

REV.	DATE	DCN #	DRAWING TREE #

- NOTES CONTINUED:
- SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON INDICATED SURFACES 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: A DXXXXXVY, 5/N, 001 VIBRATORY TOOL MAY BE USED.
 - APPROXIMATE WEIGHT - X.XXX LB.
 - MACHINE ALL SURFACES TO REMOVE CHISELS AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO E990364.
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E990364.
 - ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4.
 - ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE WIRING: 60 THREADED INSERTS.
 - 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 E990364.
 - SURFACE FINISH TO BE AS PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E100083 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.
 - DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
 - 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.

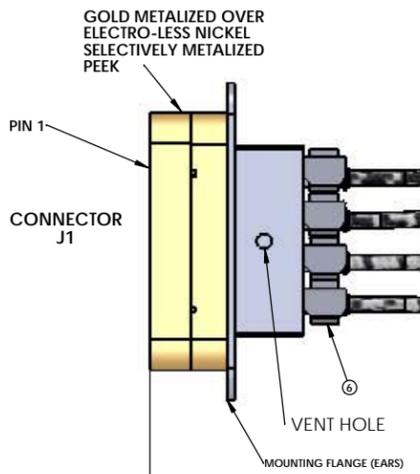
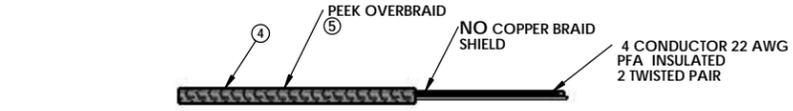
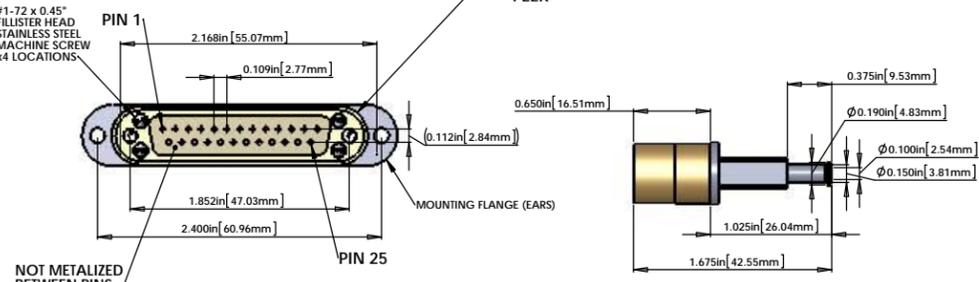
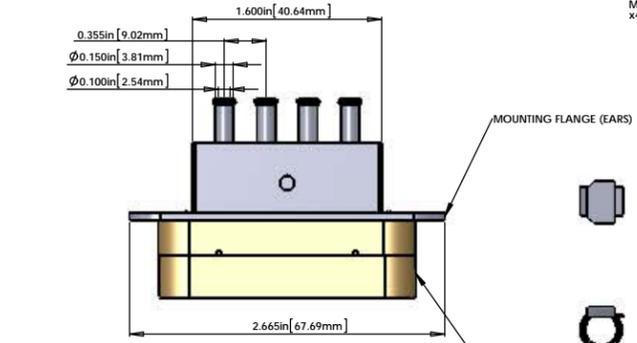
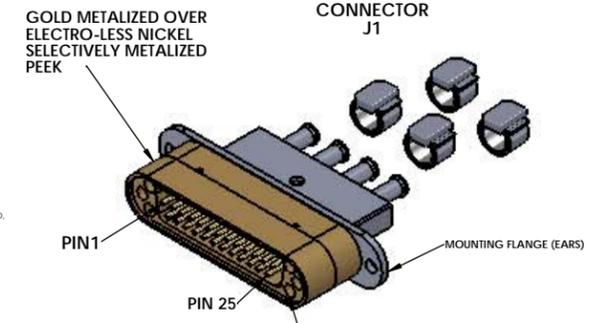
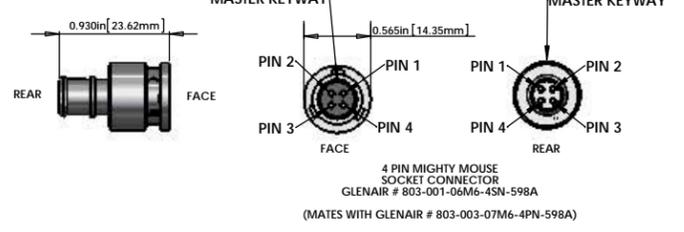
NOTES 13 and 14 DO NOT APPLY TO THIS PART

V25AC-36 CABLE ASSEMBLY CIRCUIT SUMMARY V-DB25 M/S1-36-4_MM4PIN F/X			
FROM			
CONNECTOR J1 - 25 PIN SUBMINI_D CONNECTOR (GOLD METALIZED PEEK)			
PIN	WIRE NAME	LENGTH *	TWISTED PAIR
1, SHELL	NOT CONNECTED		
13	(CABLE 1) WIRE 13	36"	TP-1
25	(CABLE 1) WIRE 25	36"	TP-1
12	(CABLE 1) WIRE 12	36"	TP-2
24	(CABLE 1) WIRE 24	36"	TP-2
11	(CABLE 2) WIRE 11	36"	TP-3
23	(CABLE 2) WIRE 23	36"	TP-3
10	(CABLE 2) WIRE 10	36"	TP-4
22	(CABLE 2) WIRE 22	36"	TP-4
9	(CABLE 3) WIRE 9	36"	TP-5
21	(CABLE 3) WIRE 21	36"	TP-5
8	(CABLE 3) WIRE 8	36"	TP-6
20	(CABLE 3) WIRE 20	36"	TP-6
7	(CABLE 4) WIRE 7	36"	TP-7
19	(CABLE 4) WIRE 19	36"	TP-7
6	(CABLE 4) WIRE 6	36"	TP-8
18	(CABLE 4) WIRE 18	36"	TP-8

PIN 14,2,15,3,16,4,17,5 N/C (NOT CONNECTED)

SEE REFERENCE DCC# LIGO-D1100670

CONNECTOR J2, J3, J4, J5



NO COPPER BRAID SHIELD ON CABLE # 1,2,3,4

36" [914.4mm]

NOT TO SCALE

V25AC-36 CABLE #4 ASSEMBLY CIRCUIT SUMMARY		
TO		
CONNECTOR J5 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL	NOT CONNECTED	
1	(CABLE 4) WIRE 7	PICOMOTOR PAIR M4 HORIZONTAL SIGNAL
2	(CABLE 4) WIRE 19	PICOMOTOR PAIR M4 HORIZONTAL RETURN
3	(CABLE 4) WIRE 6	PICOMOTOR PAIR M4 VERTICAL SIGNAL
4	(CABLE 4) WIRE 18	PICOMOTOR PAIR M4 VERTICAL RETURN

V25AC-36 CABLE #3 ASSEMBLY CIRCUIT SUMMARY		
TO		
CONNECTOR J4 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL	NOT CONNECTED	
1	(CABLE 3) WIRE 9	PICOMOTOR PAIR M3 HORIZONTAL SIGNAL
2	(CABLE 3) WIRE 21	PICOMOTOR PAIR M3 HORIZONTAL RETURN
3	(CABLE 3) WIRE 8	PICOMOTOR PAIR M3 VERTICAL SIGNAL
4	(CABLE 3) WIRE 20	PICOMOTOR PAIR M3 VERTICAL RETURN

V25AC-36 CABLE #2 ASSEMBLY CIRCUIT SUMMARY		
TO		
CONNECTOR J3 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL	NOT CONNECTED	
1	(CABLE 2) WIRE 11	PICOMOTOR PAIR M2 HORIZONTAL SIGNAL
2	(CABLE 2) WIRE 23	PICOMOTOR PAIR M2 HORIZONTAL RETURN
3	(CABLE 2) WIRE 10	PICOMOTOR PAIR M2 VERTICAL SIGNAL
4	(CABLE 2) WIRE 22	PICOMOTOR PAIR M2 VERTICAL RETURN

V25AC-36 CABLE #1 ASSEMBLY CIRCUIT SUMMARY		
TO		
CONNECTOR J2 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL	NOT CONNECTED	
1	(CABLE 1) WIRE 13	PICOMOTOR PAIR M1 HORIZONTAL SIGNAL
2	(CABLE 1) WIRE 25	PICOMOTOR PAIR M1 HORIZONTAL RETURN
3	(CABLE 1) WIRE 12	PICOMOTOR PAIR M1 VERTICAL SIGNAL
4	(CABLE 1) WIRE 24	PICOMOTOR PAIR M1 VERTICAL RETURN

BILL OF MATERIALS				
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	LENGTH
1	TICOR # TS0125-3	DB25 MALE CONNECTOR (J1) FOR UHV (GOLD METALIZED PEEK)	1	
2		DB25 CONNECTOR BACKSHELL FOR UHV (STAINLESS)	1	
3	GLENNAIR # 803-001-06M6-4SN-598A	MIGHTY MOUSE SOCKET CONNECTOR (J2,J3,J4,J5)	4	
4	COONER WIRE # CZ2205 22GA PFA INSULATED BIOMEDICAL WIRE	4 COND. CABLE 22GA PFA INSULATED (WITH PEEK OVERBRAID) NO SHIELD. - PARTS SUPPLIED BY LIGO	4	36 in.*
5	PART # 6759	PEEK BRAID - PART #6759 MANUFACTURED WITH ZEUS 0.016" BLACK PEEK DRAWN MONOFILAMENT - SUPPLIED BY LIGO	4	
6	GLENNAIR # 600-052 or BAND-IT # A10086	GLENNAIR # 600-052 STANDARD BRAID CLAMP or BAND-IT PART # A10086 (0.240" WIDE) ("BAG OF 100" # A10089)	8	

* NOTE: THE OVERALL LENGTH IS MEASURED FROM PIN TIP (25 PIN) TO PIN TIP (4 PIN) OF THE CABLE. USE WHATEVER LENGTH IS NECESSARY FOR THE INTERNAL WIRING OF ALL THE CONNECTORS AND STRIP LENGTH TO ACHIEVE THE CORRECT OVERALL LENGTH.

NOTES: (UNLESS OTHERWISE SPECIFIED)

- A. MATERIAL: a. J1 - CONNECTOR SHELL - GOLD OVER ELECTRO-LESS NICKEL SELECTIVELY METALIZED PEEK VICITREX 450GL30.
b. BACKSHELL - STAINLESS STEEL WITH VENT HOLE.
c. CONTACTS - BERYLLIUM COPPER ALLOY C 17300 0.00050 MIN. GOLD OVER NICKEL.
d. HARDWARE: STAINLESS STEEL, PASSIVATED.
e. PEEK BRAID - PEEK VICITREX GRADE IDS-450CA30 CARBON LOADED.

- B. CABLE 4 COND. 22 AWG, WITH PFA INSULATION COONER WIRE #CZ2205. OVERALL PEEK BRAID MIN. 50% COVERAGE. OVERALL CABLE O.D. WILL BE APPROX. 0.200 IN.

- C. CONNECTORS WILL BE SUPPLIED WITH HARDWARE. (LENGTH OF SCREWS AS SHOWN ARE APPROXIMATE SCREWS SHOULD BE THE PROPER LENGTH FOR PROPER MATING).

TEST LIST	
FROM	TO
J1	J2
PIN	PIN
J1 - 1, SHELL	J2 - NOT CONNECTED
J1 - 13	J2 - 1
J1 - 25	J2 - 2
J1 - 12	J2 - 3
J1 - 24	J2 - 4

TEST LIST	
FROM	TO
J1	J3
PIN	PIN
J1 - 1, SHELL, SHIELD	J3 - NOT CONNECTED
J1 - 11	J3 - 1
J1 - 23	J3 - 2
J1 - 10	J3 - 3
J1 - 22	J3 - 4

TEST LIST	
FROM	TO
J1	J4
PIN	PIN
J1 - 1, SHELL, SHIELD	J4 - NOT CONNECTED
J1 - 9	J4 - 1
J1 - 21	J4 - 2
J1 - 8	J4 - 3
J1 - 20	J4 - 4

TEST LIST	
FROM	TO
J1	J5
PIN	PIN
J1 - 1, SHELL, SHIELD	J5 - NOT CONNECTED
J1 - 7	J5 - 1
J1 - 19	J5 - 2
J1 - 6	J5 - 3
J1 - 18	J5 - 4

V25AC - V-DB25 M/S1-36-4_MM4PIN F/S		
STANDARD USE FOR THIS CABLE		
SUBSYSTEM	AIR/VAC	STANDARD USE
ISC	IN-VAC	PICOMOTORS TABLE TO MOTORS

NOTES AND TOLERANCES: UNLESS OTHERWISE SPECIFIED

1. INTERPRET DRAWING PER ASME Y14.5-1994.

2. REMOVE ALL SHARP EDGES. 100% OIS FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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.

DIMENSIONS ARE IN: TOLERANCES: .XXX ± .XXX ± ANGULAR: ±

MATERIAL: FINISH: NEXT ASSY: SCALE: 2:1 PROJECTION: SHEET 1 OF 1

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: CUSTOM CABLE SPECIFICATION V25AC-36

DESIGNER: R. ABBOTT DATE: 2/20/12 DRAFTER: E. BROWN DATE: 2/20/12 CHECKER: APPROVAL: SCALE: 2:1 PROJECTION: SHEET 1 OF 1

REV: v5