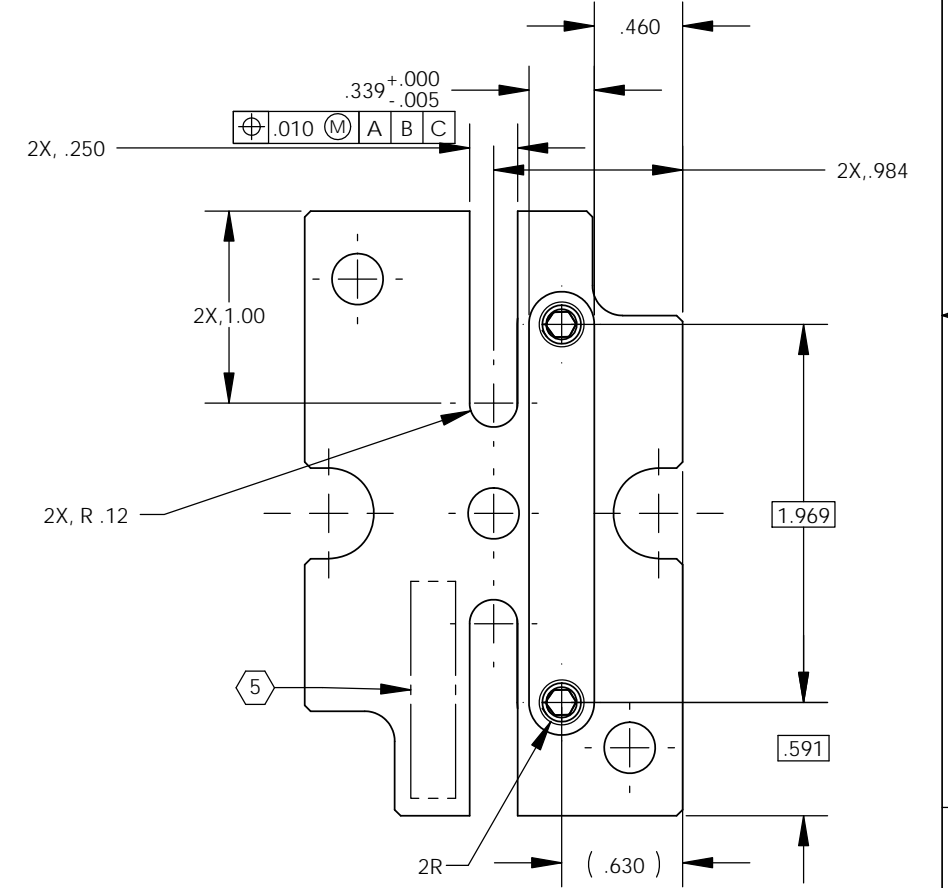
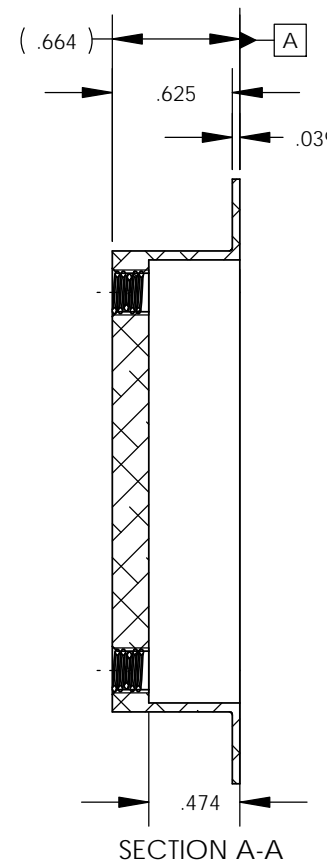
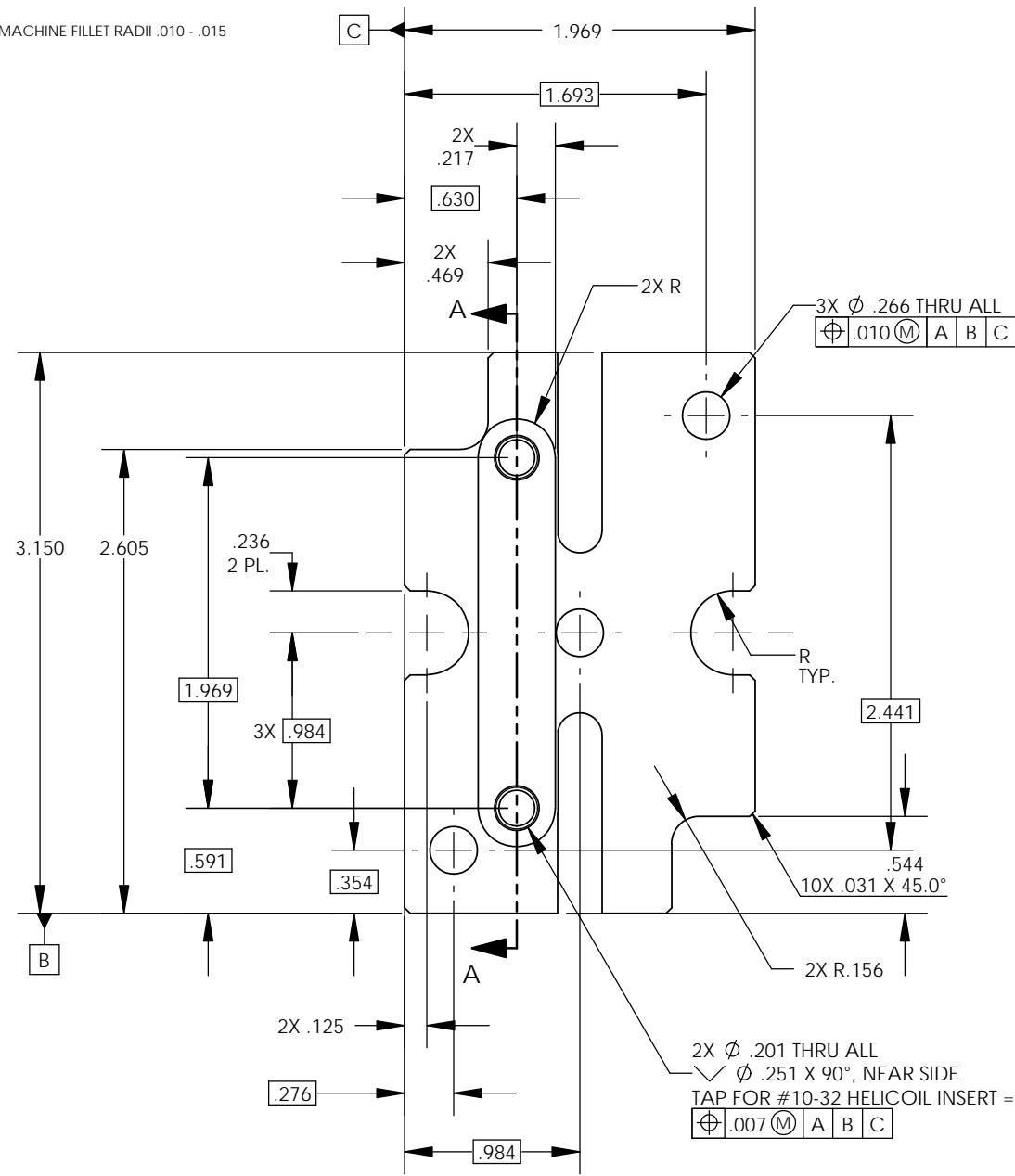
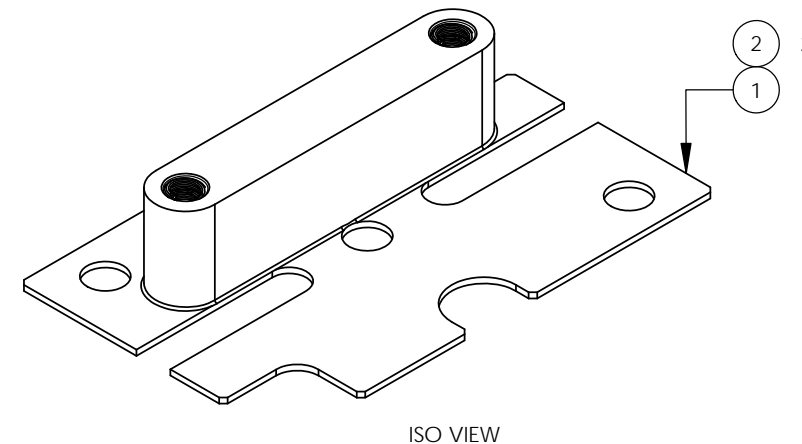


D1102133 ALIGO, SUS, QUAD NPTYPE WIRING HARNESS, MASS WIRE CLAMP (REDESIGNED), PART PDM REV: X-003, DRAWING PDM REV: X-005

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 = 0.038 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	02 NOV 2011	-	-
v2	10 NOV 2011	E1101092-x0	-
v3	01 DEC 2011	E1101132-x0	-
v4	13 APR 12	E1200387-x0	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
2	3591-3EN190	HELICOIL, 10-32 X 1 DIA.	NITRONIC 60	2
1	D1102133-1	ALIGO, SUS, QUAD, NPTYPE WIRING HARNESS, 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 DRAWINGS.
 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

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

DESIGNER	E.SANCHEZ	02 NOV 2011	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	02 NOV 2011	B	D1102133	v4
CHECKER	SEE DCC	SEE DCC	SCALE:	1:1	PROJECTION:
APPROVAL	SEE DCC	SEE DCC	SHEET 1 OF 1		

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS NEXT ASSY: D1102146

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1