REV.	DATE	DCN #	DRAWING TREE #

NOTES CONTINUED:

Ⓢ 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: DXXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

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.

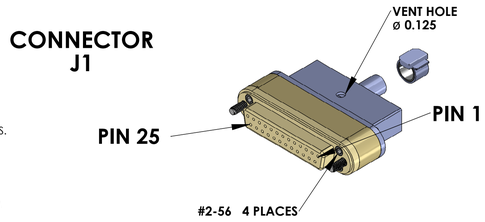
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

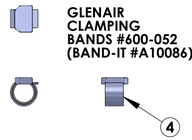
12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

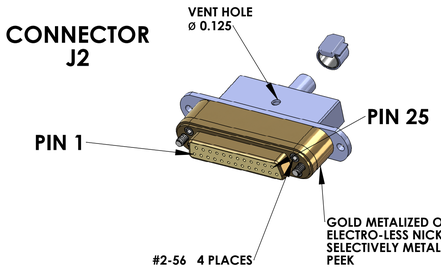
13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.

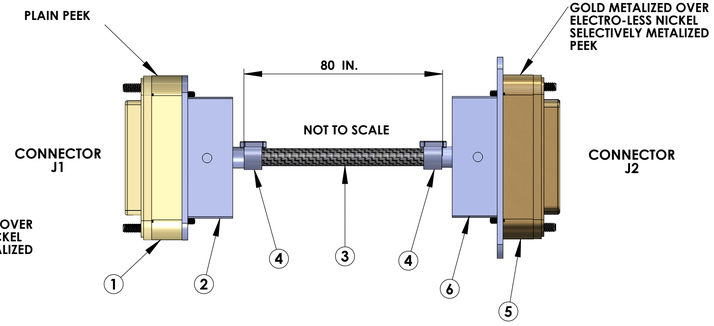
14. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

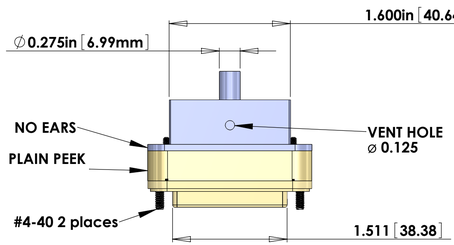
15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

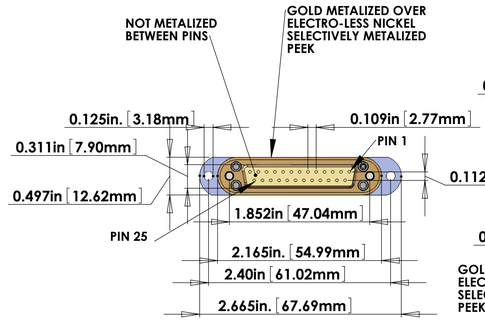


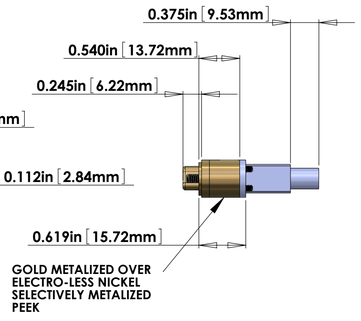


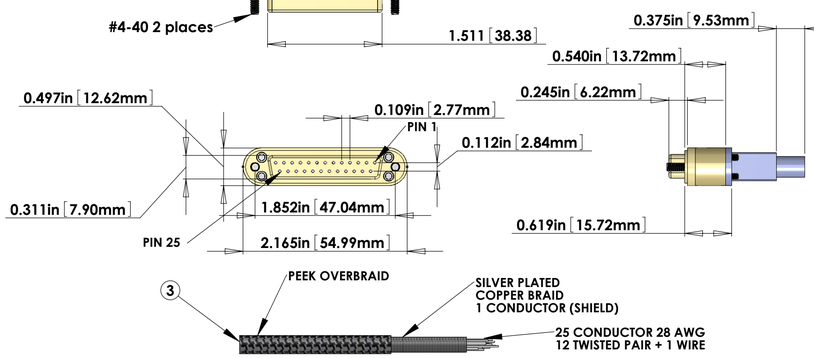


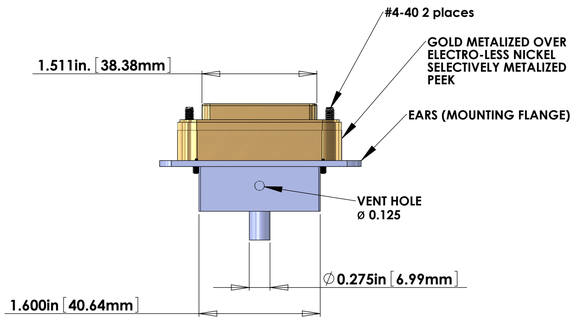












ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	LENGTH
①	CUSTOM DB25 FEMALE	DB25 FEMALE CONNECTOR (J1) FOR UHV (PEEK)	1	
②	CUSTOM BACKSHELL	DB25 CONNECTOR BACKSHELL (NO EARS) FOR UHV (STAINLESS)	1	
③	C1	25 COND. (12 TW PAIR + 1 WIRE + SHIELD) CABLE WITH COPPER BRAID (SHIELD) AND PEEK OVERBRAID	1	80in +
④	GLENAIR CLAMPING BANDS #600-052 (BAND-IT #A10086)	GLENAIR #600-052 STANDARD BRAID CLAMP or BAND-IT PART # A10086 (0.240" WIDE) ("BAG OF 100" #A10089)	2	
⑤	CUSTOM DB25 FEMALE	DB25 FEMALE CONNECTOR (J2) FOR UHV (METALIZED PEEK)	1	
⑥	CUSTOM BACKSHELL	DB25 CONNECTOR BACKSHELL (WITH EARS) FOR UHV (STAINLESS)	1	

*** NOTE: 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)

1. MATERIAL:
   a. J1 CONNECTOR SHELL - PEEK VICTREX 450GL30
   b. J2 CONNECTOR SHELL - SELECTIVELY METALIZED OVER PEEK VICTREX 450GL30.
   c. BACKSHELLS - STAINLESS STEEL WITH VENT HOLE.
   d. CONTACTS - BERYLLIUM COPPER ALLOY C17300
      0.000050 MIN. GOLD OVER NICKEL
   e. HARDWARE: CORROSION RESISTANCE STEEL, PASSIVATED
   f. PEEK BRAID - PEEK VICTREX GRADE TDS-450CA30 CARBON LOADED - SUPPLIED BY LIGO

2. CABLE 25 COND. 28 AWG, (40 STRD 44 AWG) WITH 2 LAYERS OF KAPTON TAPE
   12 TWISTED PAIRS (4 TO 5 TWISTS PER INCH) + 1 WIRE
   OVERALL 40AWG COPPER BRAID 50% COVERAGE - SUPPLIED BY LIGO
   OVERALL PEEK BRAID MIN. 50% COVERAGE
   OVERALL CABLE O.D. WILL BE 0.240 IN.

3. CONNECTORS WILL BE SUPPLIED WITH HARDWARE LENGTH OF SCREWS AS SHOWN ARE APPROXIMATE

4. SCREWS SHOULD BE THE PROPER LENGTH FOR PROPER MATING

V25A-80 CABLE ASSEMBLY CIRCUIT SUMMARY
V-DB25 F/S1-80-DB25 F/S1

CABLE NAME	COND.-WIRE ID	TWISTED PAIR	LENGTH *	FROM	TO
V25A-80	25 COND. CABLE	(12 TOTAL)	80 in.	Conn. J1	Conn. J2
	W1	SHIELD	80 in	PIN 1, SHELL	PIN 1, SHELL
	W2	**TP-1**	**80 in**	**PIN 2**	**PIN 2**
	W14		**80 in**	**PIN 14**	**PIN 14**
	W3	TP-2	80 in	PIN 3	PIN 3
	W15		80 in	PIN 15	PIN 15
	W4	**TP-3**	**80 in**	**PIN 4**	**PIN 4**
	W16		**80 in**	**PIN 16**	**PIN 16**
	W5	TP-4	80 in	PIN 5	PIN 5
	W17		80 in	PIN 17	PIN 17
	W6	**TP-5**	**80 in**	**PIN 6**	**PIN 6**
	W18		**80 in**	**PIN 18**	**PIN 18**
	W7	TP-6	80 in	PIN 7	PIN 7
	W19		80 in	PIN 19	PIN 19
	W8	**TP-7**	**80 in**	**PIN 8**	**PIN 8**
	W20		**80 in**	**PIN 20**	**PIN 20**
	W9	TP-8	80 in	PIN 9	PIN 9
	W21		80 in	PIN 21	PIN 21
	W10	**TP-9**	**80 in**	**PIN 10**	**PIN 10**
	W22		**80 in**	**PIN 22**	**PIN 22**
	W11	TP-10	80 in	PIN 11	PIN 11
	W23		80 in	PIN 23	PIN 23
	W12	**TP-11**	**80 in**	**PIN 12**	**PIN 12**
	W24		**80 in**	**PIN 24**	**PIN 24**
	W13	TP-12	80 in	PIN 13	PIN 13
	W25		80 in	PIN 25	PIN 25

*** The length shown in this list is the length of the cable between the two connectors. Add additional length as necessary for the internal wiring of the connectors and strip length.**

V-DB25 F/S1-80-DB25 F/S1		
STANDARD USE FOR THIS CABLE		
SUBSYSTEM	AIR/VAC	STANDARD USE
SEI	IN-VAC	FROM FLANGE TO BRACKET GS-13,L-4C

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN

TOLERANCES:
.XX ±
.XXX ±

ANGULAR ± °

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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: Material <not specified>

FINISH: µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: LIGO

SUB-SYSTEM: SEI, ISC

NEXT ASSY

PART NAME: **CUSTOM CABLE SPECIFICATION V25A-80**

DESIGNER	B.ABBOTT	OCT/03/2011	SIZE	DWG. NO.	REV.
DRAFTER	E.BROWN	OCT/03/2011	D	D1100153	v4
CHECKER					
APPROVAL			SCALE: 1:1	PROJECTION:	SHEET 1 OF 1