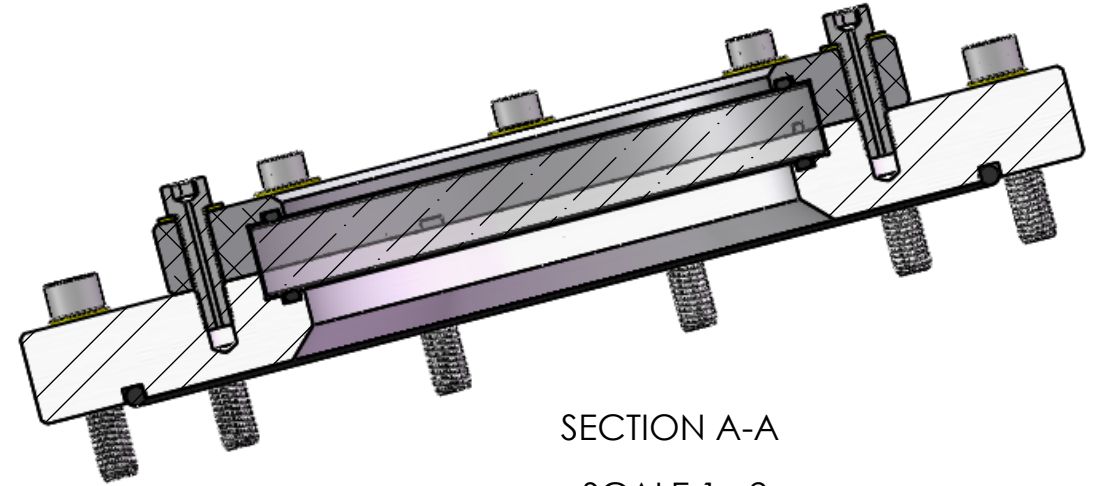
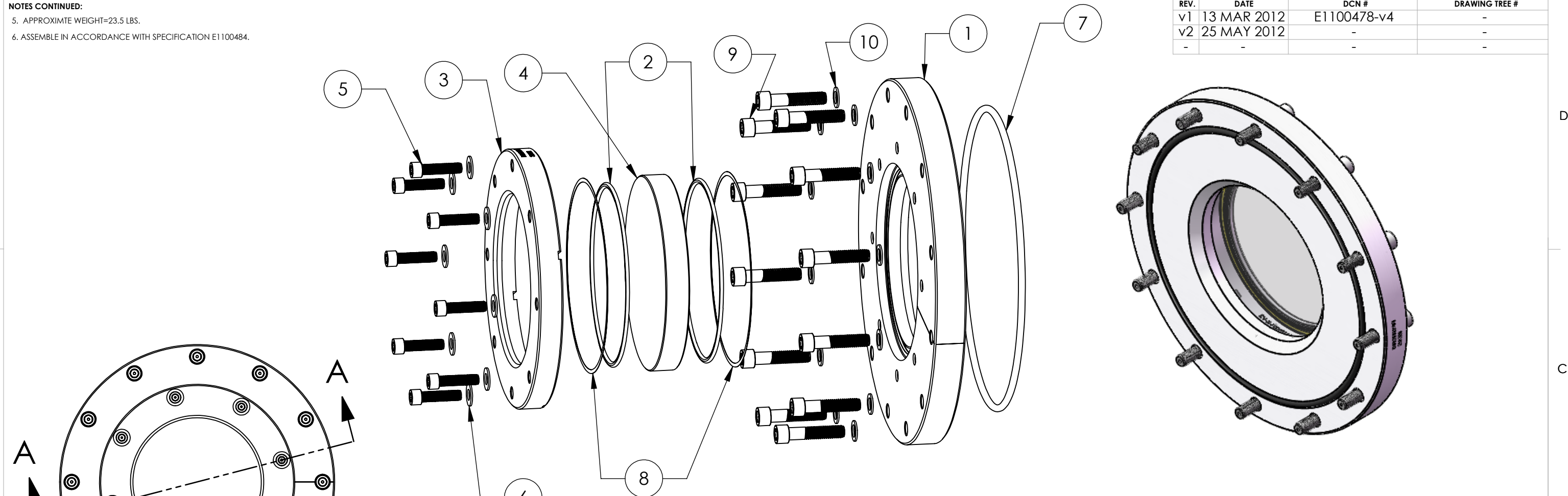


NOTES CONTINUED:
 5. APPROXIMATE WEIGHT=23.5 LBS.
 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION E1100484.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 MAR 2012	E1100478-v4	-
v2	25 MAY 2012	-	-
-	-	-	-

D1200436 aLIGO, Septum Viewport Assy, non-wedged, uncoated, PART PDM REV: X-005, DRAWING PDM REV: X-005



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", Vented, Silver Plated SS, UC Components, #C-3120-A (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.
 MATERIAL N/A
 FINISH N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		aLIGO Septum Viewport Assy, non-wedged_uncoated	
	SYSTEM ADVANCED LIGO	SUB-SYSTEM SLC	DESIGNER TQ. NGUYEN	DATE 13 MAR 2012
NEXT ASSY	CHECKER L. AUSTIN	DATE 7 SEPT 2011	SIZE B	DWG. NO. D1200436
	APPROVAL M. SMITH	DATE 7 SEPT 2011	SCALE 1:3	REV. v2

PROJECTION: SHEET 1 OF 1