

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

THIS REQUIRES STRIKE OUT OF THE PART IDENTIFIERS "D1101002-v3" "SN 00X"

6 APPROXIMATE WEIGHT = 1.6 LB

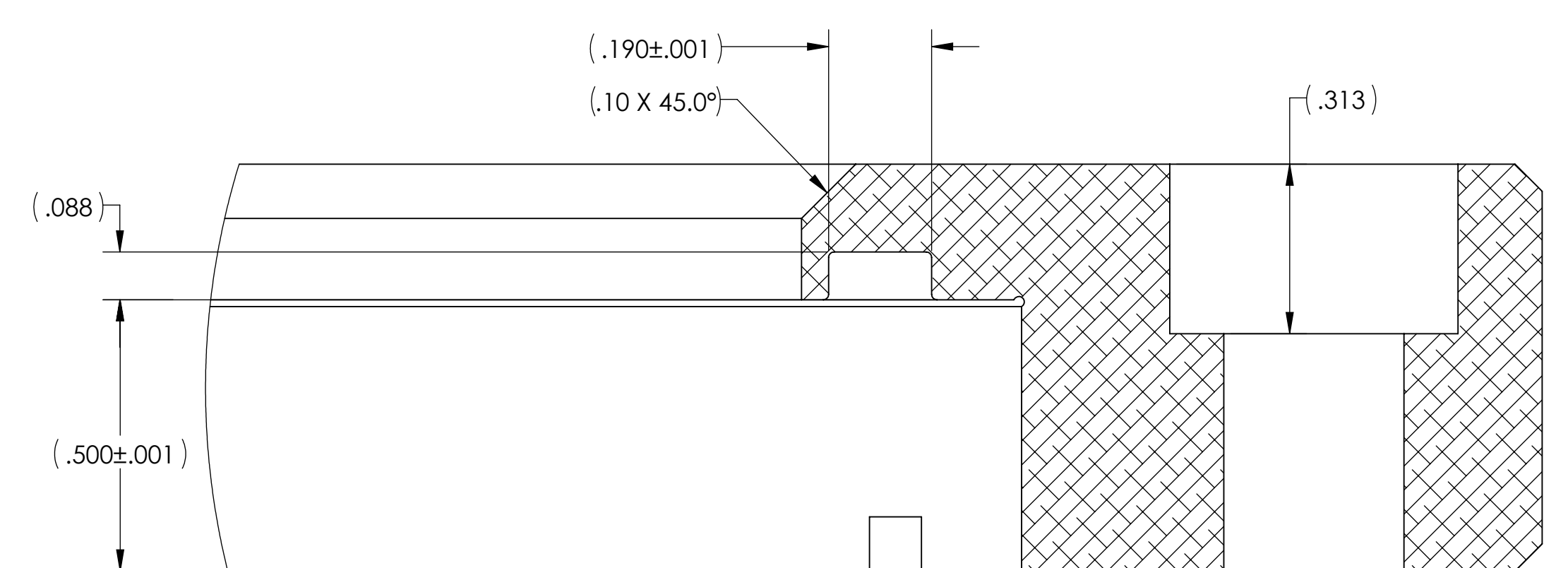
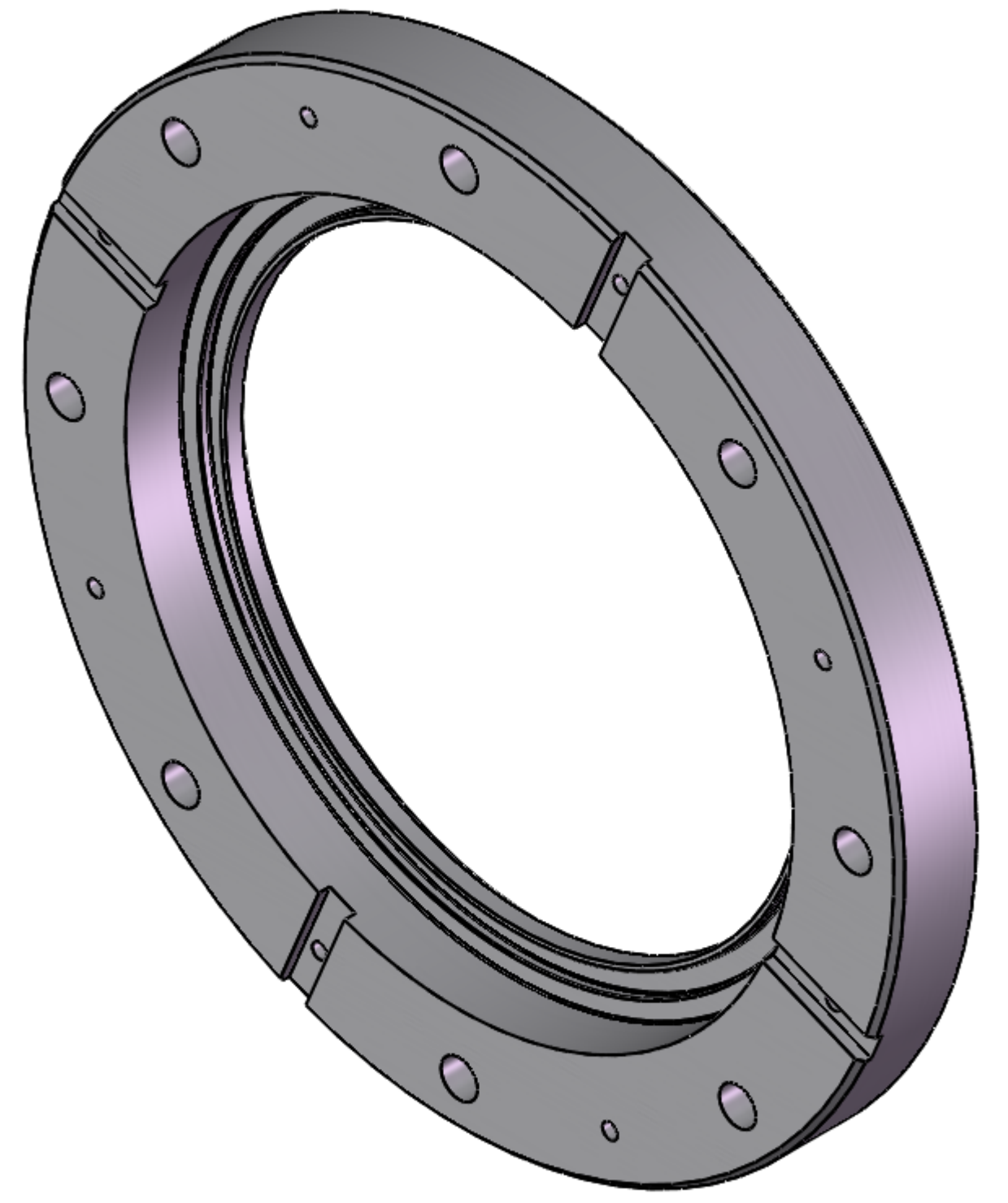
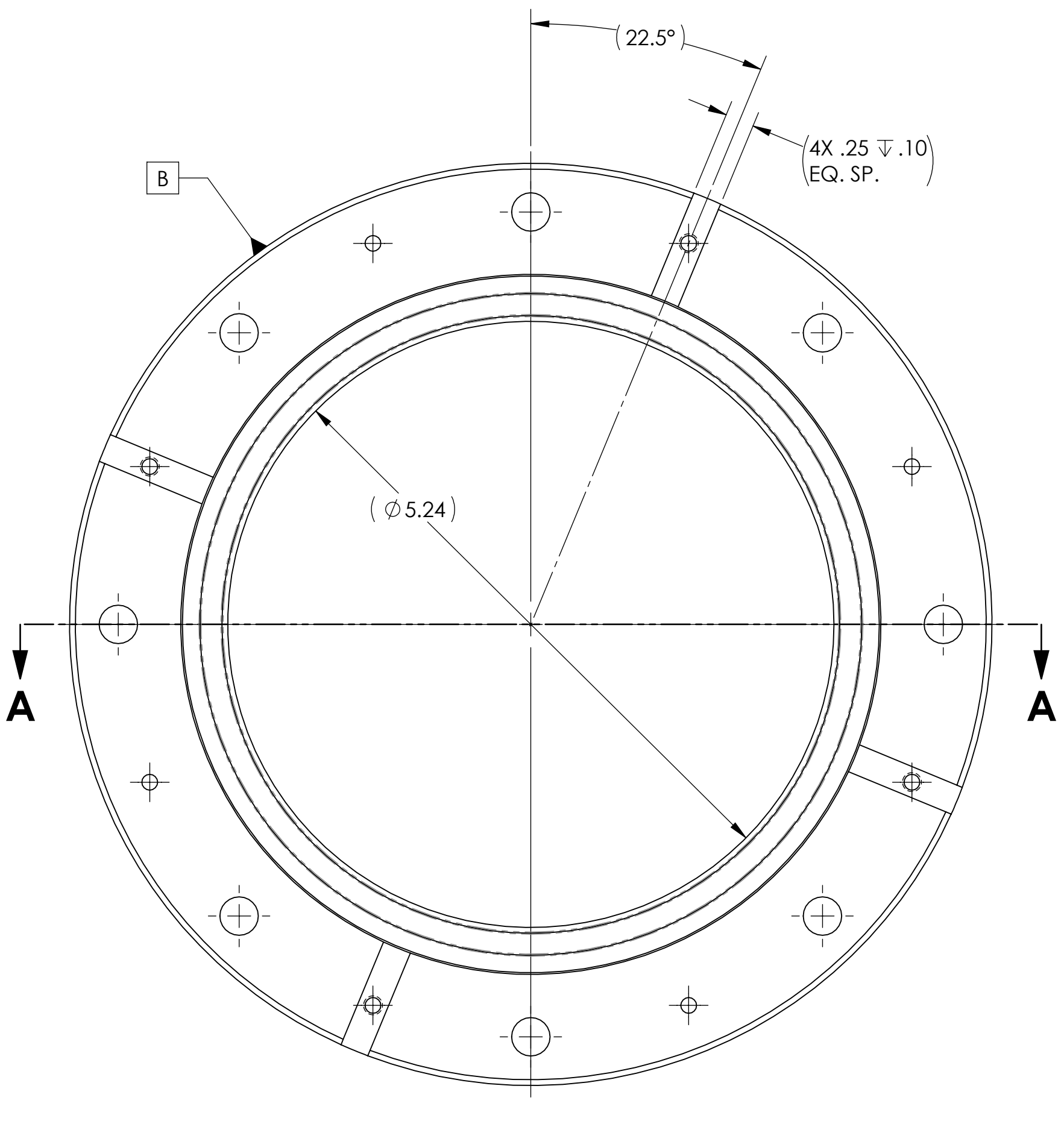
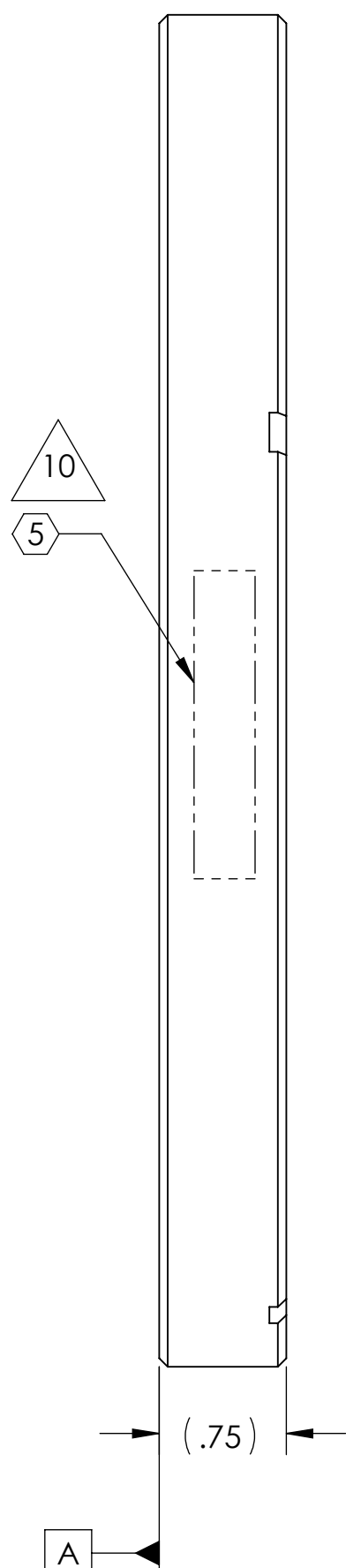
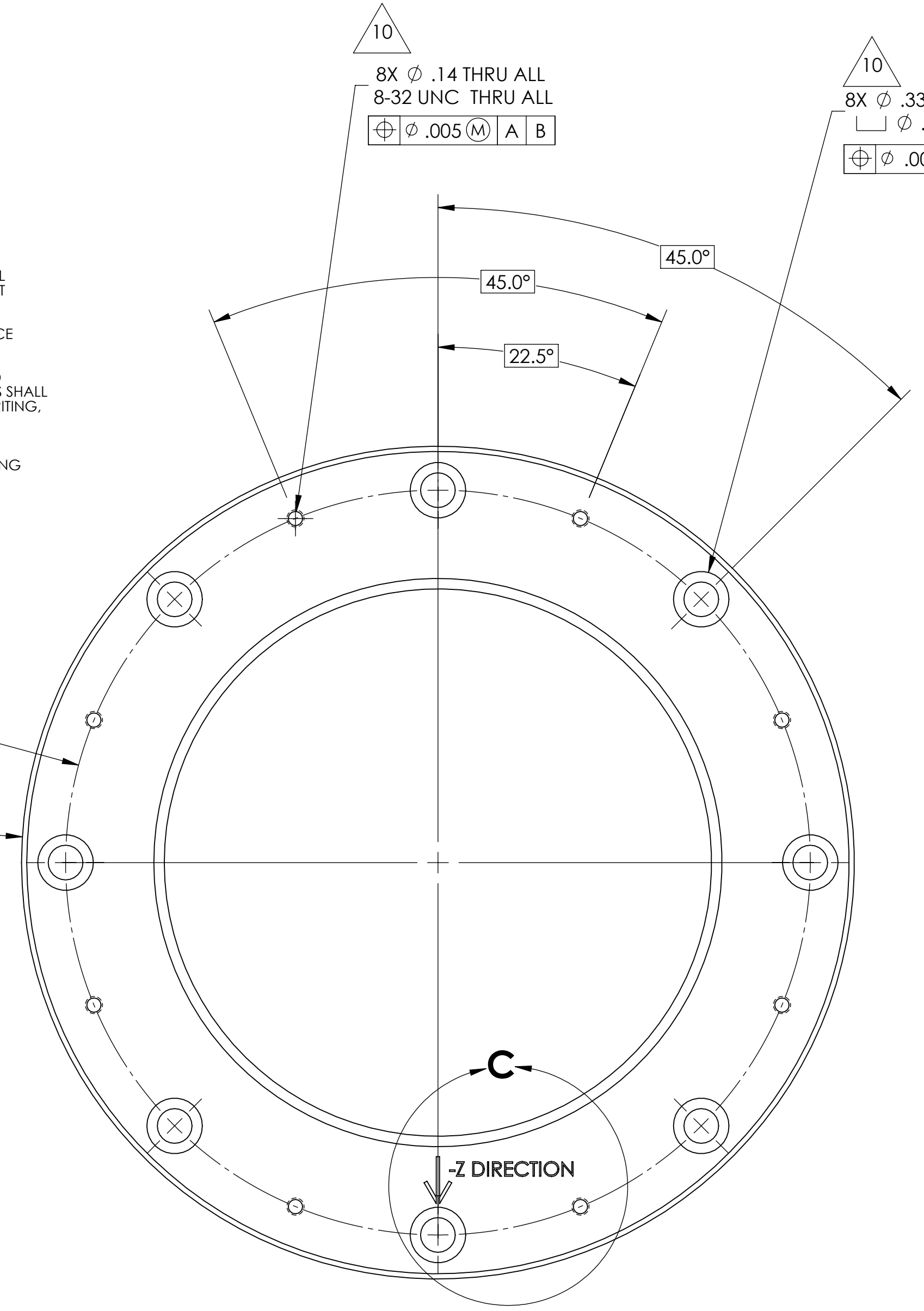
7 MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

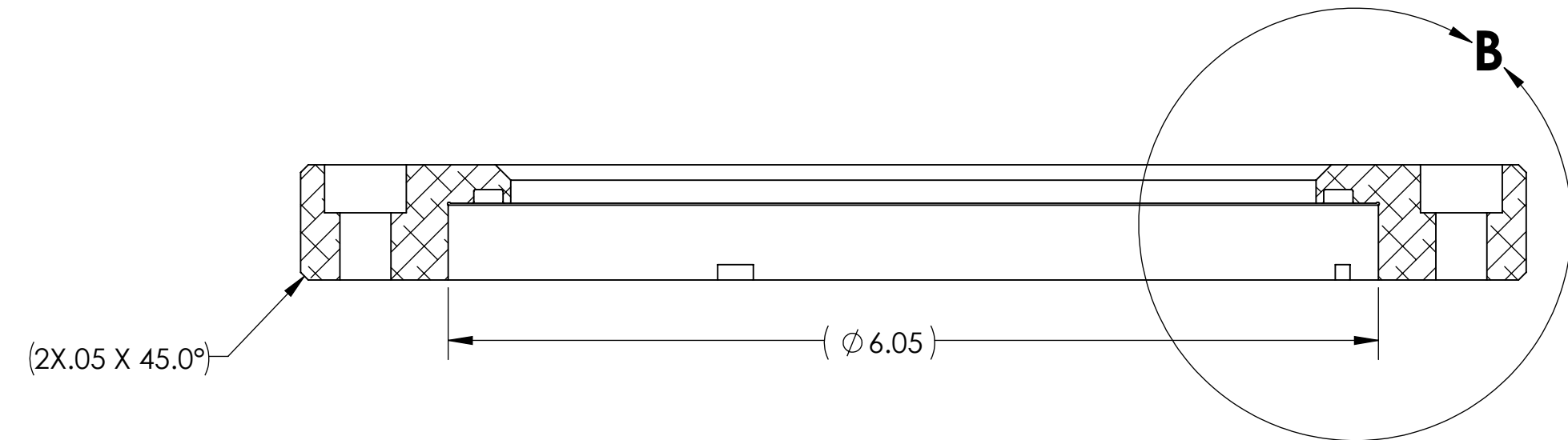
9 ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

10 FEATURES ARE POST-MACHINED STARTING FROM EXISTING PARTS GIVEN BY D1101002-v3

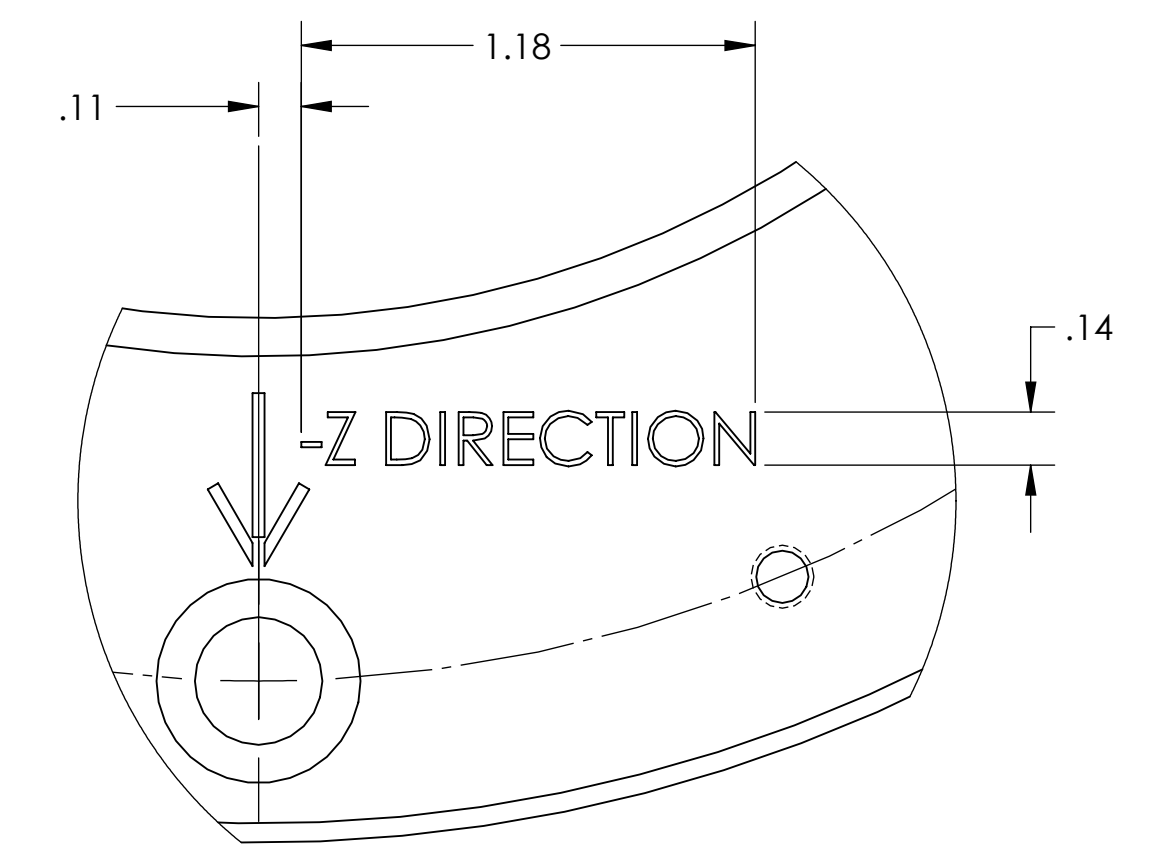
REV.	DATE	DCN #	DRAWING TREE #
v1	13-JUN-2012	E1200620-v1	E1200621-v1
-	-	-	-
-	-	-	-



**DETAIL B
SCALE 4 : 1**



SECTION A-A



**DETAIL C
SCALE 2 : 1**

DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ± 1.0°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		NEXT ASSY		SYSTEM		SUB-SYSTEM		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL		SIZE		DWG. NO.		REV.	
		.XX ± .01				1. INTERPRET DRAWING PER ASME Y14.5-1994.		6061 Alloy		63 μinch		D1200911		ADVANCED LIGO		AOS		aLIGO TCS HWS HAM4 VIEWPORT CLAMP		A.COLE		A.COLE		M.JACOBSON		A.BROOKS		D		D1102396		v1	
		.XXX ± .005				2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.								CALIFORNIA INSTITUTE OF TECHNOLOGY		MASSACHUSETTS INSTITUTE OF TECHNOLOGY				02-APR-2012		02-APR-2012		14-JUN-2012		15-JUN-2012		SCALE: 1:1		PROJECTION:		SHEET 1 OF 1	
						3. DO NOT SCALE FROM DRAWING.								LIGO																			
						4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.																											

D1102396-aLIGO TCS HWS HAM4 VIEWPORT CLAMP - PART PDM REV: X-010 - DRAWING PDM REV: X-011