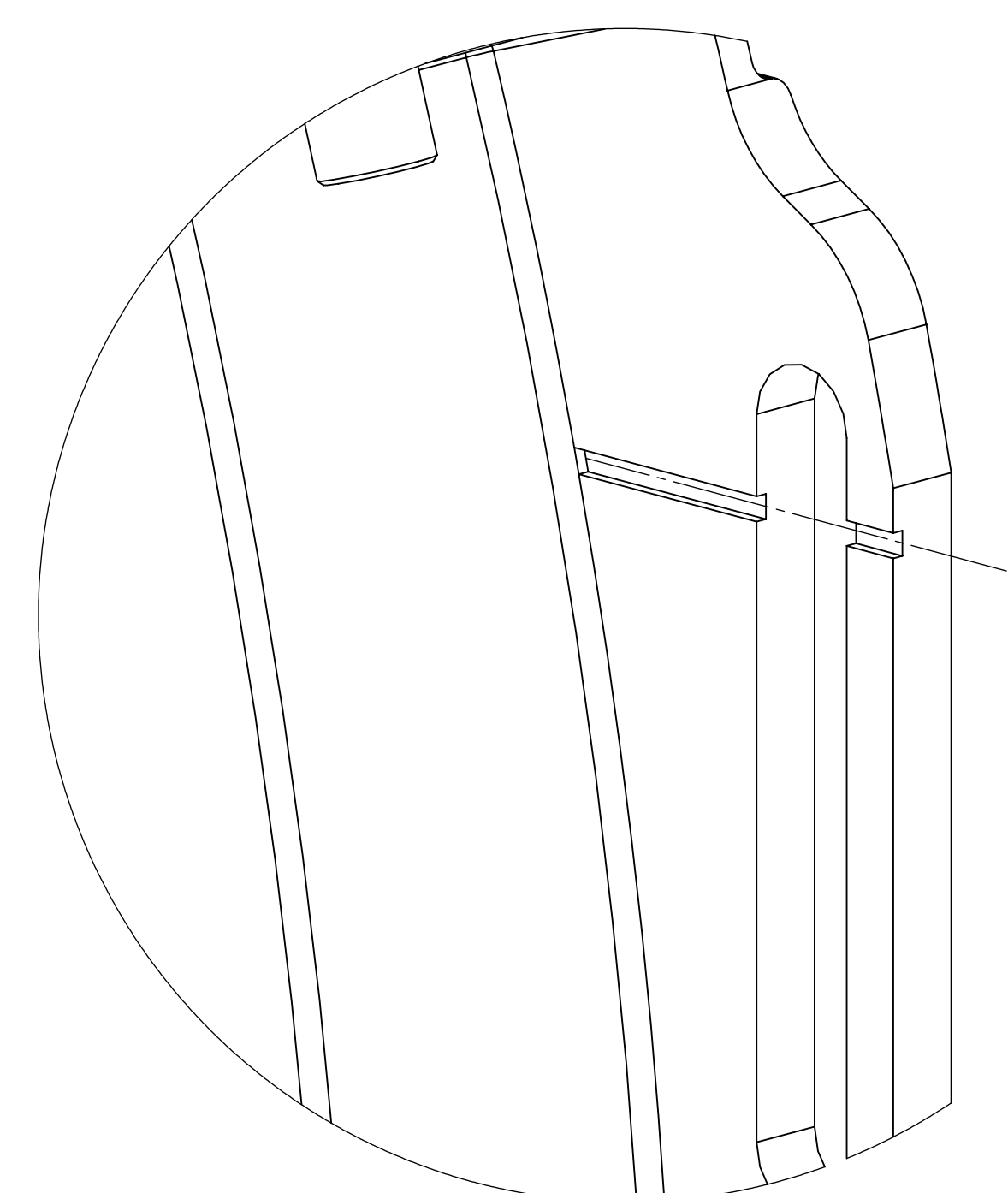
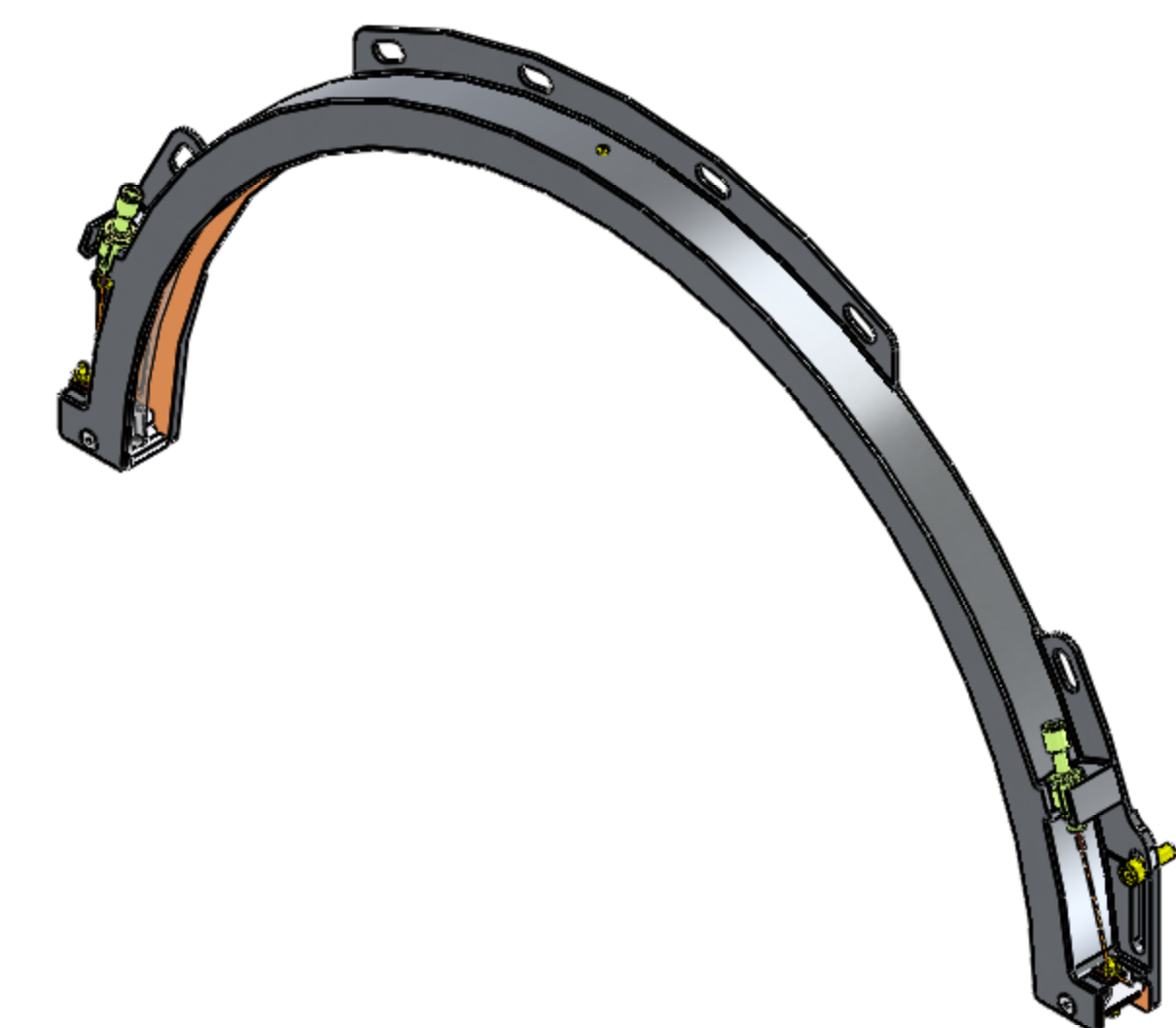
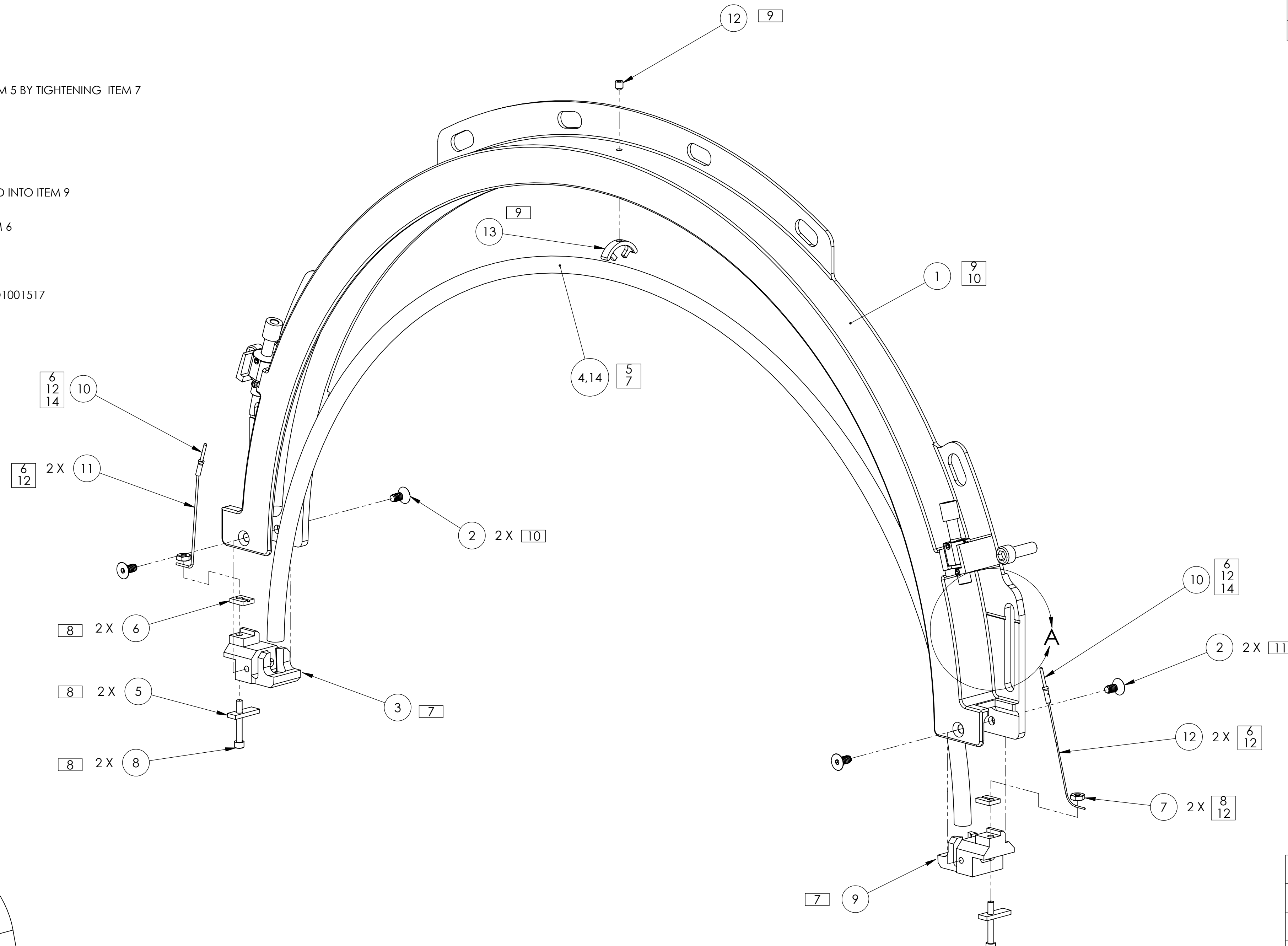


NOTES CONTINUED:

- 5. ITEM 16 IS NOT DEPECTED; IT IS PRE-FORMED USING LIGO-D1002047 AND SLEEVED ONTO ITEM 4 PRIOR TO ASSEMBLY
- 6. ASSEMBLY STEP 1: TWO PIECES OF ITEM 11 ARE PRE-STRIPPED AND CRIMPED INTO ITEM 10
- 7. ASSEMBLY STEP 2: ITEMS 4 AND 16 ARE SET INTO ITEMS 3 AND 9
- 8. ASSEMBLY STEP 3: ITEM 16 IS WOUND ABOUT THE STEM OF ITEM 8 AND SECURED AGAINST ITEM 5 BY TIGHTENING ITEM 7
- 9. ASSEMBLY STEP 4: EITHER ITEM 13 OR ITEM 14 IS SECURED TO ITEM 1 USING ITEM 12
- 10. ASSEMBLY STEP 5: ITEM 1 IS BROUGHT INTO PLACE AND 2X ITEM 2 ARE SECURED INTO ITEM 3
- 11. ASSEMBLY STEP 6: ITEM 1 IS PIVOTED INTO PLACE ABOUT ITEM 9 AND 2X ITEM 2 ARE SECURED INTO ITEM 9
- 12. ASSEMBLY STEP 7: ITEM 7 IS USED TO SECURE THE COMBINED ITEMS 10 AND 11 AGAINST ITEM 6
- 13. SUBSYSTEM INTEGRATION STEP 1: TWO #8-32 ARE USED TO SECURE THE ASSEMBLY INTO PLACE
- 14. SUBSYSTEM INTEGRATION STEP 2: ITEM 10 IS SECURED INTO EACH OF THE JOINTS J2 AND J3 OF ASSEMBLY D1001517

REV.	DATE	DCN #	DRAWING TREE #
v1	04-AUG-2010	E1000291	E1000295-v1
v2	16-NOV-2010	E1000291-v3	E1000295-v4
v3	03-DEC-2010	E1000291-v4	E1000295-v5
v4	06-JAN-2011	E1000291-v5	E1000295-v6



DETAIL A  
SCALE 4 : 1

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
14	MM 8880K52	24AWG NICHROME WIRE, PRE-CUT	CHROMEL-C	20 FT	20 FT	40 FT
13	D1003009	RH ELEMENT SPACER WHEEL	MACOR CERAMIC	1	0	1
12	T-402	SCREW, SOCKET SET, #4-40 UNC-2A X 0.125 LONG	300 SSSL	1	0	1
11	CZ1105	28 AWG PFA COATED COPPER WIRE, 2X 2X 3-IN PRE-STRIPPED	Copper	12 IN	6 IN	18 IN
10	100170	10-24 AWG ACCUGLASS PIN CONTACT	AU-PLATED CU	2	2	4
9	D1002544	RH ELEMENT RETAINER, SIMPLIFIED RIGHT	MACOR CERAMIC	1	0	1
8	C-210-N	SHCS #2-56 UNC-2A X .625 LG, UC COMPONENTS	18-8 SS	2	2	4
7	N-256-A	#2-56 UNC 2B, HEX NUT, UC COMPONENTS	18-8 SS, Ag Plated	2	2	4
6	D1001849	UPPER COPPER PLATE	Cu, ALLOY 110	2	2	4
5	D1001850	LOWER COPPER PLATE	Cu, ALLOY 110	2	2	4
4	D1002538	SIMPLIFIED GLASS FORMER	Glass	1	1	2
3	D1002543	RH ELEMENT RETAINER, SIMPLIFIED LEFT	MACOR CERAMIC	1	0	1
2	FA-404	VENTED SS 18-8 FSHCS #4-40 UNC-2A x .25 LG, UC COMPONENTS	18-8 SS	4	2	6
1	D1001679	αLIGO TCS UPPER MONOLITHIC RH SHIELD	6061 Alloy	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN	
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: D1002027

PART NAME: αLIGO TCS RING HEATER ASSY, UPPER SEGMENT

DESIGNER	M. JACOBSON	29 JUL 2010	SIZE	DWG. NO.	REV.
DRAFTER	A. COLE	29 JUL 2010	D	D1001838	v4
CHECKER	C. TORRIE	06 JAN 2011	SCALE:	1:2	PROJECTION:
APPROVAL	P. WILLEMS	11 JAN 2011	SHEET 1 OF 1		

D1001838 αLIGO TCS UPPER SEGMENT RING HEATER ASSY, PART FDM REV: 3-090, DRAWING FDM REV: X-021