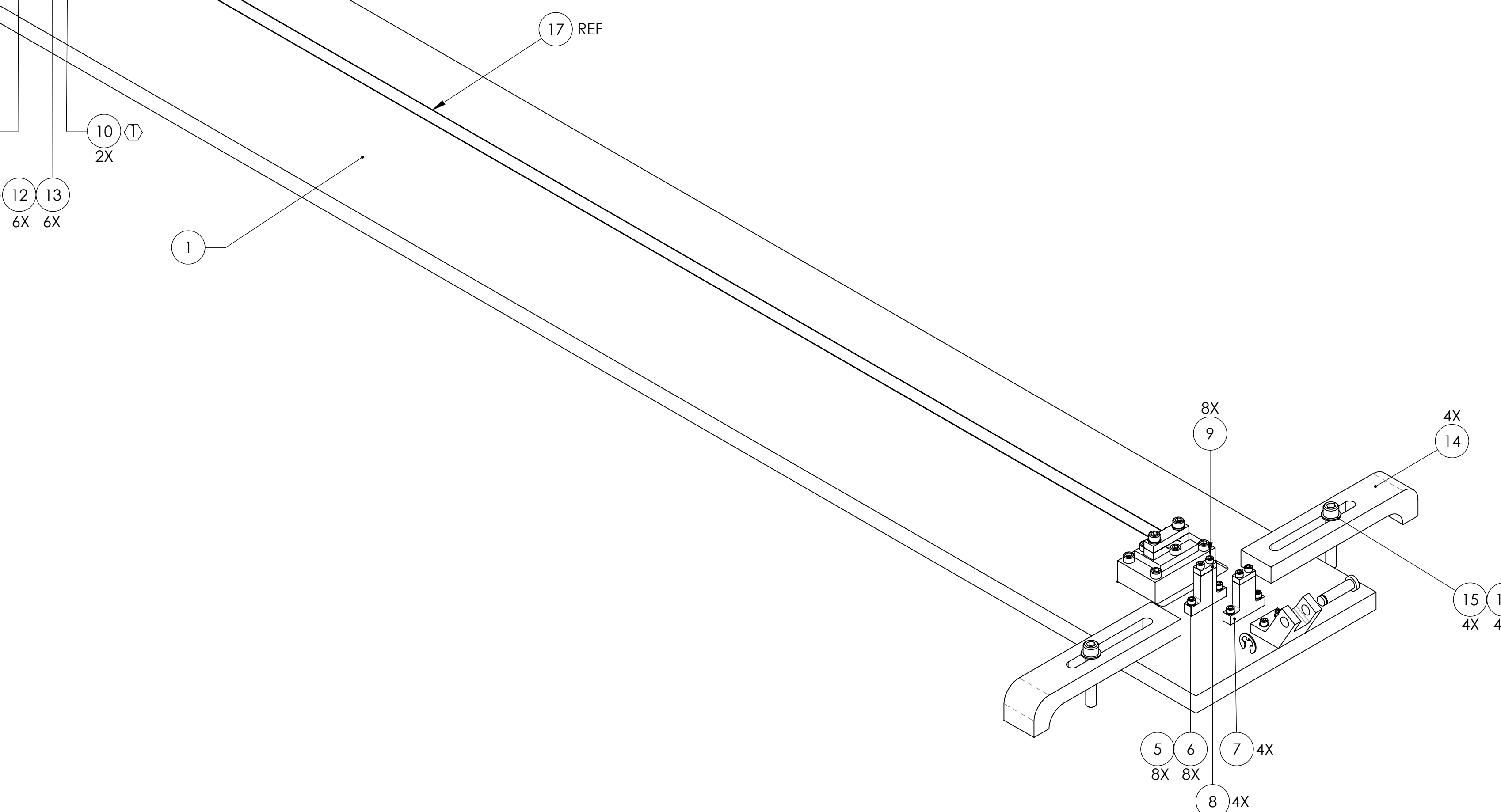
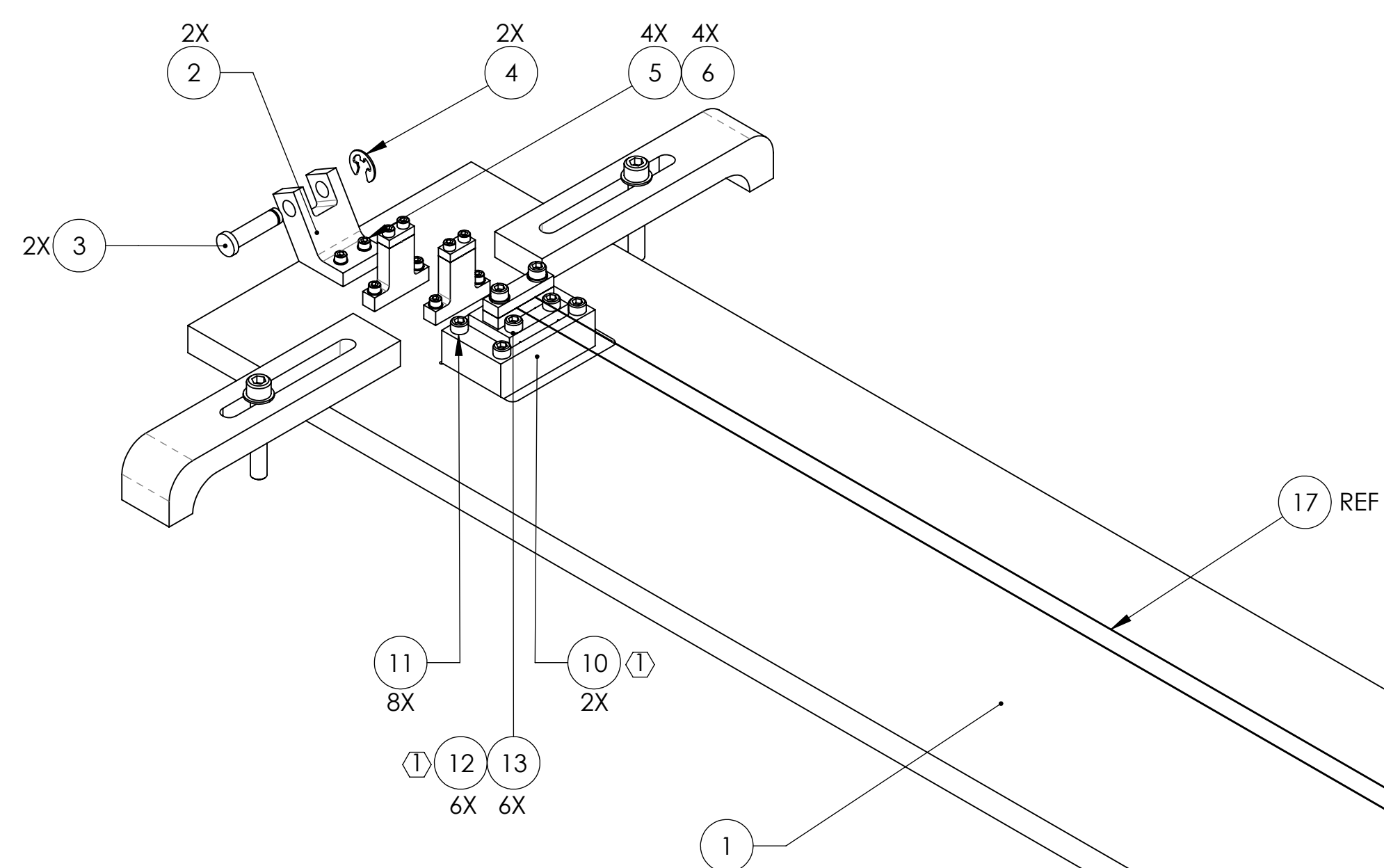
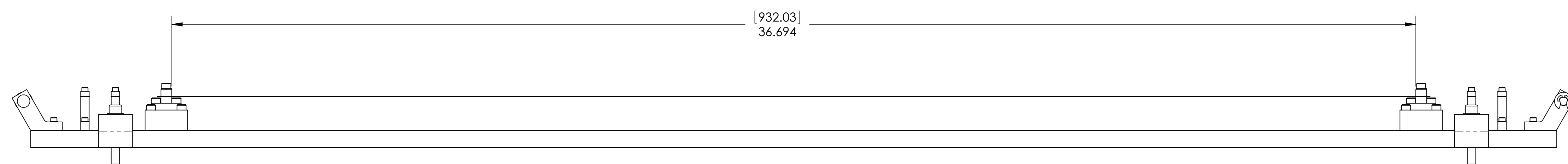


REV.	DATE	DCN #	DRAWING TREE #
v1	17 JUL 2009	E0900205	E080191
v2	21 JAN 2011	E1100057	E080191
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
17	D070436	LOWER LOOP WIRE ASSY	N/A	REF	0	0
16	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 1.5 LONG	300 SSSL	4	1	5
15	-	WASHER, FLAT, VENTED, 1/4 (U-C COMPONENTS P/N WFV-25 OR EQUIVALENT)	300 SSSL	4	1	5
14	D980184	LOS CLAMP, LONG	304, 316 OR 302 SSSL	4	0	4
13	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	300 SSSL	6	2	8
12	1185-2EN410	HELICOIL, #8-32 X 0.41 LONG (1)	NITRONIC 60	6	4	10
11	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 1 LONG	300 SSSL	8	2	10
10	D0901436	WIRE CLAMP MOUNT (1)	6061-T6 Al	2	0	2
9	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.375 LONG	Ag-PLATED 300 SSSL	8	2	10
8	D020380	WIRE START CLAMP, OUTSIDE	304, 316 OR 302 SSSL	4	1	5
7	D0901435	WIRE START CLAMP, INSIDE	304, 316 OR 302 SSSL	4	1	5
6	-	WASHER, FLAT, VENTED, #4 (U-C COMPONENTS P/N WFV-04 OR EQUIVALENT)	300 SSSL	12	3	15
5	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.5 LONG	300 SSSL	12	3	15
4	98408A120	RETAINING RING (MCMASTER-CARR P/N)	300 SSSL	2	1	3
3	92735A230	CLEVIS PIN (MCMASTER-CARR P/N)	300 SSSL	2	1	3
2	D0900563	PIN SUPPORT, WIRE JIG	6061-T6 Al	2	0	2
1	D0901433	BASE PLATE	6061-T6 Al	1	0	1

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

(1) HELICOILS TO BE INSTALLED INTO ITEM NO. 10 BY LIGO PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.

2. THIS JIG TO BE USED IN THE ASSEMBLY OF D070436 LOWER LOOP WIRE ASSEMBLY AS DESCRIBED IN E080208 HLTS ASSEMBLY SPECIFICATION.

DIMENSIONS ARE IN INCHES [MM]

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005

ANGULAR ± 0.5°

**LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY**

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: HLTS OVERALL ASSY AND FIXTURES

**PART NAME: LOWER LOOP WIRE JIG ASSY, HLTS**

DESIGNER: D. BRIDGES 01 FEB 2011 SIZE: D DWG. NO.: D0901419 REV.: v2

DRAFTER: D. BRIDGES 02 FEB 2011

CHECKER: B. MOORE 03 FEB 2011

APPROVAL: [Signature]

SCALE: 1:2 PROJECTION: [Symbol] SHEET 1 OF 1

D0901419\_Avanceded\_LIGO\_SUS\_HLTS\_Lower Loop\_Wire\_Jig\_Assembly\_PART FDM REV: V1 0001 DRAWING FDM REV: V1