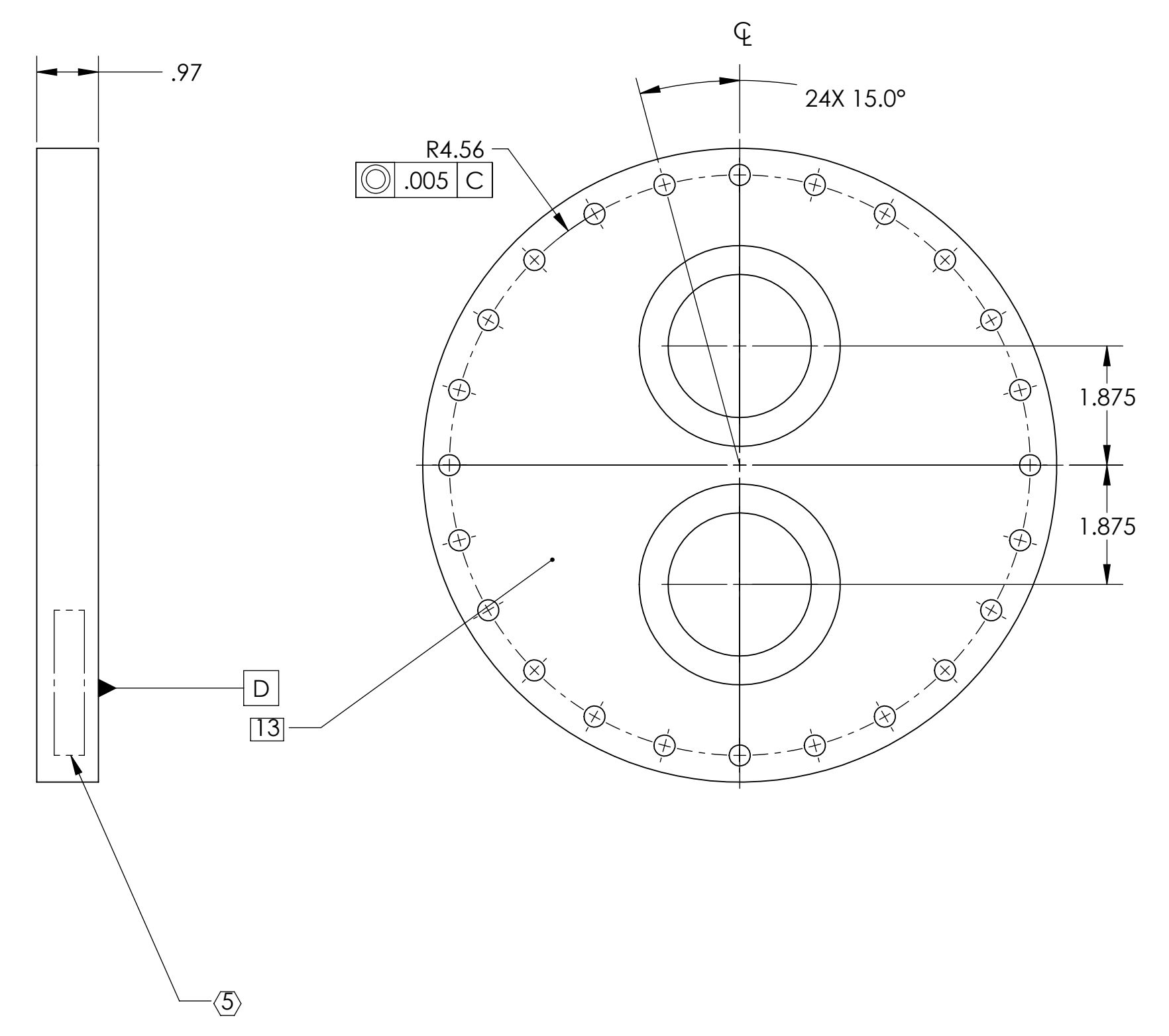
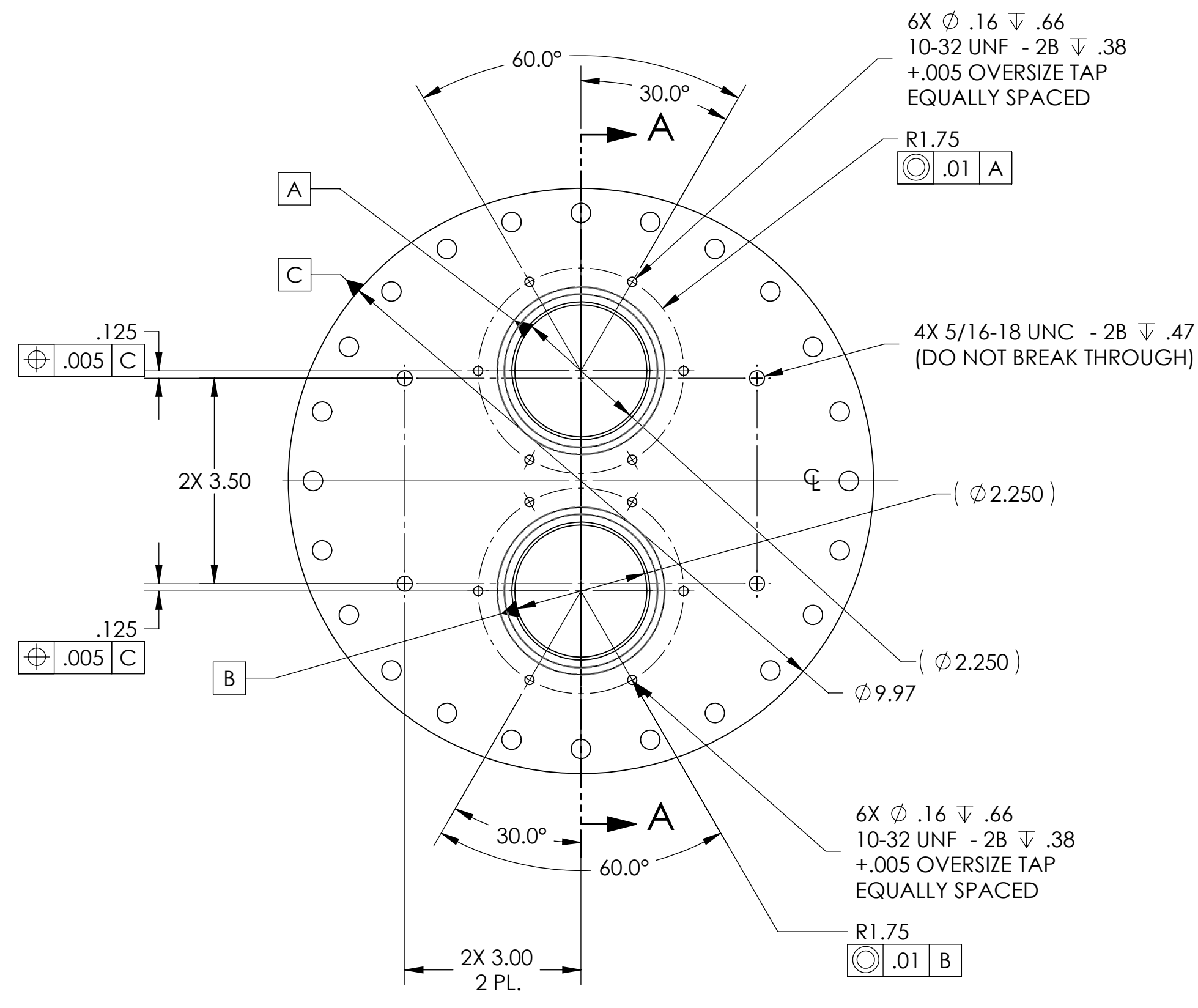
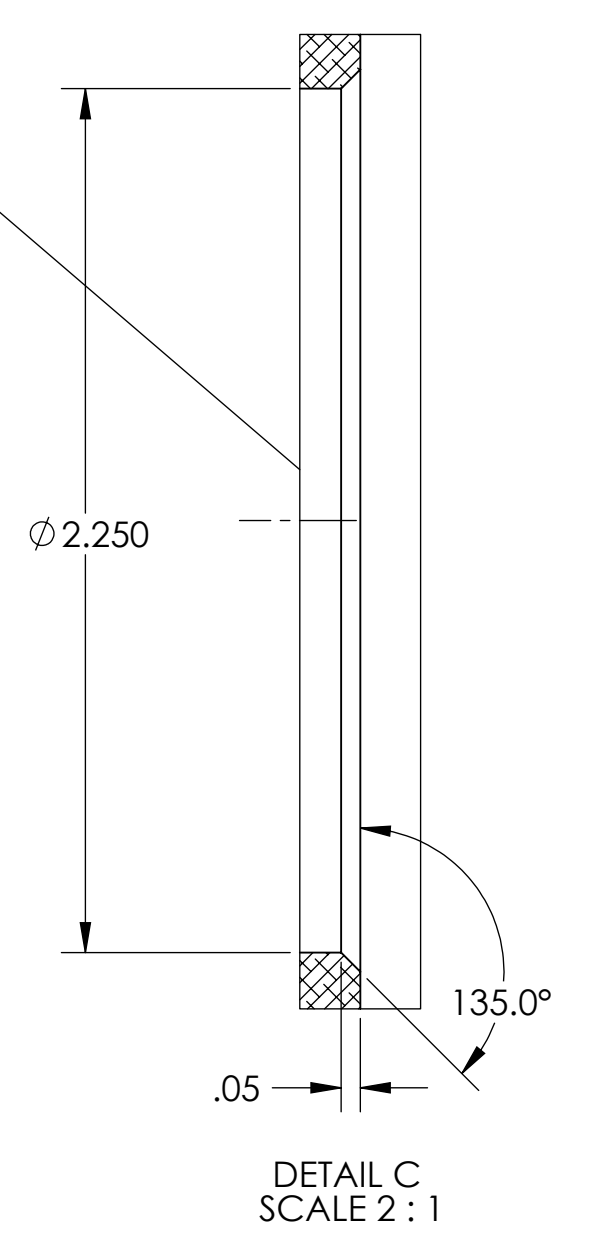
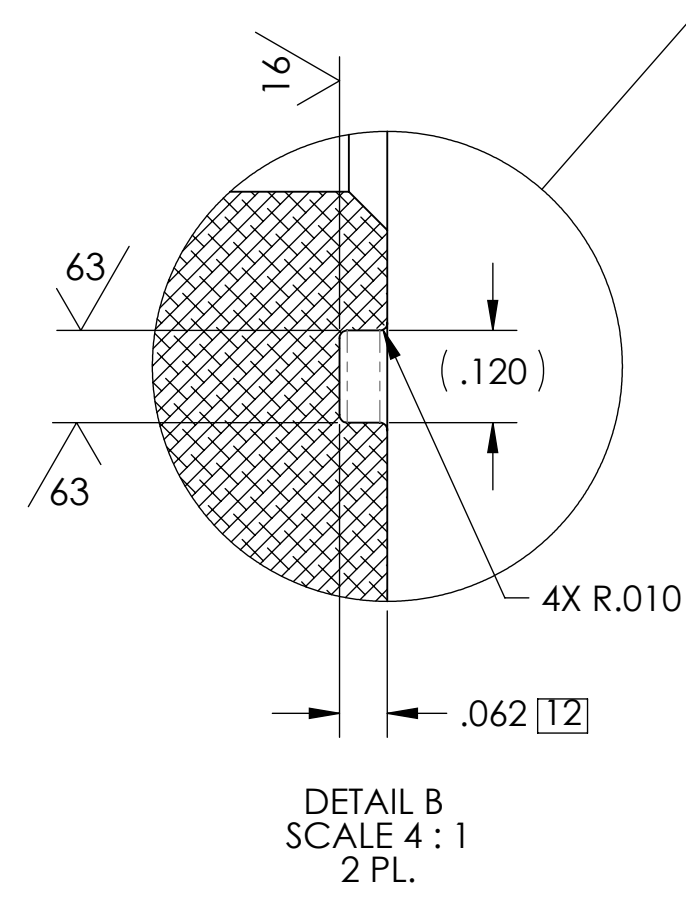
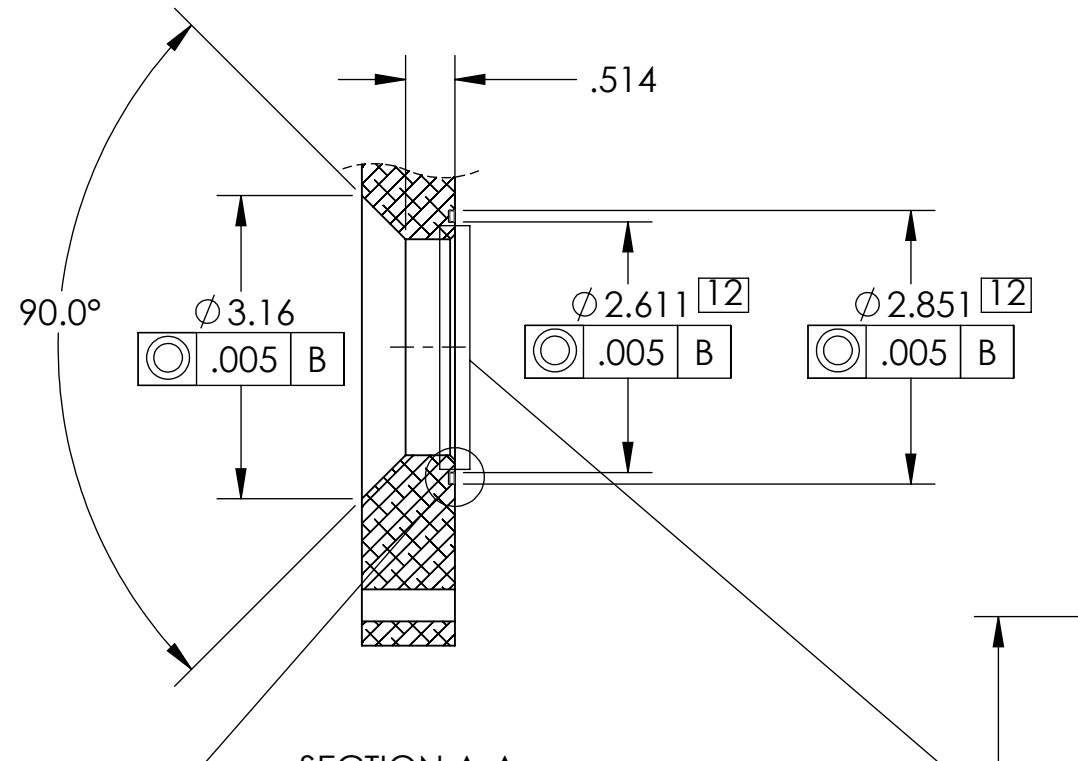
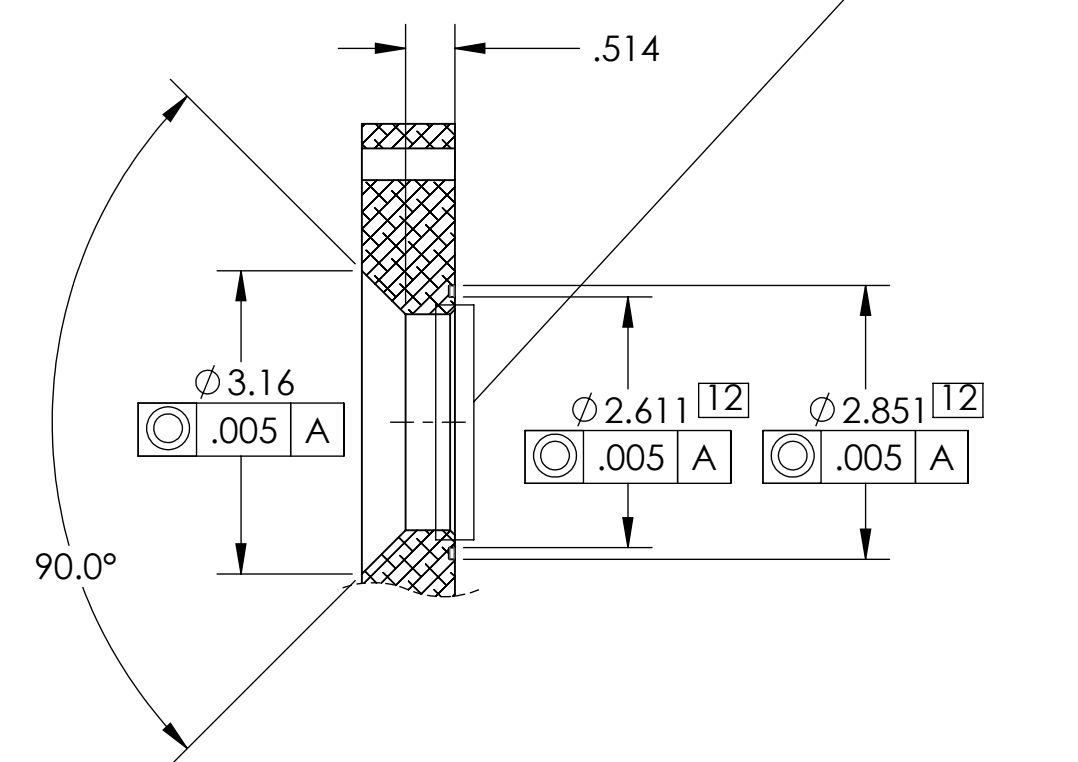
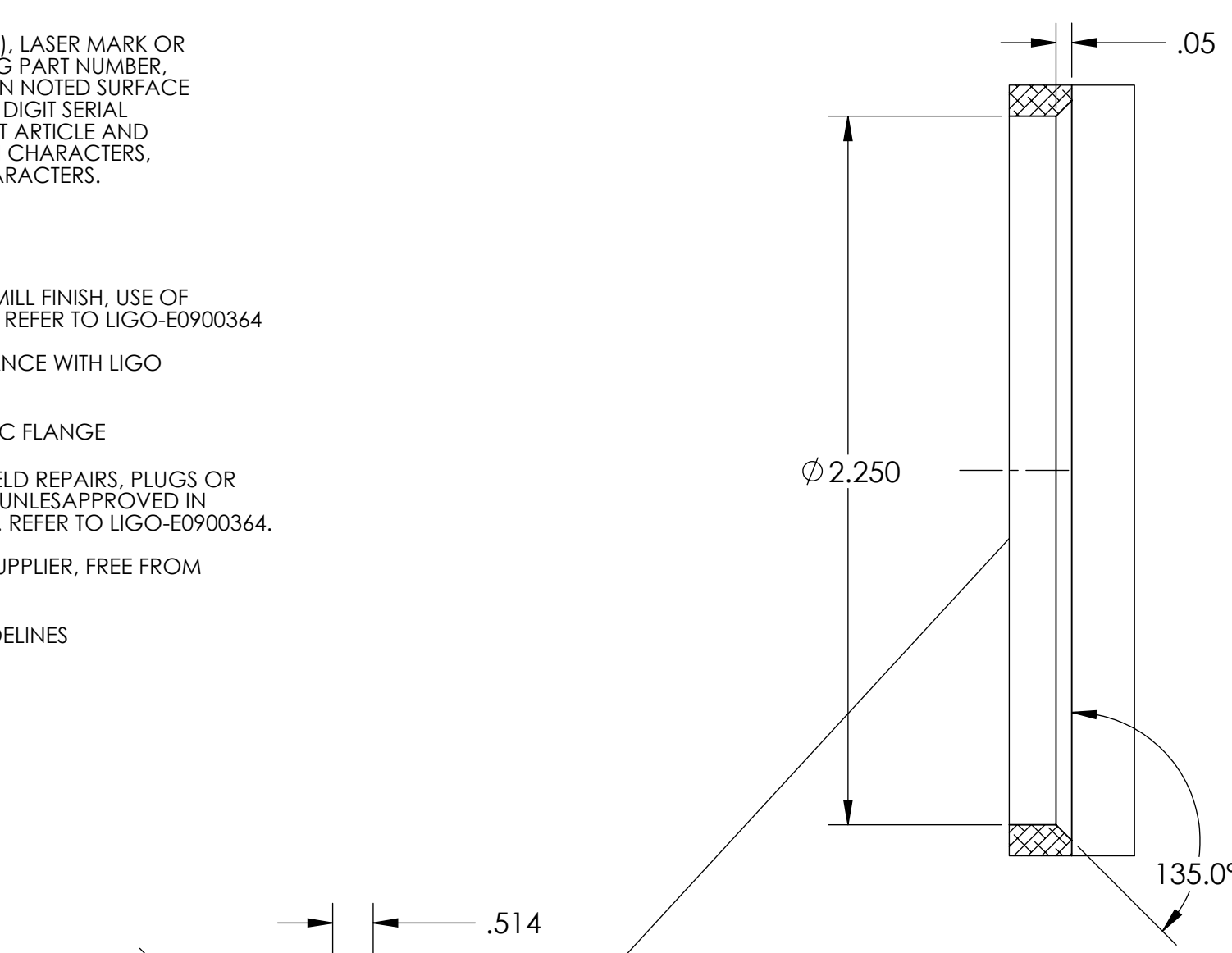


- NOTES CONTINUED:**
- 5 SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 8.352 LBS.
 - 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 PART TO BE MACHINED FROM BLANK 10" OD CF MDC FLANGE
 - 10 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.
 - 11 SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - 12 REFER TO LIGO-T1100346 FOR FEATURE DESIGN GUIDELINES
 - 13 CONFLAT SURFACE OF MDC BLANK FLANGE

REV.	DATE	DCN #	DRAWING TREE #
v2	10 JUL 2011	E1100655-v1	E1100656-v1
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
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 DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				ADVANCED LIGO		TCS 10-IN CUSTOM VP FLANGE	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				MATERIAL: 304 SSSL 9 FINISH: 63 μinch		DESIGNER: A. COLE 02 DEC 2010 DRAFTER: A. LANGLEY 22 MAR 2011 CHECKER: M. JACOBSON 20 JUL 2011 APPROVAL: P. WILLEMS 10 JUL 2011	
				SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS NEXT ASSY: D1003194		SIZE: D DWG. NO.: D1003196 SCALE: 1:2 PROJECTION:	
						REV. v2 SHEET 1 OF 1	

D1003196.dwg TCS 10-In Custom Viewport Flange, PART PDM REV: X-001, DRAWING PDM REV: X-007