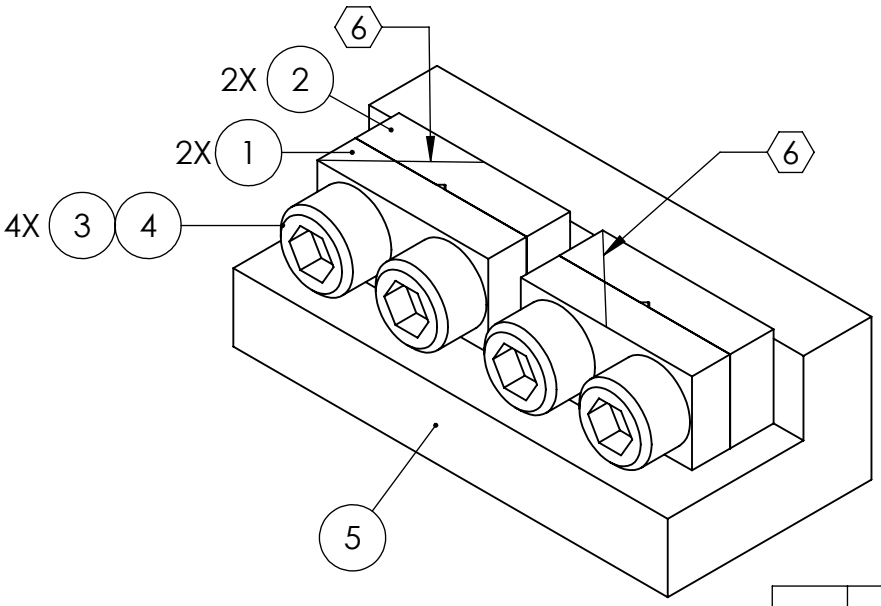
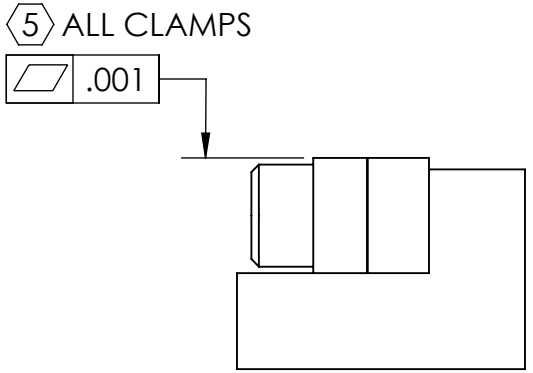
NOTES CONTINUED:

⑤ FLY CUT INDICATED SURFACES AFTER ASSEMBLY TO ACHIEVE DESIRED FLATNESS.

⑥ SCRIBE OR ETCH LINE APPROXIMATELY AS SHOWN .02 DEEP X .02 WIDE AFTER FLYCUTTING AND PRIOR TO DISASSEMBLY.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 MAY 2009	E0900160	E080191
v2	12 AUG 2009	E0900239	E080191
-	-	-	-





ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
5	D0901135	MOUNTING BLOCK, LOWER CLAMP, UPPER WIRE	6061-T6 Al	1	0	1
4	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	300 SSTL	4	0	4
3	1185-2EN246	HELICOIL, #8-32 X 0.246 LONG	NITRONIC 60	4	2	6
2	D020624	LOWER CLAMP, UPPER WIRE, OUTSIDE	304, 316 OR 302 SSTL	2	0	2
1	D020610	LOWER CLAMP, UPPER WIRE, INSIDE	304, 316 OR 302 SSTL	2	0	2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .001

ANGULAR ± 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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL: N/A

FINISH: N/A µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SUS

NEXT ASSY: UPPER WIRE ASSEMBLY

PART NAME: LOWER CLAMP ASSEMBLY, UPPER WIRE

DESIGNER	D. BRIDGES	28 MAY 2009	
DRAFTER	D. BRIDGES	14 AUG 2009	
CHECKER	J. ROMIE	14 AUG 2009	
APPROVAL			

SIZE: A

DWG. NO.: D0901079

REV.: v2

SCALE: 2:1

PROJECTION:

SHEET 1 OF 1