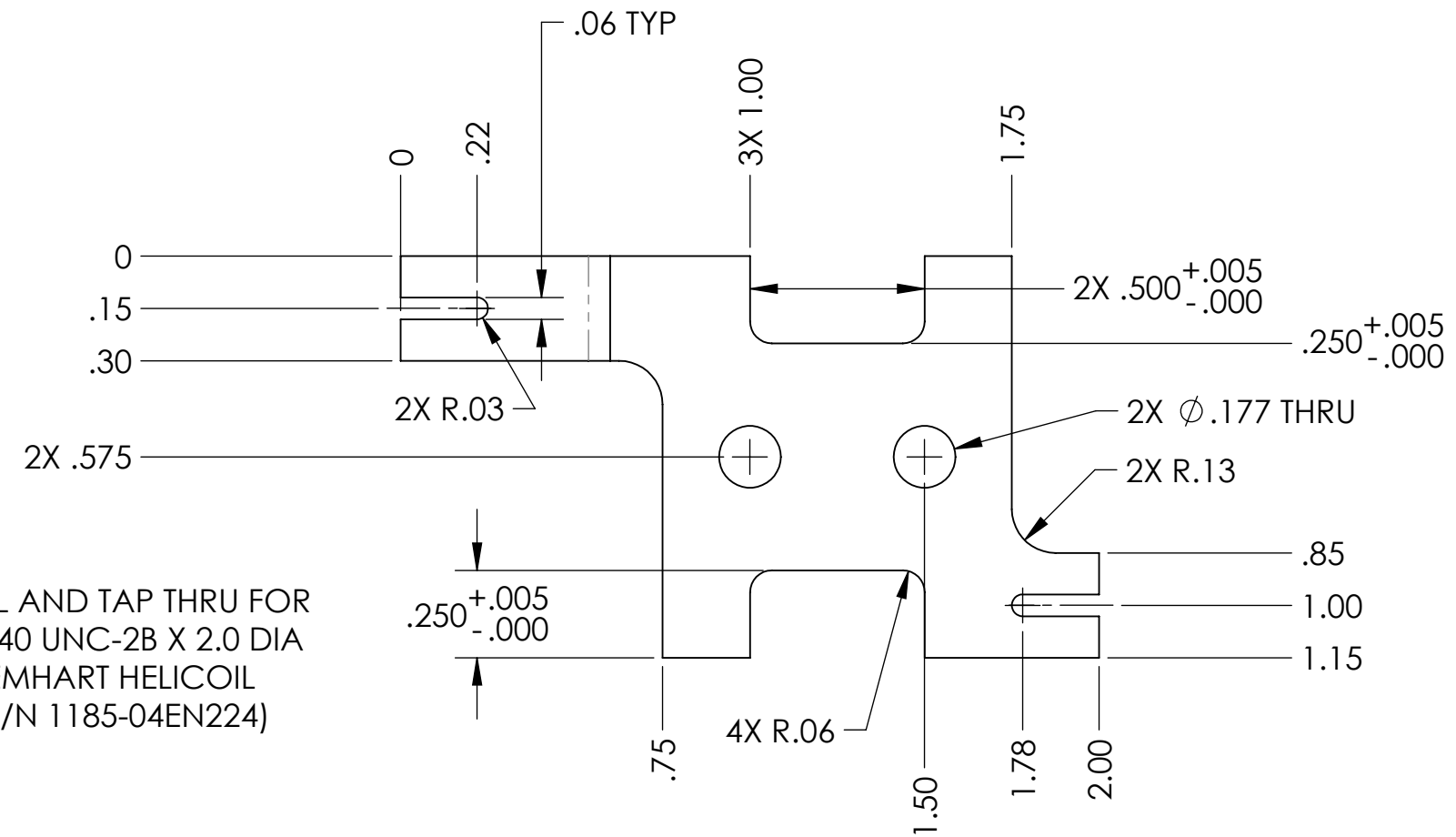
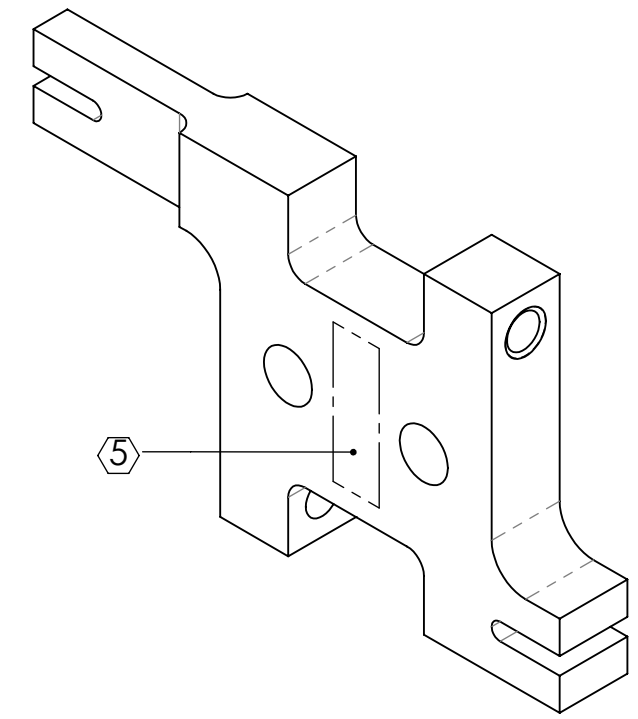
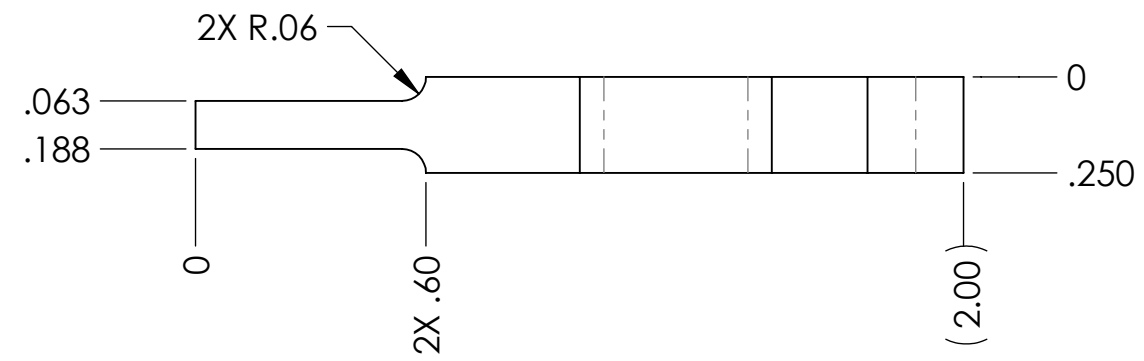
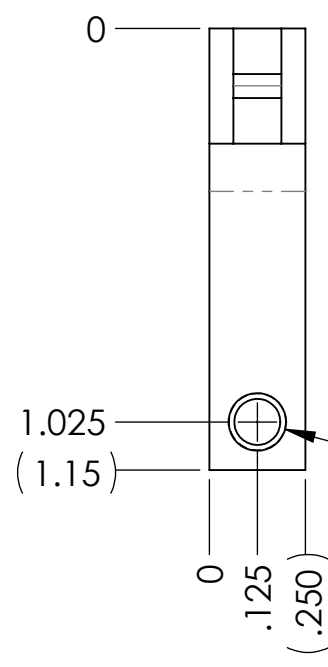


NOTES CONTINUED:
 5 SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

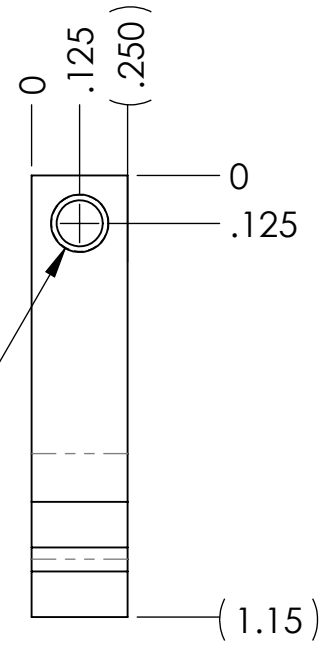
REV.	DATE	DCN #	DRAWING TREE #
v1	24 OCT 2011	E1101054	-
-	-	-	-
-	-	-	-



DRILL AND TAP THRU FOR #4-40 UNC-2B X 2.0 DIA EMHART HELICOIL (P/N 1185-04EN224)



DRILL AND TAP THRU FOR #4-40 UNC-2B X 2.0 DIA EMHART HELICOIL (P/N 1185-04EN224)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005 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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH
304, 316 OR 302 SSSL	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		WIRE JIG CLAMP, HAM TRIPLE	
DESIGNER	D. BRIDGES	05 DEC 2011	SIZE DWG. NO.
DRAFTER	D. BRIDGES	07 DEC 2011	B
CHECKER	B. MOORE	08 DEC 2011	D1102120
APPROVAL			REV. v1
NEXT ASSY		SCALE: 2:1	PROJECTION:
WIRE JIG CLAMP ASSY		SHEET 1 OF 1	

D1102120_Advanced_LIGO_SUS_HXTS_Wire_Jig_Clamp, PART PDM REV: X-000, DRAWING PDM REV: