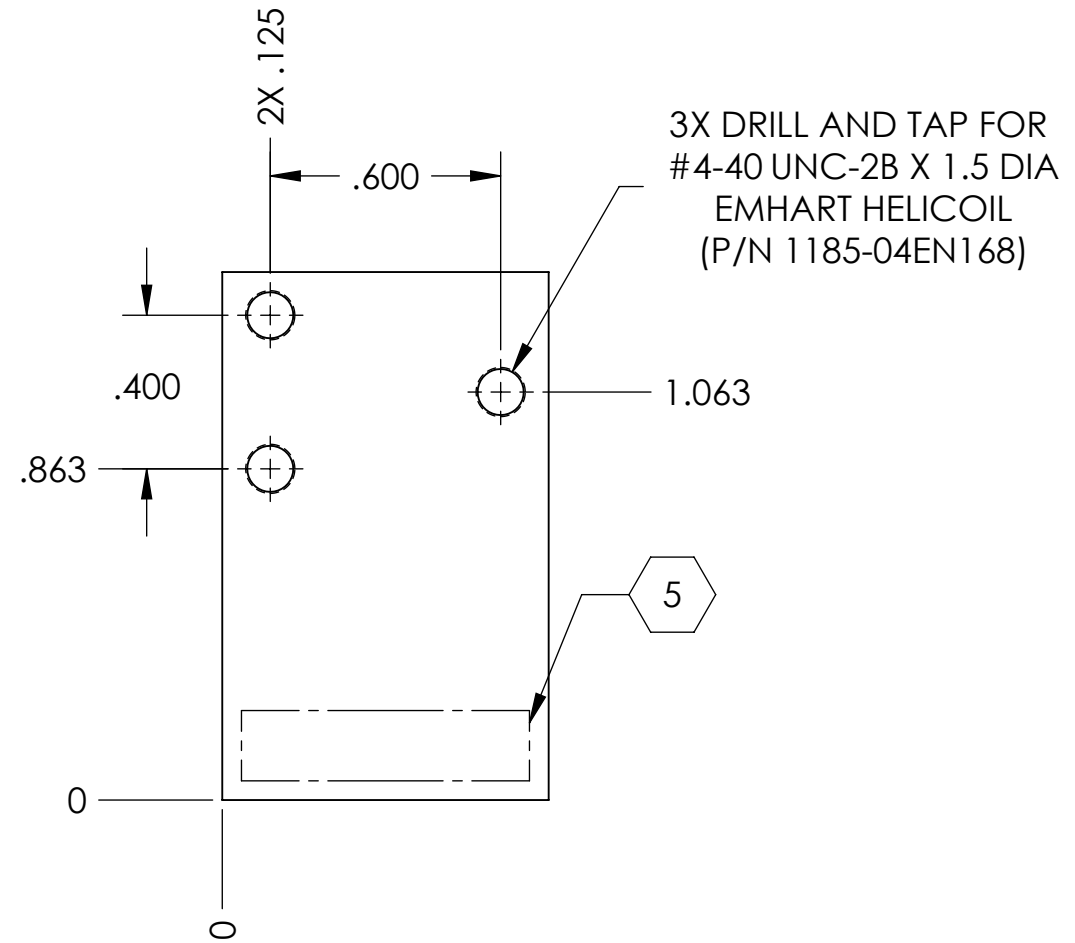
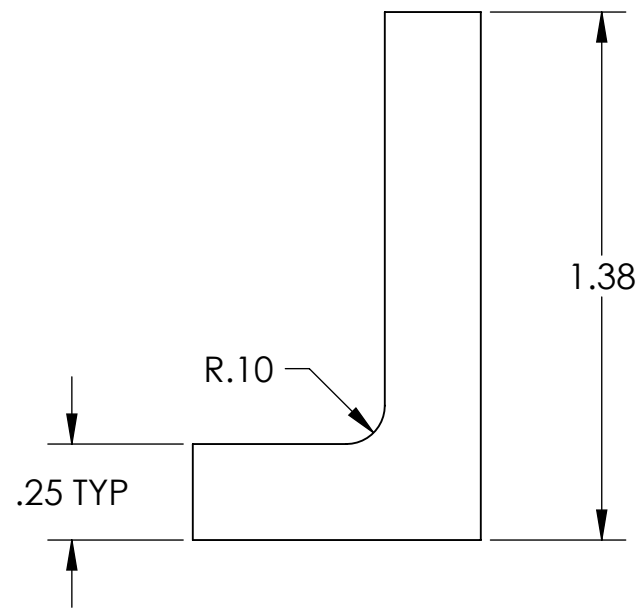
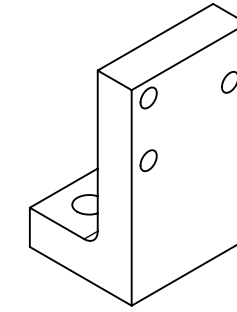
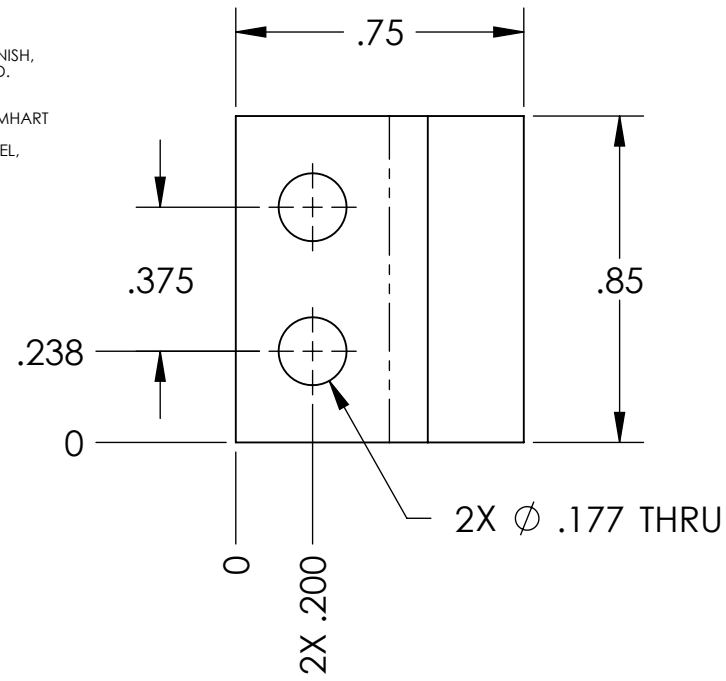


D0902533\_AdvLIGO\_SUS\_HSTS\_Intermediate Wire Jig Mass Wire Clamp Bracket, PART PDM REV: X-005, DRAWING PDM REV: X-006

- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE, 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 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
  6. APPROXIMATE WEIGHT = 0.037 LB.
  7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
  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.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 APR 2010	E0900504	E0900353
v2	02 SEP 2010	E1000347	E0900353
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
DIMENSIONS ARE IN INCHES		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SUS		MASS WIRE CLAMP BRACKET, HSTS INTERMEDIATE WIRE JIG				
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL 6061-T6 Al		FINISH 63 μinch		NEXT ASSY D0902526		DESIGNER M. MEYER	29 OCT 2009	SIZE B	DWG. NO. D0902533	REV. v2
ANGULAR ± 0.5°								CHECKER M. MEYER	17 FEB 2010	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1