NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

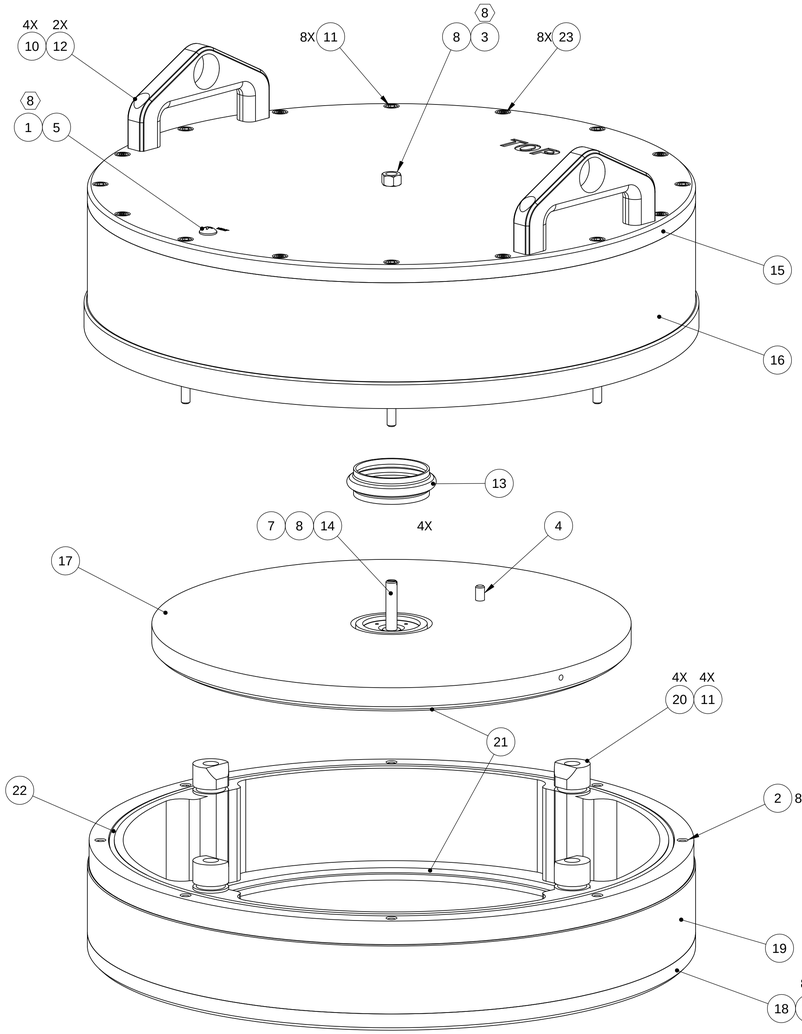
6. ESTIMATED WEIGHT FROM CAD MODEL: 58.5.9 lbs (26.5 kg)

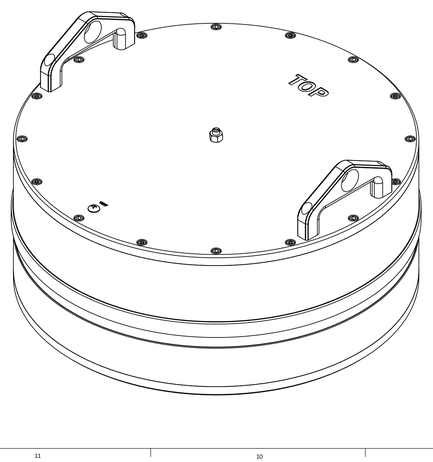
7. THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS WITH SOAP AND WATER. FOLLOW WITH SOLVENT (ACETONE) WIPE. PAY CLOSE ATTENTION TO THE TAPPED HOLES.

⑧ THE CONTRACTOR IS RESPONSIBLE FOR INSERTION OF HELI-COILS (HELICOILS ITEMS NO. 1, 2 & 3 TO BE INSTALLED INTO BASE RING, ITEM NO. 21, & COVER LID, ITEM NO. 17). EXTRA CARE SHOULD BE TAKEN ON CLEANING THE HELI-COILS AND THE HOLES PRIOR TO THE INSERTING THE HELI-COILS. (LIGO STAFF CAN HELP WITH THIS STAGE.)
   a. AFTER CLEANING THE HOLE AND HELI-COIL WITH SOAP AND WATER, AS ABOVE
   b. CLEAN THE HELI-COIL IN ACETONE AND CLEAN THE HOLE WITH ACETONE AND A BRUSH
   c. LASTLY RINSE BOTH THE HELI-COIL AND THE HOLE WITH DE-IONIZED WATER
   d. PLEASE WEAR LATEX GLOVES WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)

9. ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND CHIPS.

REV.	DATE	DCN #	DRAWING TREE #
-	-	REFER TO E0900200-v1	-
-	-	-	-
-	-	-	-





ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
23	TPA142012SP	Screw, Soc Hd Cap, w/Pin Sec. 1/4-20 x .750 (Hudson Fast #TPA142012SP)	18-8 SS	16	0	16
22	ROW Inc.	O-Ring, Base ETM, .139 Thick X 15.500 ID	Rubbber Viton	1	0	1
21	ROW Inc.	O-Ring, Supporting Optic, ETM, .275 Thick X 12.500 ID	PFA Encapsulated Viton	2	0	2
20	D0901399	Plastic Insert, Base, CP Optic Container	PFA 440 HP	4	0	4
19	D0901331	Base, Ring, CP Optic Container	6061-T6 Alum	1	0	1
18	D0901330	Base, Lid, CP Optic Container	6061-T6 Alum	1	0	1
17	D0901329	Wedge Plate, CP Optic Container	6061-T6 Alum	1	0	1
16	D0901328	Cover, Ring, CP Optic Container	6061-T6 Alum	1	0	1
15	D0901327	Cover, Lid, CP Optic Container	6061-T6 Alum	1	0	1
14	D0901320	Screw, Retaining, End Slot 5/16-18 x 1.41	17-4 SS	1	0	1
13	D0901311	Bellow, Single Convolution, Molded, Viton	Rubbber Viton	1	0	1
12	D0901064	Handle, Cover Lid, Optic Container	6061-T6 Alum	2	0	2
11	C-2072-N	Screw, Soc Hd Cap, 1/4-20 x 4.50 (UC Comp C-2072-N)	18-8 SS	8	0	8
10	C-2056-N	Screw, Soc Hd Cap, 1/4-20 x 3.50 (UC Comp #C-2056-N)	18-8 SS	4	0	4
9	C-2016-N	Screw, Soc Hd Cap, 1/4-20 x 1.00 (UC Comp #C-2016-N)	18-8 SS	4	0	4
8	94252A706	Nut, Hex, SS, 5/16-18 X 19/64, McM #94252A706	18-8 SS	1	0	1
7	91944A401	Washer, Self-Aligning, Female, 1/4-20 Screw Size, McM #91944A401	316 SSTL	1	0	1
6	91944A301	Washer, Self-Aligning, Male, 1/4-20 Screw Size, McM #91944A301	316 SSTL	1	0	1
5	91770A537	Screw, Rnd Head Phillips, 1/4-20 x .500, McM #91770A537	18-8 SS	1	0	1
4	90145A540	Pin, Dowel, Stop, Cover Lid, .25 Dia x .75, McM #90145A540	18-8 SS	1	0	1
3	1185-5EN469	#5/16-18 X .469 HELICOIL (Emhart P/N 1185-5EN469) ⑧	Nitronic 60	1	0	1
2	1185-4EN500	#1/4-20 X .500 HELICOIL (Emhart P/N 1185-4EN500) ⑧	Nitronic 60	8	0	8
1	1185-4EN375	#1/4-20 X .375 HELICOIL (Emhart P/N 1185-4EN375) ⑧	Nitronic 60	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± 0.01
.XXX ± 0.005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL: N/A

FINISH: N/A µinch

NEXT ASSY:

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: COC

PART NAME: CP Optic Container

DESIGNER	ED CHAVEZ	30 JUN 2009
DRAFTER	ED CHAVEZ	16 JUL 2009
CHECKER	REFER TO E0900200-v1	
APPROVAL	REFER TO E0900200-v1	

SIZE: D

DWG. NO.: D0901332

REV.: v1

SCALE: 1:4

PROJECTION:

SHEET 1 OF 1

D0901332 CP Optic Container, Cake Tin, PART PDM REV. X-002, DRAWING PDM REV. X-006