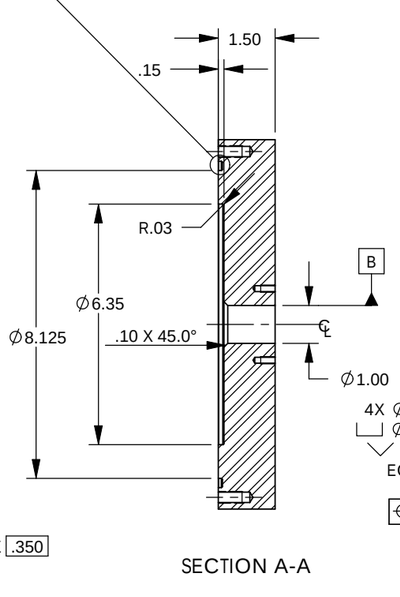


SECTION C-C

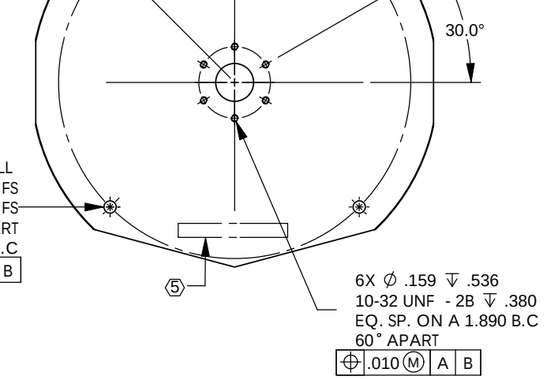
VISUAL ALIGNMENT GROOVE
(MAY BE SQ., RAD., OR 90° V)
SCALE 4 : 1
2 PLACES

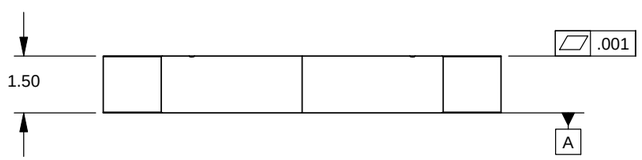






SECTION A-A





D1101937 aLIGO, AOS, VIEWPORT LEAK TEST FIXTURE, BASE PLATE, PART PDM REV: X-001, DRAWING PDM REV: X-001

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 APPROXIMATLEY R.02 FOR SHEET METAL PARTS.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL AISI 304

FINISH 63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM AOS

NEXT ASSY D1101939

PART NAME ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, BASE PLATE

DESIGNER	J.LEWIS	07 OCT 2011	
DRAFTER	E.SANCHEZ	11 OCT 2011	
CHECKER	SEE DCC	SEE DCC	
APPROVAL	SEE DCC	SEE DCC	

SIZE B **DWG. NO.** D1101937 **REV.** v2

SCALE: 1:4 **PROJECTION:** SHEET 1 OF 1