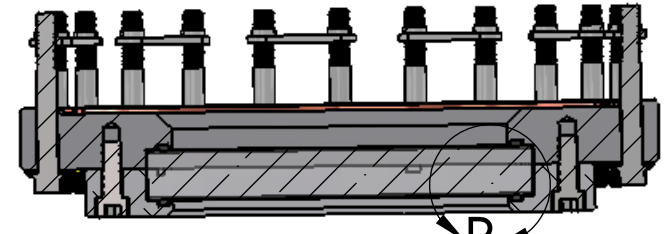
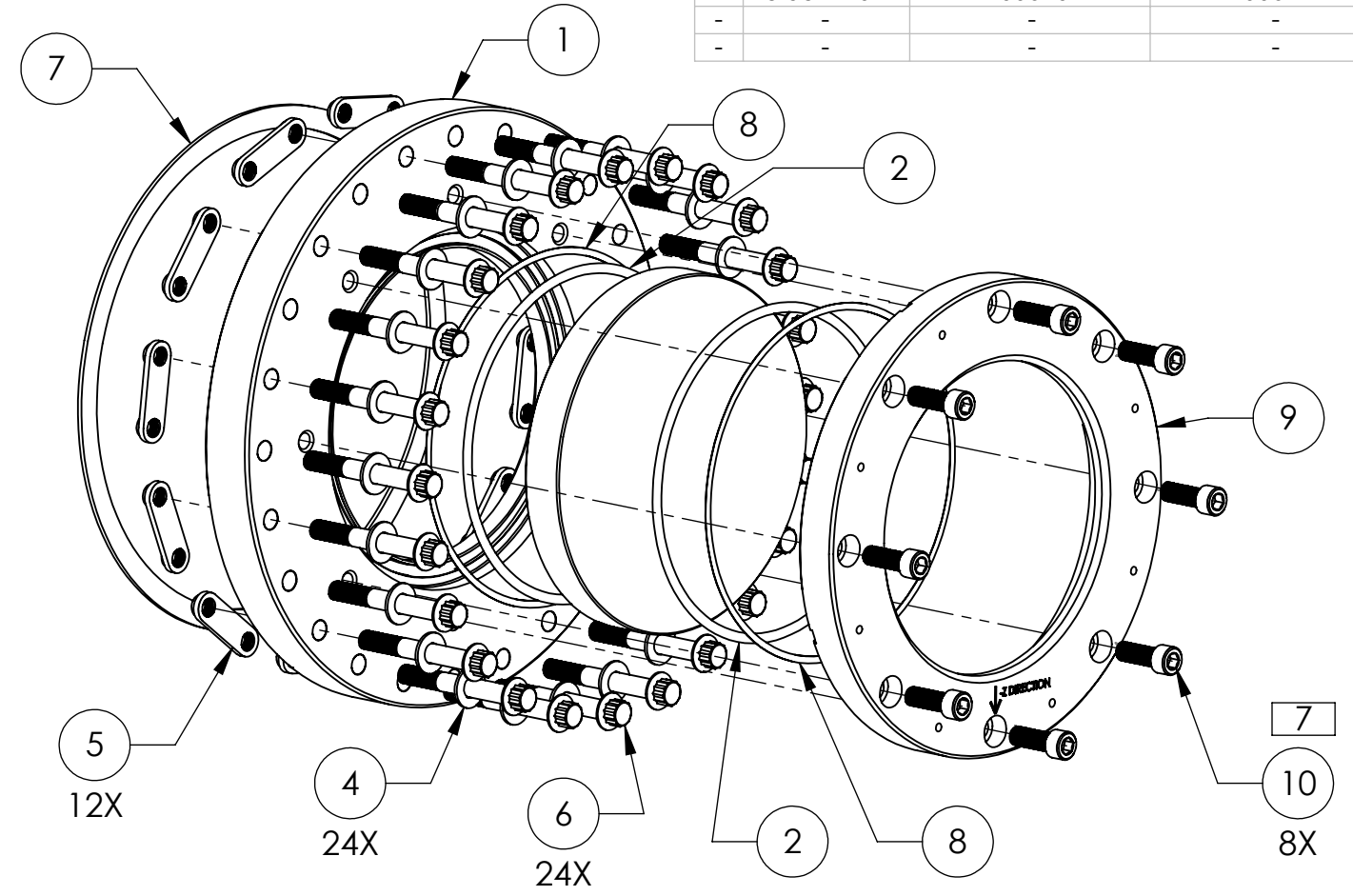
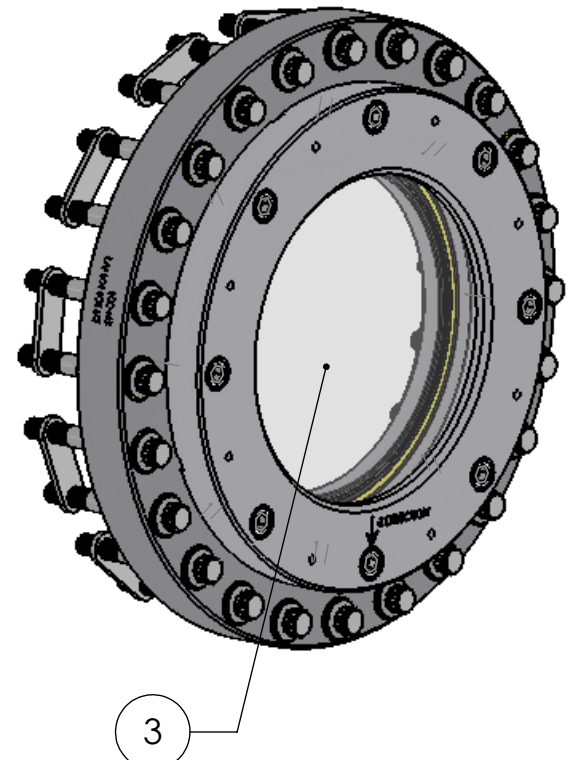
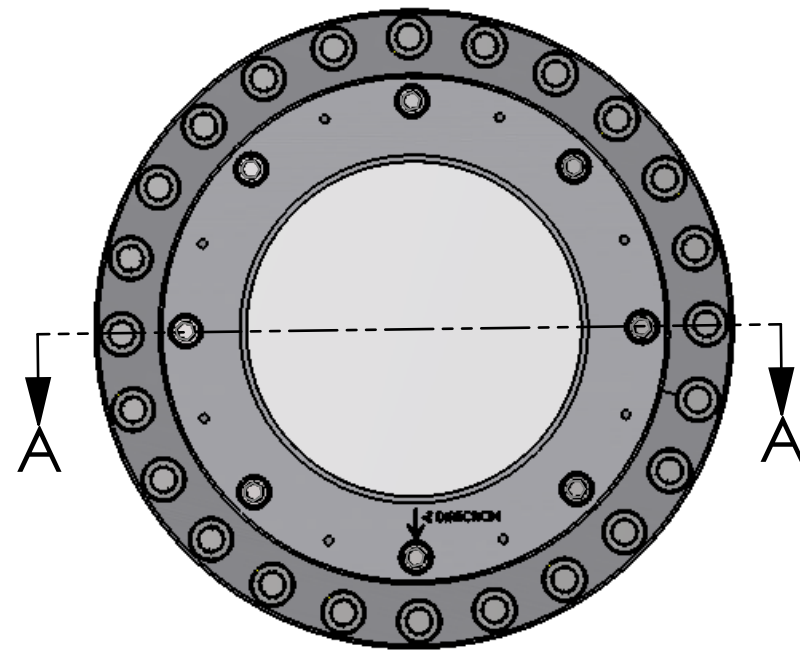


D1200911_calIGO TCS HIGH QUALITY NON-WEDGED 6IN VP ASSY_AR800-1080, PART PDM REV: X-007, DRAWING PDM REV: X-002

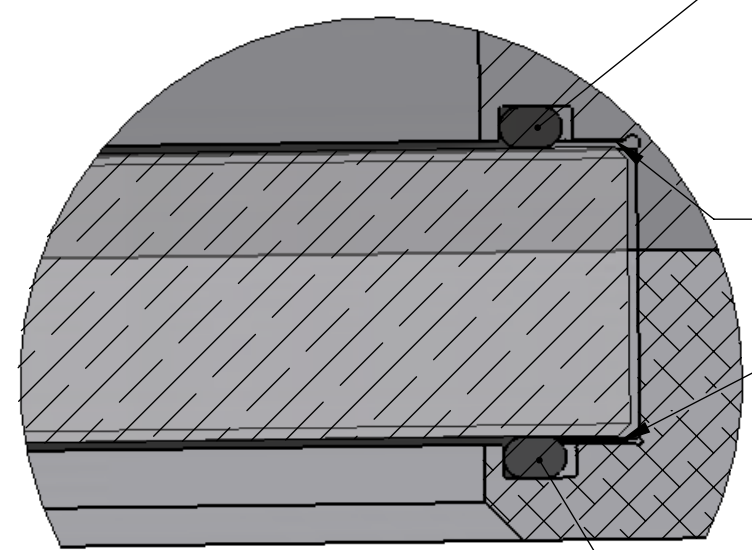
NOTES CONTINUED:

- 5. APPROXIMATE WEIGHT = 17 LB
- 6. ASSEMBLE IN ACCORDANCE WITH SPECIFICATION LIGO-E1100484
- 7. 5/16-24 MAX TORQUE = 135 in-lb

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



SECTION A-A
SCALE 1 : 3



DETAIL B
SCALE 2 : 1

10	C-3114-A	SHCS 5/16-24 X .875 LONG, VENTED, Ag PLATED	18-8 SS, Ag PLT	8	2	2
9	D1102396	aLIGO TCS HWS HAM4 VIEWPORT CLAMP	6061 Alloy	1	0	1
8	D1003207	High quality, 6in Viewport, Viewport Spacer	KAPTON	2	0	2
7	MDC #191019 (or Equivalent)	Copper Gasket, 10" Conflat	Copper	1	0	1
6	EBARA or MDC	5/16-24 UNF x 2.5", Silver Plated, 12 PT Flange Bolt, and Washers MDC Kit #190067 (qty 25) or equivalent, discard nut.	SSTL	24	0	24
5	EBARA or Nor-Cal NP-800	NUT PLATE 5/16-24, 10 IN CONFLAT	SSTL	12	0	12
4	NAS 1149-C0563R	5/16 FLAT WASHERS	300 SSTL	24	0	24
3	D1101006-2	aLIGO HIGH QUALITY NON-WEDGED 6 IN VIEWPORT OPTIC, AR800/1080	FUSED SILICA	1	0	1
2	Parker O-Ring #2-253	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.	VITON (R) FLUOROCARBON (KFM)	2	0	2
1	D1101001	aLIGO High Quality, 6in Viewport FLANGE	AISI 304	1	0	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Exploded View/REQ	SPARE	TOTAL

PARTS LIST

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 ±	
.XXX ±	
ANGULAR ± °	
MATERIAL	N/A
FINISH	N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS
 NEXT ASSY: D1102389, D1102397

PART NAME: TCS HIGH QUALITY NON-WEDGED 6 IN VIEWPORT ASSY_AR800-1080

DESIGNER	D. COYNE	12 MAR 2012	SIZE	DWG. NO.	REV.
DRAFTER	M. JACOBSON	13-JUN-2012		B	D1200911
CHECKER	A. COLE	14-JUN-2012			v1
APPROVAL	D. COYNE	08-JUN-2012	SCALE: 1:3	PROJECTION:	SHEET 1 OF 1