

NOTES CONTINUED:

Ⓢ BAG ALL ITEMS INDIVIDUALLY AND MARK OR TAG EACH BAG WITH DRAWING NUMBER, REVISION, AND QUANTITY. EXAMPLE: DXXXXX-VY, QTY: 1

REV.	DATE	DCN #	DRAWING TREE #
v1	28 APR 2009	E080418	E080191
v2	30 JUN 2009	E0900184	E080191
-	-	-	-

D

C

B

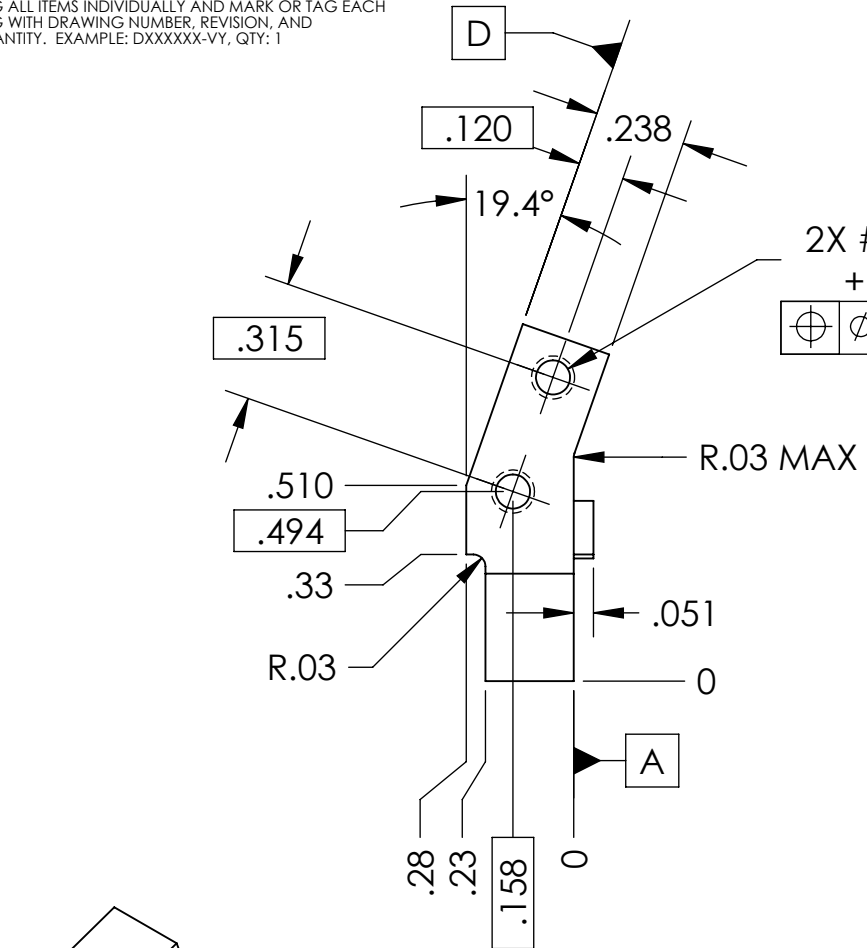
A

D

C

B

A

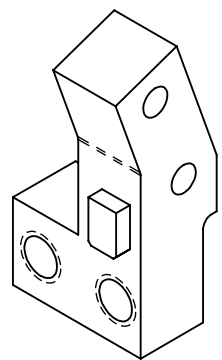
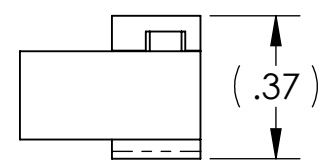
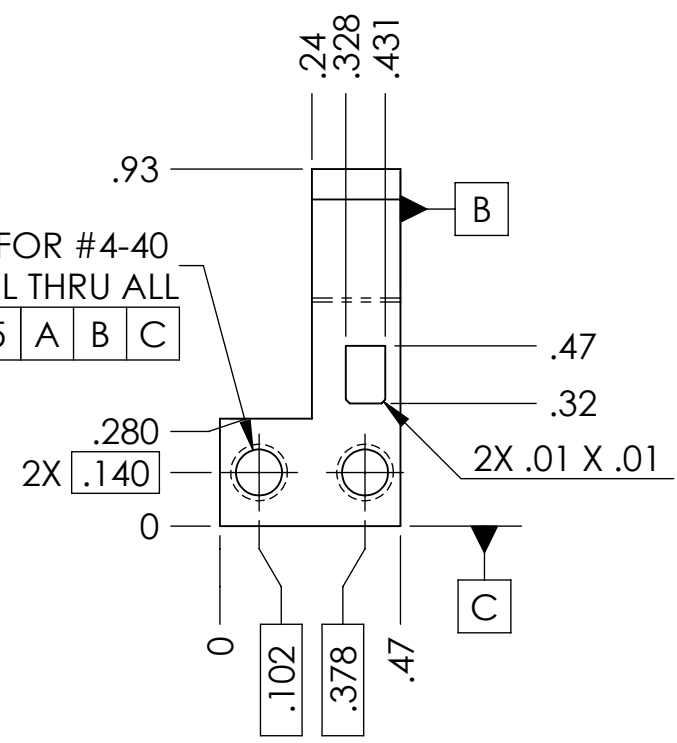


2X #4-40 UNC THRU ALL
+.005 OVERSIZE TAP

ϕ	ϕ .005	B	C	D
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2X TAP FOR #4-40
HELICOIL THRU ALL

ϕ	ϕ .005	A	B	C
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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX ± .01
.XXX ± .005

ANGULAR ± 0.1°

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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL: 304, 316 OR 302 SSSL
FINISH: 32 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SUS**

NEXT ASSY: **INTERMEDIATE WIRE ASSY**

PART NAME: **UPPER CLAMP, INT. WIRE, INSIDE**

DESIGNER: D. BRIDGES	10 OCT 2008	SIZE: A	DWG. NO.: D070585	REV.: v2
DRAFTER: D. BRIDGES	2 JUL 2009			
CHECKER: M. MEYER	6 JUL 2009			
APPROVAL:		SCALE: 2:1	PROJECTION:	SHEET 1 OF 1