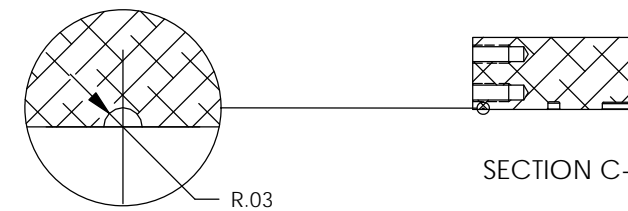
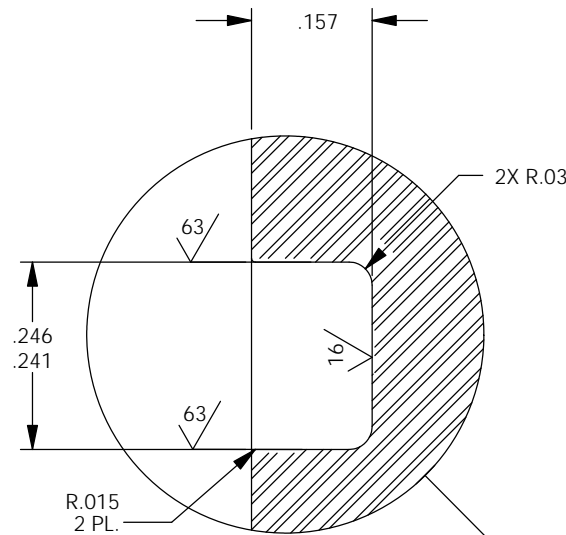


D1102155 aLIGO, AOS, SEPTUM VIEWPORT LEAK TEST FIXTURE, BASE PLATE, PART PDM REV. X-000, DRAWING PDM REV. X-002

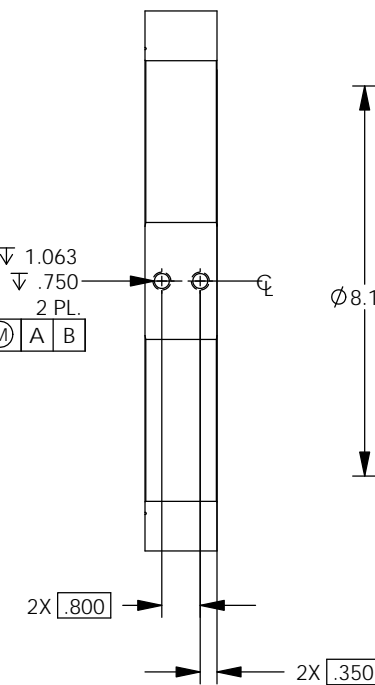
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 43.41 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.

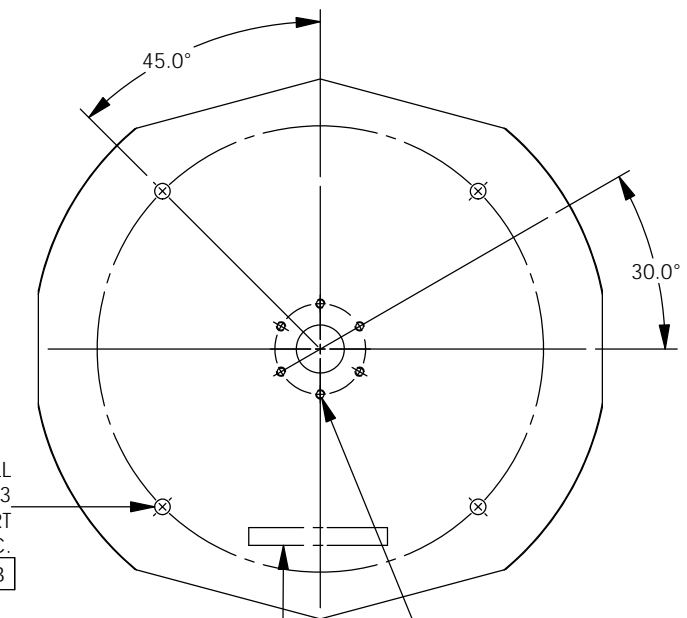
REV.	DATE	DCN #	DRAWING TREE #
v1	04 NOV 2011	-	-
v2	10 NOV 2011	E1101060-x0	-
-	-	-	-



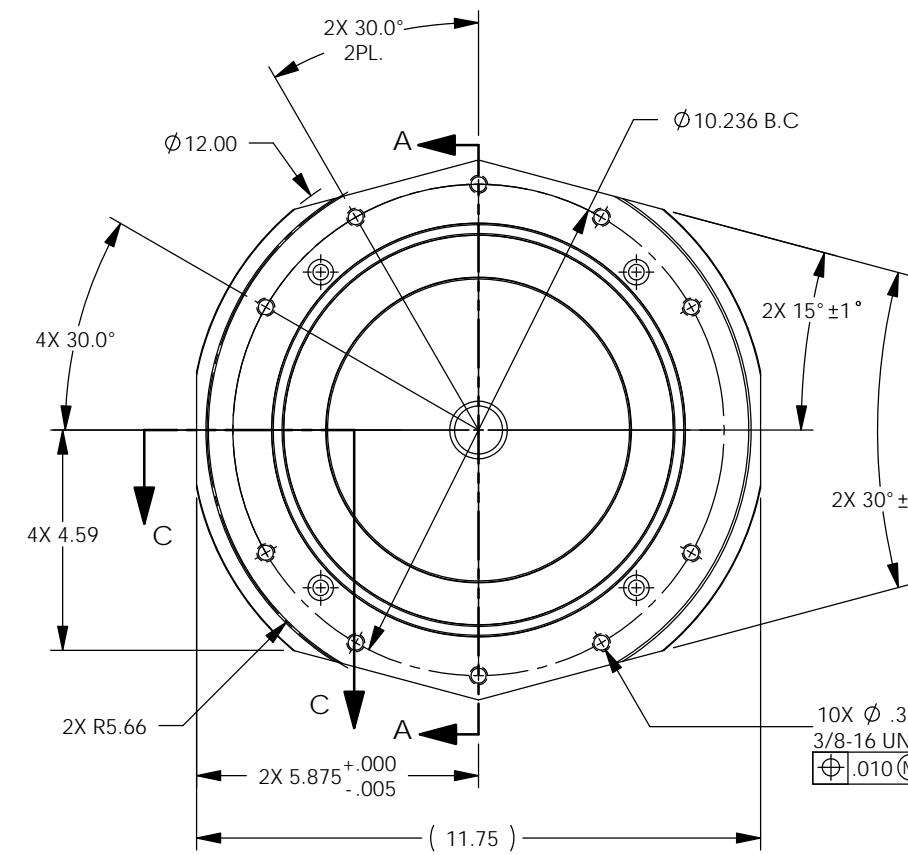
DETAIL A
SCALE 4 : 1



SECTION A-A

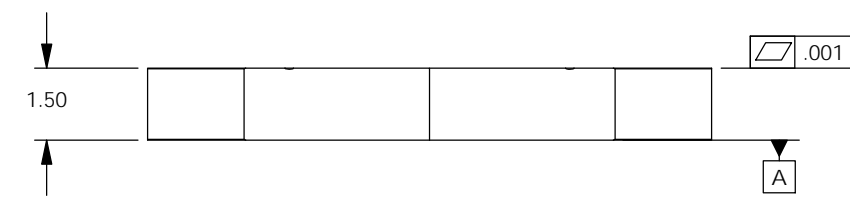


6X Ø .159 ± .536
 10-32 UNF - 2B ± .380
 EQ. SP. ON A 1.890 B.C.
 60° APART
 ⊕ .010 (M) A B



10X Ø .31 ± 1.06
 3/8-16 UNC ± .75
 ⊕ .010 (M) A B

2X Ø .313 ± 1.063
 3/8-16 UNC - 2B ± .750
 2 PL.
 ⊕ .010 (M) A B



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES: .XX ± .01 .XXX ± .005	2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
ANGULAR ± 0.5°	3. DO NOT SCALE FROM DRAWINGS.
	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
MATERIAL	304 SSSL
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM	ADVANCED LIGO	ALIGO, AOS, SEPTUM VIEWPORT LEAK TEST FIXTURE, BASE PLATE	
SUB-SYSTEM	AOS	DESIGNER	J.LEWIS 07 OCT 2011
NEXT ASSY	D1102157	DRAFTER	E.SANCHEZ 04 NOV 2011
		CHECKER	SEE DCC
		APPROVAL	SEE DCC
		SIZE	DWG. NO. D1102155
		REVISION	v2
		SCALE	1:4
		PROJECTION	ASME
		SHEET 1 OF 1	