

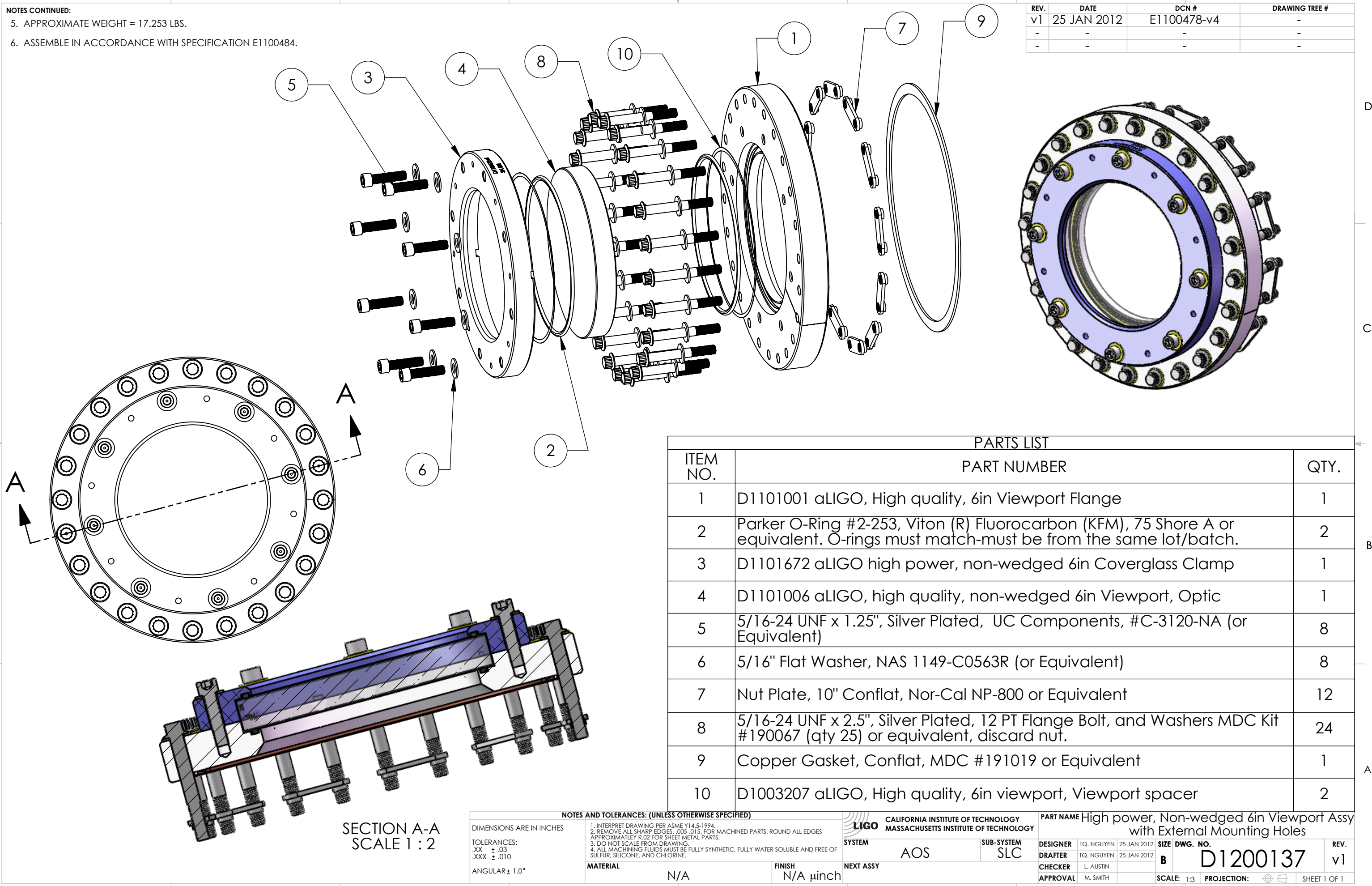
D1200137 aLIGO, high quality, non-wedged, 6in Viewport Assy with External Mounting Holes, PART PDM REV: X-001, DRAWING PDM REV: X-001

NOTES CONTINUED:

5. APPROXIMATE WEIGHT = 17.253 LBS.

6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2012	E1100478-v4	-
-	-	-	-
-	-	-	-



PARTS LIST		
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.	2
3	D1101672 aLIGO high power, non-wedged 6in Coverglass Clamp	1
4	D1101006 aLIGO, high quality, non-wedged 6in Viewport, Optic	1
5	5/16-24 UNF x 1.25", Silver Plated, UC Components, #C-3120-NA (or Equivalent)	8
6	5/16" Flat Washer, NAS 1149-C0563R (or Equivalent)	8
7	Nut Plate, 10" Conflat, Nor-Cal NP-800 or Equivalent	12
8	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
9	Copper Gasket, Conflat, MDC #191019 or Equivalent	1
10	D1003207 aLIGO, High quality, 6in viewport, Viewport spacer	2

SECTION A-A
SCALE 1 : 2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ± .03 .XXX ± .010	ANGULAR ± 1.0°
MATERIAL	FINISH	NEXT ASSY
N/A	N/A μinch	

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME High power, Non-wedged 6in Viewport Assy with External Mounting Holes	
SYSTEM	AOS	SUB-SYSTEM	SLC
DESIGNER	TQ. NGUYEN	DATE	25 JAN 2012
DRAFTER	TQ. NGUYEN	DATE	25 JAN 2012
CHECKER	L. AUSTIN		
APPROVAL	M. SMITH		
SIZE DWG. NO. B D1200137		REV.	v1
SCALE: 1:3		PROJECTION:	SHEET 1 OF 1