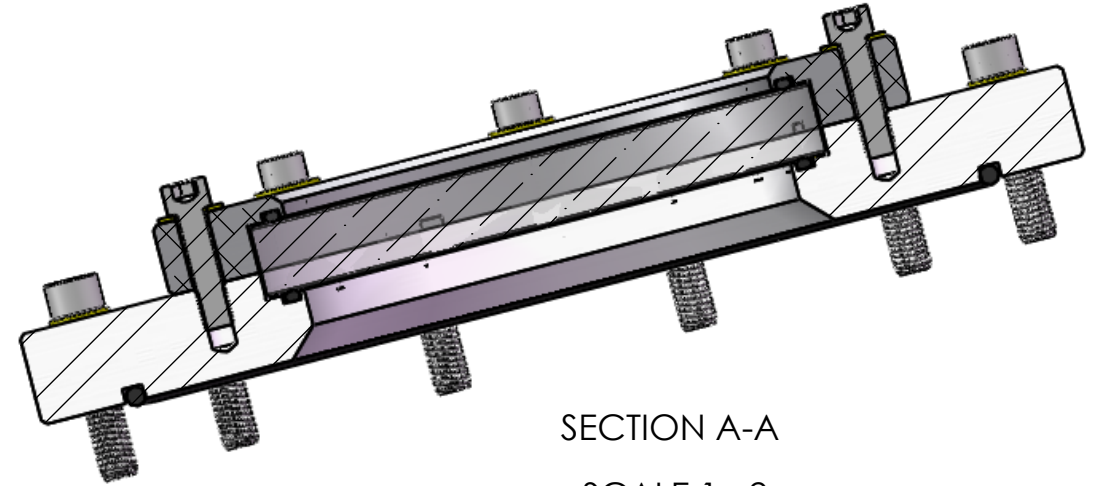
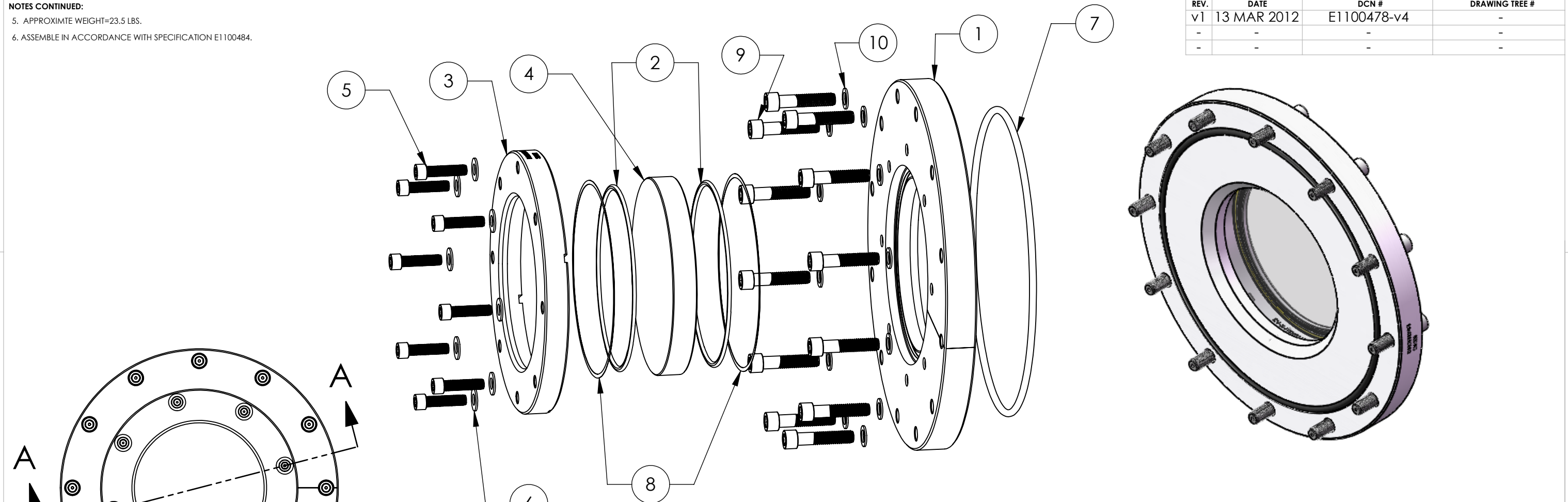


NOTES CONTINUED:  
 5. APPROXIMATE WEIGHT=23.5 LBS.  
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 MAR 2012	E1100478-v4	-
-	-	-	-
-	-	-	-

D1200436 aLIGO, Septum Viewport Assy, non-wedged, uncoated, PART PDM REV: X-002, DRAWING PDM REV: X-001



SECTION A-A  
SCALE 1 : 2

PARTS LIST		
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	D1101006-3 aLIGO, high quality, non-wedged 6in Viewport, Optic_uncoated	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-C0563-A (or Equivalent)	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.

<b>MATERIAL</b>	N/A	<b>FINISH</b>	N/A μinch
<b>SYSTEM</b>	ADVANCED LIGO	<b>SUB-SYSTEM</b>	SLC
<b>NEXT ASSY</b>		<b>PART NAME</b>	aLIGO Septum Viewport Assy, non-wedged_uncoated
<b>DESIGNER</b>	TQ. NGUYEN	<b>DATE</b>	13 MAR 2012
<b>DRAFTER</b>	TQ. NGUYEN	<b>DATE</b>	13 MAR 2012
<b>CHECKER</b>	L. AUSTIN	<b>SIZE</b>	DWG. NO. B
<b>APPROVAL</b>	M. SMITH	<b>SCALE</b>	1:3

**PROJECTION:**

**REV.** v1

**SHEET 1 OF 1**