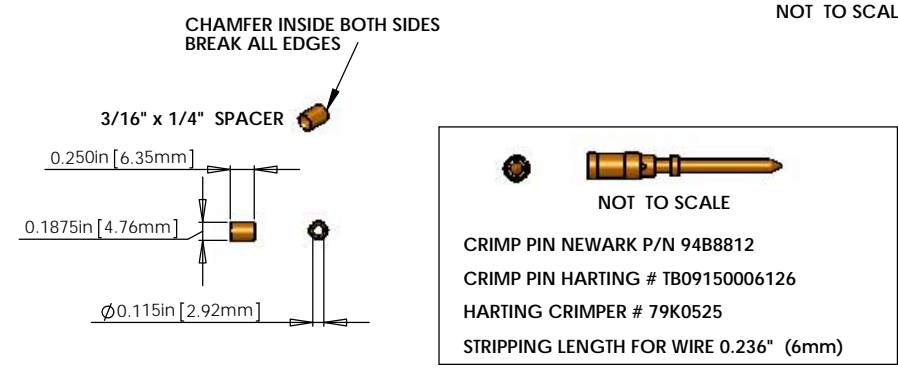
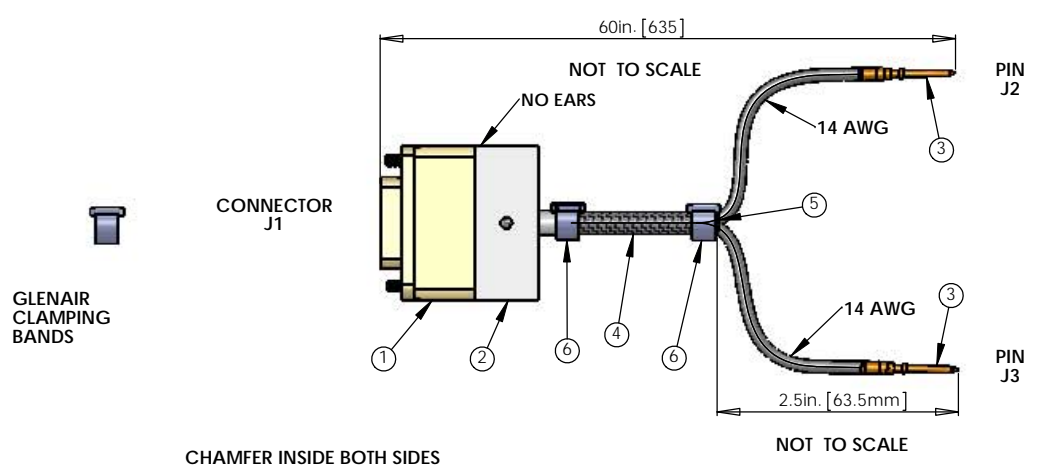
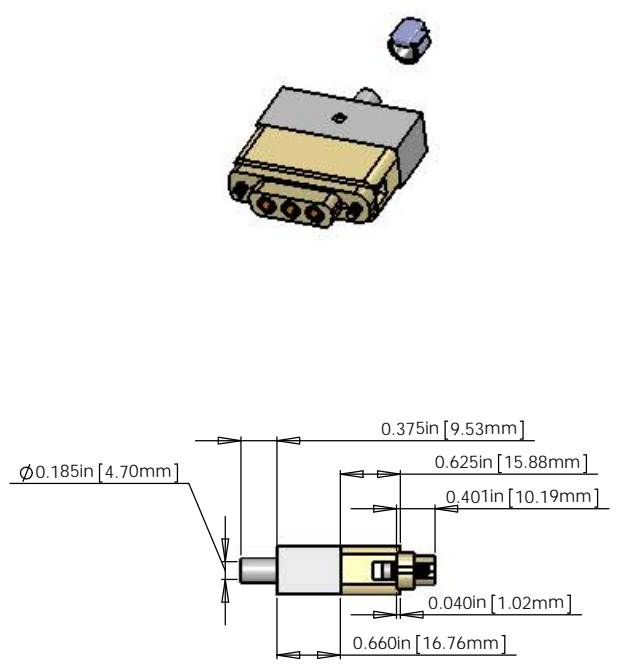
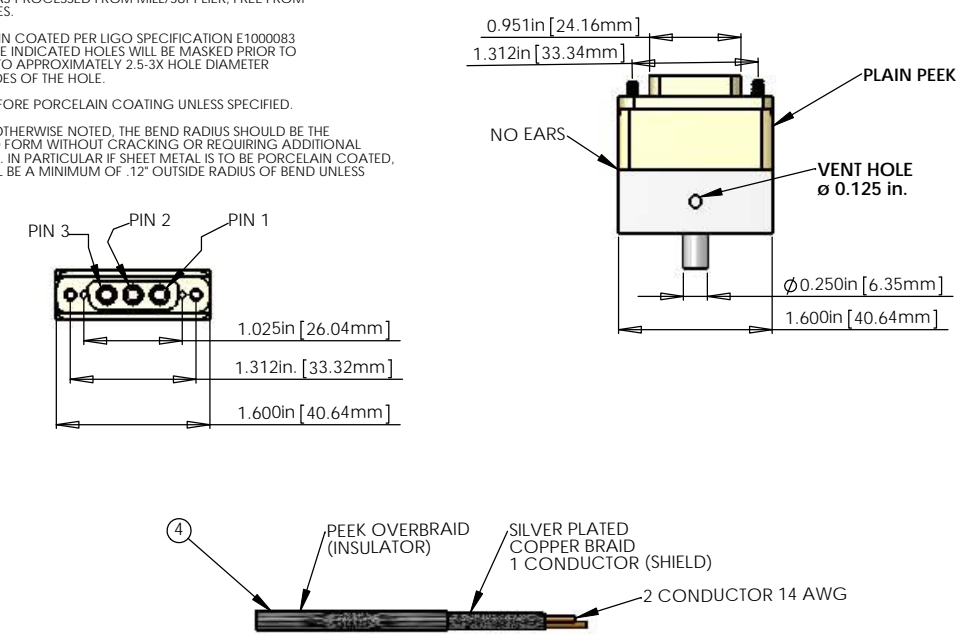


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXX-VY, S/N 001. VIBRATORY TOOL MAY BE USED. A

- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 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. 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER. FREE FROM SCRATCHES OR GOUGES.
- 13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
- 14. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
- 15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.



BILL OF MATERIALS				
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	LENGTH *
1	CUSTOM DB3 FEMALE	DB3 FEMALE CONNECTOR (J1) FOR UHV (PEEK)	1	
2	CUSTOM BACKSHELL	DB3 CONNECTOR BACK SHELL (NO EARS) FOR UHV (STAINLESS)	1	
3	94B8812	CRIMP PINS (J2, J3) HARTING # 09 15 000 6126 NEWARK # 94B8812	2	
4	C1	2 COND. (2 WIRES + SHIELD) CABLE WITH SILVER PLATED COPPER BRAID (SHIELD) AND PEEK OVERBRAID	1	60in.
5	SPACER	3/16" SPACER 1/4" LENGTH 0.115" I.D.	1	
6	GLENNAIR 600-052	GLENNAIR 600-052 STANDARD BRAID CLAMP (BAND - IT)	2	

* NOTE: THE OVERALL LENGTH IS MEASURED FROM PIN TIP (3 PIN) TO PIN TIP (CRIMP PINS) OF THE CABLE. THE OTHER MEASUREMENT IS SPACER TO PIN TIPS (CRIMP PINS). USE WHATEVER LENGTH IS NECESSARY FOR THE INTERNAL WIRING OF THE CONNECTORS AND STRIP LENGTH TO ACHIEVE THE CORRECT OVERALL LENGTHS.

- NOTES: (UNLESS OTHERWISE SPECIFIED)
- MATERIAL:
 - a. CONNECTOR SHELL - PEEK VICTREX 450GL30.
 - b. BACKSHELL - STAINLESS STEEL WITH VENT HOLE.
 - c. CONTACTS - BERYLLIUM COPPER ALLOY C17300 0.000050 MIN. GOLD OVER NICKEL
 - d. HARDWARE: CORROSION RESISTANCE STEEL, PASSIVATED
 - e. PEEK BRAID - PEEK VICTREX GRADE TDS-450CA30 CARBON LOADED - SUPPLIED BY LIGO

- CABLE 2 COND. 14 AWG. (STRANDED) WITH 2 LAYERS OF KAPTON TAPE OVERALL 40AWG COPPER BRAID 50% COVERAGE - SUPPLIED BY LIGO OVERALL PEEK BRAID MIN. 50% COVERAGE OVERALL CABLE O.D. WILL BE 0.240 IN.
- CONNECTORS WILL BE SUPPLIED WITH HARDWARE (LENGTH OF SCREWS AS SHOWN ARE APPROXIMATE SCREWS SHOULD BE THE PROPER LENGTH FOR PROPER MATING)

DIMENSIONS ARE IN		TOLERANCES:		ANGULAR ± °	
XX ±		XXX ±		Material <not specified>	
FINISH		μinch		NEXT ASSY	

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM		CUSTOM CABLE SPECIFICATION V3A-60	
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.		SUB-SYSTEM		DESIGNER B. ABBOTT	
3. DO NOT SCALE FROM DRAWING.		SEI		DRAFTER E. BROWN	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		APPROVAL		CHECKER	
		SCALE: 1:1		DWG. NO. D1100151	
		PROJECTION:		REV. v1	
		SHEET 1 OF 1			

V3A-60 CABLE ASSEMBLY CIRCUIT SUMMARY					
V-DB3 F/S1-60-2_PIN-94B8812 M/X					
CABLE NAME	WIRE NAME	WIRE SIZE	LENGTH *	FROM	TO
V3A-60				J1 PIN 1	END OF CABLE
	W1	14 AWG	60in.	J1 PIN 2	J2
	W2	14AWG	60in.	J1 PIN 3	J3

V-DB3 F/S1-60-2_PIN-94B8812 M/X		
STANDARD USE FOR THIS CABLE		
SUBSYSTEM	AIR/VAC	STANDARD USE
SEI	IN-VAC	FROM TABLE TO ISI ACTUATOR

D1100151 CABLE V3A-60-V1 PART PDM REV. DRAWING PDM REV.