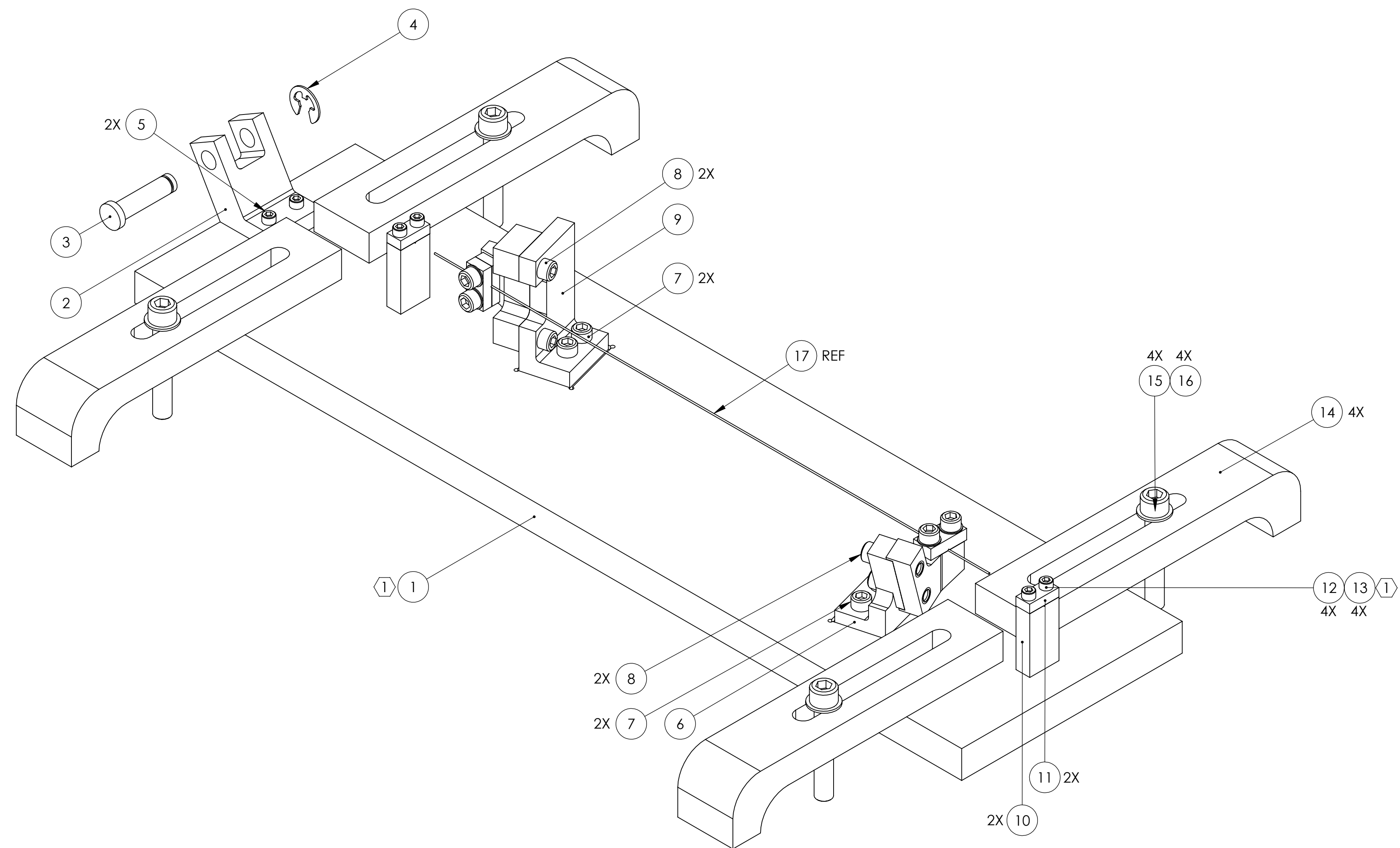


REV.	DATE	DCN #	DRAWING TREE #
v1	26 MAY 2009	E0900160	E080191
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
17	D070340	UPPER WIRE ASSEMBLY	N/A	REF	0	0
16	-	WASHER, FLAT, 1/4 (NAS 620-C416L OR EQUIVALENT)	300 SSSL	4	1	5
15	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 1.5 LONG	300 SSSL	4	1	5
14	D980184	LOS CLAMP, LONG	304, 316 OR 302 SSSL	4	0	4
13	1185-04EN336	HELICOIL, #4-40 X 0.336 LONG (1)	NITRONIC 60	4	2	6
12	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 1.5 LONG	300 SSSL	4	1	5
11	D020380	WIRE START CLAMP, OUTSIDE	304, 316 OR 302 SSSL	2	1	3
10	D0900603	WIRE START CLAMP, INSIDE	304, 316 OR 302 SSSL	2	1	3
9	D0900597	WIRE CLAMP MOUNT	6061-T6 Al	1	0	1
8	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.625 LONG	300 SSSL	4	1	5
7	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	300 SSSL	4	1	5
6	D0900596	BLADE CLAMP MOUNT	6061-T6 Al	1	0	1
5	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.5 LONG	300 SSSL	2	1	3
4	98408A120	RETAINING RING (MCMaster-CARR P/N)	300 SSSL	1	1	2
3	92735A230	CLEVIS PIN (MCMaster-CARR P/N)	300 SSSL	1	1	2
2	D0900563	PIN SUPPORT, WIRE JIG	6061-T6 Al	1	0	1
1	D0900595	BASE PLATE (1)	6061-T6 Al	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 ① HELICOILS TO BE INSTALLED INTO ITEM NO. 1 BY LIGO PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.
 2. THIS JIG TO BE USED IN THE ASSEMBLY OF D070340 HLTS UPPER WIRE ASSEMBLY AS DESCRIBED IN E080208 HLTS ASSEMBLY SPECIFICATION.

MATERIAL: N/A
 FINISH: N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: HLTS OVERALL ASSY AND FIXTURES

PART NAME: UPPER WIRE JIG ASSY, HLTS

DESIGNER: M. MEYER 01 APR 2009 SIZE: DWG. NO.
 DRAFTER: B. MOORE 29 APR 2009 D: D0900594 REV. v1
 CHECKER: D. BRIDGES 07 JUN 2009

APPROVAL: [Signature] SCALE: 1:1 PROJECTION: [Symbol] SHEET 1 OF 1

D0900594_Advanced_LIGO_SUS_HLTS_Upper_Wire_Jig_Assembly_PRT_PDM_REV-X-015_DRAWING_PDM_REV-X-006