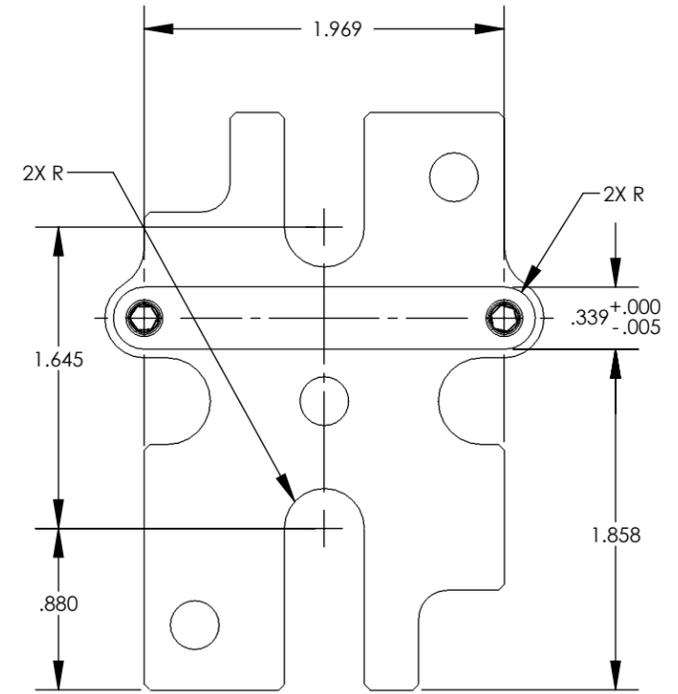
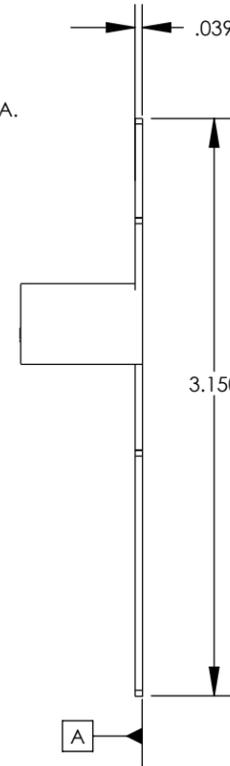
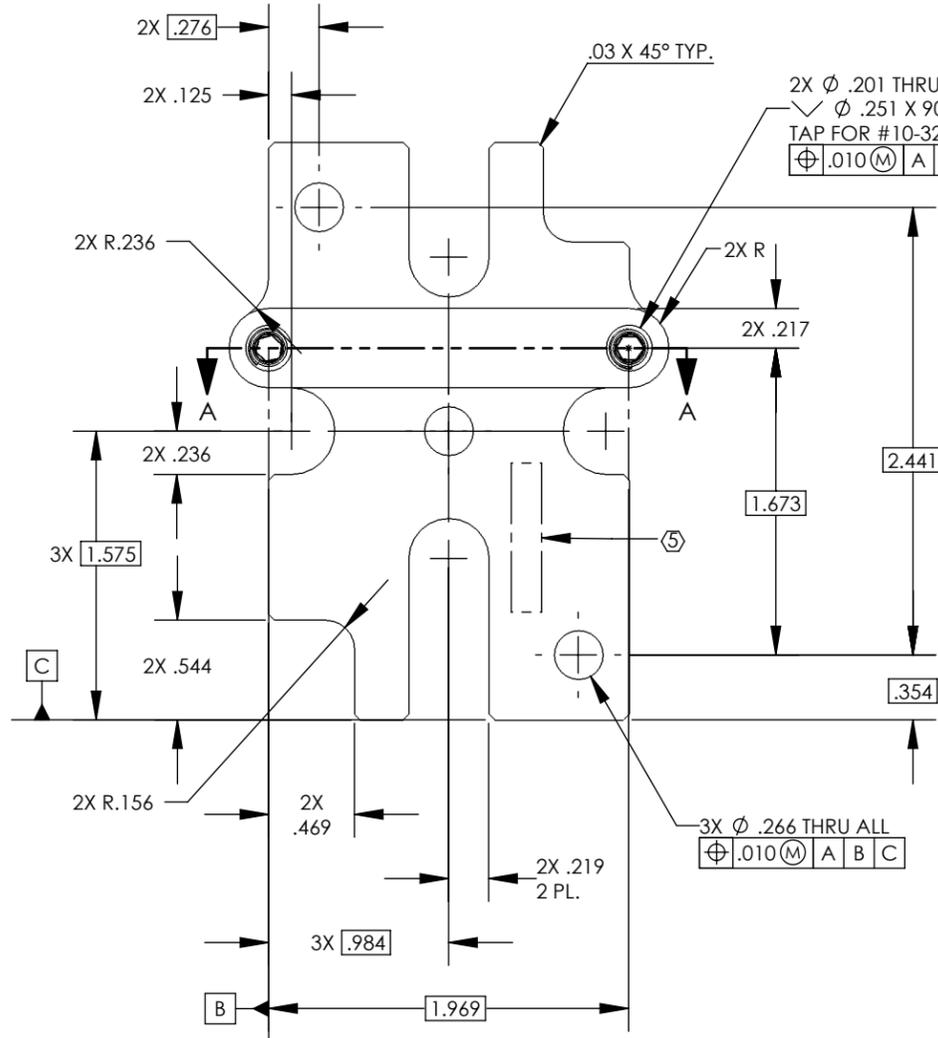
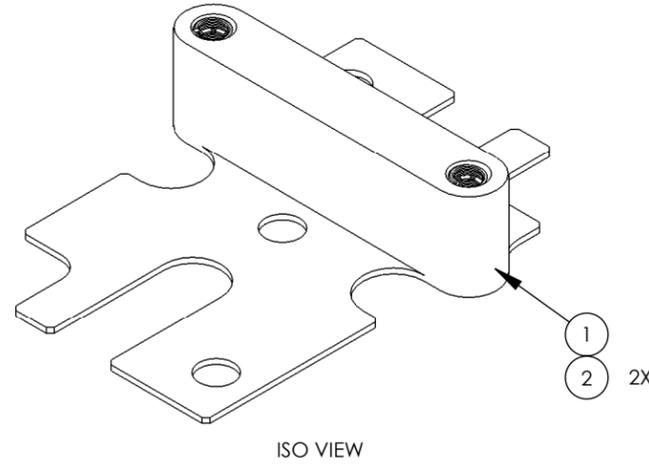
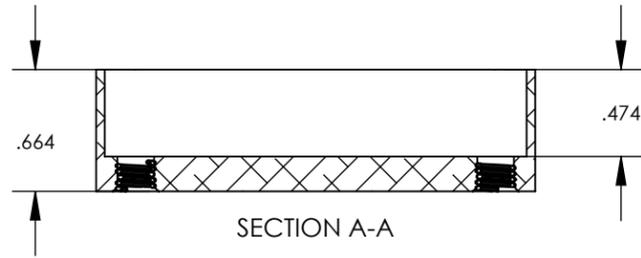


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 0.020 LB.
- 7. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 8. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 12. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .010 - .015

REV.	DATE	DCN #	DRAWING TREE #
v1	14 JUN 2007	-	-
v2	11 AUG 2007	-	-
v3	16 APR 2012	E1200388-x0	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
2	3591-3EN190	HELICOIL, 10-32 X 1 DIA.	NITRONIC 60	2
1	D070220-1	ALIGO, SUS, QUAD, NPTYPE WIRING HARNESS, UIM MASS WIRE CLAMP (REDESIGNED)	6061-T6 Al	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

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

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS
 NEXT ASSY: D070221

PART NAME: ALIGO, SUS, QUAD NPTYPE WIRING HARNESS, UIM MASS WIRE CLAMP

DESIGNER: I.WILMUT 14 JUN 2007
 DRAFTER: I.WILMUT 14 JUN 2007
 CHECKER: J.ODELL 14 JUN 2007
 APPROVAL: SEE DCC I.WILMUT

SIZE DWG. NO. B D070220
 SCALE: 1:1 PROJECTION: SHEET 1 OF 1

REV. v3

D070220 ALIGO, SUS, QUAD NPTYPE WIRING HARNESS, UIM MASS WIRE CLAMP (REDESIGNED), PART PDM REV: X-003, DRAWING PDM REV: X-002