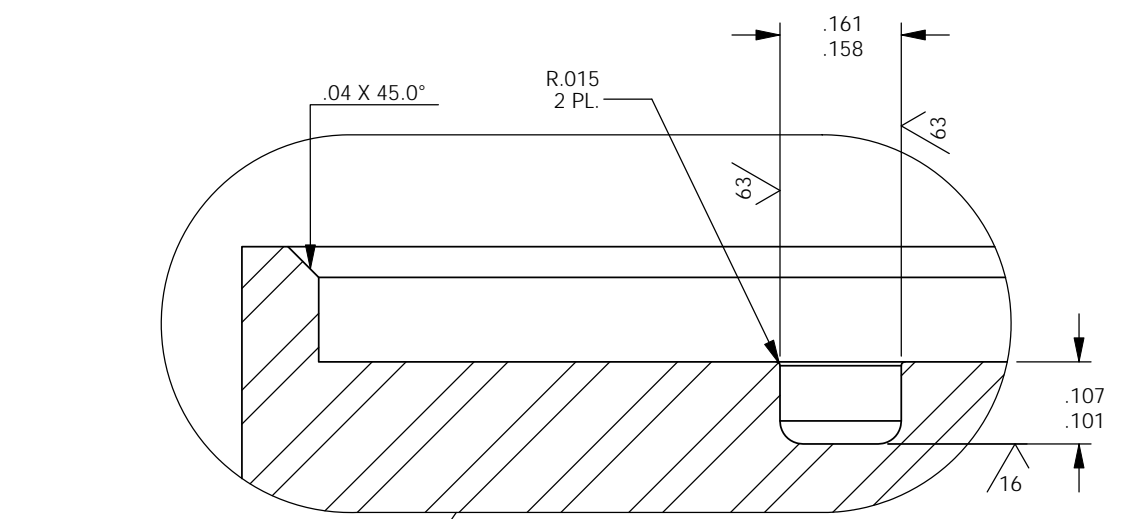
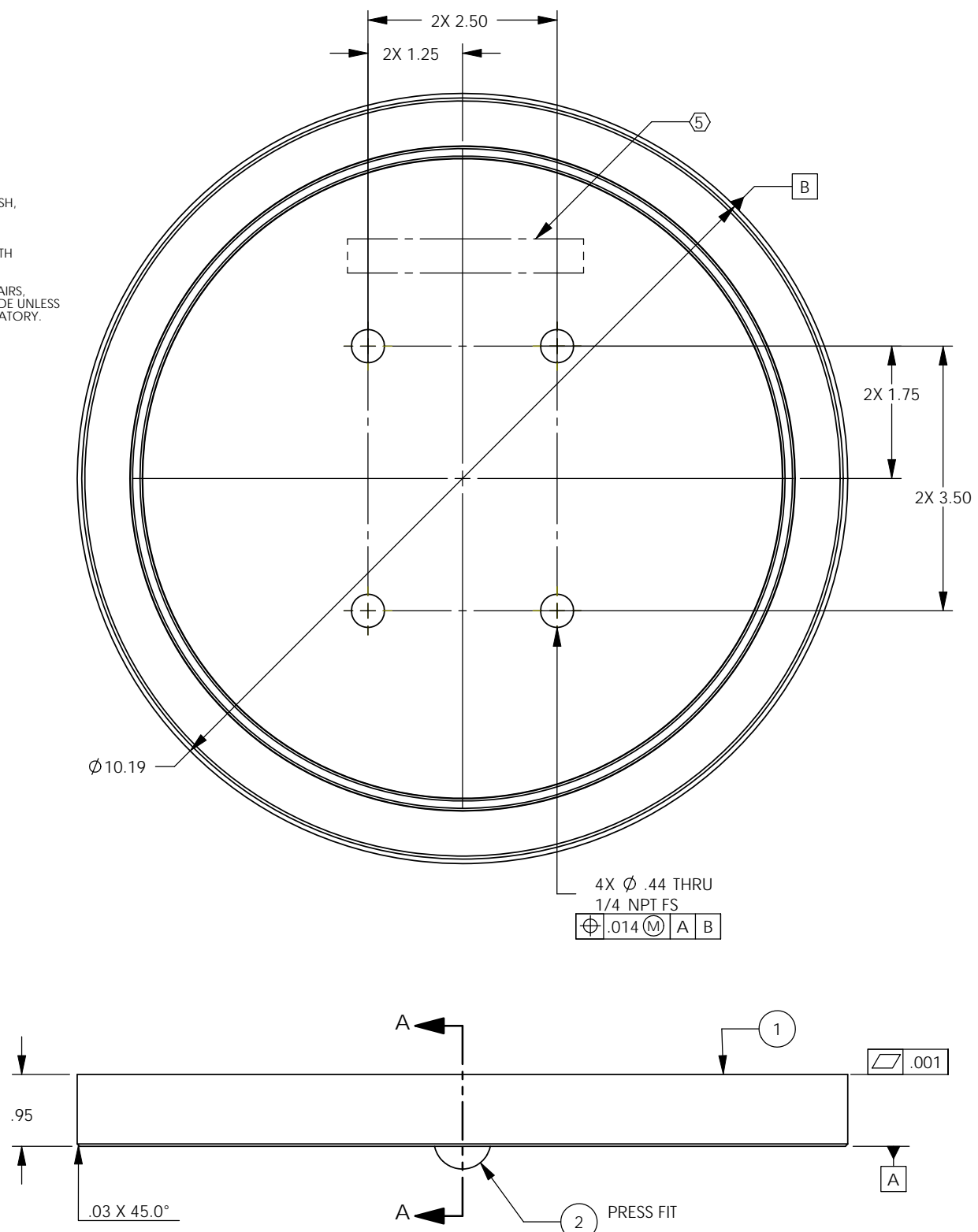


D1101964 aLIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (MDC9722012), PART PDM REV: X-000, DRAWING PDM REV: X-000

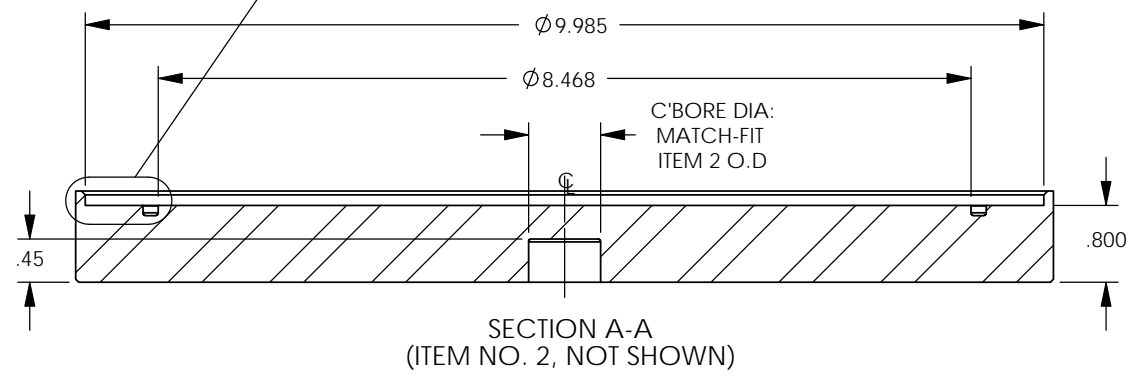
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 11.98 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	27 OCT 2011	E1101060-x0	-
-	-	-	-
-	-	-	-



DETAIL B
 SCALE 4 : 1
 NOTE: O-RING GROOVE
 MUST BE TURNED



SECTION A-A
 (ITEM NO. 2, NOT SHOWN)

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
2	-	PRECISION BALL, .750 O.D, NITRONIC 60	Nitronic 60	1
1	D1101964-1	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (MDC9722012)	AISI 304	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

ADVANCED LIGO **AOS**

PART NAME
 ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (MDC9722012)

DESIGNER J.LEWIS 07 OCT 2011 **SIZE** DWG. NO. **B**
DRAFTER E.SANCHEZ 11 OCT 2011 **D1101964**
CHECKER SEE DCC SEE DCC **v1**
APPROVAL SEE DCC SEE DCC

MATERIAL SEE PARTS LIST **FINISH** 63 μinch **NEXT ASSY** D1101940 **SCALE:** 1:2 **PROJECTION:** **SHEET 1 OF 1**