REV.	DATE	DCN #	DRAWING TREE #
v1	11 NOV 2011	E1101060-x0	-
-	-	-	-
-	-	-	-

NOTES CONTINUED:

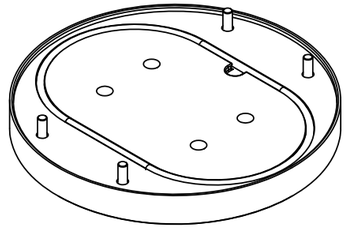
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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 = 13.75 LB.

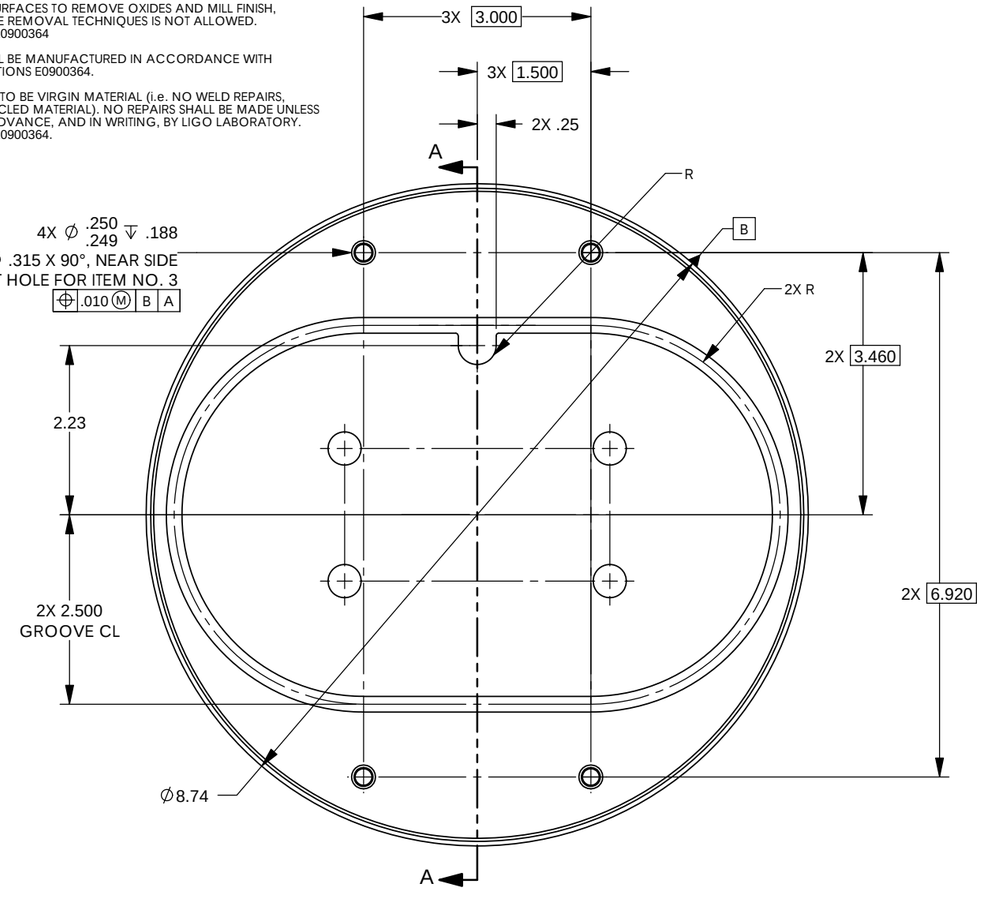
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

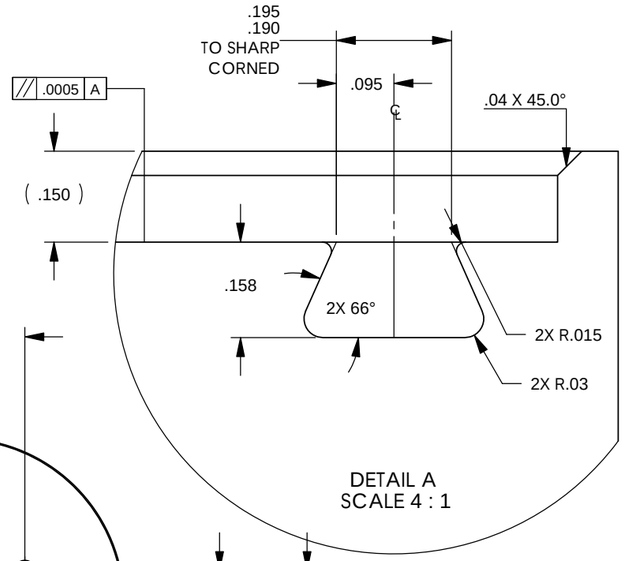
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATIONS E0900364.

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.

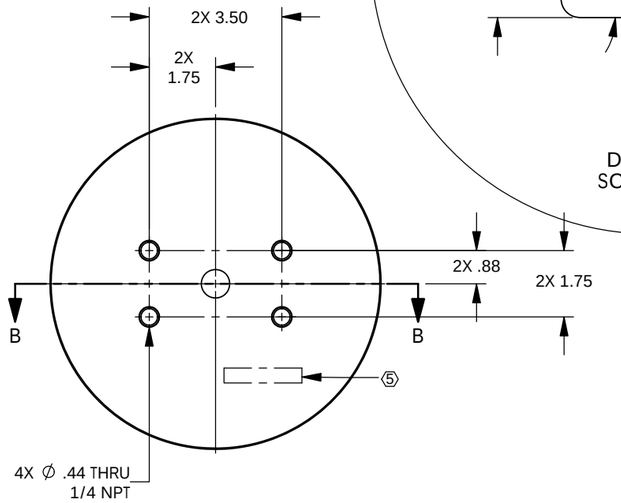


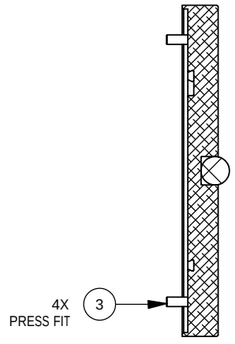
ISO VIEW
(UNDERSIDE VIEW)



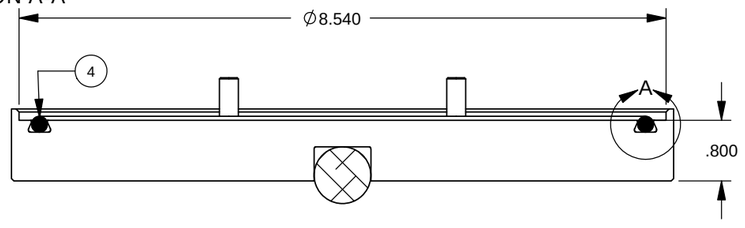


DETAIL A
SCALE 4 : 1

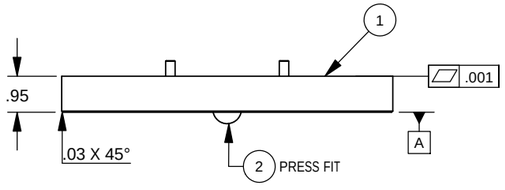




SECTION A-A



SECTION B-B
SCALE 1 : 2



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
4	PARKER NO.:2-364	O-RING. 3/16 WIDE	VITON	1
3	MS16555-646	PIN, DOWEL, .25 X .75 LG.	18-8 SSTL	4
2	-	PRECISION BALL, .750 O.D, NITRONIC 60	NITRONIC 60	1
1	D1102191-1	ALIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP (CO2P)	304 SSTL	1

PARTS LIST

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 N/A

FINISH N/A 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, PROOF TEST CAP ASSY. (CO2P VP)

DESIGNER	E.SANCHEZ	11 NOV 2011
DRAFTER	E.SANCHEZ	11 NOV 2011
CHECKER	SEE DCC	SEE DCC
APPROVAL	SEE DCC	SEE DCC

SIZE B | **DWG. NO.** D1102191 | **REV.** v1

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

D1102191 aLIGO, AOS, VIEWPORT LEAK TEST FIXTURE, PROOF TEST CAP ASSY. (CO2P), PART PDM REV: X-002, DRAWING PDM REV: X-003