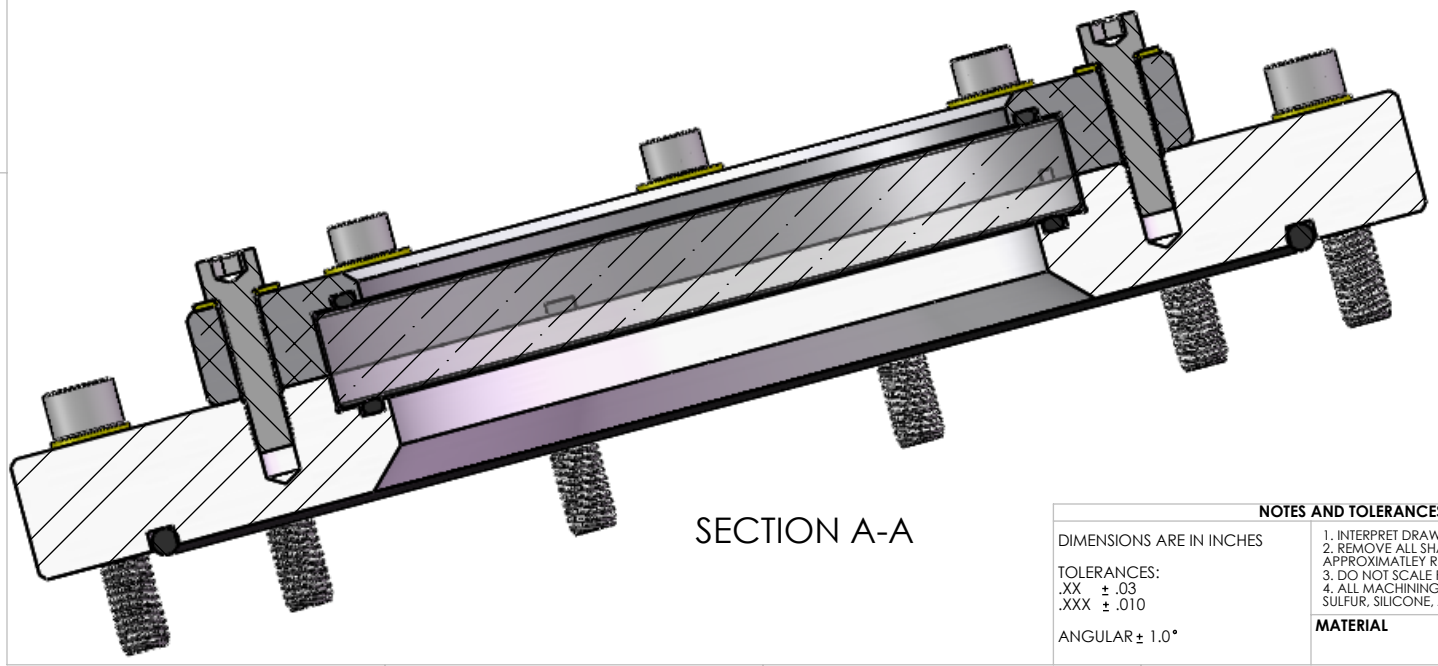
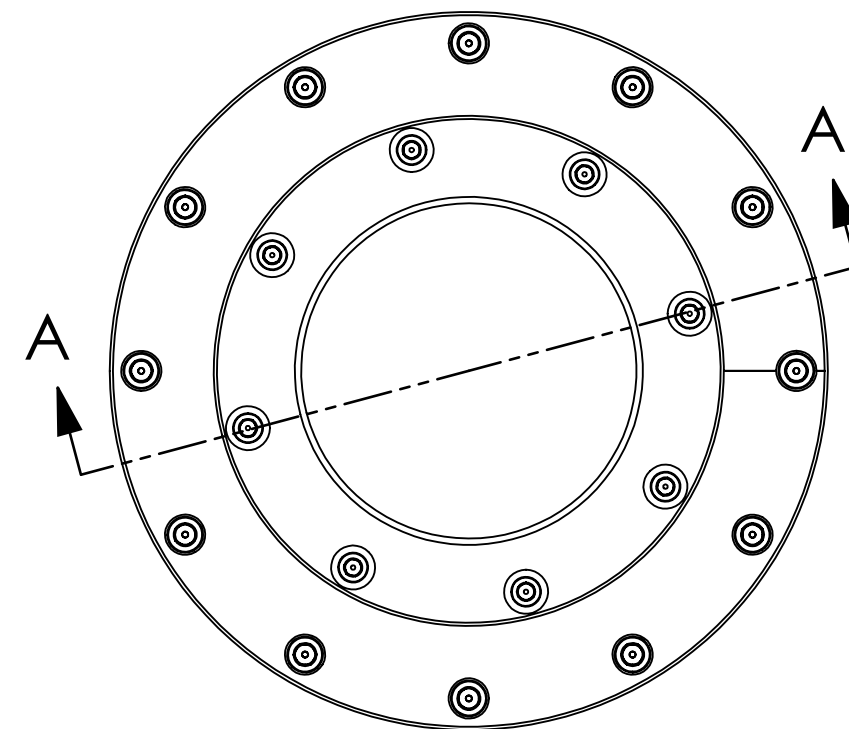
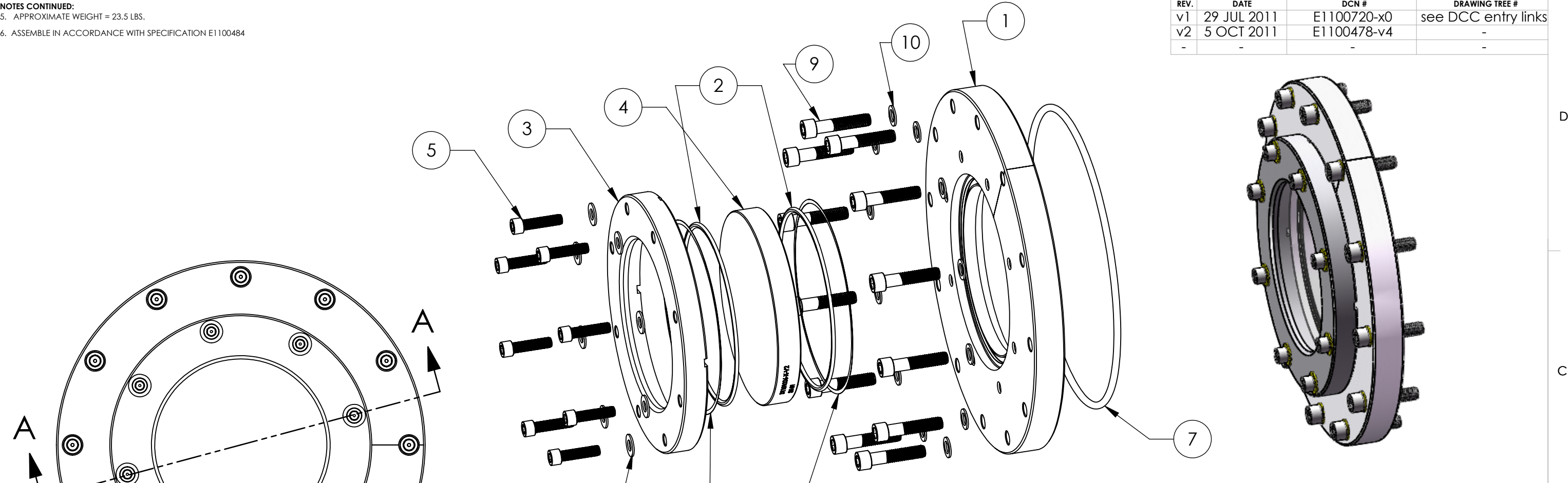


8 7 6 5 4 3 2 1

NOTES CONTINUED:
 5. APPROXIMATE WEIGHT = 23.5 LBS.
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484

REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUL 2011	E1100720-x0	see DCC entry links
v2	5 OCT 2011	E1100478-v4	-
-	-	-	-

D1101535 aLIGO Septum Viewport Assy non-wedged, PART PDM REV: X-003, DRAWING PDM REV: X-003



ITEM NO.	PART NUMBER	QTY.
1	D1101117 aLIGO Septum Viewport Flange	1
2	Parker O-Ring #2-253, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent. O-Rings must match-must be from the same lot/batch.	2
3	D1101002 aLIGO, high quality, 6in Viewport Clamp	1
4	D1101006-1 aLIGO, high quality, non-wedged, 6in Viewport, Optic AR1064/532	1
5	5/16-24 UNF x 1.25", Vented, Silver Plated SS, UC Components #C-3120-A or equivalent	8
6	5/16" FLAT WASHERS, NAS 1149-C0563-A (OR EQUIV.)	8
7	Parker O-Ring #2-373, Viton(R) Fluorocarbon (KFM), 75 Shore A or equivalent	1
8	D1003207 aLIGO, high quality, 6in Viewport, Viewport Spacer	2
9	3/8-16 UNC x 1.75", SHCS, Vented, Silver plated SS, UC Components #C-1628-A or equivalent	12
10	3/8" Flat washer, NAS 1149-C0663R or equivalent	12

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .03
 .XXX ± .010
 ANGULAR ± 1.0°

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.

MATERIAL N/A FINISH N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME aLIGO Septum Viewport Assy, non-wedged AR1064/532

DESIGNER	Dennis Coyne	29 JUL 2011	SIZE	DWG. NO.	REV.
DRAFTER	Dennis Coyne	29 JUL 2011	B	D1101535	v3
CHECKER	Mike Smith	29 JUL 2011	SCALE	1:4	PROJECTION:
APPROVAL	See DCN	See DCN	SHEET	1 OF 1	

8 7 6 5 4 3 2 1