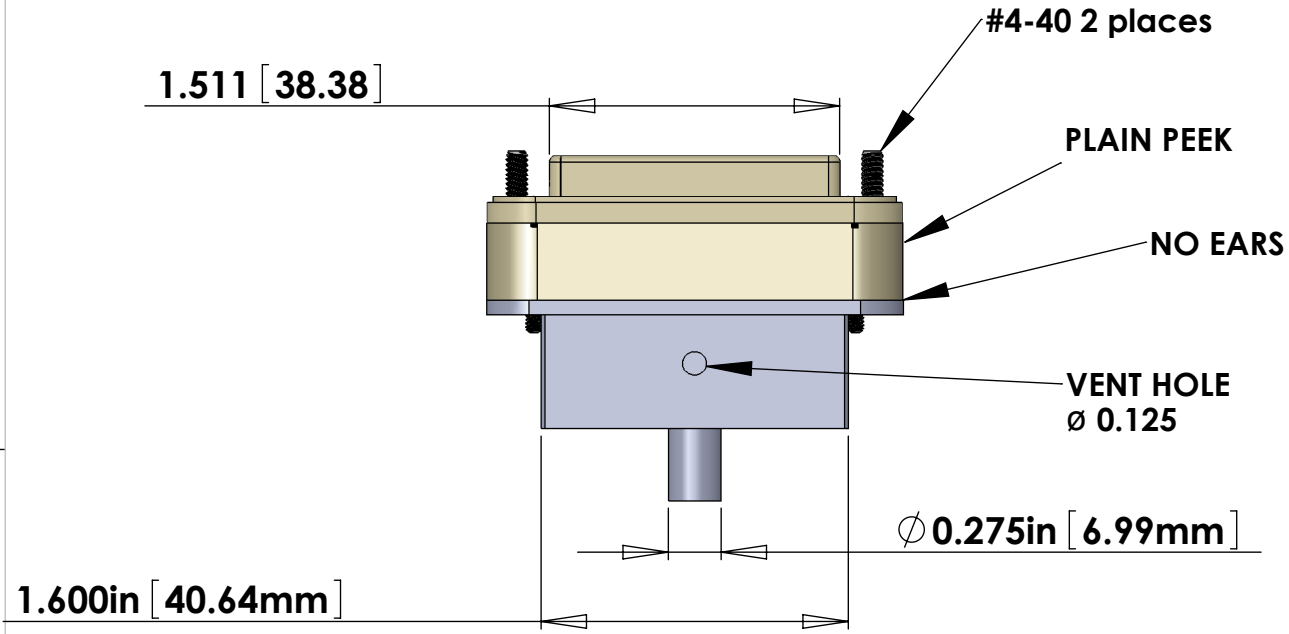
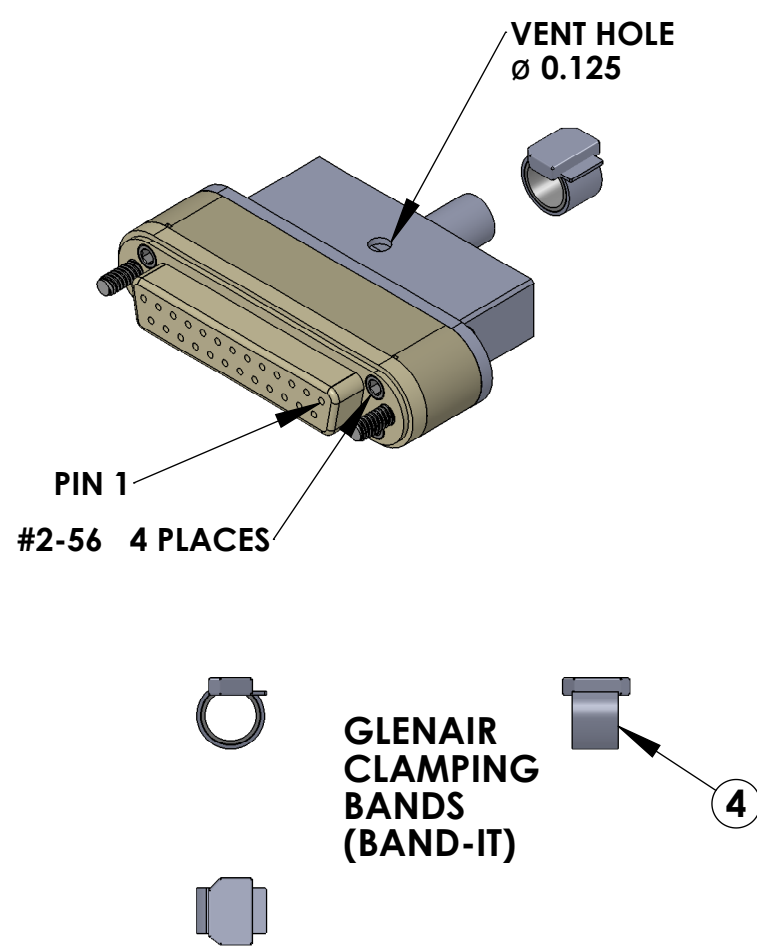


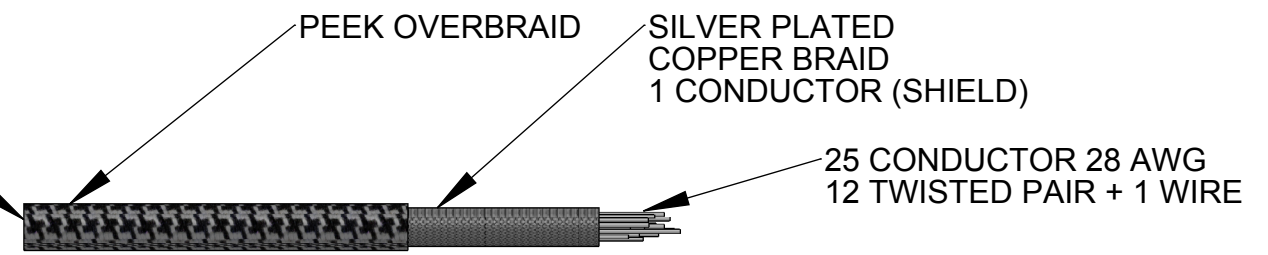
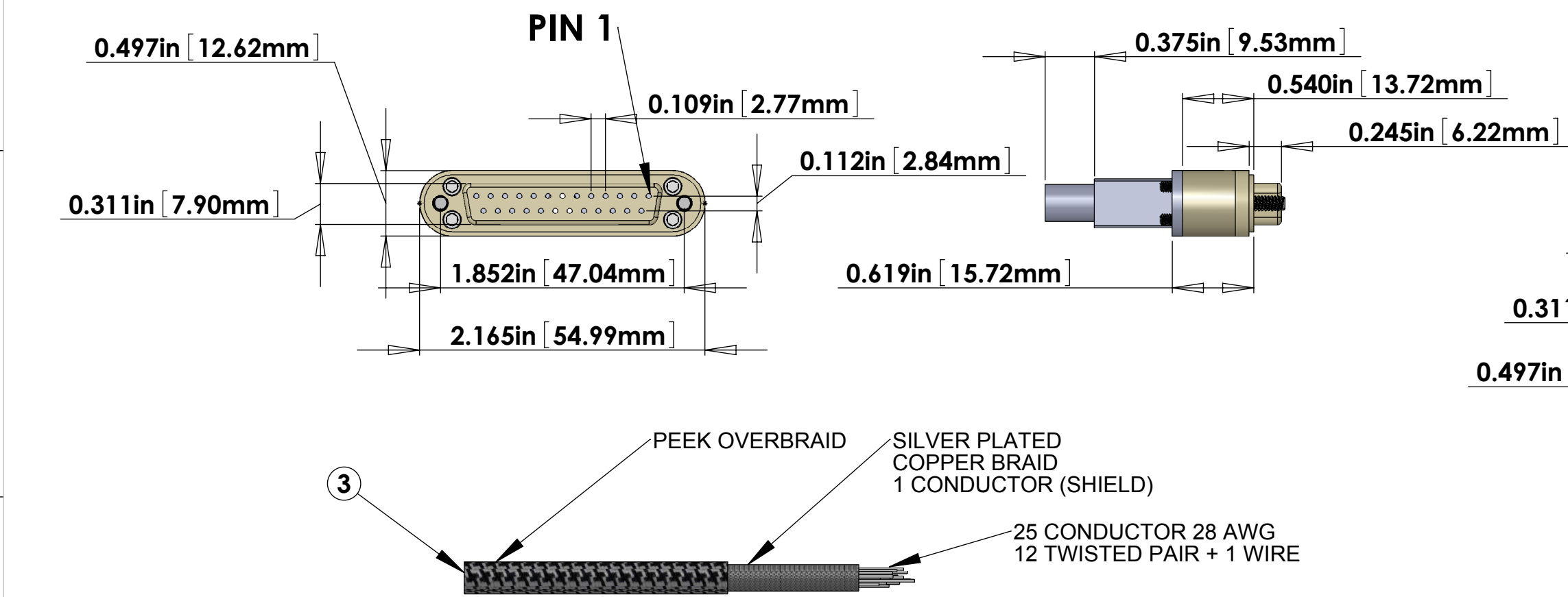
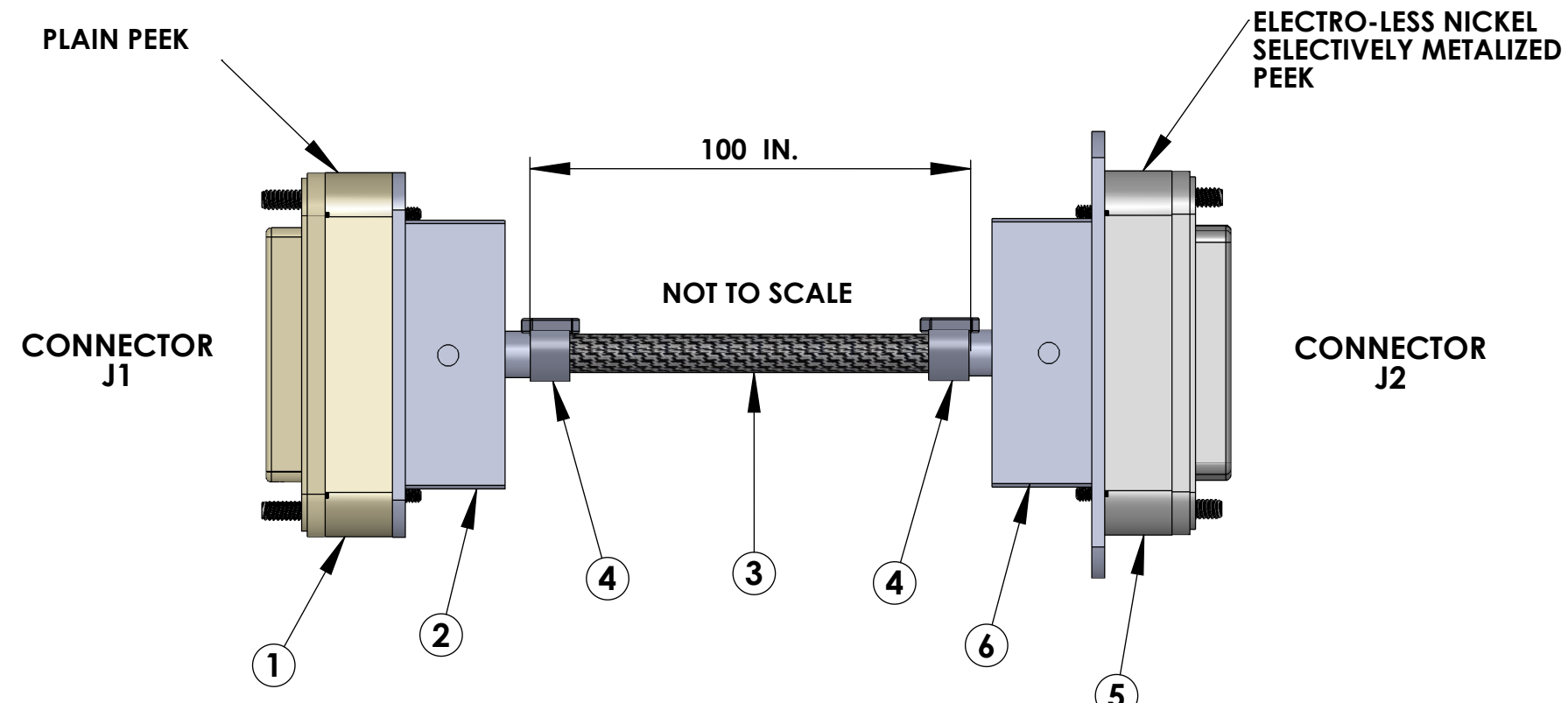
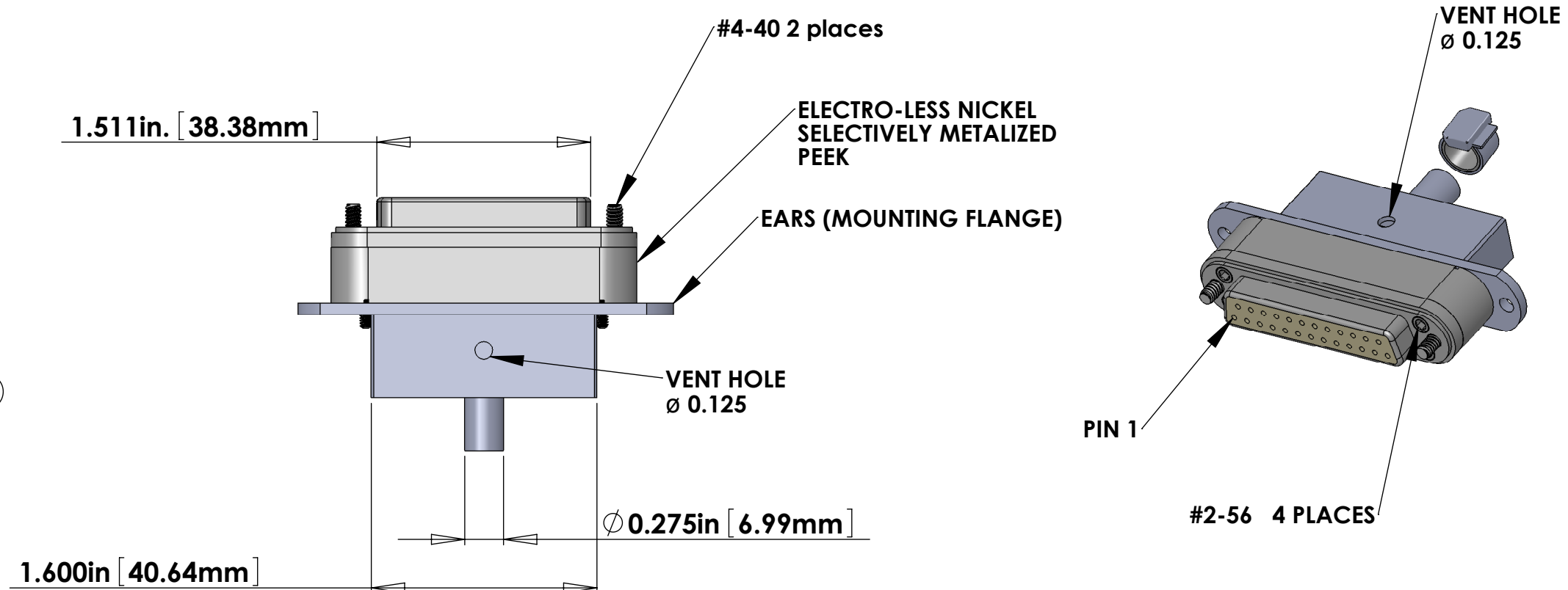
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXX-VY, S/N 001. VIBRATORY TOOL MAY BE USED.

6. APPROXIMATE WEIGHT = X.XXX LB.
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e., NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.

CONNECTOR J1



CONNECTOR J2



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	LENGTH
1	CUSTOM DB25 FEMALE	DB25 FEMALE CONNECTOR (J1) FOR UHV (PEEK)	1	
2	CUSTOM BACKSHELL	DB25 CONNECTOR BACKSHELL (NO EARS) FOR UHV (STAINLESS)	1	
3	C1	25 COND. (12 TW PAIR + 1 WIRE + SHIELD) CABLE WITH COPPER BRAID (SHIELD) AND PEEK OVERBRAID	1	100in +
4	GLENAIR 600-052	GLENAIR 600-052 STANDARD BRAID CLAMP (BAND - IT)	2	
5	CUSTOM DB25 FEMALE	DB25 FEMALE CONNECTOR (J2) FOR UHV (METALIZED PEEK)	1	
6	CUSTOM BACKSHELL	DB25 CONNECTOR BACKSHELL (WITH EARS) FOR UHV (STAINLESS)	1	

* NOTE: USE WHATEVER LENGTH IS NECESSARY FOR THE INTERNAL WIRING OF THE CONNECTORS AND STRIP LENGTH TO ACHIEVE THE CORRECT OVERALL LENGTHS.

- NOTES: (UNLESS OTHERWISE SPECIFIED)
- MATERIAL:
 - J1 CONNECTOR SHELL - PEEK VICTREX 450GL30
 - J2 CONNECTOR SHELL - SELECTIVELY METALIZED OVER PEEK VICTREX 450GL30.
 - BACKSHELLS - STAINLESS STEEL WITH VENT HOLE.
 - CONTACTS - BERYLLIUM COPPER ALLOY C17300 0.000050 MIN. GOLD OVER NICKEL
 - HARDWARE: CORROSION RESISTANCE STEEL, PASSIVATED
 - PEEK BRAID - PEEK VICTREX GRADE TDS-450CA30 CARBON LOADED - SUPPLIED BY LIGO
 - CABLE 25 COND. 28 AWG, (40 STRD 44 AWG) WITH 2 LAYERS OF KAPTON TAPE 12 TWISTED PAIRS (4 TO 5 TWISTS PER INCH) + 1 WIRE OVERALL 40AWG COPPER BRAID 50% COVERAGE - SUPPLIED BY LIGO OVERALL PEEK BRAID MIN. 50% COVERAGE OVERALL CABLE O.D. WILL BE 0.240 IN.
 - CONNECTORS WILL BE SUPPLIED WITH HARDWARE (LENGTH OF SCREWS AS SHOWN ARE APPROXIMATE SCREWS SHOULD BE THE PROPER LENGTH FOR PROPER MATING)

V25A-100 CABLE ASSEMBLY CIRCUIT SUMMARY
V-DB25 F/S1-100-DB25 F/S1

CABLE NAME	COND.- WIRE ID	TWISTED PAIR	LENGTH *	FROM	TO
V25A-100	25 COND. CABLE	(12 TOTAL)	100 in.	Conn. J1	Conn. J2
	W1	SHIELD	100 in	PIN 1, SHELL	PIN 1, SHELL
	W2	TP-1	100 in	PIN 2	PIN 2
	W14		100 in	PIN 14	PIN 14
	W3	TP-2	100 in	PIN 3	PIN 3
	W15		100 in	PIN 15	PIN 15
	W4	TP-3	100 in	PIN 4	PIN 4
	W16		100 in	PIN 16	PIN 16
	W5	TP-4	100 in	PIN 5	PIN 5
	W17		100 in	PIN 17	PIN 17
	W6	TP-5	100 in	PIN 6	PIN 6
	W18		100 in	PIN 18	PIN 18
	W7	TP-6	100 in	PIN 7	PIN 7
	W19		100 in	PIN 19	PIN 19
	W8	TP-7	100 in	PIN 8	PIN 8
	W20		100 in	PIN 20	PIN 20
	W9	TP-8	100 in	PIN 9	PIN 9
	W21		100 in	PIN 21	PIN 21
	W10	TP-9	100 in	PIN 10	PIN 10
	W22		100 in	PIN 22	PIN 22
	W11	TP-10	100 in	PIN 11	PIN 11
	W23		100 in	PIN 23	PIN 23
	W12	TP-11	100 in	PIN 12	PIN 12
	W24		100 in	PIN 24	PIN 24
	W13	TP-12	100 in	PIN 13	PIN 13
	W25		100 in	PIN 25	PIN 25

* The length shown in this list is the length of the cable between the two connectors. Add additional length as necessary for the internal wiring of the connectors and strip length.

V-DB25 F/S1-100-DB25 F/S1

STANDARD USE FOR THIS CABLE

SUBSYSTEM	AIR/VAC	STANDARD USE
SEI	IN-VAC	GS-13,L-4C

DIMENSIONS ARE IN TOLERANCES: .XX ± .XXX ± ANGULAR ± °		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY SYSTEM SEI, ISC NEXT ASSY		PART NAME CUSTOM CABLE SPECIFICATION V25A-100 DESIGNER B.ABBOTT SEP/21/2011 DRAFTER E.BROWN SEP/21/2011 CHECKER APPROVAL		SIZE DWG. NO. D LIGO - D1000221 SCALE: 1:1 PROJECTION:		REV. V5 SHEET 1 OF 1	
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D:\000221\cable\25A-100_V5_PART_PDM_REV1.DWG PDM REV1. DRAWING PDM REV1.