

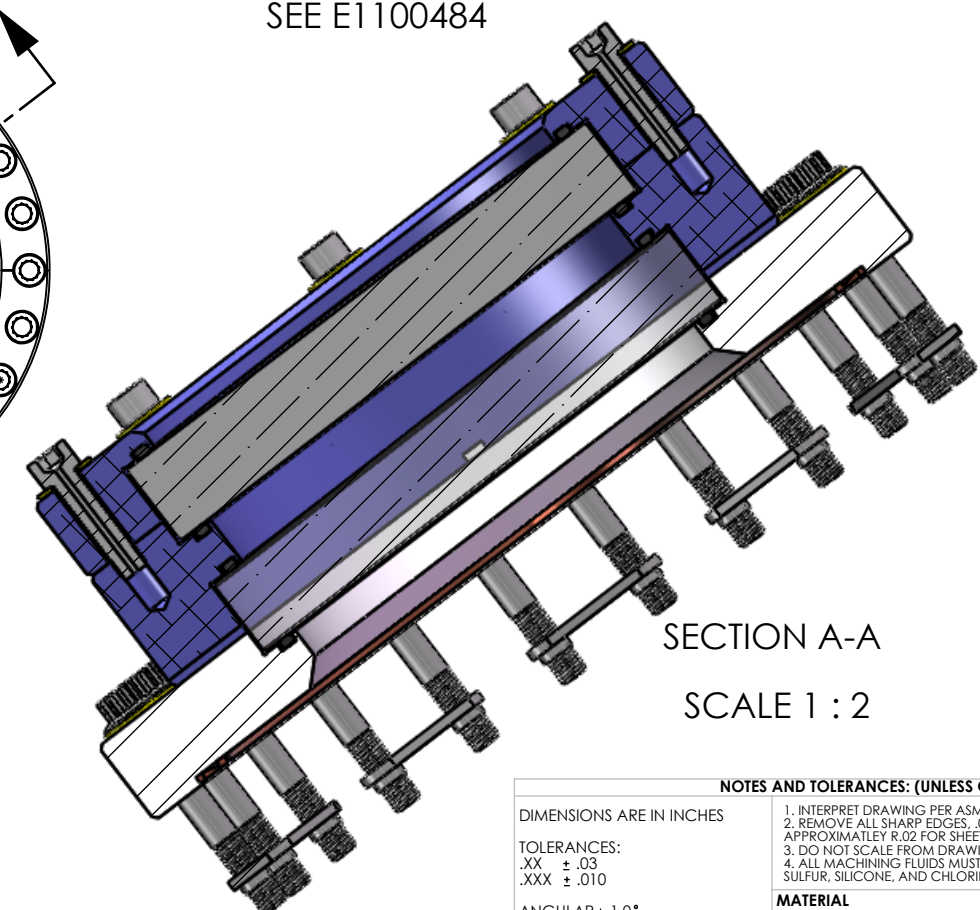
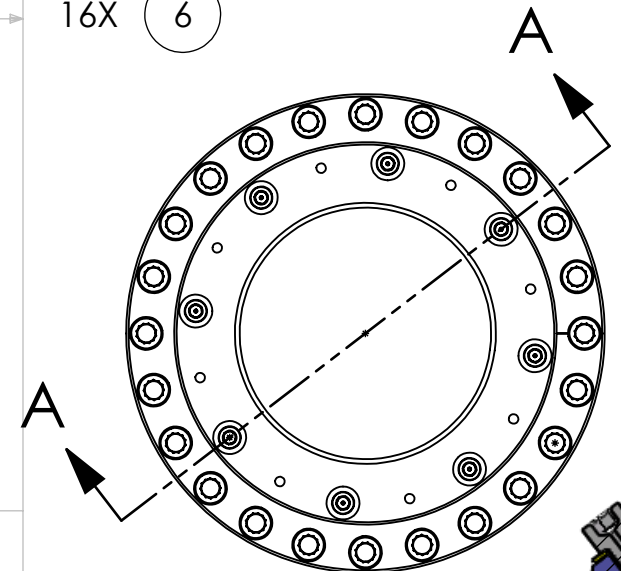
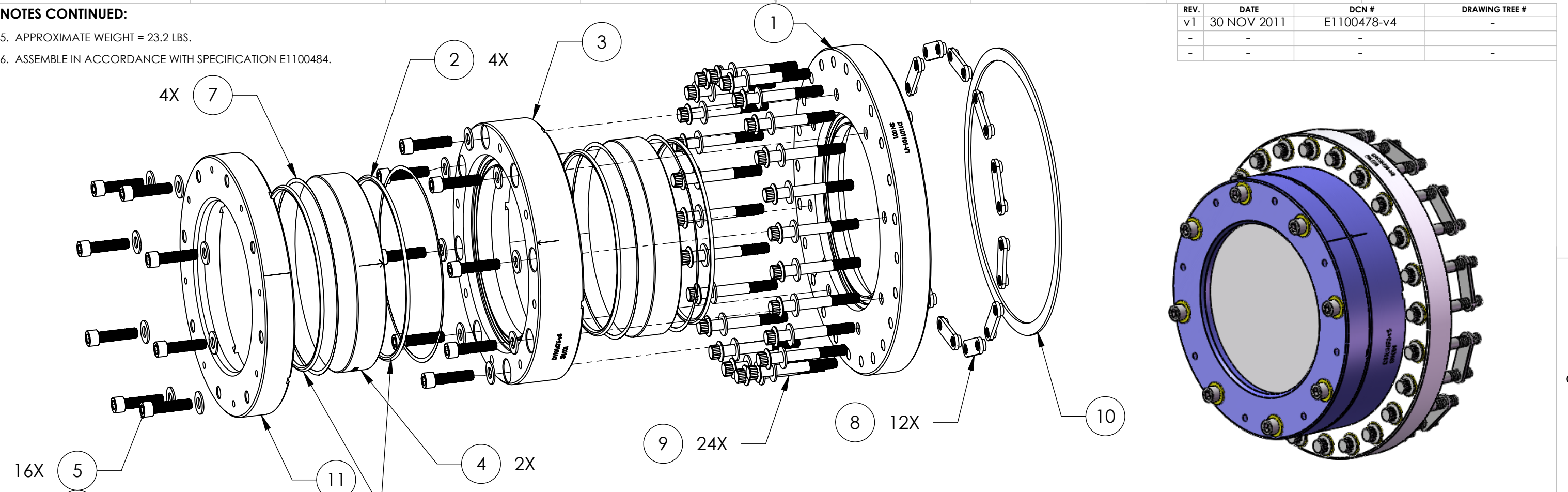
NOTES CONTINUED:

5. APPROXIMATE WEIGHT = 23.2 LBS.

6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

REV.	DATE	DCN #	DRAWING TREE #
v1	30 NOV 2011	E1100478-v4	-
-	-	-	-
-	-	-	-

D1101714 ALIGO HIGH POWER WEDGED 6IN VIEWPORT ASSY, PART PDM REV: X-017, DRAWING PDM REV: X-017



ITEM NO.	PART NUMBER	QTY.
1	D1101001 aLIGO, High quality, 6in 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.	4
3	D1101676, ALIGO, high power, Wedged, 6in Clamp	1
4	D1101005 ALIGO, High quality, Wedged 6in viewport, Optics	2
5	5/16-24 UNF x 1.25", Vented, Silver Plated SS, UC Components, #C-3120-A (or Equivalent)	16
6	5/16" FLAT WASHER, NAS 11149-C0563R (or Equivalent)	16
7	D1003207 aLIGO, High quality, 6in viewport, Viewport spacer	4
8	Nut plates, 10" Cnflat, Nor-Cal NP-800 (or Equivalent)	12
9	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt, and Washers MDC Kit #190067 (qty 25) or equivalent, discard nut.	24
10	Copper Gasket, 10" Conflat, MDC #191019 (or Equivalent)	1
11	D1101710 ALIGO, High power, Wedged, 6in Coverglass Clamp	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .03
 .XXX ± .010
 ANGULAR ± 1.0°

MATERIAL: N/A
 FINISH: N/A μinch

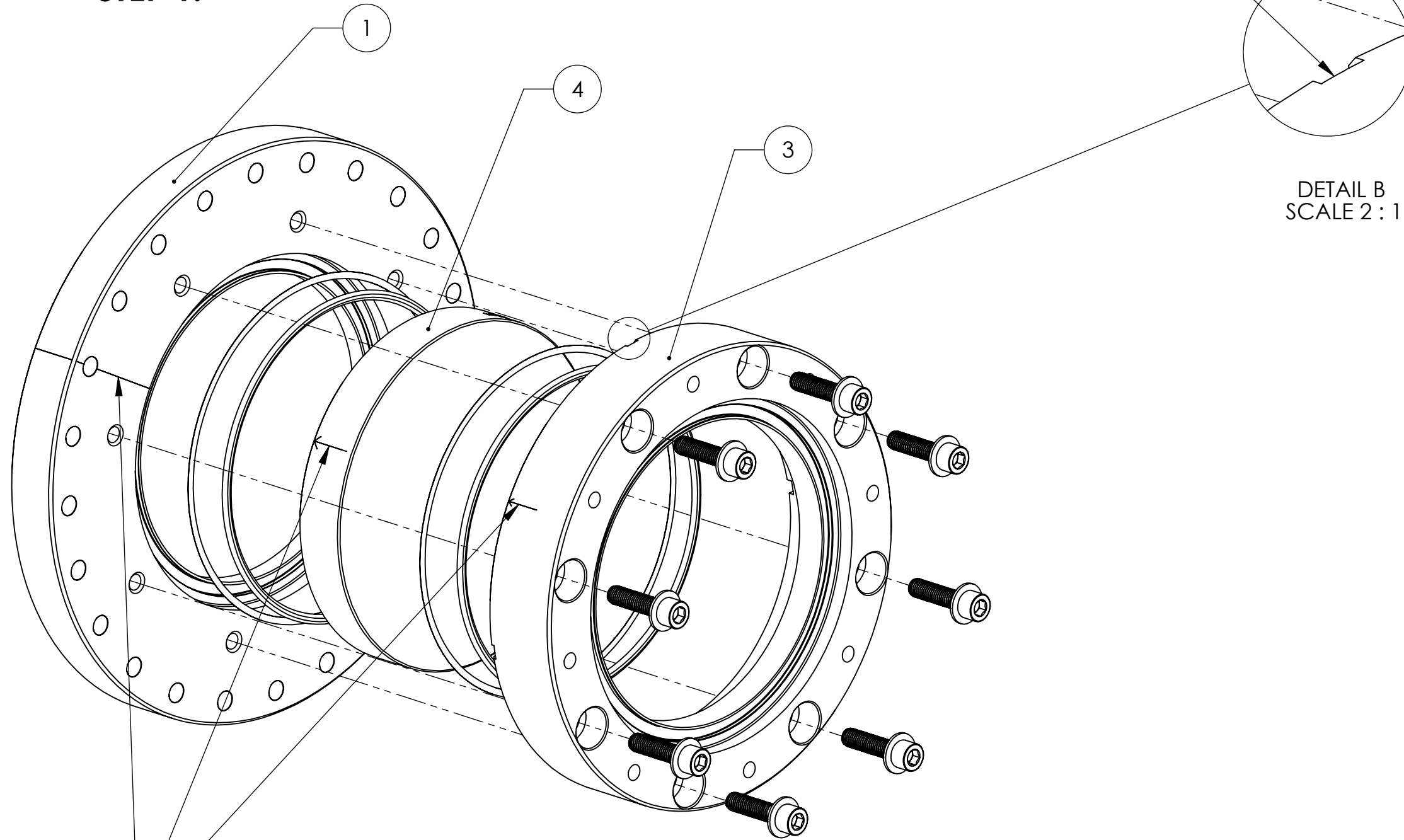
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

UNIVERSITY OF FLORIDA CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME High Quality, Wedged, 6in Viewport Assy	
	DESIGNER: J. GLEASON DRAFTER: D. KUMAR CHECKER: L. AUSTIN APPROVAL: M. SMITH	DATE: 30 May 2011 DATE: 28 OCT 2011 DATE: 16 DEC 2011 DATE: 16 DEC 2011
SYSTEM: ADVANCED LIGO SUB-SYSTEM: SLC NEXT ASSY:	SCALE: 1:3 PROJECTION:	REV. v3 SHEET 1 OF 3

STEP 1:

VENT CHANNELS IN CLAMP SHOULD
FACE THE VIEWPORT FLANGE
4 PLACES

DETAIL B
SCALE 2 : 1

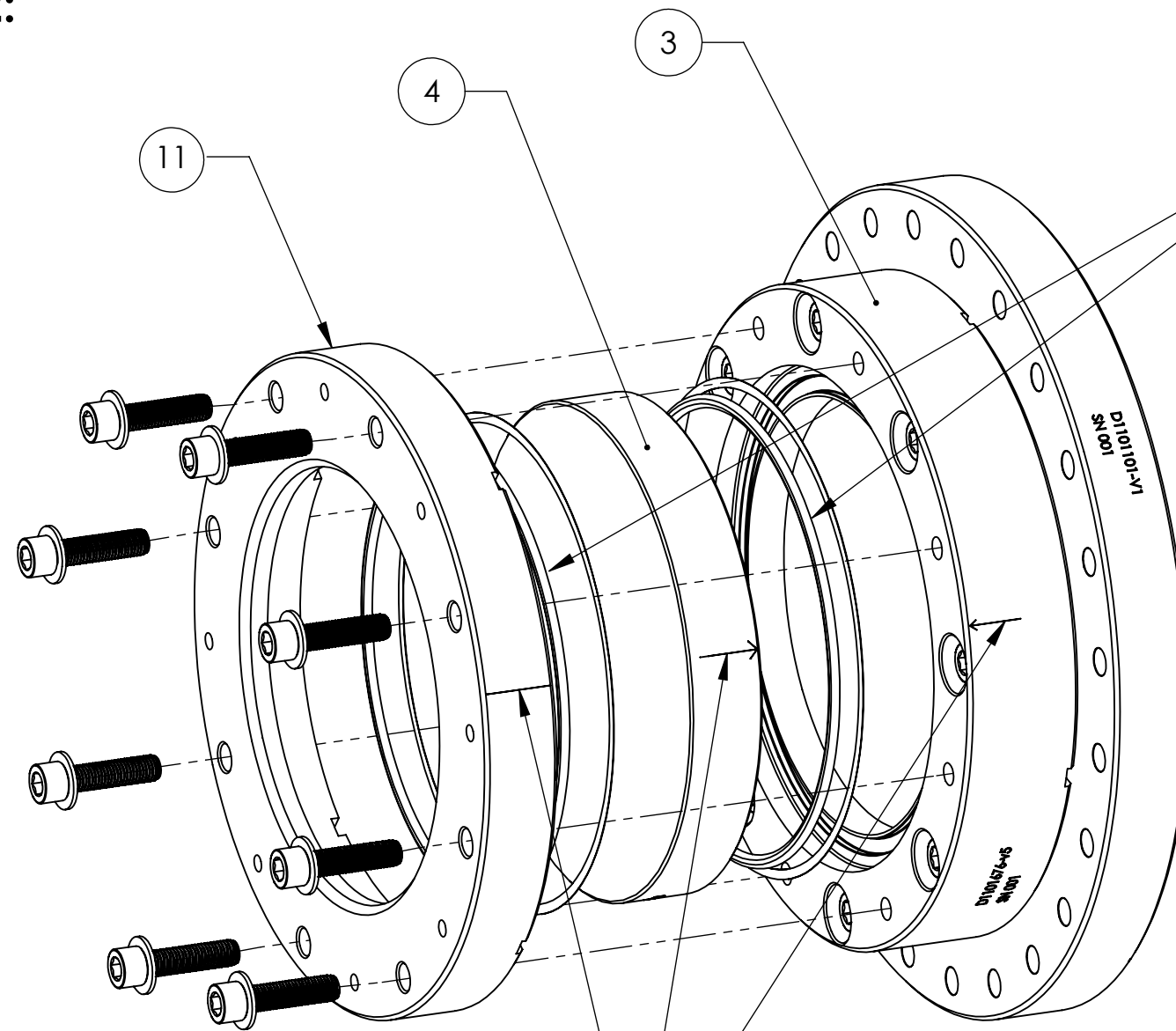


THE ARROWS ON PARTS (3) AND (4) INDICATED (VIEWPORT CLAMP AND VIEWPORT OPTIC)
ALIGNED WITH THE SCRIBE ON PART (1) (VIEWPORT FLANGE) SHOULD POINT TOWARD THE FLANGE.

D1101714 ALIGO HIGH POWER WEDGED 6IN VIEWPORT ASSY, PART PDM REV: X-017, DRAWING PDM REV: X-017

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1101714	REV. v3
SCALE: 1:3	PROJECTION: 	SHEET 2 OF 3

STEP 2:



COVERGLASS O-RINGS TO BE CUT 2 PLACES
180 DEGREES APART FOR VENTING
SEE E1100484

THE SCRIBE ON PART (11) (COVERGLASS CLAMP) SHOULD BE ALIGNED
WITH THE ARROW ON PART (3) (VIEWPORT CLAMP) THAT IS POINTING
TOWARD PART 10. THE ARROW ON PART (4) (COVERGLASS) SHOULD BE
ALIGNED WITH AND POINTING TOWARDS THE ARROW ON PART (3).