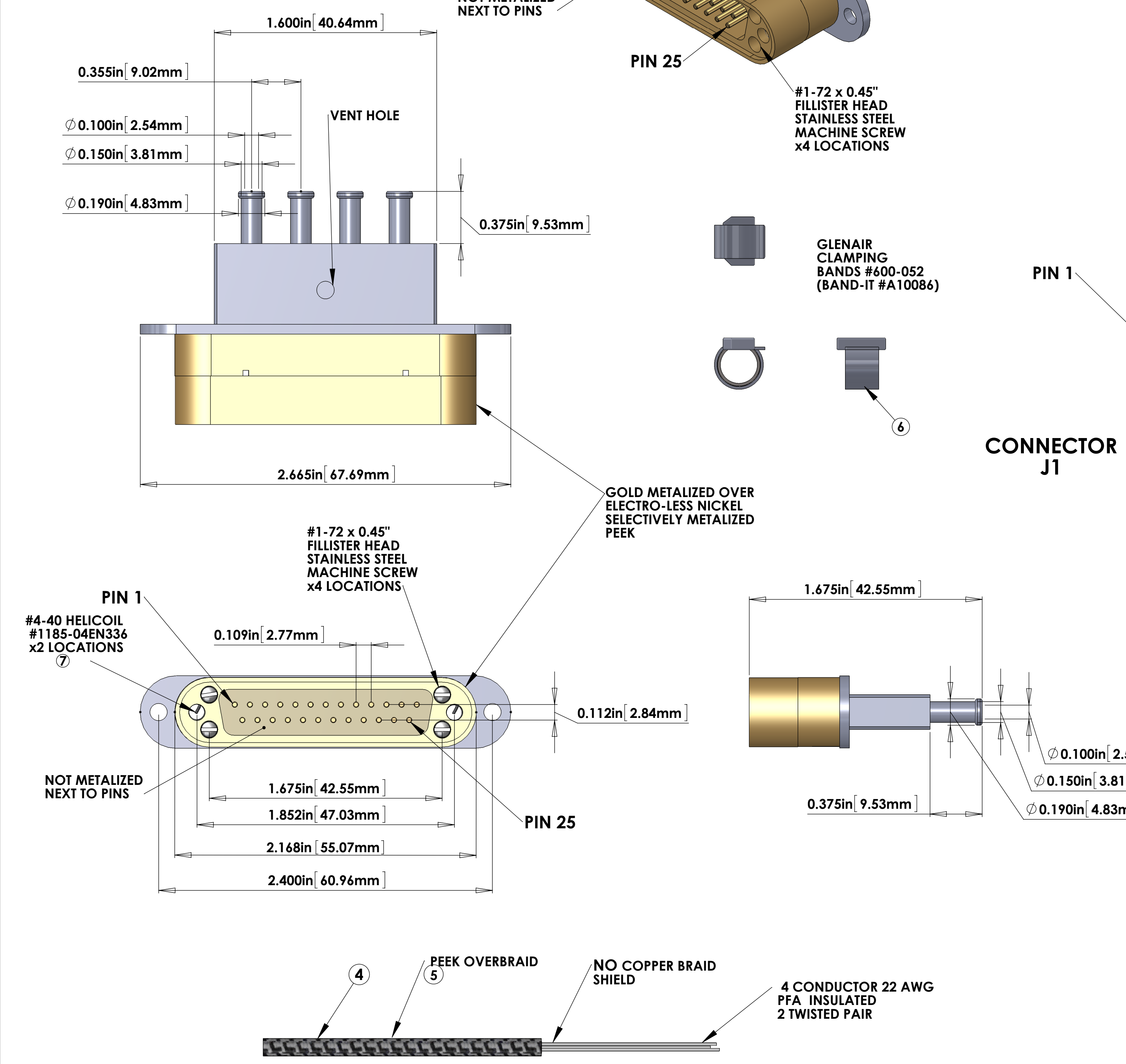


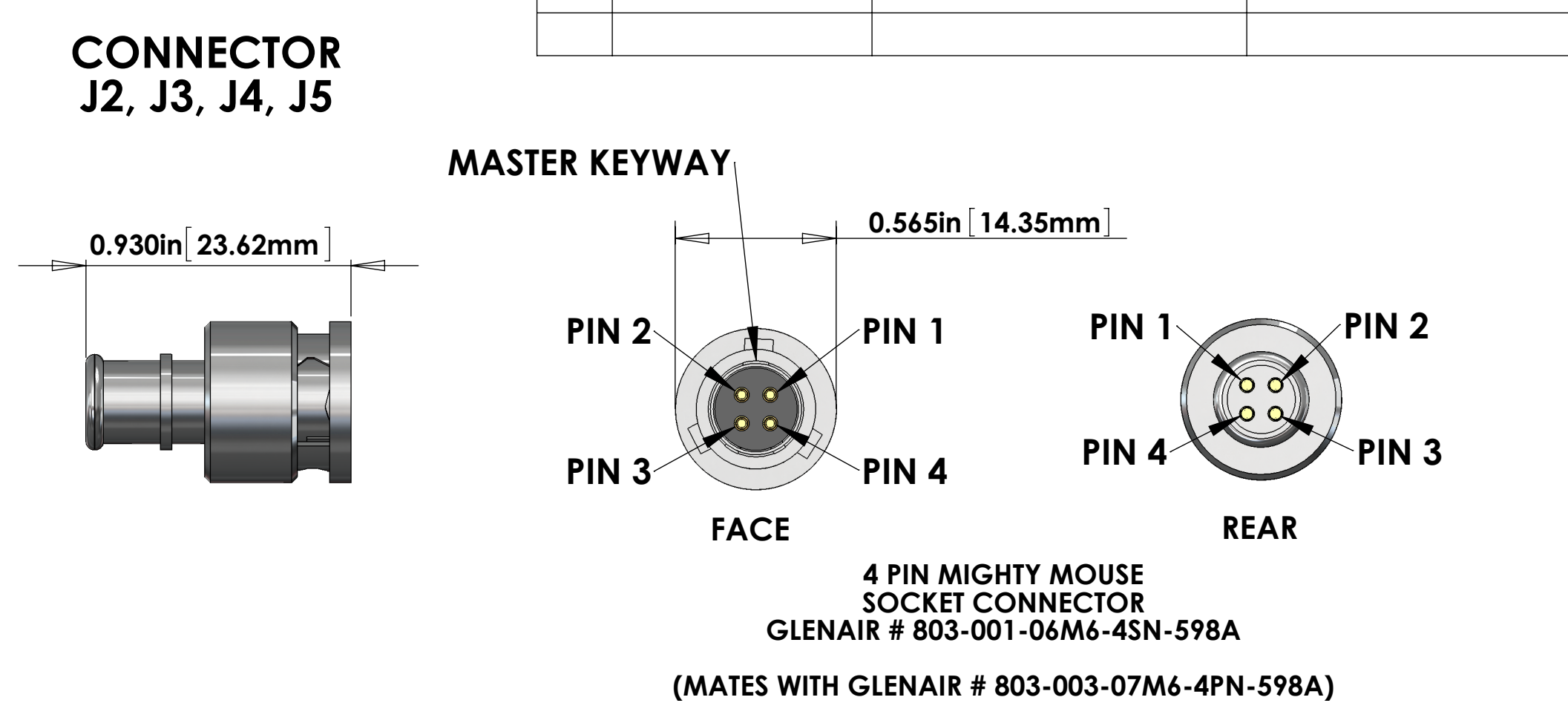
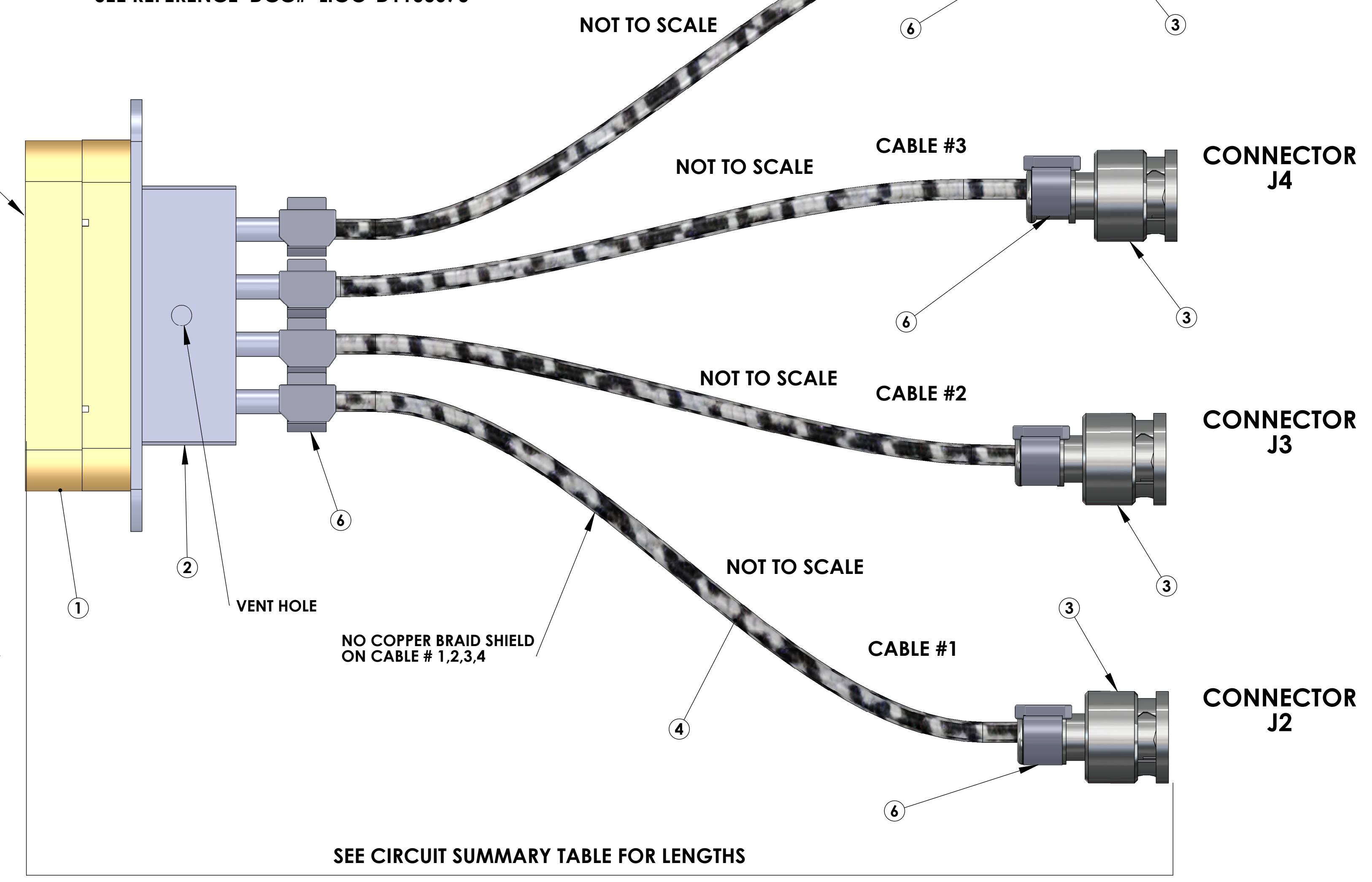
NOTES CONTINUED:
 3. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE 07" HIGH CHARACTERS. EXAMPLE: DXXXXXXV, S/N 001. VIBRATORY TOOL MAY BE USED.
 4. APPROXIMATE WEIGHT = X.XXX LB.
 5. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-EP900364
 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 7. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO SHWARTZ HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 8. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, FLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE. AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-EP900364.
 10. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 11. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E100083 AFTER FABRICATION. THE INDICATED HOLES WILL BE PORCELAIN COATED TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
 12. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
 13. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF 12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.
 NOTES 13 and 14 DO NOT APPLY TO THIS PART



V25AC-35-54-35-60 CABLE ASSEMBLY CIRCUIT SUMMARY
V-DB25HD M/S1-35,54,35,60-MM4PINHD F/X

FROM			
CONNECTOR J1 - 25 PIN SUBMINI_D CONNECTOR (PEEK)			
PIN	WIRE NAME	LENGTH *	TWISTED PAIR
1. SHELL (SHIELD) NOT CONNECTED			
13	(CABLE 1) WIRE 13	35"	TP-1
25	(CABLE 1) WIRE 25	35"	TP-1
12	(CABLE 1) WIRE 12	35"	TP-2
24	(CABLE 1) WIRE 24	35"	TP-2
11	(CABLE 2) WIRE 11	54"	TP-3
23	(CABLE 2) WIRE 23	54"	TP-3
10	(CABLE 2) WIRE 10	54"	TP-4
22	(CABLE 2) WIRE 22	54"	TP-4
9	(CABLE 3) WIRE 9	35"	TP-5
21	(CABLE 3) WIRE 21	35"	TP-5
8	(CABLE 3) WIRE 8	35"	TP-6
20	(CABLE 3) WIRE 20	35"	TP-6
7	(CABLE 4) WIRE 7	60"	TP-7
19	(CABLE 4) WIRE 19	60"	TP-7
6	(CABLE 4) WIRE 6	60"	TP-8
18	(CABLE 4) WIRE 18	60"	TP-8

PIN 14,2,15,3,16,4,17,5 N/C (NOT CONNECTED)
 SEE REFERENCE DCC# LIGO-D1100670



V25AC-35-54-35-60 CABLE #4 ASSEMBLY CIRCUIT SUMMARY

TO		
CONNECTOR J5 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL (SHIELD) NOT CONNECTED		
1	(CABLE 4) WIRE 7	PICOMOTOR PAIR M4 HORIZONTAL SIGNAL
2	(CABLE 4) WIRE 19	PICOMOTOR PAIR M4 HORIZONTAL RETURN
3	(CABLE 4) WIRE 6	PICOMOTOR PAIR M4 VERTICAL SIGNAL
4	(CABLE 4) WIRE 18	PICOMOTOR PAIR M4 VERTICAL RETURN

V25AC-35-54-35-60 CABLE #3 ASSEMBLY CIRCUIT SUMMARY

TO		
CONNECTOR J4 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL (SHIELD) NOT CONNECTED		
1	(CABLE 3) WIRE 9	PICOMOTOR PAIR M3 HORIZONTAL SIGNAL
2	(CABLE 3) WIRE 21	PICOMOTOR PAIR M3 HORIZONTAL RETURN
3	(CABLE 3) WIRE 8	PICOMOTOR PAIR M3 VERTICAL SIGNAL
4	(CABLE 3) WIRE 20	PICOMOTOR PAIR M3 VERTICAL RETURN

V25AC-35-54-35-60 CABLE #2 ASSEMBLY CIRCUIT SUMMARY

TO		
CONNECTOR J3 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL (SHIELD) NOT CONNECTED		
1	(CABLE 2) WIRE 11	PICOMOTOR PAIR M2 HORIZONTAL SIGNAL
2	(CABLE 2) WIRE 23	PICOMOTOR PAIR M2 HORIZONTAL RETURN
3	(CABLE 2) WIRE 10	PICOMOTOR PAIR M2 VERTICAL SIGNAL
4	(CABLE 2) WIRE 22	PICOMOTOR PAIR M2 VERTICAL RETURN

V25AC-35-54-35-60 CABLE #1 ASSEMBLY CIRCUIT SUMMARY

TO		
CONNECTOR J2 - 4 PIN SOCKET MIGHTY MOUSE CONNECTOR		
PIN	WIRE NAME	SIGNAL
SHELL (SHIELD) NOT CONNECTED		
1	(CABLE 1) WIRE 13	PICOMOTOR PAIR M1 HORIZONTAL SIGNAL
2	(CABLE 1) WIRE 25	PICOMOTOR PAIR M1 HORIZONTAL RETURN
3	(CABLE 1) WIRE 12	PICOMOTOR PAIR M1 VERTICAL SIGNAL
4	(CABLE 1) WIRE 24	PICOMOTOR PAIR M1 VERTICAL RETURN

BILL OF MATERIALS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	LENGTH
1	TICOR # TS0125-3 (TS0149-25C20B54-100F) OR EQUIVALENT	DB25 MALE CONNECTOR (J1) FOR UHV (GOLD METALIZED PEEK)	1	
2		DB25 CONNECTOR BACKSHELL FOR UHV (STAINLESS)	1	
3	GLENAIR # 803-001-06M6-4SN-598A	MIGHTY MOUSE SOCKET CONNECTOR (J2,J3,J4,J5)	4	
4	COONER WIRE # CZ2205 22GA PFA INSULATED BIOMEDICAL WIRE	4 COND. CABLE 22GA PFA INSULATED (WITH PEEK OVERBRAID) 5 NO SHIELD. - PARTS SUPPLIED BY LIGO	4	35.54,35.60 in.*
5	PART # 6759	PEEK BRAID - PART #6759 MANUFACTURED WITH ZEUS 0.016" BLACK PEEK DRAWN MONOFILAMENT - SUPPLIED BY LIGO	4	35.54,35.60 in.*
6	GLENAIR # 600-052 or BAND-IT # A10086	GLENAIR #600-052 STANDARD BRAID CLAMP or BAND-IT PART # A10086 (0.240" WIDE) ("BAG OF 100" #A10089)	8	
7	HELICOIL #1185-04EN336	#4-40 Nitronic 60s HELICOIL 0.336" LENGTH	2	

* NOTE: THE OVERALL LENGTH IS MEASURED FROM PIN TIP (25 PIN) TO PIN TIP (4 PIN) OF THE CABLE. USE WHATEVER LENGTH IS NECESSARY FOR THE INTERNAL WIRING OF THE CONNECTORS AND STRIP LENGTH TO ACHIEVE THE CORRECT OVERALL LENGTH.

NOTES: (UNLESS OTHERWISE SPECIFIED)
 A. MATERIAL: a. CONNECTOR SHELL - GOLD OVER ELECTRO-LESS NICKEL SELECTIVELY METALIZED PEEK VICTREX 450GL30.
 b. BACKSHELL - STAINLESS STEEL WITH VENT HOLE.
 c. CONTACTS - BERYLLIUM COPPER ALLOY C17300 0.00050 MIN. GOLD OVER NICKEL
 d. HARDWARE: STAINLESS STEEL, PASSIVATED.
 e. PEEK BRAID - PEEK VICTREX GRADE TDS-450CA30 CARBON LOADED - SUPPLIED BY LIGO.
 B. CABLE 4 COND. 22 AWG. (150/44) WITH PFA INSULATION COONER WIRE #CZ2205. OVERALL PEEK BRAID MIN. 50% COVERAGE. OVERALL CABLE O.D. WILL BE APPROX. 0.200 IN.
 C. CONNECTORS WILL BE SUPPLIED WITH HARDWARE. SCREWS SHOULD BE THE PROPER LENGTH FOR MATING.

TEST LIST

FROM	TO
J1	J2
J1	J3
J1	J4
J1	J5
J1	J2
J1	J3
J1	J4
J1	J5

V25AC-35-54-35-60 - V-DB25HD M/S1-35,54,35,60-MM4PINHD F/X

STANDARD USE FOR THIS CABLE		
SUBSYSTEM	AIR/VAC	STANDARD USE
ISC	IN-VAC	PICOMOTORS TABLE TO MOTORS

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES. 0.05-0.15. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN: .XX ± .XXX ±

ANGULAR ± °

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SYSTEM: ISC

PART NAME: CUSTOM CABLE SPECIFICATION V25AC-35-54-35-60
 DESIGNER: R. ABBOTT MAY/04/2012
 DRAFTER: E. BROWN MAY/04/2012
 CHECKER: []
 APPROVAL: []

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