

REV.	DATE	DCN #	DRAWING TREE #
A	24 JUNE 2004	E040303-00	

D030049_ASSEMBLY_INT_WIRE_JIG.step

ITEM NO	REQ.	SPARE	TOT.	PART NUMBER	DESCRIPTION	MATERIAL
9	4	4	8		Ag-SST SOCKET HEAD CAP SCREW #2-56 UNC-3A X 0.3125 LONG	300 SSSL
8	2	2	4	D020159	LOWER BLADE WIRE JIG (INTERMEDIATE WIRES)	6061-T6-AI
7	4	4	8		SST SOCKET HEAD CAP SCREW 0.25-20 UNC-3A X 1.125 LONG	300 SSSL
6	4	4	8	D980184	LOS CLAMP LONG	300 SSSL
5	4	4	8		SST SOCKET HEAD CAP SCREW #8-32 UNC-3A X 0.375 LONG	300 SSSL
4	2	2	4		SST SOCKET HEAD CAP SCREW #4-40 UNC-3A X 0.5 LONG	300 SSSL
3	1	1	2	D020380	WIRE START CLAMP UPPER	6061-T6-AI
2	1	1	2	D020376	WIRE START GROOVED CLAMP	6061-T6-AI
1	1	1	2	D020153	BAR JIG (UPPER AND INT. WIRE)	6061-T6-AI

PARTS LIST

NOTES: (UNLESS OTHERWISE SPECIFIED)

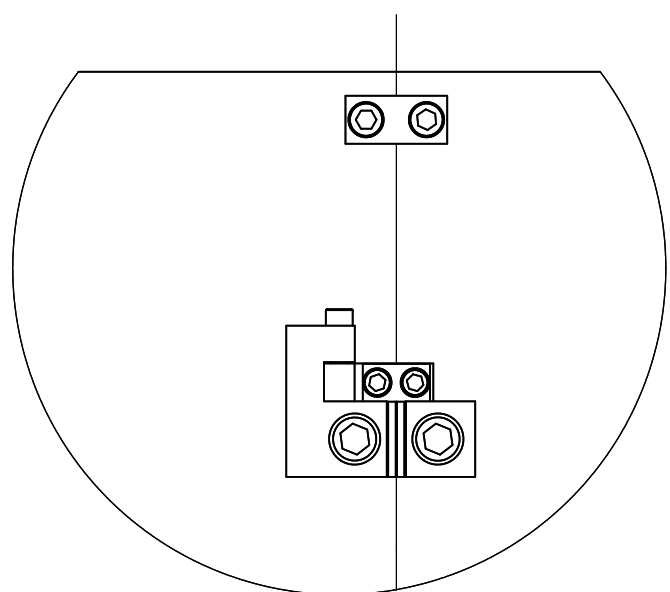
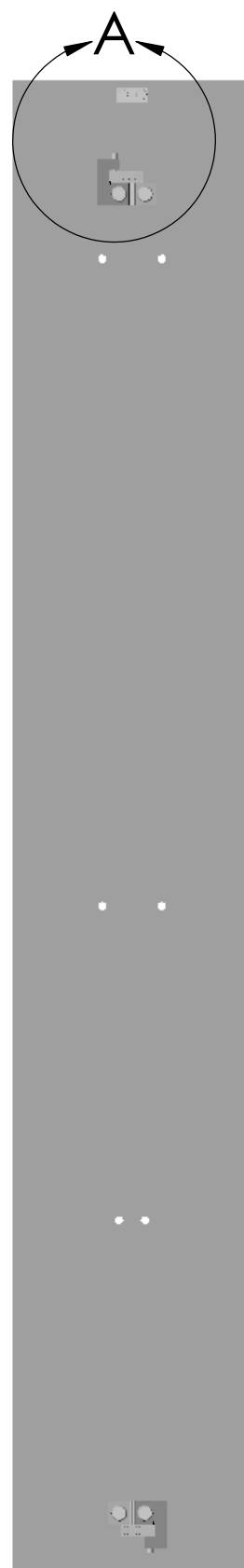
- 1) WIRE USED IS 0.008 THOU DIAMETER MUSIC WIRE.
- 2) MASS SUSPENDED IS 3kg, THIS SHOULD BE LEFT FOR APPROX. 1 HOUR.
- 3) CLAMP-WIRE-CLAMP ASSEMBLY SHOULD BE REMOVED BY LOOSENING WIRE JIG D020159, ITEM NO. 2

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± 0.01
.XXX ± 0.005
ANGULAR ± 0.5 °

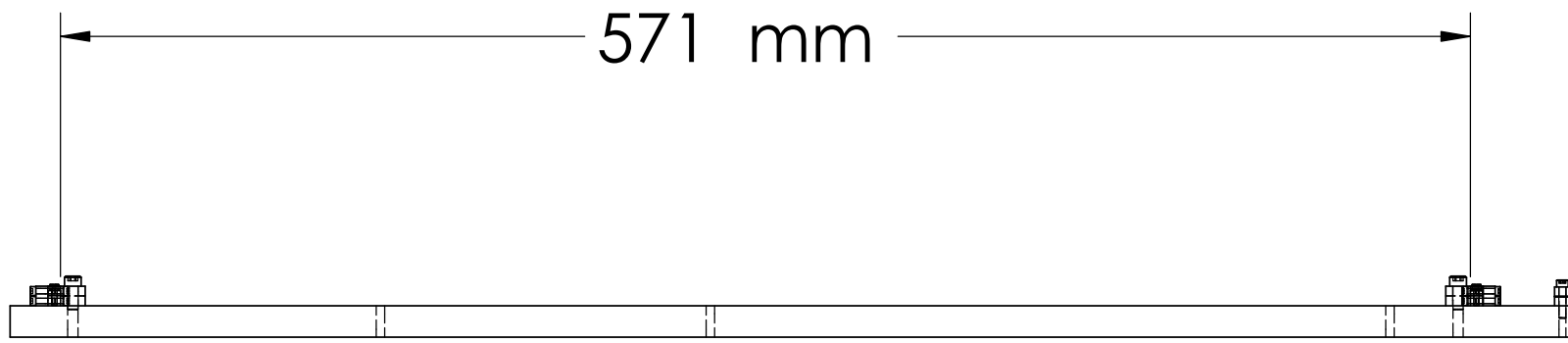
NAME	DATE	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
DRAWN CIT	02/03/03	
CHECKED		SYSTEM ADVANCED LIGO SUB-SYSTEM SUS NEXT ASSY MC: WIRE JIG PART NAME ASSEMBLY INTERMEDIATE WIRE JIG
SIZE B	DWG. NO. D030049	REV. A SCALE: NTS PROJECTION: SHEET 1 OF 2

FILE NAME/LOCATION: ERROR!File name / Location

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DETAIL A
SCALE 1 : 1



PARTS LIST			
<p>NOTES: (UNLESS OTHERWISE SPECIFIED)</p> <p>1. REMOVE ALL SHARP EDGES, R.02 MIN. 2. DO NOT SCALE FROM DRAWING. 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)</p> <p>④ SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.</p>		<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES: .XX ± 0.01 .XXX ± 0.005</p> <p>ANGULAR ± 0.5 °</p>	
<p>FINISH</p>		<p>MATERIAL</p>	
<p>DRAWN</p>		<p>NAME</p>	
<p>CHECKED</p>		<p>DATE</p>	
<p>APPROVED</p>		<p>SIZE</p>	
<p>B</p>		<p>DWG. NO. D030049</p>	
<p>SCALE: 1:8</p>		<p>PROJECTION: </p>	
<p>SYSTEM ADVANCED LIGO</p>		<p>REVISION REV. A</p>	
<p>SUB-SYSTEM SUS</p>		<p>REVISION REV. A</p>	
<p>NEXT ASSY MC: WIRE JIG</p>		<p>REVISION REV. A</p>	
<p>PART NAME ASSEMBLY INTERMEDIATE WIRE JIG</p>		<p>REVISION REV. A</p>	
<p>SCALE: 1:8</p>		<p>PROJECTION: </p>	
<p>SIZE B</p>		<p>SHEET 2 OF 2</p>	



SYSTEM ADVANCED LIGO
SUB-SYSTEM SUS
NEXT ASSY MC: WIRE JIG
PART NAME ASSEMBLY INTERMEDIATE WIRE JIG
SCALE: 1:8
PROJECTION:
SHEET 2 OF 2