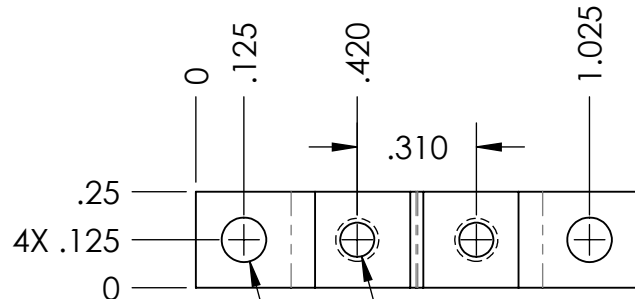


NOTES CONTINUED:

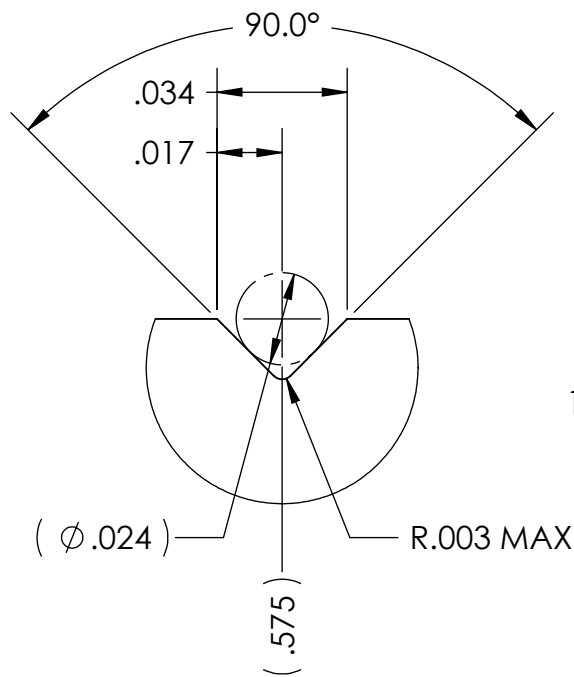
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 MAY 2009	E0900160	E080191
v2	21 JAN 2011	E1100057	E080191
-	-	-	-

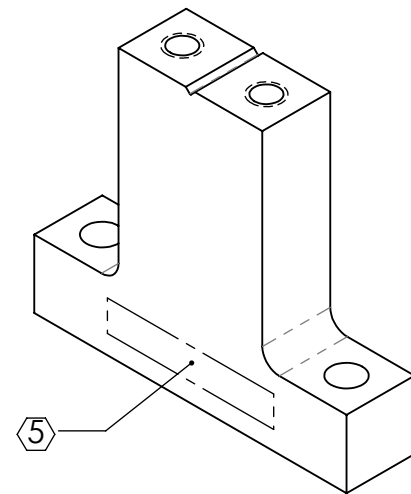
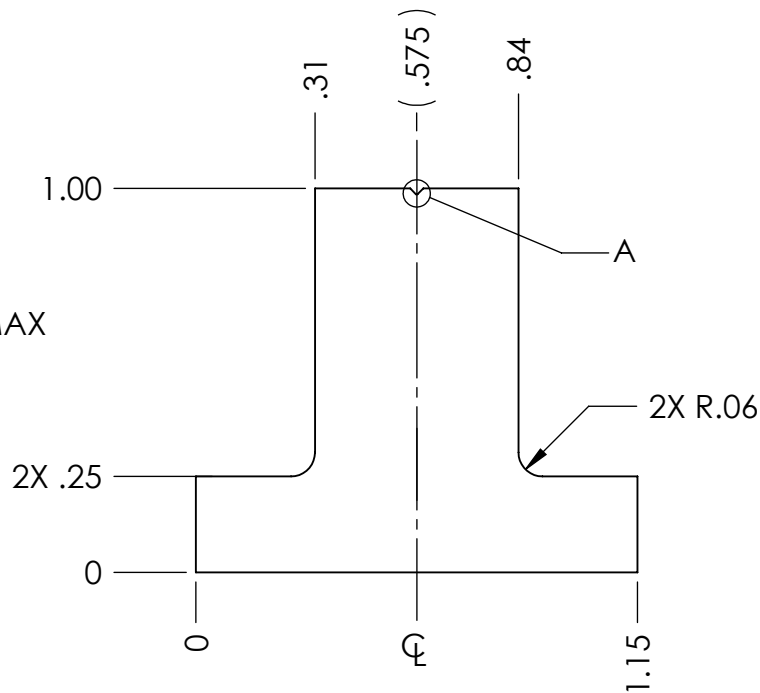


2X ϕ .089 ∇ .38
 #4-40 UNC ∇ .25
 +.005 OVERSIZE TAP

2X ϕ .116 THRU



DETAIL A
SCALE 20 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX \pm .01
 .XXX \pm .005

ANGULAR \pm 0.5°

- 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.

MATERIAL 304, 316 OR 302 SSSL
 FINISH 63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS

NEXT ASSY UPPER WIRE JIG, HLTS

PART NAME

WIRE START CLAMP, INSIDE

DESIGNER D. BRIDGES 21 JAN 2011
 DRAFTER D. BRIDGES 21 JAN 2011
 CHECKER B. MOORE 21 JAN 2011
 APPROVAL

SIZE DWG. NO. A D0900603
 REV. v2

SCALE: 2:1 PROJECTION: SHEET 1 OF 1