

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = X.XXX LB.

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

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

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	06-29-12	TO FOLLOW	-
v2	07-05-12	TO FOLLOW	-
-	-	-	-

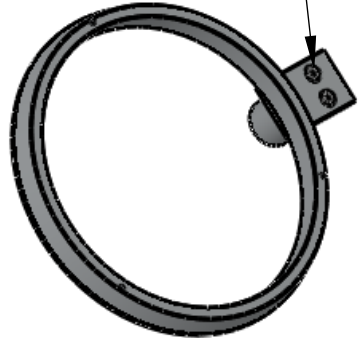
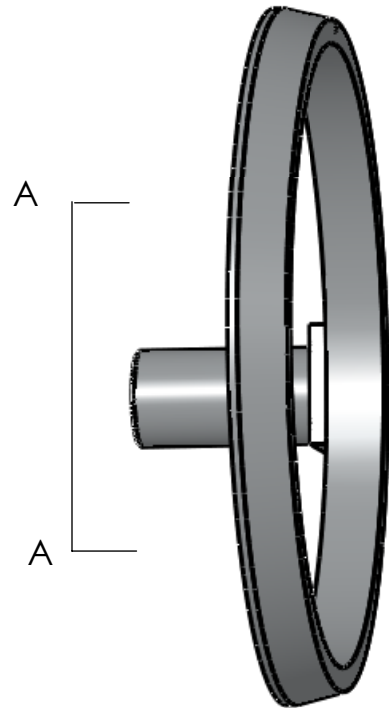
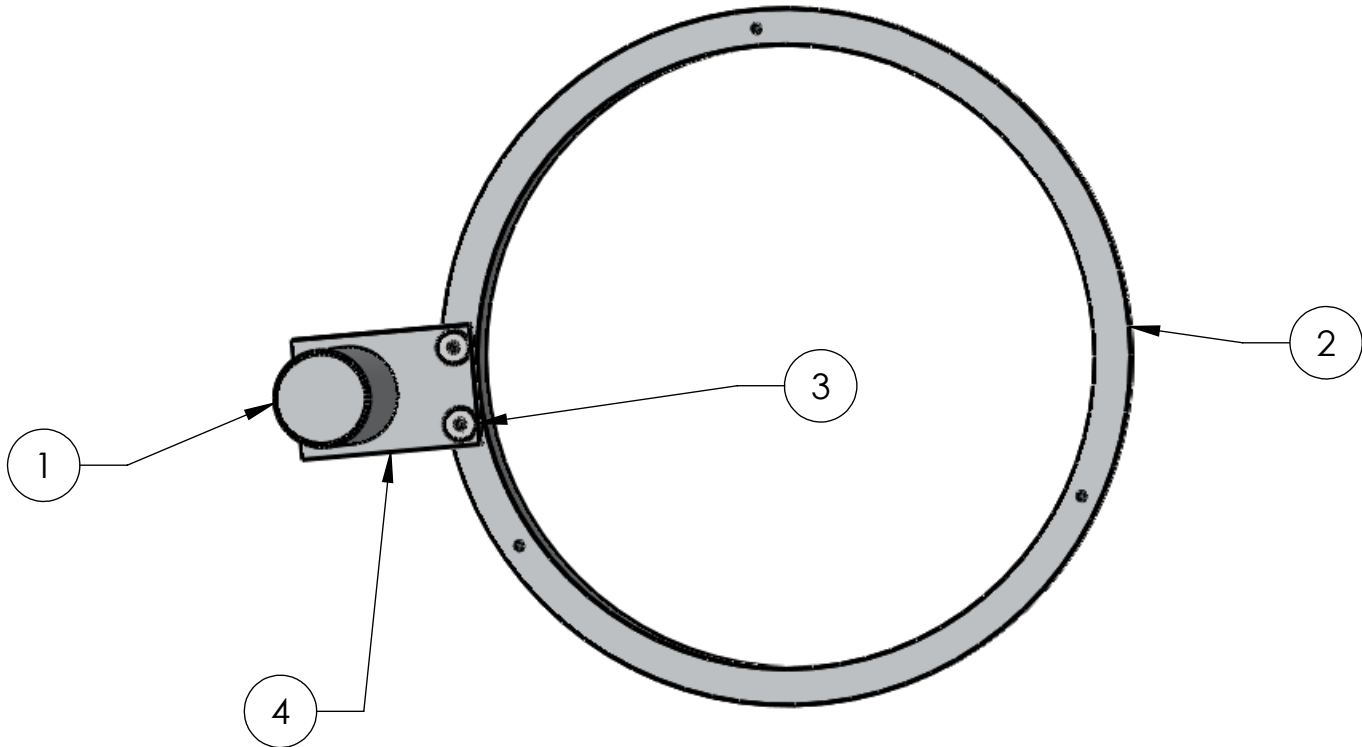
SET SCREW FOR PAPER TARGET PIN
3 PL REF

BUTTON HD
OPTION REF

MIRROR OPTION

3

VIEW A-A
SCALE 1 : 4



4	D1200904 aLigo viewport target ring bracket	1
3	MC MASTER # 92210A192	4
2	D1200872 aLigo viewport target ring	1
1	D1200906 aLigo viewport target ring shaft	1
ITEM NO.	PART NUMBER	QTY

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		
DIMENSIONS ARE IN INCHES		
1. INTERPRET DRAWING PER ASME Y14.5-1994.		
2. REMOVE ALL SHARP EDGES, R.02 MIN.		
3. DO NOT SCALE FROM DRAWING.		
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		
TOLERANCES:		
.XX	± .02	
.XXX	± .005	
ANGULAR	± 1.0°	
MATERIAL	--	FINISH
		-- μinch

	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
	SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS
NEXT ASSY D1200845	PART NAME aLigo_Ham_ViewPort_Target_Ring_Assem	

DESIGNER KEN MAILAND	6-6-2012	SIZE DWG. NO. B	D1200935	REV. v2
DRAFTER KEN MAILAND	06-29-12	SCALE: 1:2		PROJECTION:
CHECKER KEN MAILAND	06-29-12			
APPROVAL				