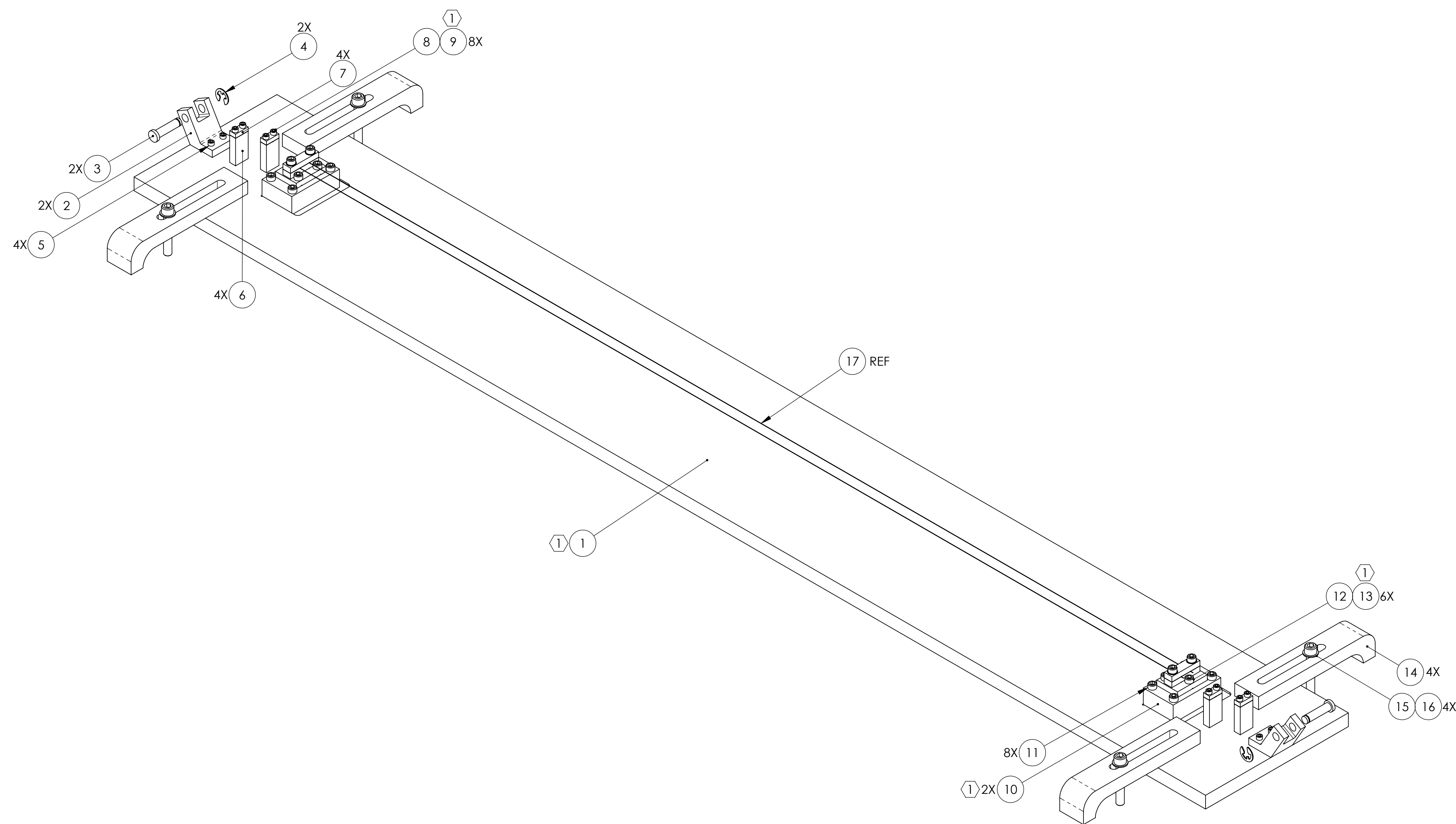
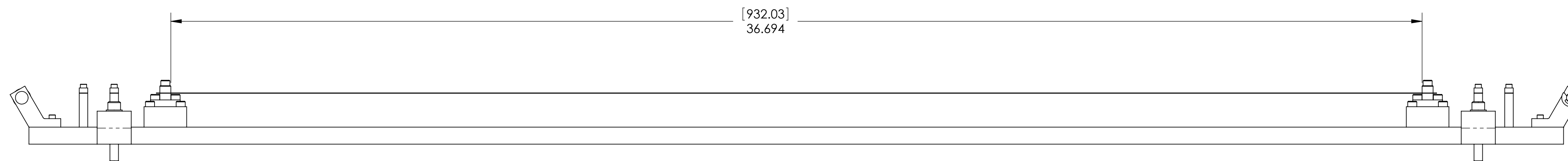


REV.	DATE	DCN #	DRAWING TREE #
v1	17 JUL 2009	E0900205	E080191
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
17	D070436	LOWER LOOP WIRE ASSY	N/A	REF	0	0
16	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 1.5 LONG	300 SSSL	4	1	5
15	-	WASHER, FLAT, 1/4 (NAS 620-C416L OR EQUIVALENT)	300 SSSL	4	1	5
14	D980184	LOS CLAMP, LONG	304, 316 OR 302 SSSL	4	0	4
13	1185-2EN246	HELICOIL, #8-32 X 0.246 LONG (1)	NITRONIC 60	6	4	10
12	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	300 SSSL	6	2	8
11	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 1 LONG	300 SSSL	8	2	10
10	D0901436	WIRE CLAMP MOUNT (1)	6061-T6 Al	2	0	2
9	1185-04EN224	HELICOIL, #4-40 X 0.224 LONG (1)	NITRONIC 60	8	5	13
8	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 1.5 LONG	300 SSSL	8	2	10
7	D020380	WIRE START CLAMP, OUTSIDE	304, 316 OR 302 SSSL	4	1	5
6	D0901435	WIRE START CLAMP, INSIDE	304, 316 OR 302 SSSL	4	1	5
5	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.5 LONG	300 SSSL	4	1	5
4	98408A120	RETAINING RING (MCMaster-CARR P/N)	300 SSSL	2	1	3
3	92735A230	CLEVIS PIN (MCMaster-CARR P/N)	300 SSSL	2	1	3
2	D0900563	PIN SUPPORT, WIRE JIG	6061-T6 Al	2	0	2
1	D0901433	BASE PLATE (1)	6061-T6 Al	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

(1) HELICOILS TO BE INSTALLED INTO ITEM NO. 1 AND ITEM NO. 10 BY LIGO PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.

2. THIS JIG TO BE USED IN THE ASSEMBLY OF D070436 LOWER LOOP WIRE ASSEMBLY AS DESCRIBED IN E080208 HLTS ASSEMBLY SPECIFICATION.

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL: N/A

FINISH: N/A μinch

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SUS

NEXT ASSY: HLTS OVERALL ASSY AND FIXTURES

PART NAME: LOWER LOOP WIRE JIG ASSY, HLTS

DESIGNER: D. BRIDGES

DRAFTER: W. RASCH

CHECKER: D. BRIDGES

APPROVAL:

DATE: 23 JUL 2009

DATE: 24 JUL 2009

DATE: 10 AUG 2009

SIZE: D

DWG. NO.: D0901419

REV.: v1

SCALE: 1:2

PROJECTION:

SHEET 1 OF 1

D0901419\_Avanced\_LIGO\_305\_HLTS\_Lower Loop\_Wire\_Jig\_Assembly\_PART PDM REV: X-009\_PART PDM REV: X-009\_DRAWING PDM REV: X-000