



California Institute of Technology
LIGO Project, MC 18-34
 1200 E. California Blvd.
 Pasadena, CA 91125-0600

REQUEST FOR QUOTATION

RFQ No. **C1001717-v1** RFQ date: 9-13-2010

To be accepted, your quotation must be received no later than 3:00 P.M. local time on 9-20-2010

This Quotation is valid for 30 days

Address all inquires and forward quote to:

Heidy Kelman Email: hkelman@ligo.caltech.edu

Phone: 626.395.2559 Fax: 626.793.9744

State Sales Tax will be determined at time of purchase

Provide a firm fixed quotation for the following requirements. This solicitation does not constitute a commitment, implied or otherwise, that Caltech will take procurement action in this particular matter.

Statement of Work (SOW) for Prototype Manifold-Cryo Baffle Parts and Assembly (LIGO-[C1001587-v1](#))

Date material required at destination: **4 week ARO**

Payment Terms:

Attach Quote: Provide unit prices for each deliverable item

Days A.R.O. material will be shipped: _____ Est. Shipping Weight: _____ F.O.B. Point: _____

We hereby submit the above Quotation (Supplier name): _____

By (typed name): _____ Signature: _____ Date: _____



**Statement of Work
 Fabrication of Prototype Manifold-Cryo Baffle Weldment Assy
 for Advanced LIGO**

The following documents are incorporated into and made a part this purchase order. Click on the following LIGO Document Control Center (DCC) links to access these documents or go on line to the LIGO Public DCC at <https://dcc.ligo.org/> to access the DCC#.

1.0 Terms:

<u>DCC #</u>	<u>Description</u>
C080185-v1	Laser Interferometer Gravitational Wave Observatory (LIGO) Commercial Items or Services Contract General Provisions California Institute of Technology “Institute”, LIGO Rev 11/12/08
F0810001-v4	Technical Direction Memorandum.

2.0 Quality Control:

<u>DCC #</u>	<u>Description</u>
Q0900001-v4	Advanced LIGO Supplier Quality Requirements, dated 2/10/10, describes following contractor/supplier QA/QC actions for this procurement:
<input checked="" type="checkbox"/> 3.1 Pre-Award Inspection	<input checked="" type="checkbox"/> 3.9 Discrepant Material Storage
<input checked="" type="checkbox"/> 3.2 Supplier In Process Quality Control	<input checked="" type="checkbox"/> 3.10 Quality Records
<input checked="" type="checkbox"/> 3.3 In Process Inspection	<input type="checkbox"/> 3.11 Drawing and Specification Change Control
<input checked="" type="checkbox"/> 3.4 Pre-Ship Inspection	<input checked="" type="checkbox"/> 3.12 Welding Certification
<input checked="" type="checkbox"/> 3.5 Receiving Inspection	<input checked="" type="checkbox"/> 3.13 End Item Data Package (including Certifications of Compliance)
<input checked="" type="checkbox"/> 3.6 Discrepant Material	<input type="checkbox"/> 4.1 Design Verification
<input type="checkbox"/> 3.7 Material Review Action	<input type="checkbox"/> 4.2 Raw Material Procurement
<input checked="" type="checkbox"/> 3.8 Material Review Actions at Contractor	<input checked="" type="checkbox"/> 4.3 Traceability of Materials
	<input checked="" type="checkbox"/> 4.4 Calibration Program
	<input type="checkbox"/> 4.5 Critical Interface
	<input checked="" type="checkbox"/> 4.6 Cleanliness
	<input checked="" type="checkbox"/> 4.7 Packaging
	<input checked="" type="checkbox"/> 4.8 Storage
	<input type="checkbox"/> 4.9 Transport
	<input type="checkbox"/> 4.10 Customs

For the above list the Supplier shall: 1) Identify the corresponding sections/paragraphs in their existing QA/QC system 2) meet or exceed the design requirements contained in the attached engineering documents for each area called out.

LIGO prefers to utilize the vendors existing QA/QC programs to the fullest extent possible consistent with the LIGO QA and QC requirements. All bidders are requested to submit a written description/plan of their existing QA/QC system with their quotes. The bidder must also submit QA/QC plans for managing subcontractor work and materials.

In the event that a prospective contractor lacks an existing quality system, the contractor/vendor shall develop and implement a quality assurance program in compliance with requirements negotiated at contract/PO award.

3.0 End Item Data Package:

Parts and assemblies will not be delivered but will have 'fit check' performed and parts will be transported back to CalTech by LIGO staff as specified in Delivery Requirements below. At the time of completion of the parts, the Supplier shall also provide the following data, as a minimum:

- Any as-built modifications (with approval of the LIGO Contracting Officer) as mark-ups to the drawings
- Dimensional & QC inspection reports—this shall include a report showing that parts have been inspected and fall within specified tolerances of:
 1. The first article piece part drawings.
 2. The first article weldment subassembly drawings.
 3. Top assembly drawing, D1002061.
- Certificate or statement of compliance with all contract and drawing process restrictions.

4.0 Included Documents:

In addition to the specifications listed below, all part and assembly drawings, with required quantities, along with a drawing tree for the top level assembly are included in a single pdf file under [D1002309-v1](#).

<u>DCC #</u>	<u>Description</u>
E0900048-v7	Welding Specification for Weldments used within the Advanced LIGO Vacuum System

5.0 Scope:

This SOW is for the fabrication of sheet metal parts and welding of four weldment structures and two piece parts required to build one prototype Manifold-Cryo Baffle Weldment Assembly

6.0 Quantity Required:

One complete baffle weldment assembly which includes 4 subassemblies (weldments) and 2 individual piece parts. For individual parts list see pdf file [D1002309-v1](#) excluding part number D1000572 which will be manufactured by LIGO.

7.0 Delivery Requirements:

The final parts and weldments will have a 'fit check' performed by LIGO staff at the vendor's facility and then will be transported by LIGO staff. 'Fit check' includes bolting all manufactured weldments and parts per top assembly drawing D1002061.

LIGO will be responsible for providing shipping containers and transportation which protects these parts from damage from the transportation environment (weather, handling, accidents, etc.). Mating edges of parts should be especially protected from damage during shipping.

8.0 Manufacturing:

8.1 Precedence

The Statement of Work (SOW) sections below regarding processing or fabrication of the parts are meant to convey the scope and nature of the requested work. If there is a conflict between the SOW and the drawing, the drawing has precedence.

8.2 Materials

All parts shall be made using A424 Enameling Steel Type I, 18ga or 14ga, specified on drawings. This material has been approved for use in the UHV environment in LIGO. No materials may be substituted or added without prior knowledge and testing by LIGO. Enameling steel shall be procured and delivered by LIGO.

8.3 Machining

No grinding or lapping with abrasive wheels, cloth or stones is permitted. No sanding of any type. No use of Scotch-Brite (tm) or similar abbrasive products. All machining fluids must be fully synthetic, water soluble (not simply water miscible) and free of sulfur, chlorine, and silicone.

8.4 Welding

For weld requirements see [E0900048-v7](#) also referenced in the “Included Documents” section of this SOW. Full penetration fillet welds will primarily be used to create weldments as specified on all weldment assembly drawings. Full penetration seam weld will be used to create cylinder part, D1000570. All welding rods must be cleaned and degreased per cleaning specification in weld requirement document.

8.5 Marking

Parts shall be marked per drawing notes.

9.0 Delivery Schedule:

All parts/weldments to be completed within 4 weeks after receipt of order.



LIGO Laboratory / LIGO Scientific Collaboration

LIGO-Q0900001-V4-P

Advanced LIGO

February 10th, 2010

Advanced LIGO Supplier Quality Requirements

Mick Flanigan, Rod Luna, William Tyler

Distribution of this document:
LIGO Scientific Collaboration

This is an internal working note
of the LIGO Laboratory.

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Revision History

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00	Mick Flanigan	All	08/15/08	N/A
01	Mick Flanigan	All	08/29/08	N/A
02	Mick Flanigan	5, 6	02/10/10	N/A

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1. Quality Program Guideline

1.1. Purpose of this Document

The purpose of this document is to provide guidance, requirements and general procedures for a Quality Assurance and Quality Control program (QA/QC) as it applies to procurements and contracted effort. It provides recommendations on the policies and phrases to be used in all “Request for Proposal” (RFP) or “Request for Quote” (RFQ) solicitations to be sent to prospective suppliers and vendors for Advanced LIGO components, parts, or services. The audience for this document is the LIGO technical and procurement staff, as well as the potential suppliers bidding against and RFQ/RFP. Section 3 and 4 provide detailed descriptions of the applicable sections in the RFQ/RFP that are checked by the LIGO procurements and Engineering teams, providing suppliers definitions to assist in formulating the bids.

Advanced LIGO is a project undertaken by the LIGO Laboratory (or simply ‘LIGO’).

This document is intended for use when the supplier is manufacturing and/or assembling components, or providing services, which require a LIGO review of the supplier QA/QC monitoring. LIGO engineering, projects, procurement and QA teams will make determinations on the applicability of this document on a case by case basis.

1.2. Purpose of a Quality Program

A Quality Program is a framework for ensuring completeness, correctness, reliability and maintainability of a system and its components. The specific goals and deliverables of a Quality program for Advanced LIGO are:

- 1.2.1. All designs are to be carefully reviewed and finalized through an Advanced LIGO Design Review process.
- 1.2.2. The supplier has an accurate and complete set of design specifications, drawings, and material and performance characteristics.
- 1.2.3. The supplier maintains an internal quality program to ensure systems are fabricated, assembled, and tested to specifications provided by LIGO.
- 1.2.4. The supplier ensures appropriate workmanship, including but not limited to certification, safety, handling, cleanliness and documentation.
- 1.2.5. The supplier will provide appropriate packaging and shipping methods to protect the component(s) from damage in transit.
- 1.2.6. The supplier shall provide reliability estimates, maintenance procedures and schedules, if applicable.

1.2.7. Both LIGO and the supplier may, in general (depending upon the particular aspects and criticality of the effort), participate in pre-award audits, in process inspections; post-assembly and post-install inspections and acceptance testing. Enable LIGO and the supplier to establish specific expectations, and mechanisms, up front on remedying issues which arise during fabrication and testing, where the component does not meet design, assembly or performance specifications due to improper manufacturing, faulty sub-components, or improper fit or performance of critical interfaces, or improper packaging and shipping methods. An example is a Material Review Board (MRB)

1.3. Relevant Documents

LIGO-E010613-02, Generic Requirements & Standards for Detector Subsystems [in particular section 9]

LIGO-E030350-A, Drawing Requirements

Other documents specific to the given RFP/RFQ will be provided as part of the package and not referenced here. Also additional documents may be released once the bid process is complete and contract award is taking place.

2. Procurement Process

2.1. Pre-Procurement Activities

RFPs and RFQs shall be written to use contractor/vendor existing QA systems to the fullest extent possible consistent with the provisions outlined in LIGO Quality Assurance Plan M960076-P. Should a contractor lack an existing quality system, the contractor shall develop a quality assurance plan in compliance with the requirements negotiated at contract award.

2.2. LIGO Procurement Documentation

LIGO will provide the supplier with the following documentation in support of the bid process (if and as applicable):

- 2.2.1. Technical documents, drawings, and specifications, identified by revision.
- 2.2.2. Preservation, packaging, storage, and shipping requirements.
- 2.2.3. Requirements for component longevity.
- 2.2.4. Specific Inspection and Test requirements.
- 2.2.5. End Item Data Package requirements.
- 2.2.6. Requirements for source inspection by customer.
- 2.2.7. Safety Performance requirements.

2.3. Supplier Bid Package Requirements

As part of the bid package, and for consideration in contract award, the supplier shall confirm the intent to comply with the following Quality Program requirements (if and as applicable):

- 2.3.1. Provide with the deliverables all supplier-generated technical documents, drawings, and specifications, identified by revision, with all red line items updated in electronic format (source files and Adobe Acrobat) for the as-built system or component.
- 2.3.2. Adhere to all shipping, packaging and cleanliness requirements as required in the Advanced LIGO design documents.
- 2.3.3. Submit all tests and inspection reports to LIGO immediately following completion, in agreed upon electronic format.
- 2.3.4. Fulfill requirements for source inspection by customer, which can include a pre-award inspection, in process audits, as well as a pre-ship inspection.
- 2.3.5. Provide a copy of their existing QA/QC program, with a strategy for implementing in conformance to Advanced LIGO requirements, if necessary.

3. Manufacture, Assembly and Receiving Inspection Requirements

3.1. Pre-Award Inspection

Prior to contract award LIGO staff may perform an audit of the prospective supplier quality programs. The need to perform an audit will be determined by the Contracting Officer's Technical Representative (COTR), the subsystem leader and/or the chief engineer, based on criticality, cost, and use case of components. The audit scope includes but is not limited to:

- Calibration program review.
- Maintenance and reliability programs for manufacturing equipment.
- Critical worker certification levels (i.e., welding, electrical, CNC, etc.).
- Supplier QA/QC program and how it will be implemented for Advanced LIGO contracts.
- Manufacturing methodologies, especially as regards cleanliness and use of approved materials and fluids.
- Cleaning and packaging methodologies compared to RFP/RFQ requirements.

3.2. Supplier in Process Quality Control

Critical processes shall be controlled using manufacturing travelers or procedures established and qualified prior to LIGO equipment production. As an example, these manufacturing procedures shall include:

- Equipment to be used including calibration requirements.

- Identification of operational constraints.
- Workmanship standards.
- Call-outs for inspections, tests, and other verification processes.
- Acceptance criteria.

3.3. In Process Inspection

In-process inspections shall be performed where subsequent assembly stages will prevent/limit inspection access, and to detect defects early in the process. In-process inspections shall be identified in fabrication and assembly by planning Mandatory Control Points (MCPs). Suppliers shall document all deficiencies and discrepancies, and report immediately to LIGO. Electronic format, via email transmission, is the preferred method of report delivery.

3.4. Pre-Shipment Inspection

Supplier shall inspect and validate system integrity prior to shipment of equipment to any LIGO site. LIGO may choose to send a representative to participate in inspections deemed critical. Pre-shipment inspection of equipment to be delivered to the LIGO observatories shall include the following (as appropriate):

- End Item Data Package review.
- Certificate of Compliance, where required.
- Shipping documentation such as the manifest or shipper.
- LIGO property control documentation, when LIGO materials are in possession of a supplier.
- Verification of the adequacy of the shipment packaging and weather protection.
- Evidence of contractor quality assurance acceptance.
- Evidence of safety requirements compliance.
- Verification that transportation environmental controls and monitoring requirements will be satisfied.

3.5. Receiving Inspection

Receiving inspection will be performed to ensure that articles procured by LIGO, or its suppliers, conform to contractual or procurement document requirements prior to release of payment to supplier. This will be a time-critical activity. Receiving inspection includes the following (as applicable):

- Inspection of incoming hardware and documentation for compliance to applicable Drawings, Specifications, and/or other documentation specified by the procurement documentation.
- Evidence of acceptance by contractor/supplier inspection.
- Evidence of source inspection acceptance as applicable.
- Identification of deviations from requirements specified in the procurement documentation.
- Securing dispositions of discrepant materials.
- Verification that equipment complies with shipping, handling and safety constraints.
- Identification of hardware acceptance status with appropriate labels.
- Documentation of receiving inspection, one copy stored at site and a second sent to procurements for potential release of payments, shall be completed by LIGO personnel.

3.6. Discrepant Material

When an article does not conform to applicable engineering design documentation it shall be identified as non-conforming. It shall be segregated from on-going work operations, and held for further action. When a discrepancy has been identified and documented it shall be reported immediately to the responsible LIGO science or engineering personnel and the LIGO Quality Assurance Officer.

Only LIGO personnel responsible for the item submitted to the discrepancy evaluation process, or their designees are authorized to issue dispositions for the discrepant item. Initial discrepant hardware dispositions include the following:

- Rework to drawing or specification.
- Repair: Articles that are modified to a useable state but remain nonconforming to drawing or specification requirements.
- Return to vendor.
- Use-as-is: Articles that are useable in the present state without further processing.
- Suspended Action: Articles of which resolution is determined after drawing or specification change, or after hardware fit check.
- Scrap.

LIGO quality assurance representative concurrence is required for all LIGO science or engineering personnel discrepant material dispositions.

3.7. Material Review Action

The Material Review Action shall determine dispositions of nonconforming articles that cannot be resolved by the initial discrepant hardware disposition. For discrepant articles submitted to Material Review Action the LIGO Project Manager shall, with the concurrence of the LIGO Quality Assurance Officer, determine the final disposition.

3.8. Material Review Actions at Contractor

Material Review Actions conducted at a contractor are the responsibility of that contractor. LIGO personnel will not participate as members of the contractor's Material Review Board. However, Contractor Material Review Actions will be subject to review and concurrence by LIGO engineering and quality assurance personnel. Contractor Material Review Actions shall become a part of the EIDP.

3.9. Discrepant Material Storage

Discrepant Material shall be identified and to the degree possible, separated from acceptable material until the disposition action has been completed.

3.10. Quality Records

The LIGO Quality Assurance Office will maintain quality records which provide evidence of inspections, tests, as built configuration, and Material Review Actions.

The LIGO Project Office will establish a facility and procedures for the long term storage of LIGO project QA documentation and other related records. Satellite record storage facilities may also be established at the observatory sites for equipment or materials located at or peculiar to the site. This data shall be maintained for at least the duration of the 20 year operational life of the observatories.

3.11. Drawing and Specification Change Control

All drawings and specifications will be controlled by the suppliers Quality Assurance Department, including receipt and distribution. Upon receiving the order/contract, all drawings will be verified as to correct number and revision.

All such documents shall be marked to indicate that they have been included in the system. Supplier shall ensure distributed copies of master documents must be marked as controlled or uncontrolled. Controlled documents should be numbered serially (1,2,3...n) and recorded in the contract file.

A controlled document must be kept updated at every document change or engineering change. The contract administrator under the guidance of QA will insure that all controlled documents, whether in house or out, will be updated.

Controlled documents must be returned to QA or the contract administrator at the end of their use. At that time they will be removed from the controlled list.

The supplier shall take appropriate measures to control obsolete and uncontrolled documents from contaminating the contract work. This includes a method of marking, checking out, or destroying.

Upon receipt of drawing and specification changes, the supplier Quality Assurance or other appropriate personnel will remove obsolete drawing specification and issue the latest drawing specification to proper personnel. Obsolete drawings will be marked “obsolete” if needed for record or destroyed.

3.12. Welding Certifications

For any work on Advanced LIGO parts or components that requires welding, Caltech will require any contractor to supply certifications for the welders performing the work. Certifications must show valid dates, as well as certified welding type/class for the work to be done. All welders who will be performing work will be required to be certified for the work, and samples of work may be requested.

3.13. End Item Data Package

The end item data package is the set required documents to be supplied to LIGO upon delivery of ordered parts or services, which may include but is not limited to the following items:

- As Built Modifications (with approval of the LIGO Contracting Officer) as markups to the drawings
- Material Certifications
- Dimensional and QC reports, including all test procedures and results
- Certificate or Statement of Compliance with all contract and process restrictions
- Welding Certifications

Specific items above pertinent to a given contract will be called out in the statement of work, as well as any additional EIDP requirements not listed above.

4. Supplier Quality Assurance Review: Definitions

4.1. Design Verification

At appropriate stages of the design process, design verification shall be performed to ensure that the proposed design meets the requirements (see M0500220). This will normally be accomplished through the Design Review process. However, additional design verifications may be instituted where critical elements are involved, or where a potential for errors may have significant impact to functional performance, cost or schedule. In particular if a supplier/contractor/vendor is tasked with design effort, LIGO must plan to review the delivered design before authorization to fabricate.

4.2. Raw Material Procurement

Suppliers of raw materials shall provide certifications and country of origin indicating that materials being provided are in compliance with requirements specified in the procurement documents. Reports of chemical and physical tests are required for critical usage materials to verify conformance to applicable specifications and drawings.

4.3. Traceability of Materials

Materials considered critical for LIGO observatories' successful operations, or used in the vacuum system, shall require identification and country of origin by lot, batch or production run. Materials process records shall be delivered by the supplier and retained in the LIGO Documentation Control Center. Questions regarding traceability requirements for specific items should be directed to the LIGO Quality Assurance Officer.

4.4. Calibration Program

The supplier shall maintain a calibration program of all instruments and tools requiring calibration. Schedules of calibration shall be in accordance with the instrument or tool manufacturers' recommendations. Labels on the instrumentation and tools or their cases shall be in plain view, and have a calibration record referenced to a report on file with the supplier, as well as a date of performed calibration, due date for next cycle, as well as a signature and disposition of calibration (pass or fail). All instruments that have failed calibration will be required to have on file a document showing repair, repair facility, reason for out of spec, and recalibration report showing unit has passed. Out of calibration is defined as a device that is not only out of spec on measurement accuracy, but also one that may function properly but has not sustained an up to date calibration certification.

4.5. Critical Interfaces

A Critical Interface is defined as that particular junction between systems or components which have a specific design characteristic and/or requirement, which are critical to the proper function of the overall LIGO system. If these design requirements or characteristics are not met then there could be an increased likelihood of improper functioning, system failure, and/or damage to itself and/or other attached systems or components. It is the responsibility of the LIGO teams to identify and call out all critical interfaces in the design documents and drawings, and to ensure that appropriate standards of inspection and testing are applied to the systems at these interfaces.

The supplier shall perform levels of inspection as defined by the LIGO teams during the manufacturing and assembly process, including verification to design specifications and (if appropriate) interface tests for fit, function and/or performance. Development and performance of the test plan will be in accordance with the negotiated contract, and the final test plan will be reviewed by the supplier and the LIGO team(s). The supplier shall provide LIGO teams with the results from all tested critical interfaces, and the LIGO team(s) shall work with the supplier to assess the results and review discrepancies and proposed solutions.

4.6. Cleanliness

All components are to meet cleanliness standards as outlined in the technical documents provided to the vendor. Cleanliness and contamination control will be particularly sensitive with systems and components installed in the vacuum chambers. As part of the bid package, all suppliers of in-vacuum components must include detailed plans for achieving and maintaining cleanliness of manufactured items during the manufacturing process, through the final cleaning process, as well as processes to maintain this state during transport and storage.

4.7. Packaging

Guidelines shall be developed for packaging to provide sufficient protection for LIGO equipment from the point of manufacture to the delivery at the LIGO observatory sites. Suppliers must ensure that all packaging will meet requirements as defined in the RFP or RFQ, and any deficiencies are reported immediately to LIGO representatives. This includes packaging to protect against environmental, shock, transport noise and vibration, as well as protection from ESD and contamination as required in the negotiated contract or PO. LIGO staff will inspect all packaging upon arrival at a LIGO facility for damage and deficiencies. Note that components and assemblies which have been cleaned for in-vacuum service have special packaging requirements as defined in E960022.

All packaged items shall have appropriate labels attached to properly identify the following:

- Destination Site
- LIGO Subsystem team
- Boldly identify components as clean or environmentally sensitive to prevent opening and contamination in receiving area.
- List any special handling notifications or warnings
- LIGO Contact person and information
- Part ID, serial number or other identifying data
- Shipping manifest with long text description of enclosed items

4.8. Storage

Supplier shall protect system or components against environmental damage or unauthorized personnel access prior to shipment of finished goods. All items shall be stored with appropriate labeling to ensure removal from storage and transport of item is accurate.

4.9. Transport

Transport of items to LIGO facilities shall be handled via LIGO approved shipper, and will be insured as directed in the LIGO-Supplier's contract. All critical and/or environmentally sensitive items must be shipped in a manner that will minimize damage in transit. Supplier and shipping company shall utilize proper ride mechanism (air ride or other specific suspension types, isolation techniques, etc), container types and handling methods to protect sensitive items, such as optics and electronics, from vibration, shock pulse, impacts and crushing, as defined by LIGO. Shipping containers and the items they contain shall be properly secured for transport to avoid falling and shuffling of goods internally.

4.10. Customs

Customs documentation will be filled out appropriately to ensure proper handling, contamination controls and timely throughput while in possession of customs agents. This includes labeling which clearly defines contents, hazards, valuation and contact information. For all customs requirements please contact Rod Luna at Caltech, email luna_r@ligo.caltech.edu

5. System Integration and Commissioning Inspection Requirements

5.1. System Integration Inspection Process

With few exceptions, system installation, integration and commissioning are LIGO Laboratory responsibilities with no supplier involvement. Final inspection shall consist of the following:

- Verification of the product (subsystem or subassembly) against requirements and test parameters identified as requirements in the subsystem documentation.
- Verification of key physical and interface parameters.
- Verification of Configuration.
- Verification of quality of workmanship.
- Verification of a complete set of as-built documentation

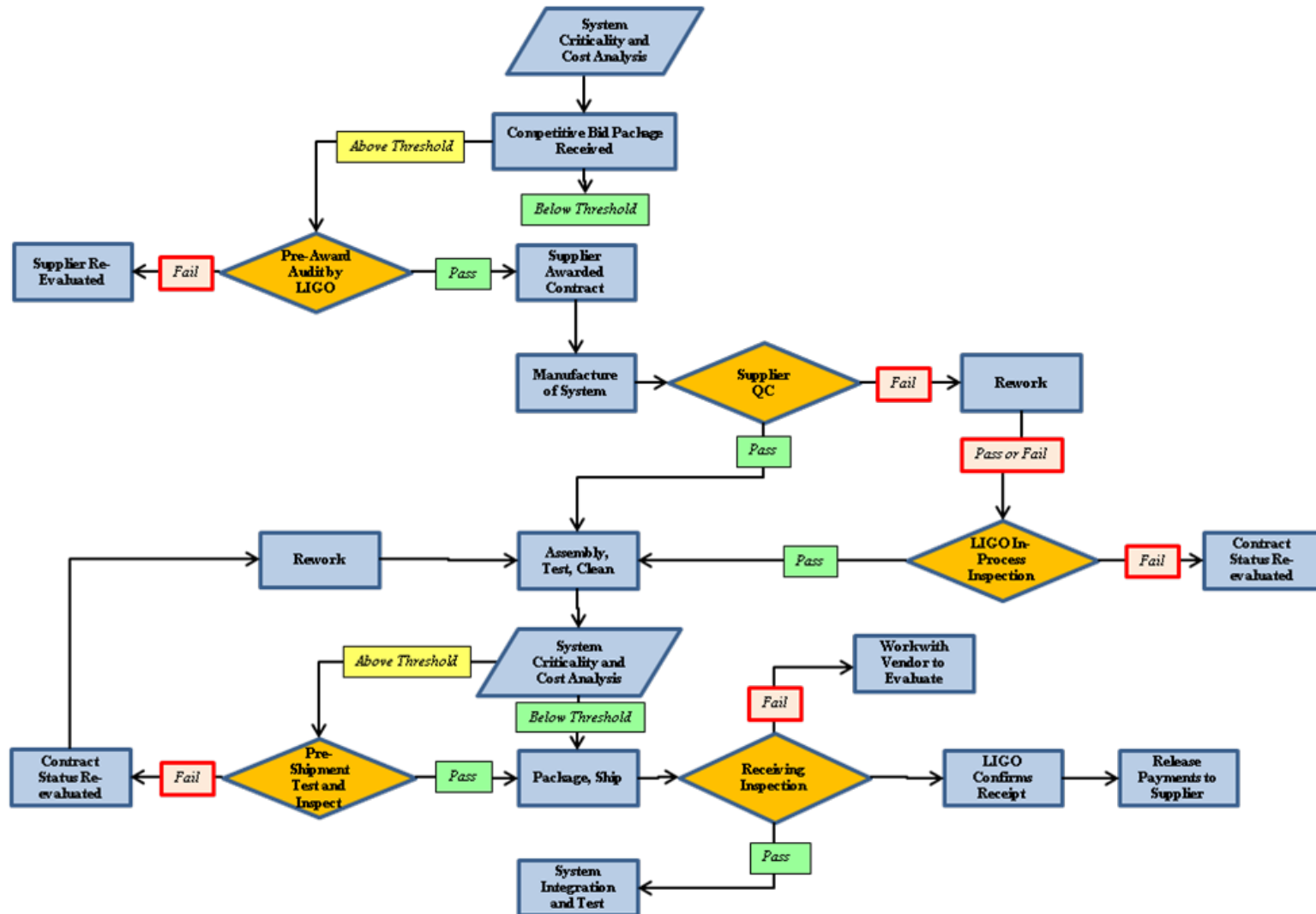
5.2. System Integration Acceptance Test

System integrated acceptance testing is a LIGO Laboratory responsibility. Acceptance testing shall be performed after completion of all required operations. LIGO final acceptance testing requirements are as follows:

- Commissioning acceptance testing plans and reports shall be reviewed and approved (and witnessed if possible) by LIGO QA personnel.
- The test shall be performed in accordance with the current version of the appropriate test procedure.
- Instruments and gages used to determine performance characteristics must be within the range of acceptable calibration parameters, including inspection cycles and tested against known standards.
- Tests shall be conducted in the order specified by the test procedure unless otherwise authorized by responsible LIGO engineering personnel.
- Completed test results shall be documented on authorized summary forms or test data sheets.
- Any deviations from the test procedure or discrepancies noted during the conduct of the test shall be documented.
- If appropriate, and to the extent practical, a post-test inspection shall be conducted of the item under test, for the purpose of identifying and recording any changes that may have occurred as a result of the test.



6. Advanced LIGO QA Inspection Workflow Chart





7. Glossary

Quality Assurance	QA is defined as a procedure or set of procedures intended to ensure that a product or service under development (before work is complete, as opposed to afterwards) meets specified requirements.
Quality Control	Quality control (QC) is a procedure or set of procedures intended to ensure that a manufactured product or performed service adheres to a defined set of quality criteria or meets the requirements of the client or customer.
System Criticality and Cost Analysis	Evaluation taken place to determine whether a system being manufactured meets the minimum threshold for applying additional inspection criteria. Example: An in vacuum component may not meet minimum cost levels to add a supplier pre-award inspection; however since it is in vacuum it is a critical item that requires added inspections. Determination of criticality and cost thresholds is set by the LIGO teams.
Cost Threshold	A LIGO determined value of a component or system which triggers or precludes an audit or inspection point. LIGO sub-teams will determine this value on a case by case basis, and is evaluated in conjunction with criticality thresholds. In some cases criticality thresholds may require a triggered audit or inspection despite the cost being below a threshold. LIGO has sole determination of these values, however at any time LIGO may require an audit or inspection, and will communicate these to the supplier ahead of time.
Criticality Threshold	A LIGO determined level of importance assigned to a system or component. This assignment is based upon factors including but not limited to duty cycle, installation area, redundancy, availability of spares, lead time to manufacture, etc. LIGO sub-teams are solely responsible for assigning criticality levels to components, and will make the determination for inspections and audits based on criticality independent of cost.
Pre Award Audit	Audit/Inspection by LIGO performed to determine to ability of a supplier to meet to the system or component manufacturing requirements including QA/QC. Safety, capacity, cleanliness, skill and stability.
In Process Inspection	Any inspection that takes place during the manufacturing process. This inspection may be performed by supplier as part of its regular quality control processes, or by LIGO as a spot check of workmanship or as a result of a deficiency in the performance of the supplier or the manufactured component.

Receiving Inspection	<p>Inspection at the LIGO site to verify that goods shipped arrive in good condition, without visible damage, contamination, or other problems that may have been caused during the packaging and shipping process. It is also the point at which LIGO team members look for problems related to improper packaging, as well as missing pieces or cartons. During a Receiving Inspection, LIGO team members will provide an inspection report noting any issues. If shipped item passes inspection it will be moved to the proper storage until its intended use. LIGO members will also submit a passed inspection report which authorizes procurements to release payments to supplier as agreed in contract.</p> <p>If the system does not pass receiving inspection, it will be at the discretion of the LIGO Project on how to handle the issues, which may include returning items to vendor, requiring vendor supported testing and rework, or additional testing at LIGO site before receiving inspection is signed off and payments are released to supplier.</p>
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LASER INTERFEROMETER GRAVITATIONAL WAVE OBSERVATORY (LIGO)

COMMERCIAL ITEMS OR SERVICES CONTRACT

GENERAL PROVISIONS CALIFORNIA INSTITUTE OF TECHNOLOGY "INSTITUTE"

GENERAL PROVISION TITLE

1. Offer and Contract
2. Time of Delivery
3. Improper Delivery
4. Assignment
5. Authority of Institute Representative and Required Notices
6. Changes
7. Force Majeure
8. Existing Commercial Computer Software – Licensing
9. Export Licenses
10. Disputes and Governing Law
11. Inspection and Acceptance
12. Insurance
13. Indemnification
14. New Material
15. Order of Precedence
16. Payment
17. Use of Name
18. Title and Risk of Loss
19. Government Title to Property Purchased or Fabricated with Contract Funds
20. Taxes
21. Termination
22. Warranty
23. Audit and Records
24. Site Visits
25. Nondiscrimination
26. Equal Employment Opportunity
27. Anti-Kickback
28. Clean Air Act and the Federal Water Pollution Contract Act
29. Debarment and Suspension
30. Byrd Anti-Lobbying Amendment
31. Copeland "Anti-Kickback" Act
32. Davis Bacon Act
33. Surety Bonds
34. Rights to Inventions – 37 CFR part 401
35. Patent Rights - Bayh-Dole Act [35 U.S.C. 200 et seq.]

(See Page 2 for Individual General Provision Applicability)

APPLICABILITY OF INDIVIDUAL GENERAL PROVISIONS

APPLICABLE TO ALL TRANSACTIONS IN THE UNITED STATES

The term *United States* includes the several States of the United States, the District of Columbia, the Commonwealth of Puerto Rico, the Virgin Islands, American Samoa, Guam, Wake Island, the Canal Zone, and all other territories and possessions of the United States, and the term *States* includes any one of the forgoing.

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|----------------------------------------------------------------|------------------------------------------------------------------------------|
| 1. Offer and Contract | 16. Payment |
| 2. Time of Delivery | 17. Use of Name |
| 3. Improper Delivery | 18. Title and Risk of Loss |
| 4. Assignment | 19. Government Title to Property Purchased or Fabricated with Contract Funds |
| 5. Authority of Institute Representatives and Required Notices | 20. Taxes |
| 6. Changes | 21. Termination |
| 7. Force Majeure | 22. Warranty |
| 8. Existing Commercial Computer Software – Licensing | 23. Audit and Records |
| 10. Disputes and Governing Law | 24. Site Visits |
| 11. Inspection and Acceptance | 25. Nondiscrimination |
| 13. Indemnification | 26. Equal Employment Opportunity |
| 14. New Material | 28. Clean Air Act and the Federal Water Pollution Control Act |
| 15. Order of Precedence | |

TAXES

20. The applicability of State sales tax is addressed on the face of the Purchase Order
[For imports] Value Added Tax (VAT) is addressed on the face of the Purchase Order

APPLICABLE IN SPECIAL CIRCUMSTANCES ACCORDING TO THEIR TERMS

9. **[For exports]** Compliance with Export Regulations
12. **[Suppliers Working on Site]** Insurance
27. **[For Contracts in excess of \$100,000]** Anti-Kickback Enforcement Act of 1986
29. **[For Contracts in excess of \$25,000]** Debarment and Suspension
30. **[For Contracts of \$100,000 or More]** Byrd Anti-Lobbying Amendment
31. **[For designated Construction/Repair Contracts in excess of \$2,000]** Copeland “Anti-Kickback” Act
32. **[For designated Construction/Repair Contracts in excess of \$2,000]** Davis-Bacon Act
33. **[For designated Construction/Repair Contracts in excess of \$500,000]** Surety Bonds
34. **[For designated Experimental, Development or Research Work]** Rights to Inventions- 37 CFR part 401
35. **[For designated Experimental, Development or Research Work]** Patent Rights - Bayh-Dole Act [35 U.S.C. 200 et seq.]

APPLICABLE TO ALL TRANSACTIONS IN THE UNITED STATES

These provisions **do not apply to foreign suppliers** performing outside the United States.

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|----------------------------------|---------------------------------------------------------------|
| 25. Nondiscrimination | 32. Clean Air Act and the Federal Water Pollution Control Act |
| 27. Equal Employment Opportunity | |

This agreement is a subcontract pursuant to an NSF Cooperative Agreement (CA) between the NSF and the Institute, [PHY-0328418](#).

1. **OFFER AND CONTRACT** The following terms, together with such terms, plans, specifications or other documents as attached or incorporated by reference as set forth on the face of this purchase order, constitute the offer of the Institute to Supplier and shall, when accepted, constitute the entire agreement ("Contract") between the Institute and Supplier. Institute hereby gives notice of its objection to any different or additional terms. This Contract is valid only as written. If price, terms, shipping date or other expressed condition of this Contract are not acceptable, the Institute must be notified and any variation must be accepted in writing prior to shipment or delivery. This Contract shall be deemed to have been accepted (a) in the absence of written notification of non-acceptance by the Supplier within a reasonable time, or (b) upon timely delivery of the products identified to the shipping address specified on the face of the order.
2. **TIME OF DELIVERY** Time is of the essence in this Contract. If delivery dates cannot be met, Supplier must notify the Institute immediately. Such notification shall not, however, constitute a change to the terms of this Contract except as the order may be modified in writing by the Institute.
3. **IMPROPER DELIVERY** In addition to other remedies provided by law, the Institute reserves the right to refuse any goods or services and to cancel all or any part of this Contract if Supplier fails to deliver all or any part of the goods or services in accordance with the terms and conditions of this Contract. Acceptance of any part of this order shall not bind the Institute to accept any future shipments nor deprive it of the right to return goods already accepted.
4. **ASSIGNMENT** The Supplier shall have no right to assign this Contract or any benefits from this Contract without prior written consent of the Institute.
5. **AUTHORITY OF INSTITUTE REPRESENTATIVES AND REQUIRED NOTICES; FACSIMILE AND ELECTRONIC SIGNATURES ACCEPTABLE**
 - (a) No order, notice, or direction received by the Supplier and issued pursuant to this Contract shall be binding upon either the Supplier or the Institute, unless issued or ratified in writing by the Institute Purchasing Agent, the Director of Procurement Services, or by representatives designated in writing by either of them.
 - (b) The parties agree that facsimile (fax) or electronic signature copies of contract documents are just as binding as originally-executed documents.
6. **CHANGES** The Institute may at any time, by a written order to the Supplier, make changes within

the general scope of this Contract in any one or more of the following: (a) drawings, designs, or specifications; (b) method of shipment or packing; and (c) time or place of delivery. If any such change causes an increase or decrease in the cost of, or the time required for, the performance of any part of the work under this order, an equitable adjustment may be made in the order price or delivery schedule or both, and the order shall be modified in writing accordingly. Any claim by Supplier for adjustment under this Article must be asserted within 30 days from the date of receipt by Supplier of the notification of change; provided, however, that the Institute, if it decides that the facts justify such action, may receive and act upon any such claim asserted at any time prior to final payment under this purchase order. Nothing in this clause shall excuse Supplier from proceeding with this order as changed.

7. **FORCE MAJEURE** Each party shall not be liable for damages arising out of either its failure to deliver or any delay in delivery caused by strikes, lockouts, fires, war, or acts of God. The Supplier shall notify the Institute in writing as soon as it is reasonably possible after the commencement of any event triggering a delayed delivery or inability to deliver.
8. **EXISTING COMMERCIAL COMPUTER SOFTWARE – LICENSING** (This Article is applicable to the acquisition of any existing commercial computer software under this Contract.)
 - a) Where the Supplier proposes its standard commercial software license, only those applicable portions that comply with the provisions of this Contract are incorporated into and made a part of this Contract.
 - (b) If the Supplier does not propose its standard commercial software license until after this Contract has been issued, or at or after the time the computer software is delivered, such license shall nevertheless be deemed incorporated into and made a part of this Contract under the same terms and conditions as in paragraph (a) above. For purposes of receiving updates, correction notices, consultation, and similar activities on the computer software, any authorized user may acknowledge receipt of a registration form or card and return it directly to the Supplier; however, such signing shall not add to or alter any of the terms and conditions of this Contract.
 - (c) If the specified computer software is shipped or delivered to the Institute, it shall be understood that the Supplier has unconditionally accepted the terms and conditions set forth in this Article, and that the terms and conditions of this Contract (including the incorporated license) constitute the entire agreement between the parties concerning rights in the computer software.
 - (d) Supplier understands and agrees that the computer software may be: (1)

Used, or copied for use, in or with any computer owned or leased by, or on behalf of the Institute provided that the software is not used, nor copied for use, in or with more than one computer simultaneously, unless otherwise permitted; (2) Reproduced for safekeeping (archives) or backup purposes; (3) Modified, adapted, or combined with other computer software, provided that the modified, combined, or adapted portions of the derivative software incorporating restricted computer software shall be subject to the same restricted rights; and (4) Disclosed and reproduced for use by Institute designees in accordance with this Article. (e) Supplier agrees that the software may be used by the Institute in support and furtherance of any of its obligations to the US Government or other funding organization. (f) Supplier warrants that it has the right to sell, license, or transfer the license for the software furnished to the Institute under this Contract in accordance with the terms of this Contract.

9. **EXPORT LICENSES** The Supplier shall comply with all U.S. export control laws and regulations, including the International Traffic in Arms Regulations (ITAR), 22 CFR Parts 120 through 130, and the Export Administration Regulations (EAR), 15 CFR Parts 730 through 799, in the performance of this Contract. In the absence of available license exemptions/exceptions, the Supplier shall be responsible for obtaining the appropriate licenses or other approvals, if required, for exports of hardware, technical data, and software, or for the provision of technical assistance.

10. **DISPUTES AND GOVERNING LAW** (a) Any dispute or claim arising out of, in connection with, or relating to this Contract shall be submitted for resolution to ascending levels of management of the parties. If the dispute cannot be resolved after such negotiations, either party may pursue any appropriate legal recourse not inconsistent with the provisions of this Contract. (b) Pending any decision, appeal or judgment or the settlement of any dispute, Supplier agrees to proceed diligently with the performance of the requirements of this Contract. (c) This Contract shall be construed and enforced in accordance with the laws of the State of California. Disputes will be adjudicated in Los Angeles, California.

11. **INSPECTION AND ACCEPTANCE** The Institute shall have the right to inspect the work and activities of the Supplier under this Contract in such manner and at all reasonable times as are deemed appropriate. Final inspection shall be at the Institute's premises unless otherwise agreed in writing. The Institute, at its option, may reject any non-conforming items and (i) return such non-conforming items to the Supplier at the Supplier's

risk and expense for credit to the Institute at the full invoice price plus all transportation and other related costs, or (ii) hold them for disposition in accordance with the Supplier's instructions at the Supplier's expense, including storage and handling. If the Institute rejects items as nonconforming, the quantities under this Contract will automatically be reduced unless the Institute otherwise notifies the Supplier. The Supplier will not replace quantities so reduced without written instruction by the Institute. Payment for nonconforming goods shall not constitute an acceptance thereof, limit, or impair the Institute's right to assert any legal or equitable remedy, or relieve the Supplier's responsibility for latent defects. The Institute may also opt for a refund of the amount paid under this Contract.

12. **INSURANCE** (This Article is applicable when the Supplier will be entering Institute-controlled premises.) (a) The Supplier shall, at its own expense, provide and maintain during the entire performance period of this Contract at least the following types and minimum amounts of insurance with the Institute named as an additional insured in policies for comprehensive liability insurance with a licensed carrier authorized to do business in the State of California: (1) Workers' Compensation and Employer's Liability Insurance, as required by applicable Federal and State workers' compensation and occupational disease statutes. The Employer's Liability coverage shall be at least \$100,000, except in states with exclusive or monopolistic funds that do not permit worker's compensation to be written by private carriers. (2) Comprehensive Liability Insurance, including automobiles (owned, non-owned, or leased), completed operations, products, and contractual liability, for a combined single limit of not less than \$1,000,000 for all deaths, injuries, and property damage arising from one accident or occurrence. (b) Insurance Certificates and Endorsements. Before commencing work under this Contract, the Supplier shall furnish (i) certificates of insurance for the coverages specified in paragraph (a) above, and (ii) an additional insured endorsement naming the Institute as an additional insured to the Contract for the coverage specified above. Such certificates and the endorsement shall provide that any cancellation or material change in the insurance policies shall not be effective (i) for such period as the laws of the State in which this Contract is to be performed, or (ii) until 30 days after the insurer or the Supplier gives written notice to the Institute, whichever period is longer. Also, such certificates and the endorsement shall (i) cover contractual liability assumed under this Contract, and (ii) be primary and noncontributing to any insurance procured by the Institute. The Supplier agrees to

permit the Institute to examine its original policies, should the Institute so request. Should the Supplier at any time neglect or refuse to provide the insurance required herein, or should such insurance be canceled, the Institute shall have the right to procure same and the costs thereof shall be deducted from monies then due or thereafter to become due to the Supplier.

13. **INDEMNIFICATION** The Supplier agrees to defend, indemnify and hold harmless the Institute from and against all claims, liability and expenses, including reasonable legal fees, arising from any actual or claimed: (i) injury to any person or property resulting from any act or omission of Supplier, its employees or agents, excepting such liability as may result solely from the negligent acts or omissions of the Institute or its employees; and (ii) infringement of any patent, copyright, or trademark by reason of the sale or use of the goods provided by Supplier hereunder. The Supplier's obligations hereunder shall survive acceptance of the goods and payment thereof by the Institute.
14. **NEW MATERIAL** Unless this Contract specifies otherwise, the Supplier represents that the supplies are new and are not of such age or so deteriorated as to impair their usefulness or safety. If the Supplier believes that furnishing other than new material will be in the Institute's interest, the Supplier shall so notify the Purchasing Agent in writing and request authority to use such material.
15. **ORDER OF PRECEDENCE** To the extent there is inconsistency among any documents relating to this order, the inconsistency will be resolved in the following order of priority: (a) These General Provisions; (b) The details specified on the order, or description of products or services; (c) any other documents the Institute agrees in writing to incorporate by reference.
16. **PAYMENT** (a) Invoices shall be submitted in duplicate to the attention of the Institute's Accounts Payable Department, unless otherwise specified, and shall contain the following information as applicable: (i) Contract number, (ii) item number, (iii) description of supplies or services, (iv) size, (v) quantity, (vi) unit price, (vii) extended totals and (viii) any other information which may be specified on the face of this Contract. Any applicable state sales or use taxes or Federal excise taxes shall be shown separately on the invoice. (b) The Institute shall pay the Supplier, upon the submission of proper invoices, the prices stipulated in this Contract for supplies delivered and accepted or services rendered and accepted, less any deductions provided in this Contract. (c) The Institute shall make its best effort to make payments within the net period, if any, specified in the Contract, measured from the date of receipt of

the goods or services at the destination or the date of receipt of the invoice, whichever is later. Discount time periods will be measured from the same date. Payment shall be deemed to have been made on the date the check is mailed or on the date on which an electronic funds transfer was made. In no event will the Institute be liable for or pay a surcharge, interest, or any kind of penalty as a result of the Institute's payment not being made within the net period, if any, specified in the Contract or the date of payment by electronic funds transfer. (d) Payment for goods or services in accordance with this paragraph will not waive or otherwise affect the right of the Institute to inspect such goods or services or to reject, or revoke acceptance of, nonconforming goods.

17. **USE OF NAME** Supplier agrees not to use the name or trademarks of the Institute or any member its staff in sales promotional work or advertising, or in any form of publicity, without the prior written permission of the Institute.
18. **TITLE AND RISK OF LOSS** (a) Unless otherwise provided in Section 19 or elsewhere in this Contract, title to tangible property (property of any kind except intangible property and debt instruments) furnished under this Contract shall pass to the Institute upon formal acceptance by the Institute, regardless of when or where the Institute takes physical possession, unless the Contract specifically provides for earlier passage of title. (b) Risk of loss shall not pass to the Institute until the tangible property called for in this Contract has been actually received and accepted by the Institute at the destination specified. Supplier assumes all responsibility for packing, crating, marking, transportation and liability for loss or damage in transit, notwithstanding any agreement by Institute to pay freight, express or other transportation charges. Supplier agrees to trace lost or delayed shipments at the request of the Institute.
19. **GOVERNMENT TITLE TO PROPERTY PURCHASED OR FABRICATED WITH CONTRACT FUNDS** Title to tangible property shall vest in the Government upon acquisition when the tangible property is intended to be installed at, incorporated into, built, or necessary for the construction or operation of either the Hanford or Livingston Observatories. All Government property acquired in accordance with this Section 19 shall be subject to the requirements set forth below:
 1. Title.
 - (a) Tangible Property means property of any kind except intangible property and debt instruments. Title to all tangible property procured with funds provided through this Contract, and subject to this Section 19, shall vest in the Government as follows:

1) If this Contract contains a provision directing the Supplier to purchase material which the Government will reimburse as a direct item of cost under the Institute's primary Award, title to property shall pass to and vest in the Government upon delivery of such property to the Government, to the Institute, to the Supplier, to any subcontractor, or to any agent of the Government, of the Supplier, or of any subcontractor; and

2) Title to all other property shall pass to and vest in the Government upon the earliest to occur of the following:

(i) issuance of the property for use in contract performance pursuant to this Contract;

(ii) commencement of processing of the property or its use in contract performance pursuant to this Contract; or

(iii) reimbursement of the cost of the property by the Institute on behalf of the Government.

2. Legal title to all tangible property furnished by the NSF or acquired from other Government agencies shall remain with the Government, unless otherwise specified in this Contract.

3. Title to Government property shall not be affected by the incorporation or attachment thereof to any property not owned by the Government, nor shall any Government property lose its identity by reason of affixation to any reality.

4. All subcontracts issued or awarded with respect to the performance of this Contract shall include provisions regarding the determination of title to tangible property acquired by the subcontractor in accordance with Sections 18 and 19.

5. Should Supplier purchase tangible property pursuant to this Contract and subject to this Section 19, Supplier shall be a limited agent of the NSF solely for the purpose of transferring and vesting title to such tangible property in the Federal Government. The agent shall be solely responsible for the payment of the purchase price of tangible property acquired, and the agent shall have no authority to bind or obligate the Institute, NSF or the Federal Government for payment of the purchase price to any third party. Such agents shall be and shall remain liable for the risk of loss of, destruction of, or damage to tangible property acquired until such tangible property is transferred to the possession of the Government or acceptance by the Institute.

20. **TAXES** (a) **Except as may be otherwise provided on this order**, the contract price includes all applicable Federal, State, and local taxes and duties. With respect to transactions for which the

Institute may be exempt from any tax or duty, the Institute will provide, upon request, evidence to support its claim to such exemption. (b) The Institute will comply with all Federal and State income tax laws with respect to withholding and year-end tax reporting. (c) The Internal Revenue Service (IRS) requires the Institute to have on file a Taxpayer Identification Number (TIN) for every US person or US business that receives a payment, regardless if the payment is tax reportable or not. This information is provided on IRS Form W-9. US Citizens and Resident Aliens are required to complete a Form W-9 before receiving any payments from the Institute. A TIN can be any of the following: a Social Security Number (SSN) an Individual Taxpayer Identification Number (ITIN) or an Employer Identification Number (EIN). Failure to provide a TIN will result in delay of payment and/or backup withholding. (d) Foreign businesses providing services in the US for the Institute are required to provide the appropriate IRS Form W-8 (i.e., Form W-8BEN, W-8ECI, or W-8IMY). (e) Foreign individuals providing services in the US for the Institute are required to provide an IRS Form W-8BEN or IRS Form 8233 depending on the appropriate tax withholding treatment.

21. **TERMINATION** (a) **For Cause.** The Institute may terminate this Contract, or any part of it, for cause in the event of any default by the Supplier, or if the Supplier fails to comply with any Contract terms and conditions, or fails to provide the Institute, upon request, with adequate assurances of future performance. In the event of termination for cause, the Institute shall not be liable to the Supplier for any amount for supplies or services not accepted, and the Supplier shall be liable to the Institute for any and all rights and remedies provided by law. If it is determined that the Institute improperly terminated this Contract for cause, such termination shall be deemed a termination for convenience. (b) **For Convenience.** The Institute reserves the right to terminate this Contract, or any part hereof, for its sole convenience. In the event of such termination, the Supplier shall immediately stop all work hereunder and shall immediately cause any and all of its subcontractors to cease work. Subject to the terms of this Contract, the Supplier shall be paid a percentage of the Contract price reflecting the percentage of the work performed prior to the notice of termination, plus reasonable charges the Supplier can demonstrate to the satisfaction of the Institute, using its standard record keeping system, have resulted from the termination. The Supplier shall not be paid for any work performed or costs incurred which reasonably could have been avoided.

22. **WARRANTY** Supplier expressly warrants all goods and services delivered under this Contract to be free from defects in material and workmanship and to be of the quality, size and dimensions ordered. This express warranty shall not be waived by reason of the acceptance of the goods or services or payment by Institute. The Supplier shall provide the Institute with a copy of any standard warranty which is normally offered on a commercial product deliverable under this Contract. The commercial product warranty shall be deemed to be incorporated by reference and the Institute shall be entitled to all rights under such warranty.
23. **AUDIT AND RECORDS** Financial records, supporting documents, statistical records, and other records pertinent to this Contract shall be retained by the Supplier for a period of five years from acceptance by the Institute. Supplier agrees that the Institute, the National Science Foundation, the Comptroller General of the United States, or any of their duly authorized representatives, shall have access to any books, documents, papers and records of the Supplier which are directly pertinent to this Contract, for the purpose of making audits, examinations, excerpts and transcriptions.
24. **SITE VISITS** NSF and the Institute, through authorized representatives, have the right, at all reasonable times, to make site visits to review project accomplishments and management control systems and to provide such technical assistance as may be required. If any site visit is made by NSF or the Institute on the premises of the Supplier or a contractor under a subcontract, the Supplier shall provide and shall require its contractors to provide all reasonable facilities and assistance for the safety and convenience of the Institute or Government representatives in the performance of their duties. All site visits and evaluations shall be performed in such a manner that will not unduly delay the work.
25. **NONDISCRIMINATION** The Contract is subject to the provisions of Title VI of the Civil Rights Act of 1964 [42 U.S.C. § 2000d], Title IX of the Education Amendments of 1972 [20 USC §§ 1681 et seq.], the Rehabilitation Act of 1973 [29 U.S.C. § 794], the Age Discrimination Act of 1975 [42 U.S.C. §§ 6101 et seq], and all regulations and policies issued by NSF pursuant to these statutes. In accordance with these statutes, regulations, and policies, no person on the basis of race, color, national origin, sex, disability, or age shall be excluded from participation in, be denied the benefits of, or otherwise be subjected to discrimination under the Contract.
26. **EQUAL EMPLOYMENT OPPORTUNITY** This Contract is subject to the requirements of Executive Orders 11246 and 11375 and the rules and regulations or the Secretary of Labor (41 CFR Chapter 60) in promoting Equal Employment Opportunities.
27. **ANTI-KICKBACK ENFORCEMENT ACT OF 1986** This Contract is subject to the provisions of the Anti-Kickback Enforcement Act of 1986, Public Law 99-634 (41 U.S.C. 51-58). By accepting this order, Seller certifies that it has not paid kickbacks directly or indirectly to any Institute employee for the purpose of obtaining this or any other Institute purchase order or to obtain favorable treatment in an Institute matter.
28. **CLEAN AIR ACT AND THE FEDERAL WATER POLLUTION CONTROL ACT** – Should this Contract be for an amount in excess of \$100,000, Supplier agrees to comply with all applicable standards, orders or regulations issued pursuant to the Clean Air Act (42 U.S.C. 7401 et seq.) and the Federal Water Pollution Control Act as amended (33 U.S.C. 1251 et seq.). Further, Supplier agrees as follows:
- To comply with all the requirements of Section 114 of the Clean Air Act [42 U.S.C. §7414] and Section 308 of the Clean Water Act [33 U.S.C. § 1318], respectively, relating to inspection, monitoring, entry, reports and information, as well as other requirements specified in Section 114 and Section 308 of the Clean Air Act and the Clean Water Act, respectively, and all regulations and guidelines issued thereunder before the Contract.
 - That no portion of the work required by the Contract will be performed in a facility listed on the Environmental Protection Agency List of Violating Facilities on the date that the Contract was awarded unless and until EPA eliminates the name of such facility or facilities from such listing.
 - To use its best efforts to comply with clean air standards and clean water standards at the facility in which the Contract is being performed.
 - To insert the substance of the provisions of this article into any nonexempt subcontract.
29. **DEBARMENT AND SUSPENSION** – (a) Supplier shall fully comply with the requirements stipulated in 2 CFR Part 180, as modified by 45 CFR 620.330 and shall ensure that any lower tier covered transaction, as described in 2 CFR 180.220 and modified by 45 CFR 620.200 and 620.220 includes a term or condition requiring compliance with these requirements. The Supplier acknowledges that failing to disclose the information required under 45 CFR § 620.335 may result in the termination of the Contract, or pursuance of other available remedies, including suspension and debarment. Supplier may access the Excluded Parties List System at <http://epls.arnet.gov>. (b) No contract at any tier shall be made to parties listed on the General Services Administration's List

of Parties Excluded from Federal Procurement or Nonprocurement Programs in accordance with E.O.s 12549 and 12689, "Debarment and Suspension." This list contains the names of parties debarred, suspended, or otherwise excluded by agencies, and contractors declared ineligible under statutory or regulatory authority other than E.O. 12549. Supplier, whose Contract exceeds the small purchase threshold, shall provide the required certification regarding its exclusion status and that of its principal employees.

30. **[FOR CONTRACTS OF \$100,000 OR MORE] BYRD ANTI-LOBBYING AMENDMENT** - Supplier warrants that Supplier has applied or bid on a Contract of \$100,000 or more and has filed the required certification. Each subcontracting tier must certify to the tier above that it will not and has not used Federal appropriated funds to pay any person or organization for influencing or attempting to influence an officer or employee of any agency, a member of Congress, officer or employee of Congress, or an employee of a member of Congress in connection with obtaining any Federal contract, grant or any other award covered by 31 U.S.C. 1352. Each tier shall also disclose any lobbying with non-Federal funds that takes place in connection with obtaining any Federal award. Such disclosures are forwarded from tier to tier up to the recipient.
31. **[FOR CONSTRUCTION/REPAIR CONTRACTS >\$2000] Copeland "Anti-Kickback" Act (18 U.S.C. 874 and 40 U.S.C. 276c)** Supplier shall comply with the Copeland "Anti-Kickback" Act (18 U.S.C. 874), as supplemented by Department of Labor regulations (29 CFR part 3, "Contractors and Subcontractors on Public Building or Public Work Financed in Whole or in Part by Loans or Grants from the United States").
32. **[FOR CONSTRUCTION/REPAIR CONTRACTS >\$2000] Davis-Bacon Act, as amended (40 U.S.C. 276a to a-7)** Supplier shall comply with the Davis-Bacon Act (40 U.S.C. 276a to a-7) and as supplemented by Department of Labor regulations (29 CFR part 5, "Labor Standards Provisions Applicable to Contracts Governing Federally Financed and Assisted Construction").
33. **[FOR CONSTRUCTION/REPAIR CONTRACTS >\$500,000] Surety Bonds - If so directed**, the Supplier shall furnish separate bid guarantees, performance and payment bonds to the Institute. Each bond shall set forth a penal sum in an amount not less than the Contract Price. Each bond furnished by the Supplier shall incorporate by reference the terms of this Contract as fully as though they were set forth verbatim in such bonds. In the event the Contract Price is adjusted by Change Order executed by the Contractor, the

penal sum of both the performance bond and the payment bond shall be deemed increased by like amount. The performance and payment bonds furnished by the Supplier shall be in form suitable to Institute and shall be executed by a surety, or sureties, reasonably acceptable to the Institute.

34. **[For designated Experimental, Development or Research Work] Rights to Inventions** - For non-profit organizations and small business firms, patent rights shall be governed by 37 CFR part 401, titled "Rights to Inventions Made by Non-Profit Organizations and Small Business Firms under Government Grants, Contracts and Cooperative Agreements".
35. **[For designated Experimental, Development or Research Work] Patent Rights** – Bayh-Dole Act [35 U.S.C. 200 et seq.]

Embedded Adobe XML Form

The file https://dcc.ligo.org/public/0000/F0810001/004/Technical_Direction_Memo_template_F0810001-v4.pdf is an Adobe XML Form document that has been embedded in this document. Double click the pushpin to view.



Welding Specification for Weldments used within the Advanced LIGO Vacuum System

APPROVALS	DATE	Document Change Notice
AUTHOR(S): Calum Torrie, Dennis Coyne	07-June-2010	see DCC record Status: APPROVED

1 Scope

This specification controls the process of welding aluminum and stainless steel for parts (weldments) intended for service inside the Ultra-High Vacuum (UHV) for the Advanced LIGO project. Unless otherwise directed all weldments should be fabricated in compliance with this specification.

This specification does not cover welding elements of the vacuum envelope itself, but rather parts which are placed within the vacuum envelope.

2 Certification and End Item Data Package

The fabricator must provide the following certification or documentation:

1. To approve seamed tubing, if applicable, (see section 3.2) submit an inspection report confirmation on qualification of as received stainless steel seamed tubing, prior to starting production.
2. To approve welder and weld samples submit a Procedure Qualification Record (PQR) on welder and weld samples (see section 8), prior to starting production.
3. To approve method used for production weldments (see section 7) submit a Certified Welding Procedure Specification (WPS) on production weldments, this can be submitted with the PQR, prior to starting production.
4. To approve production weldments (see section 10) submit prior to final machining:
 - a. An inspection report confirming the qualification of the production weldments to Class C, as per section 7.1 and 7.2 should be submitted.
 - b. Certification that the requirements of the specification (WPS) have been met
 - c. Material certifications for all materials (filler rod and base material) which comprise the weldment.
5. To approve final machining (see section 12) submit dimensional inspection report on final machining, at the time of delivery.

3 Acceptable Materials

3.1 Base Material

Only the material alloys defined in the associated drawings are acceptable. No substitutions shall be made without prior written consent from the LIGO Contracting Officer. All material should be selected and transported according to our requirements, for example for stainless steel tubing follow

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section 3.2.5 and 3.2.6 below. A similar specification should be followed and agreed with the LIGO Contractual officer for Aluminum or other materials.

No parts, including seamed tubing, shall be ground or cut off with grinding tools.

3.2 Stainless steel tubing

Stainless steel seamed tubing, although an option, should not be the first choice if seamless tubing is available. With prior approval from a LIGO Contract Officer stainless steel seamed tubing can be used under the following conditions: -

1. Take a cross-sectional sample of the tube weld for every ~20 ft. of every continuous weld run (batch) and verify that the weld is Class B in Table V of Mil-Std-2219. The verification requires
 - (a) visual inspection for weld discontinuities, porosity and inclusions,
 - (b) x-ray for complete penetration and fusion and
 - (c) microstructural examination of weld samples cross-sections (refer to section 8.3 for further details)
2. Supply inspection report for approval to the LIGO contract officer confirming that the as-received seamed welds conform to class B prior to continuing.
3. Prior to welding all seamed tubing (inside and out) should be electropolished to ASTM B-912. (Scotch-Brite(TM) or similar products are prohibited.)
4. As per section 11 of ASTM A554-10 the finished tubes shall be free of injurious defects and have a workmanlike finish. Surface imperfections such as handling marks, shallow pits and scratches shall not be considered as serious defects provided they are within 10% of the specified wall or 0.002 inch (0.05mm), whichever is greater.
5. Each tube should be individually wrapped and protected from scratches, pitting and digs during transport and handling. Each tube should be inspected and handled appropriately.

If stainless steel seamless tubing is available items 3.2.4 and 3.2.5 still apply.

3.3 Filler Rod

The following Table shows the filler rod that should be used with various alloys:

Table 1: Welding Filler Rod

Material	Alloy	Filler
Stainless Steel	304	308, 308L
	304L	308L
	316	316, 316L
	316L	316L
	321	347
	347	347
Aluminum	6061	4043 (Linde H.Q.)

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4 Cleaning and Preparation

1. Pre weld machining must be carefully controlled. All machines & fixtures are to be cleaned to avoid cross contamination before any machining takes place.
2. Weld preps must be machined and under no circumstances should weld preps be ground (due to risk of cross contamination). If machining is impractical use new carbide burrs.
3. Welds are not to be ground (due to risk of cross contamination); If welds need to be cleaned up, they must be cut.
4. Water soluble (not just water miscible) cutting fluid (lubrication) is to be used for all machining operations, such as weld prep, weld clean up or weld repair. The use of cutting fluids or lubricants, which contain sulfur, chlorine or silicone compounds is prohibited.
5. The contractor must define suitable methods for initial cleaning (oxide cleaning, degreasing, and dirt/soil removal), interpass cleaning and post-weld cleaning. An etchant (acid or basic) should be used, similar to the solutions defined in Annex G, "Solutions for Macroetching Aluminum Weldments" of AWS D1.2/D1.2M:2003 Structural Welding Code -- Aluminum. The contractor must define degreasing, deoxidizing, interpass and post-weld cleaning methods in the Weld Process Specification (WPS) and Process Qualification Record (PQR) which must be approved by LIGO before welding.
6. Prior to welding, clean the filler rod using lint- free tissue and analytical Reagent Grade isopropyl alcohol.

5 Handling and Storage

1. Latex gloves are to be worn for handling room temperature cleaned parts – parts to be welded or tools and fixtures.
2. If hot parts must be manipulated, clean tools are preferred rather than gloved hands. If hot parts or tools/fixtures need to be handled, then clean welding gloves should be used. A new pair of gloves should be dedicated to the LIGO work.
3. Tools and fixtures, which may contain cleaned parts in assembly or transport, are to be kept clean from oxides, oils, fingerprints, etc.
4. Parts are to be stored in a clean dry area until welding commences. Parts should not be stored for a long periods after cleaning, welding should commence as soon as possible and definitely within one work shift after parts are chemically cleaned.
5. Store filler metal in bonded storage and in a manner such that it is protected from oil and other contaminates. The package seal must not be broken until just prior to welding. Rod from an opened package must be kept in a cabinet or other area within the clean welding area.
6. Weldments and cleaned parts, tools and fixtures are to be covered between welding operations. The material used for covering can be UHV quality aluminum foil or clean

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stainless steel covers/boxes. If the parts are at room temperature, then cleanroom grade sheeting materials (low lint, low shedding), such as DuPont™ Tyvek®.

7. Welding should be performed in a clean, particulate and humidity (50% maximum relative) controlled environment.
8. Completed weldments are to be double wrapped and stored in a clean, controlled area prior to shipment. The inner wrap must be UHV quality aluminum foil. The outer wrapping, or bag, should be Ameristat® or similar class 100 cleanroom grade packaging material. No tape (adhesive) should be used to attach or close the inner wrapping. Heat sealing can not be performed with the part in the wrapping/bag.

6 Welding

6.1 General Requirements

1. All welding must take place in a clean, particulate and humidity (50% maximum relative) controlled environment. Welders must adhere to the contamination control practices described in these specifications.
2. Thin (less than 0.010 inch thick) stainless steel or beryllium-copper parts (e.g.: RF shields) may be spot welded using a resistance welding process. All other welding shall be by the tungsten inert gas (TIG) fusion process, unless specifically approved. Welding electrodes shall be 2 percent thoriated tungsten.
3. Prior to welding, all parts must be cleaned according to these specifications. Jigs, fixtures, chill rings (if used), and welding bench which contact the clean parts must also be cleaned according to these specifications.
4. The filler rod and must be kept clean at all times.
5. Leather welders gloves are of course used by the welder during welding. However, Latex gloves must be worn when clean “cold” parts are handled. If the gloves come in contact with anything other than clean surfaces, they must be replaced with new ones.
6. Appropriate brushes and high quality hand scrapers can be used for cleaning oxides off welds. Brushes and scrapers shall be degreased before use and kept free from oxides. Brass brushes and Scotch-Brite pads are prohibited.
7. Preheating is discouraged. If preheating the parts is necessary we would prefer that neither Propane nor Oxy-Acetylene be used as this will cause contamination in the weld. If Oxy-Acetylene is required please get prior written approval from the LIGO contracting officer.
8. All welds must be full penetration and full fusion welds. No trapped volumes are permitted. Weldments with crevices are considered non-cleanable since these crevices act as traps for cleaning solutions. Inspect the root weld before further passes, if remedial action is required only use clean Carbide burrs. Grinding (with abrasive wheels, cloth, or stones), or use of abrasive cloth or paper, is not permitted.

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9. It can be difficult to achieve full penetration with a single-sided weld. Double-sided welds are permissible, as long as sectioning of weld samples indicate weld overlap and no voids (refer to section 7).
10. The welder shall protect material adjacent to the welds to prevent damage. In general final machining and machined details (tapped holes, etc.) are added after welding, but not in all cases. Care should be taken not to blemish or damage the part while welding.

6.2 Stainless Steel

1. Careful control of the parts shall be imposed so that carbon steel contamination is prohibited. In the event of carbon steel contamination, skim with a carbide tool to remove any residual contaminant
2. Back purge stainless steel welds in all cases. Maintain gas flow until the metal cools to prevent oxidation. Use Argon or Nitrogen Commercial Grade 99.98 percent or mixture of these for cover and purge gas.
3. Stainless steel parts should be welded within 24 hours after they are chemically cleaned.

6.3 Aluminum

1. For welding thick parts, the suggested procedure is to use D.C. straight polarity with Atomic Grade Helium as the cover gas. This method does not require pre-heating of the parts.
2. For parts of 1/8 inch thickness or less, use A.C. polarity with Argon cover gas.
3. Aluminum parts should be welded within 24 hours after they are chemically cleaned.

7 Weld Quality Requirements and Inspection

1. All welds on production weldments must meet requirements for Class C in table V of Mil-Std-2219 verified by visual inspection. Note that dye penetrant may only be used on a practice weld configuration and never on a final weldment.
2. All Class C welds shall be 100% visually inspected for cracks and weld discontinuities, porosity and inclusions. This should be aided by a magnifying lens of [5X] or [10X] power wherever required to discern indications or defects otherwise not clear. Measure size and contour of welds with suitable gages. Clean welds per section 6.1.6 for inspection.
3. Submit a copy of certified Welding Procedure Specification (WPS) for approval, describing how the welding will be carried out on the production weldments. This should be submitted for approval with the LIGO Contracting Officer's Technical Representative along with the Procedure Qualification Record (PQR) referenced below in section 8. Once all of this is approved work can start on the production weldments.

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8 Weld & Welder Qualification

1. All welders should be certified to American Welding Society (AWS).
2. Qualify the weld preparation, cleaning process, welders and welds by creating sample welds representative of each type of weld in the final weldment. It is important to design the samples to mimic the weld access and heat path that will be present in the weldment.
3. The sample weldments must meet requirements for Class B in Table V of Mil-Std-2219 as verified by: -
 - (a) visual inspection for weld discontinuities, porosity and inclusions,
 - (b) x-ray for complete penetration and fusion and
 - (c) Cross-sections of weld samples, for microstructural examination, should be prepared by cutting in an orientation perpendicular to the direction of the weld bead so that the size and shape of the weld and the heat-affected zone (HAZ) can be observed. Each weld sample should be sectioned and polished by standard metallographic procedures (for example, mounted in an epoxy, polished with a 5 micron diamond paste and then be etched with Keller's reagent). The section samples should be examined and photo-micrographed at approximately 15x. Any weld discontinuities should be further examined and photographed at 50x to 200x magnification.
4. Submit a Procedure Qualification Record (PQR) and the sample welds to LIGO. The PQR should include all evidence of compliance with the Class B qualification including photographic evidence of samples and documentation on the weld preparation, parts cleaning process, welding process, and preparation and qualification of the welder(s). All welds, and associated photographs and micrographs, must be labeled and presented in the form of a test or inspection report.
5. Prior to a new welder producing a LIGO weldment. They must be qualified for the welding process(es) and weld joints used on the LIGO weldment. Copies of the welder's certification for the LIGO weldment, in the form of a Performance Qualification Record on the weld samples outlined above, must be kept on file and available for LIGO inspection.
6. Vendors should qualify the welding procedures, welders and welder operators in accordance with Section 3 of AWS D1.2/D1.2M:2003 and Section 4 of AWS D1.1/D1.1M:2008.

9 Weld Repair

1. If a weld has surface blemishes, high porosity, hairline cracks or incomplete penetration then the weld should be re-flowed and then re-inspected.

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10 Weld approval

Once the production weldments have been satisfactorily completed and prior to completing the remaining steps in this specification the contractor must have the welds accepted and approved by the LIGO Contracting Officer's Technical Representative. The approval step should include a visit by the LIGO Contracting Officer's Technical Representative. At the time of the visit the following items should be delivered to the LIGO Contracting Officer's Technical Representative: -

1. An inspection report confirming the qualification of the production weldments to Class C, as per section 7 (points one and two) should be submitted.
2. Certification that the requirements of the specification (WPS) have been met
3. Material certifications for all materials (filler rod and base material) which comprise the weldment.

The approval step can also be done without a visit and via e-mail, if approved by the LIGO Contracting Officer's Technical Representative and only if photographs of all of the welds are added to the report.

Once approval is obtained the contractor should continue with the following steps.

11 Post-Weld Stress Relief

After welding and approval all weldments must go through a stress relief heat treatment prior to any final machining.

12 Final Machining

Any features on the weldment which are dimensionally critical are machined after welding and post-welding stress relief. These features will be called out in the associated drawing package. Any dimensional inspection required will be called out in the associated RFQ / RFP / SOW.

13 Post-weld Cleaning

The weldment must be cleaned as per the following specification. (Scotch-Brite(TM) or similar products are prohibited.)

13.1 Aluminum

1. First the parts or assemblies are de-burred, and cleaned, removing all possible machining and weld process residue. Use only clean Carbide burrs. Grinding (with abrasive wheels, cloth, or stones), or use of abrasive cloth or paper, is not permitted.
2. The part(s) are then washed with Alkaline Soak Cleaner and inspected for cleanliness using the water break test.
3. The weldment is then submerged in a tank of Bright Dip chemicals at elevated temperature (typically 140 to 200 degrees F) for several minutes (typically 2 to 10 mins). The bright dip

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acid formulation, time and temperature should be chosen to achieve slight chemical etching (<0.0005 inch).

4. The weldment is then thoroughly rinsed with clean water. After rinsing, a full visual inspection is performed, to assure a satisfactory Bright Dip surface finish has been achieved uniformly, over the entire weldment
5. The parts are then dried, re-inspected and un-racked.
6. In order to remove any weld stain, left behind after the Bright Dip process, use acetone and fine Stainless Steel wire brushing, the brush bristles should be .004”/.006” in diameter.
7. No LIGO weldments intended for use within the vacuum system shall be anodized.

13.2 Stainless Steel

1. First the parts or assemblies are de-burred, and cleaned, removing all possible machining and weld process residue. Use only clean Carbide burrs. Grinding (with abrasive wheels, cloth, or stones), or use of abrasive cloth or paper, is not permitted.
2. The part(s) are then cleaned and inspected for cleanliness using the water break test. The water-break test is performed by withdrawing the surface to be tested, in a vertical position, from a container overflowing with water, refer to ASTM A380-06 and in particular ASTM F22 for further information on this step.
3. Stainless steel parts are to be pickled and passivated at room temperature, with special attention paid to sufficiently agitate the solution or flush the inside of the box section used in the particular design. The pickling and passivation process formulation, time and temperature should be chosen to achieve slight chemical etching (<0.0005 inch).
4. The weldment is then thoroughly rinsed with clean water. After rinsing, a full visual inspection is performed, to assure a satisfactory surface finish has been achieved uniformly, over the entire weldment
5. The parts are then dried, re-inspected and if appropriate un-racked.

14 Delivery and receipt

After post-weld cleaning (section 13) re-inspect all welds. Refer to RFQ / RFP / SOW for information on acceptance and deliver criteria.

15 Subsequent Processing Steps

Any subsequent processing steps are not performed by the manufacturing/welding contractor, but listed here for completeness.

15.1 Ultra-High Vacuum (UHV) Cleaning & Baking

LIGO will inspect, clean and bake in preparation for Ultra-High Vacuum (UHV) service in accordance with E960022.



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16 References

- | | |
|------------------------|-------------------------------------------------------------------------------------------------------------|
| 1. Mil-Std-2219 | Fusion Welding for Aerospace Applications |
| 2. AWS D1.2/D1.2M:2003 | Structural Welding Code - Aluminum |
| 3. AWS D1.1/D1.1M:2008 | Structural Welding Code - Steel |
| 4. ASTM E-165 | Standard Test Method for Liquid Penetrant Examination |
| 5. ASTM B-912 | Standard Specification for Passivation of Stainless Steels Using Electropolishing |
| 6. LIGO-E960022-v2 | LIGO Vacuum Compatibility, Cleaning Methods and Qualification Procedures |
| 7. ASTM A380 - 06 | Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems |
| 8. ASTM F22 | Test Method for Hydrophobic Surface Films by the Water-Break Test |

17 Supply Sources

Item	Description	Supplier
Ameristat®	Clean room sheeting Class 100 stratogrey, single wound, rollstock	Bay Stat 3575 Haven Avenue Menlo Park, CA 94025-1009 (650)364-3205 Voice (650)363-8079 Fax
UHV Aluminum Foil	Part # ASTM B 479 0.015" x 24" x 500' and 0.015" x 48" x 500' UHV Certified Aluminum Foil	All Foil 4597 Van Epps Road Brooklyn Heights, Ohio 44131 (216)661-0211 Voice (216)398-4161 Fax

D1002309

Manifold-Cryo Baffle Weldment Assembly - parts and quantities:

	<u>Part Number</u>	<u>Description</u>	<u>Rev</u>	<u>Qty</u>
1	D0902619	INNER SEGMENT, RIGHT	v1	1
2	D0902620	RADIAL SEGMENT, BOTTOM	v1	1
3	D0902621	BAFFLE BRACKET	v1	6
4	D0902622	INNER SEGMENT, LEFT	v1	1
5	D0902623	INNER SEGMENT, BOTTOM	v1	1
6	D0902657	HALF FACE PLATE	v1	2
7	D1000536	BRACE BRACKET	v1	4
8	D1000558	RADIAL SEGMENT, LEFT	v1	1
9	D1000559	RADIAL SEGMENT, RIGHT	v1	1
10	D1000570	CYLINDER	v1	1
11	D1000572	BRACE	v1	2 (To be provided by LIGO)
12	D1001018	SCRAPER BLADE	v1	1
13	D1001073	RADIAL ATTACHMENT	v1	3

Manifold-Cryo Baffle Weldment Assy- subassemblies and quantities:

(BOM for subassemblies listed on drawings)

	<u>Part Number</u>	<u>Description</u>	<u>Rev</u>	<u>Qty</u>
1	D0902654	WELDMENT SUBASSY, RIGHT	v1	1
2	D0902655	WELDMENT SUBASSY, BOTTOM	v1	1
3	D0902656	WELDMENT SUBASSY, LEFT	v1	1
4	D1001348	CYLINDER SCRAPER ASSY	v1	1

Manifold-Cryo Baffle Weldment - Drawing Tree

D1002061 WELDMENT ASSY(1) [BOM#E1000359](#)

D0902654 WELDMENT SUBASSY, RIGHT (1) [BOM#E1000091](#)

D0902619 INNER SEGMENT, RIGHT (1)

D1000559 RADIAL SEGMENT, RIGHT (1)

D0902621 BAFFLE BRACKET (2)

D1000536 BRACE BRACKET(1)

D1001073 RADIAL ATTACHMENT (1)

D0902655 WELDMENT SUBASSY, BOTTOM (1) [BOM#E1000085](#)

D0902623 INNER SEGMENT, BOTTOM (1)

D0902620 RADIAL SEGMENT, BOTTOM (1)

D0902621 BAFFLE BRACKET (2)

D1001073 RADIAL ATTACHMENT (1)

D0902656 WELDMENT SUBASSY, LEFT (1) [BOM#E1000090](#)

D0902622 INNER SEGMENT, LEFT (1)

D1000558 RADIAL SEGMENT, LEFT (1)

D0902621 BAFFLE BRACKET (2)

D1000536 BRACE BRACKET (1)

D1001073 RADIAL ATTACHMENT (1)

~~D1000572 BRACE (2) (To be provided by LIGO)~~

D1001348 CYLINDER SCRAPER ASSY (1) [BOM#E1000367](#)

D1000570 CYLINDER (1)

D1001018 SCRAPER BLADE (1)

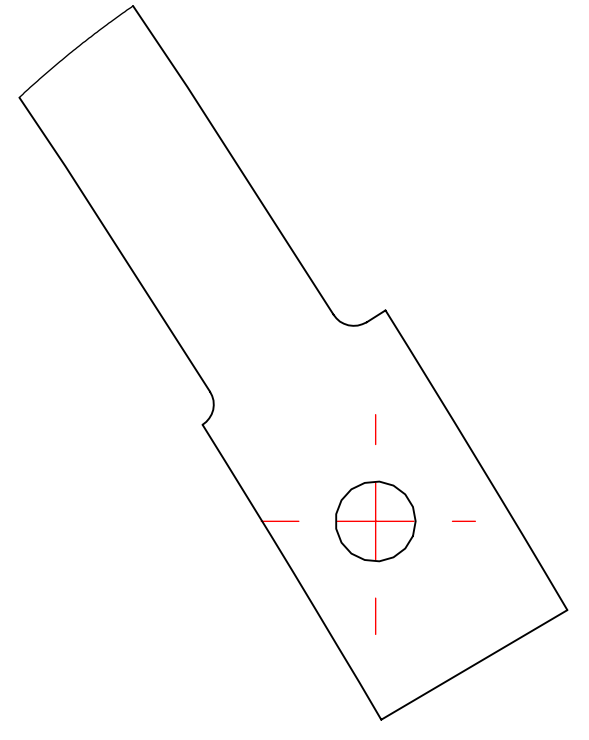
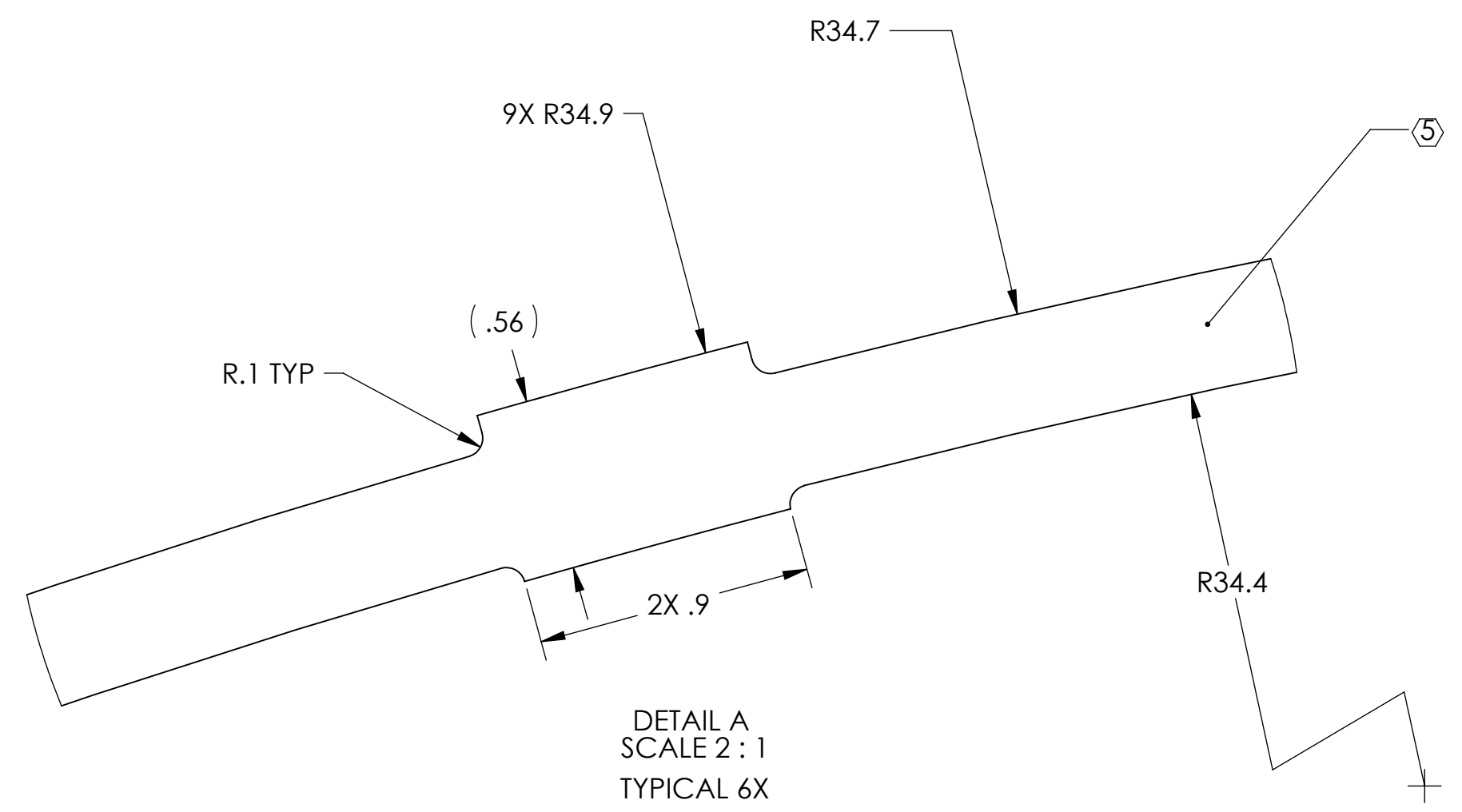
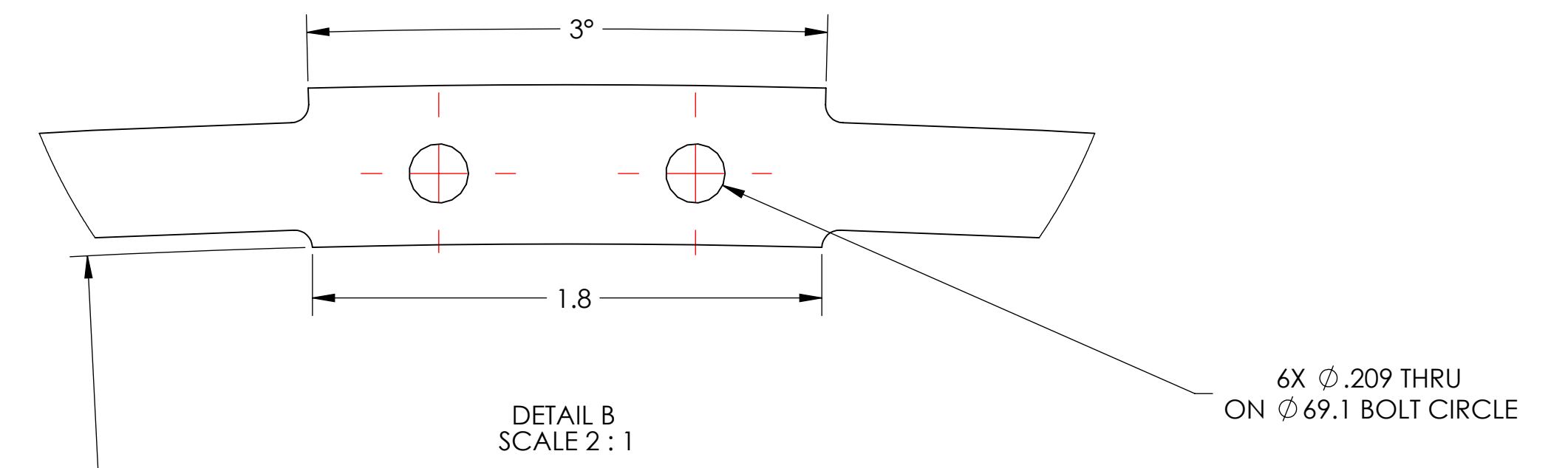
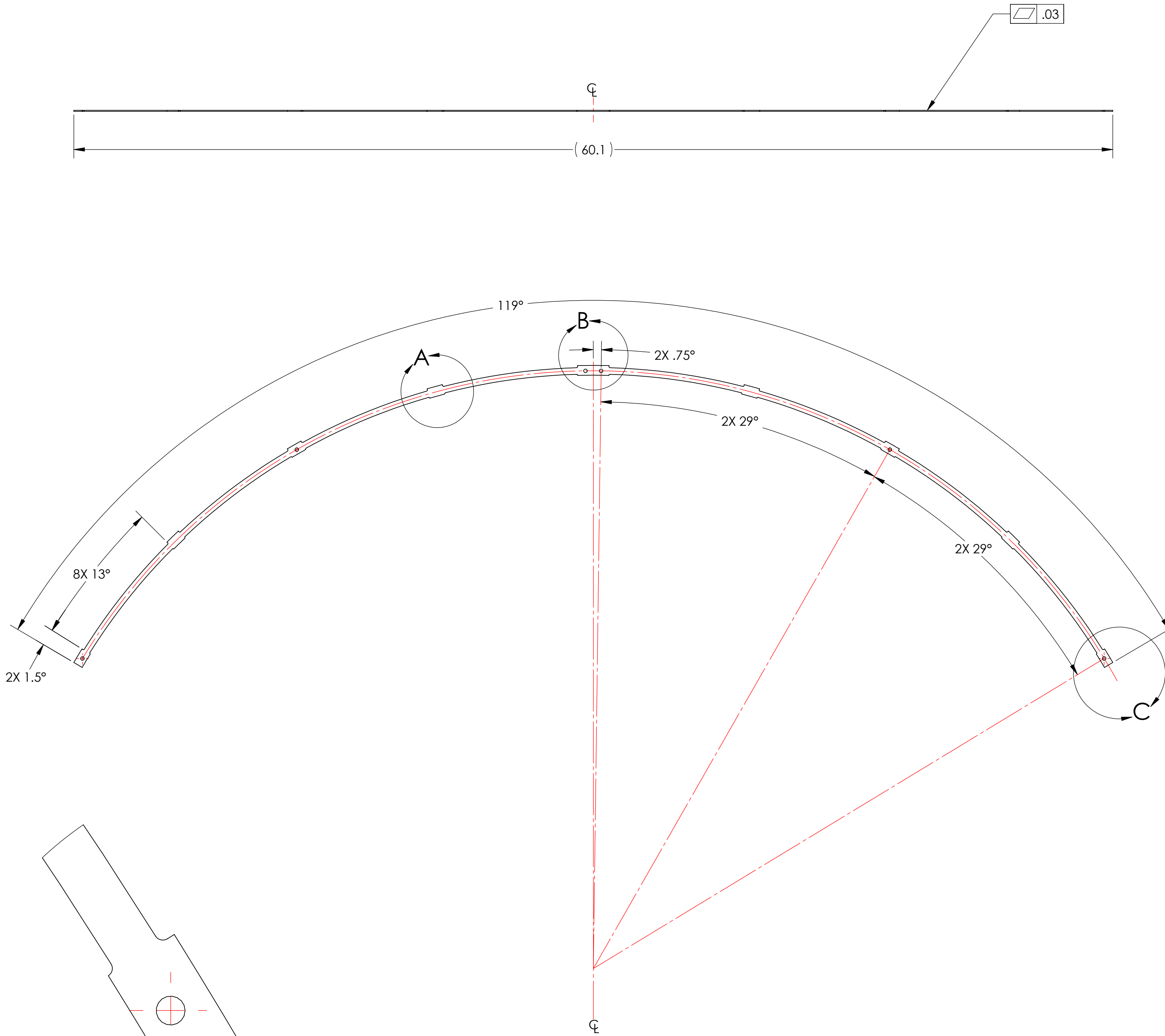
D1000536 BRACE BRACKET (2)

D0902657 HALF FACE PLATE (2)

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

⑥ AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000085
-	-	-	E1000090
-	-	-	E1000091



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES:		1. INTERPRET DRAWING PER ASME Y14.5-1994.	
.X	± .1	2. REMOVE ALL SHARP EDGES, R.02 MIN.	
.XX	± .06	3. DO NOT SCALE FROM DRAWING.	
.XXX	± .010	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
ANGULAR ± 1.0°		MATERIAL	FINISH
		14GA A424 TYPE I STEEL	⑥

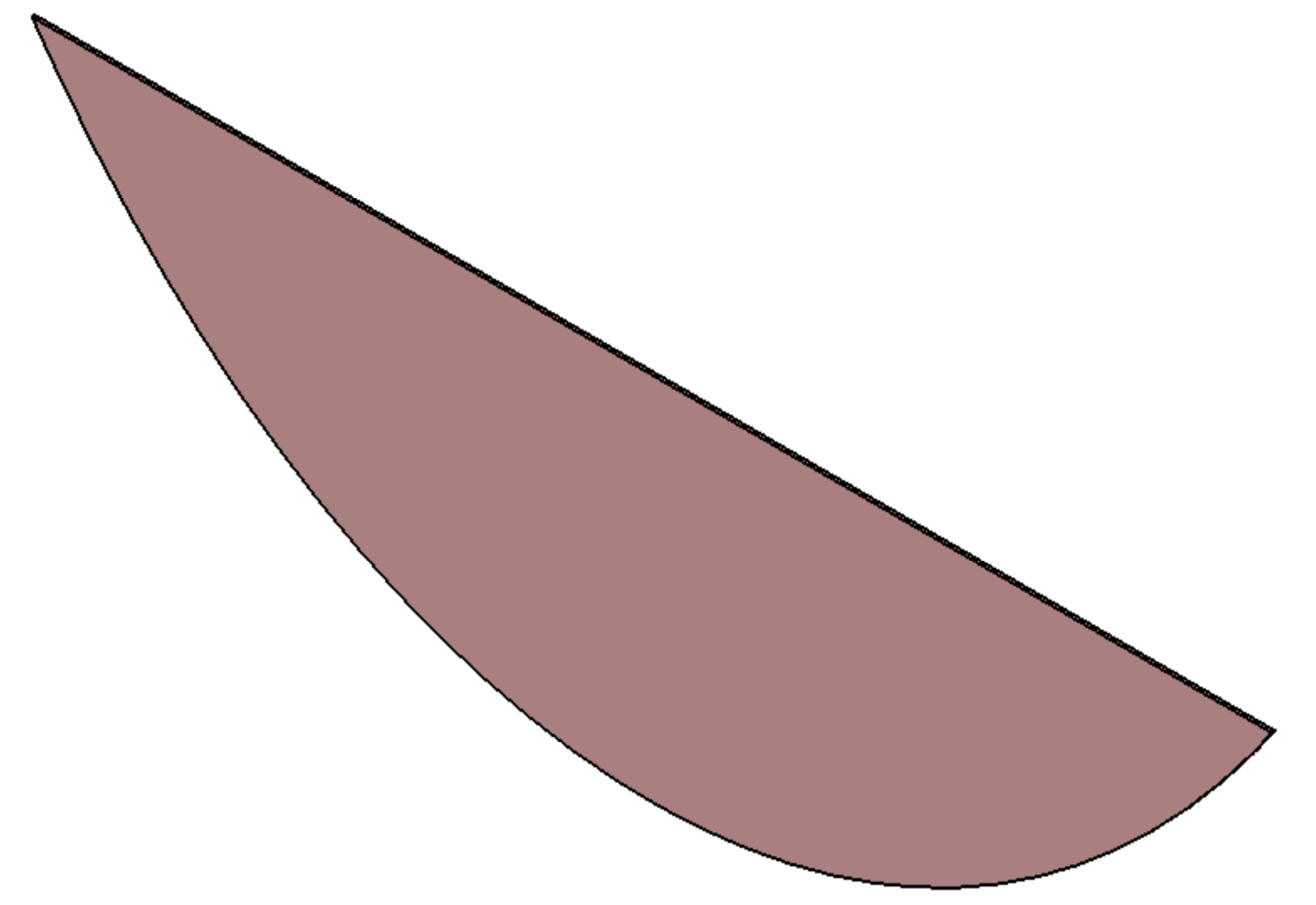
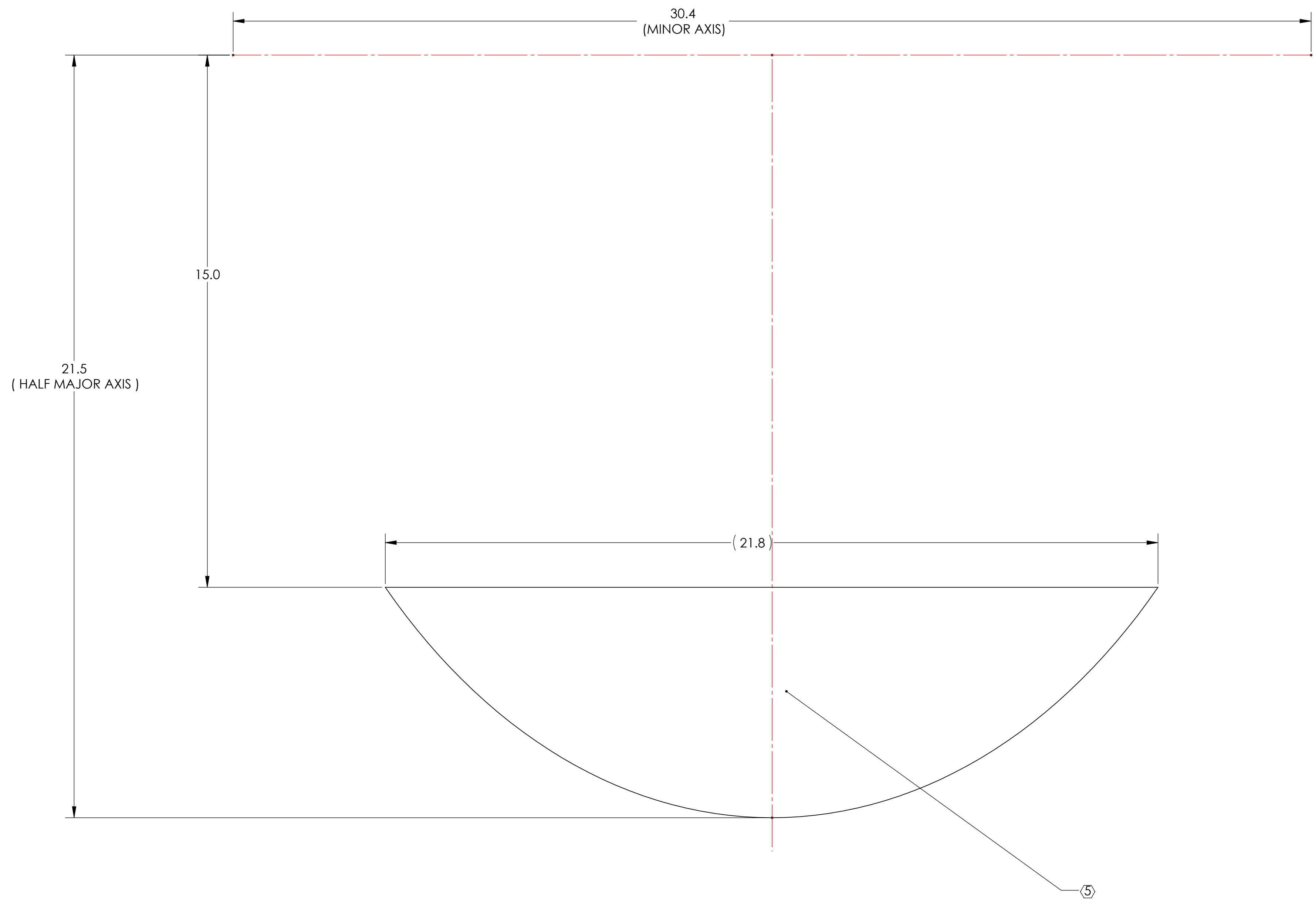
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME RADIAL ATTACHMENT NUT PLATE	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER H. KELMAN	DATE 6 APRIL 2010
NEXT ASSY D0902655, D0902654, D0902656	FINISH ⑥	CHECKER M. SMITH	SIZE D
		APPROVAL D. COYNE	DWG. NO. D1001073
		SCALE: 1:4	PROJECTION:
		SHEET 1 OF 1	

D1001073.dwg, Weld, Nut, Plate, PART FDM REV: X01.3, DRAWING FDM REV: X-006

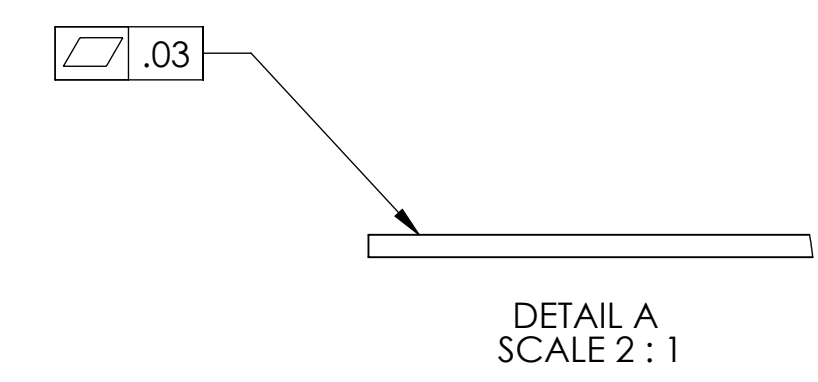
NOTES CONTINUED:
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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

(6) AS RECEIVED MACHINE FINISH

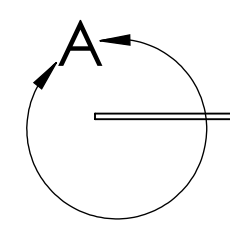
REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000367
-	-	-	-
-	-	-	-



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



DETAIL A SCALE 2 : 1



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D1001348 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
TOLERANCES: .X ±.1 .XX ±.06 .XXX ±.010		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		ELLIPSE SCRAPER BLADE	
ANGULAR ± 1.0°		MATERIAL 14GA A424 TYPE I STEEL		FINISH (6)		NEXT ASSY D1001348		DESIGNER H. KELMAN	
						SIZE D		DWG. NO. D1001018	
						CHECKER M. SMITH		REV. v1	
						APPROVAL D. COYNE		SCALE: 1:2	
						PROJECTION:		SHEET 1 OF 1	

D:\001018_d1001018_Monitichl_Cryo_Baffle_Scraper_Blade_PART.PDM REV.X-004.DRAWING.PDM REV.X-008

8 7 6 5 4 3 2 1

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: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	-
-	-	-	-
-	-	-	-

D

D

C

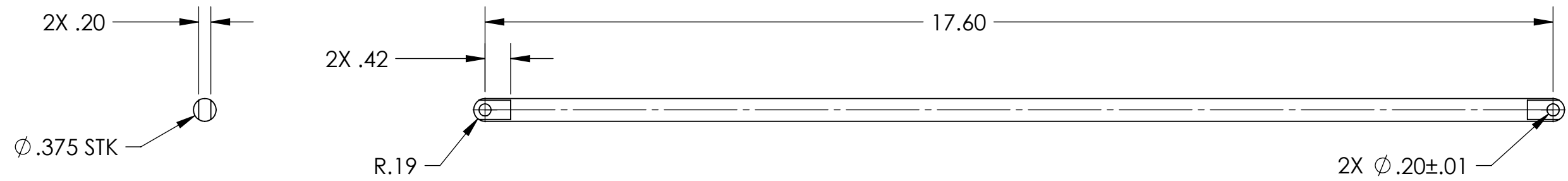
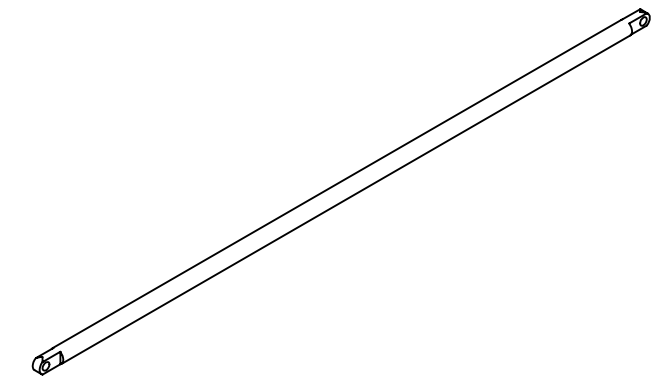
C

B

B

A

A



D1000572_Manifold_Cryo_Baffle_Square_Brace, PART PDM REV: X-004, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .010 ANGULAR ± 1.0°		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		PART NAME MANIFOLD-CRYO BAFFLE BRACE	
MATERIAL 304, 316 OR 302 SSSL		FINISH 32		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1001348		DESIGNER H. KELMAN 18 MAY 2010		SIZE DWG. NO. B D1000572		REV. v1	
		CHECKER APPROVAL		SCALE: 1:4 PROJECTION:		SHEET 1 OF 1	

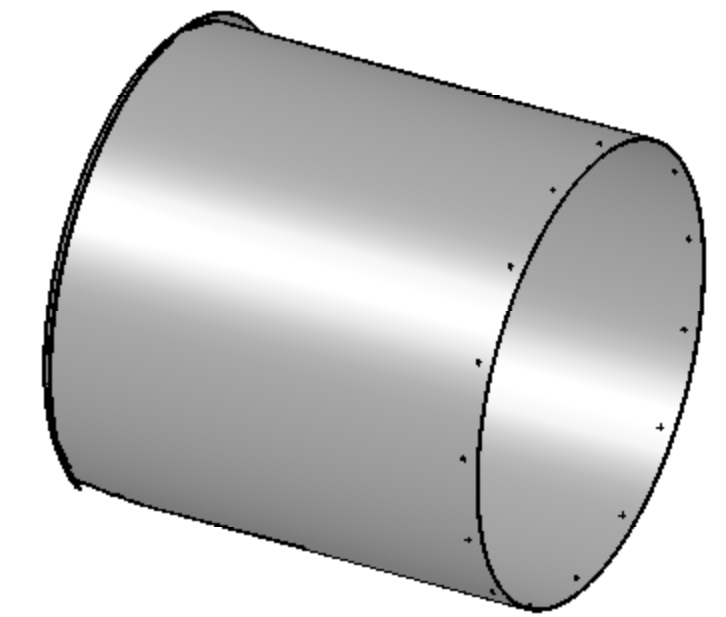
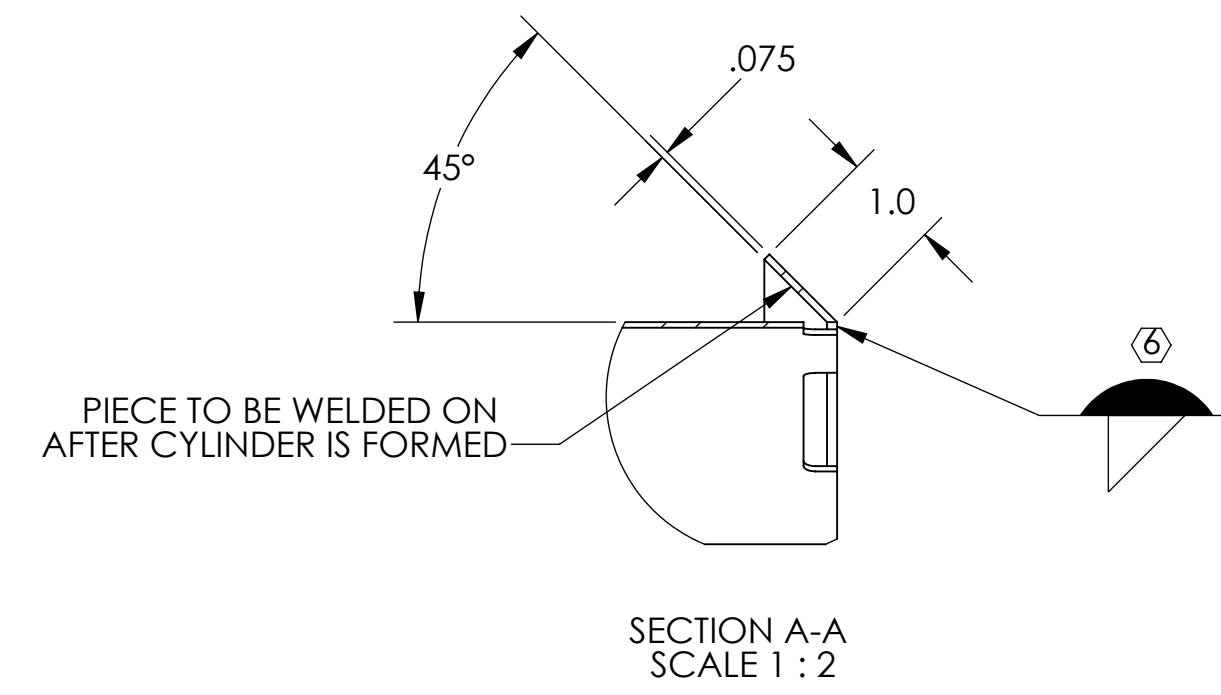
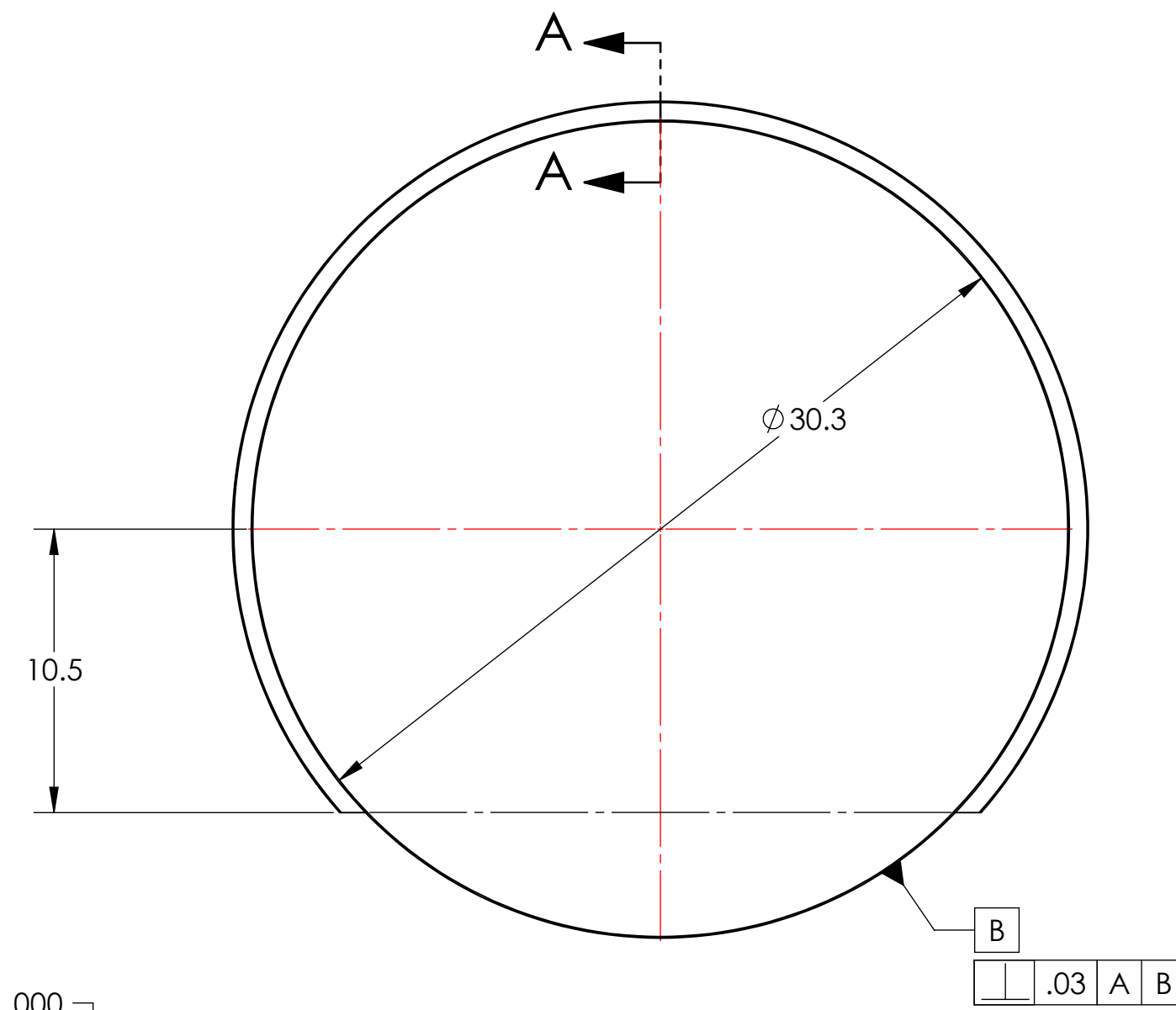
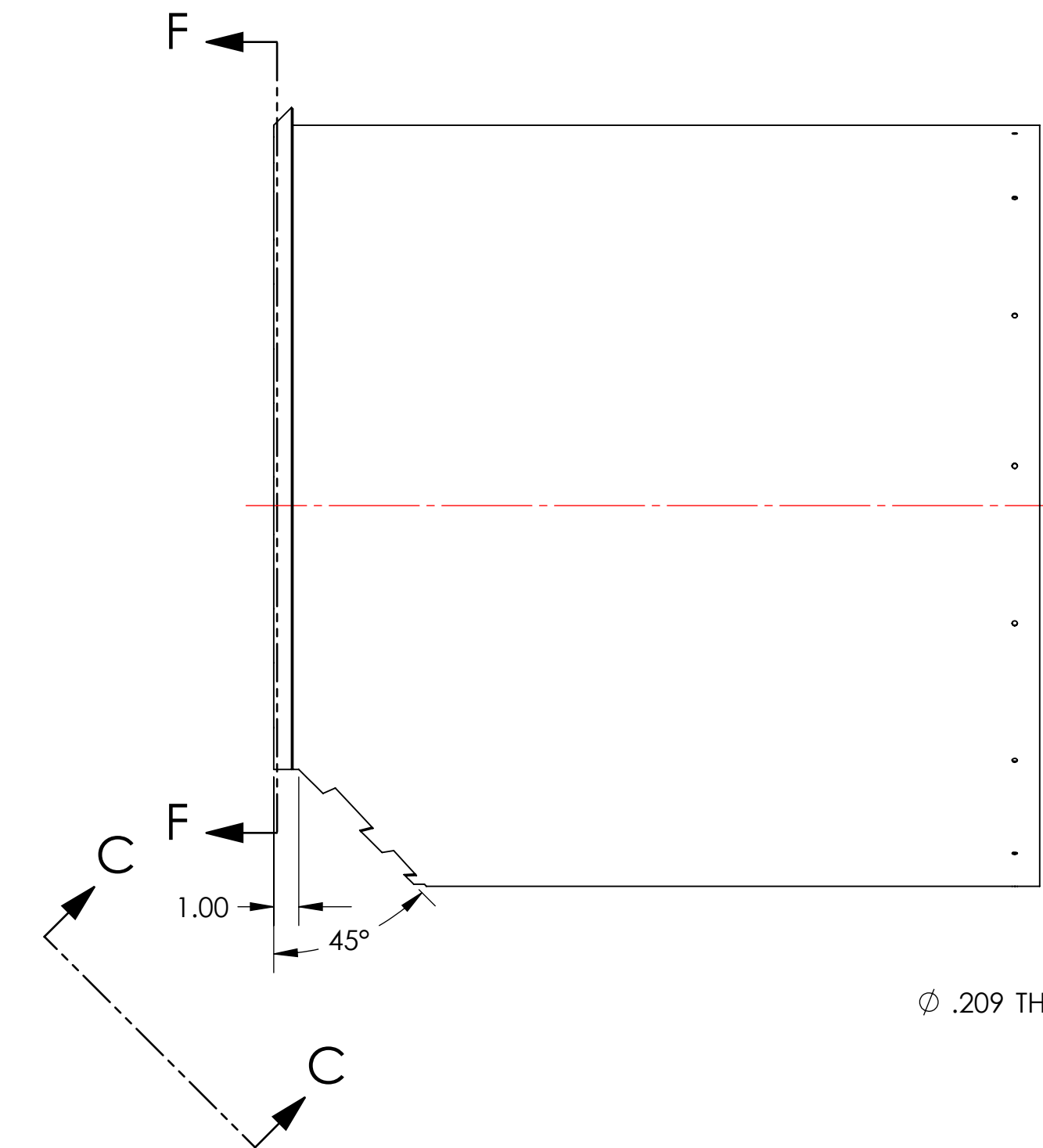
8 7 6 5 4 3 2 1

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

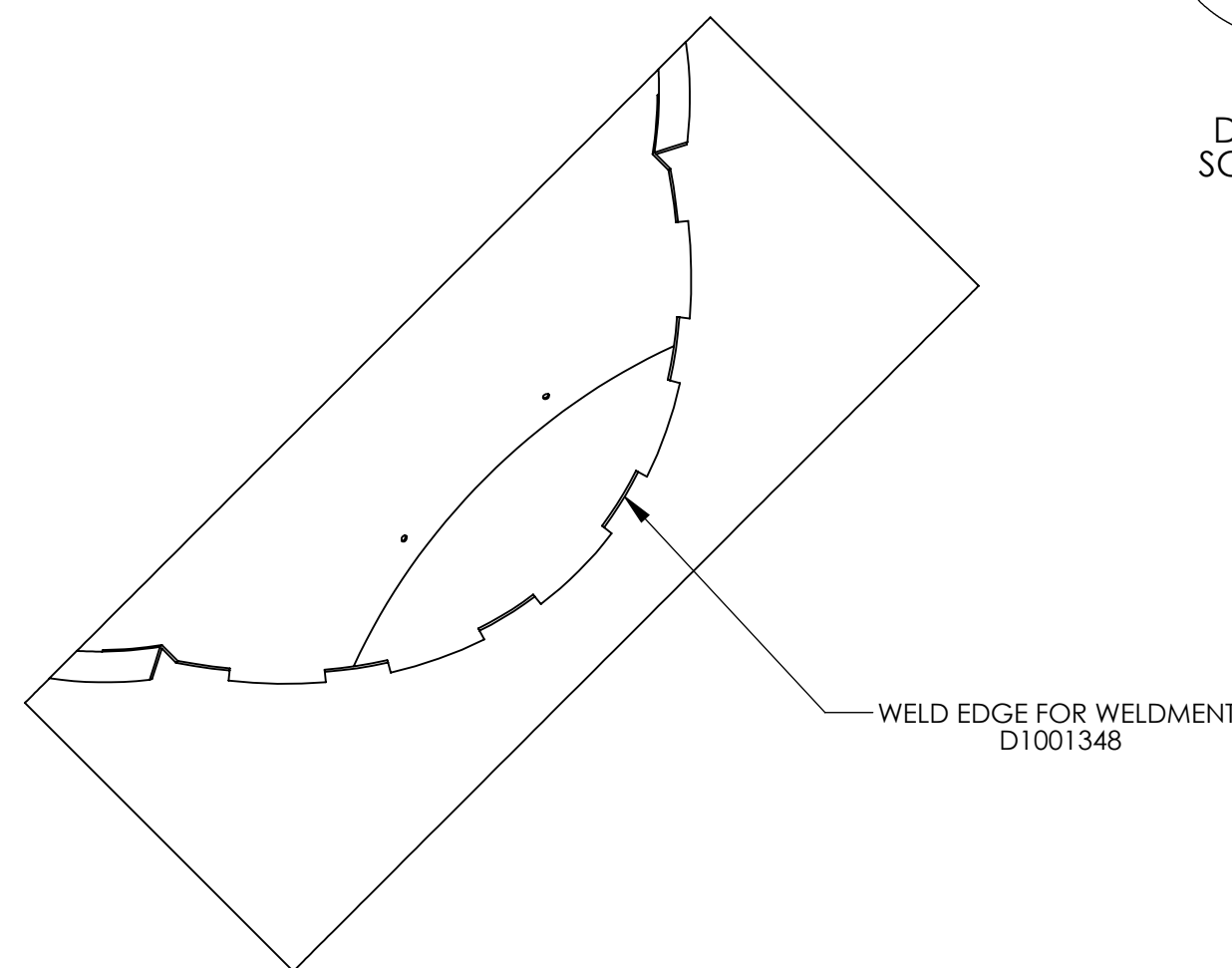
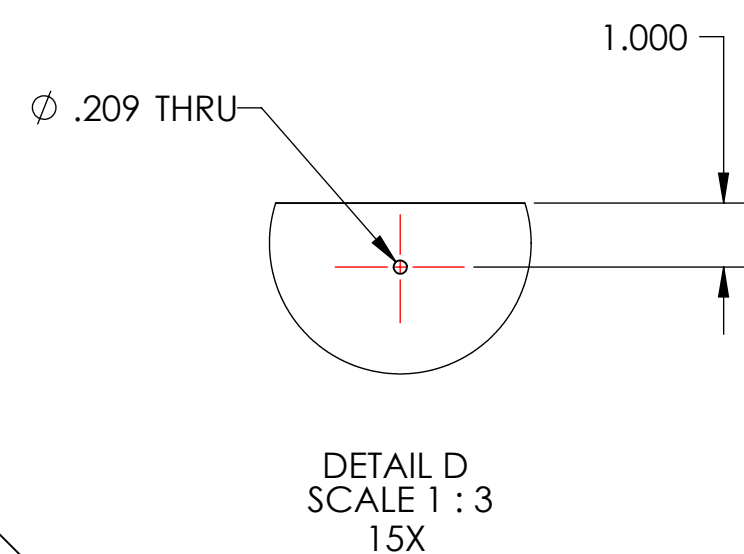
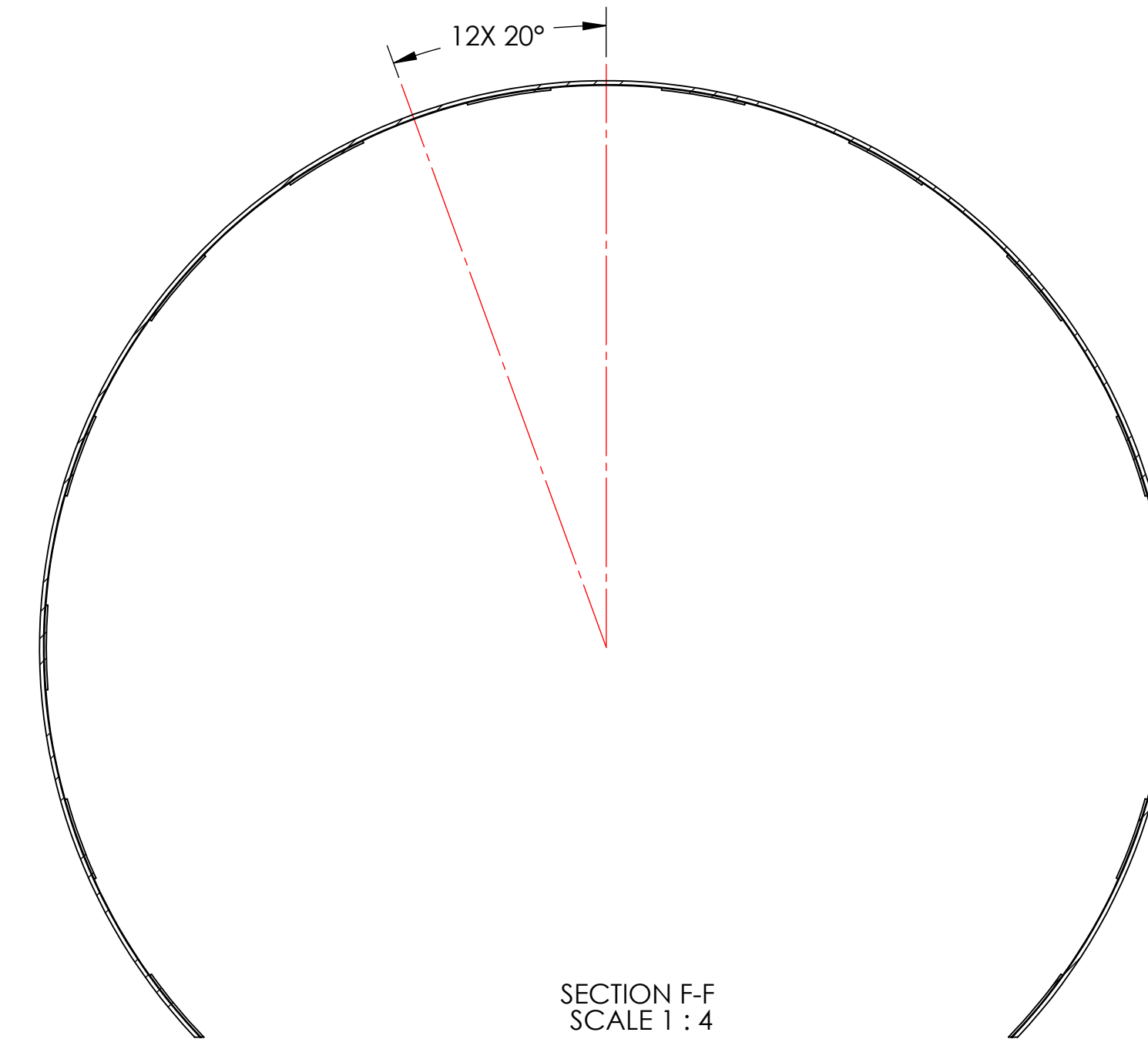
⑥ FILLET WELD WHERE RING AND CYLINDER MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

⑦ AS RECEIVED MACHINE FINISH

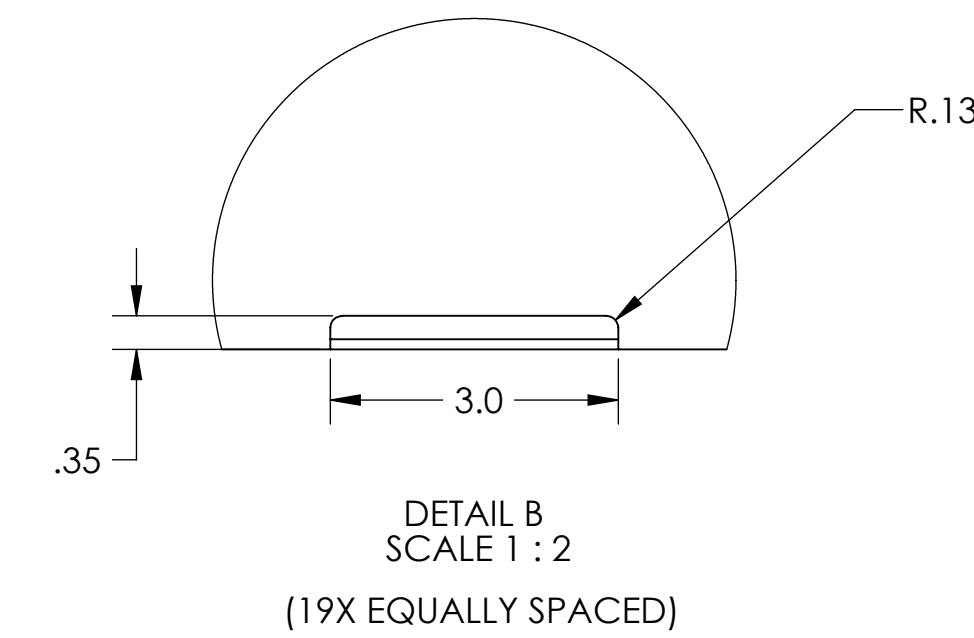
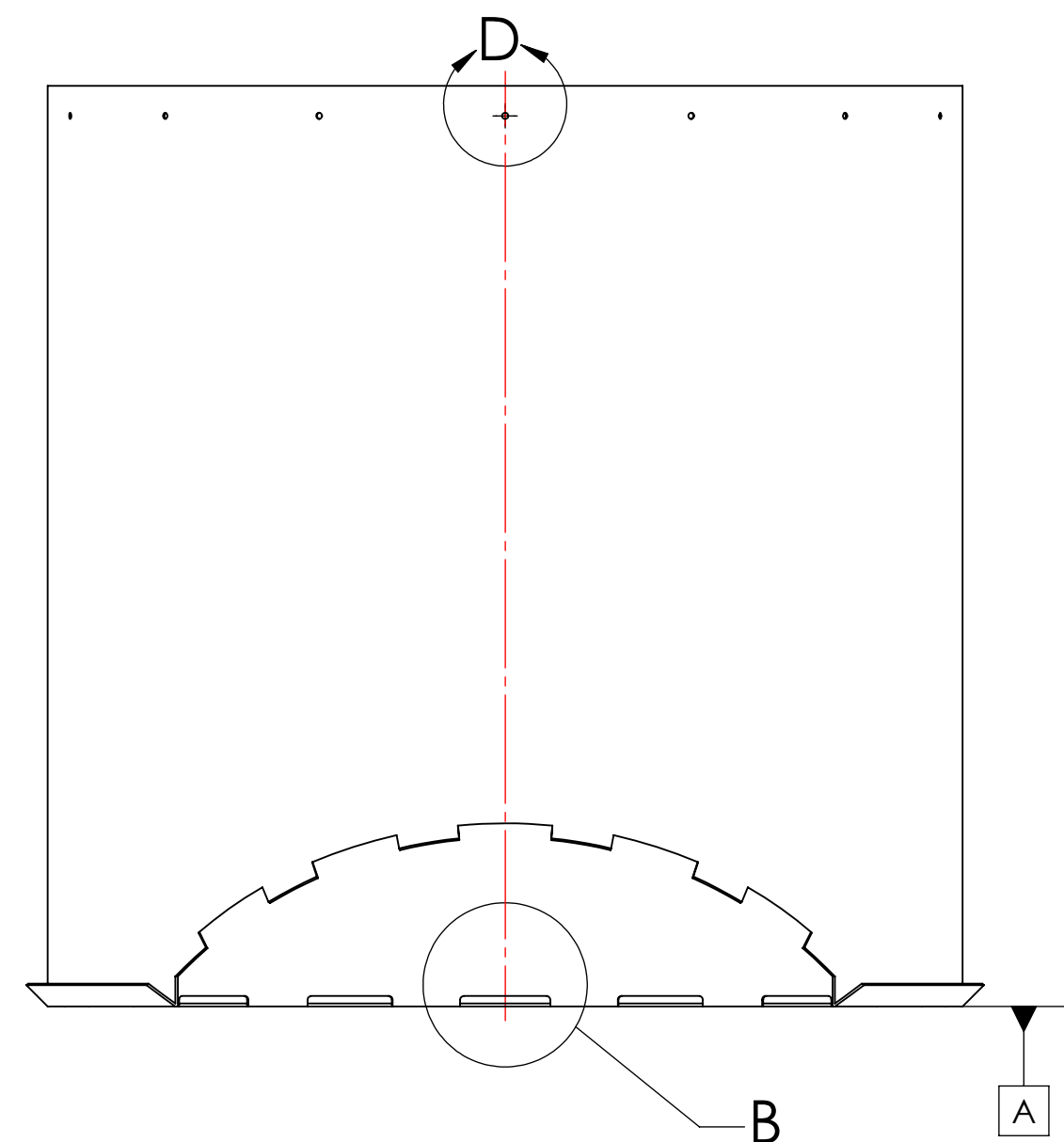
REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000367



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION C-C



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

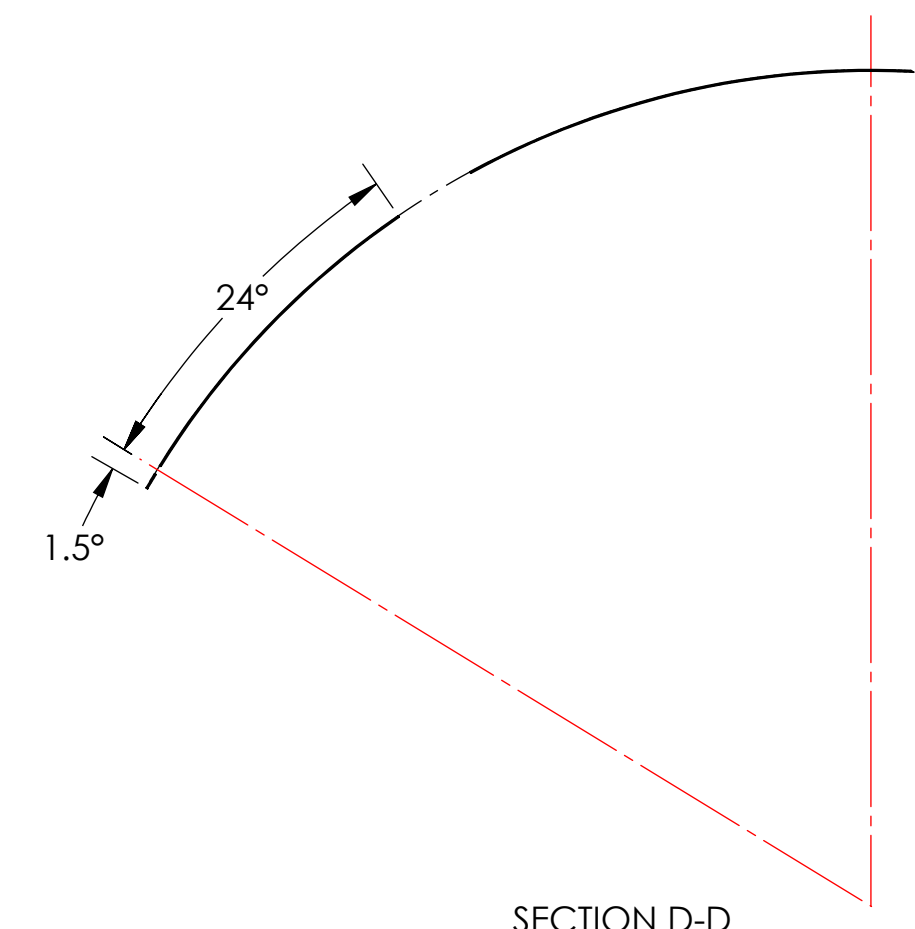
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		MANIFOLD-CRYO BAFFLE CYLINDER	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		FINISH ⑦		NEXT ASSY D1001348		DESIGNER H. KELMAN	
								5 APR 2010	
								SIZE D	
								DWG. NO. D1000570	
								REV. v1	
								CHECKER M. SMITH	
								APPROVAL D. COYNE	
								SCALE: 1:6	
								PROJECTION:	
								SHEET 1 OF 1	

D1000570.dwg - Manifold_Cryo_Baffle_Cylinder_Parts - PART FDM REV: X014 - DRAWING FDM REV: X005

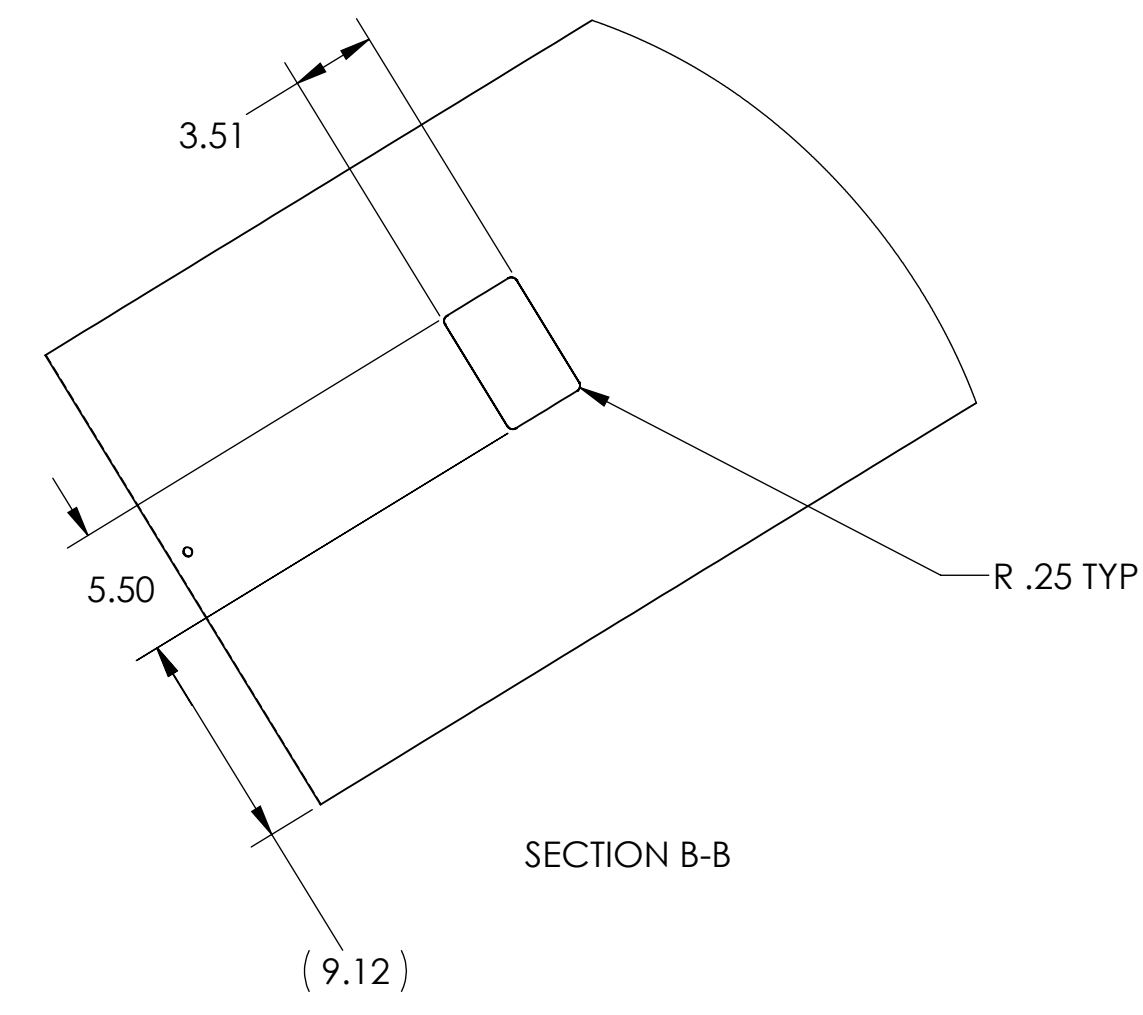
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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

⑥ MATERIAL AS RECEIVED MACHINE FINISH

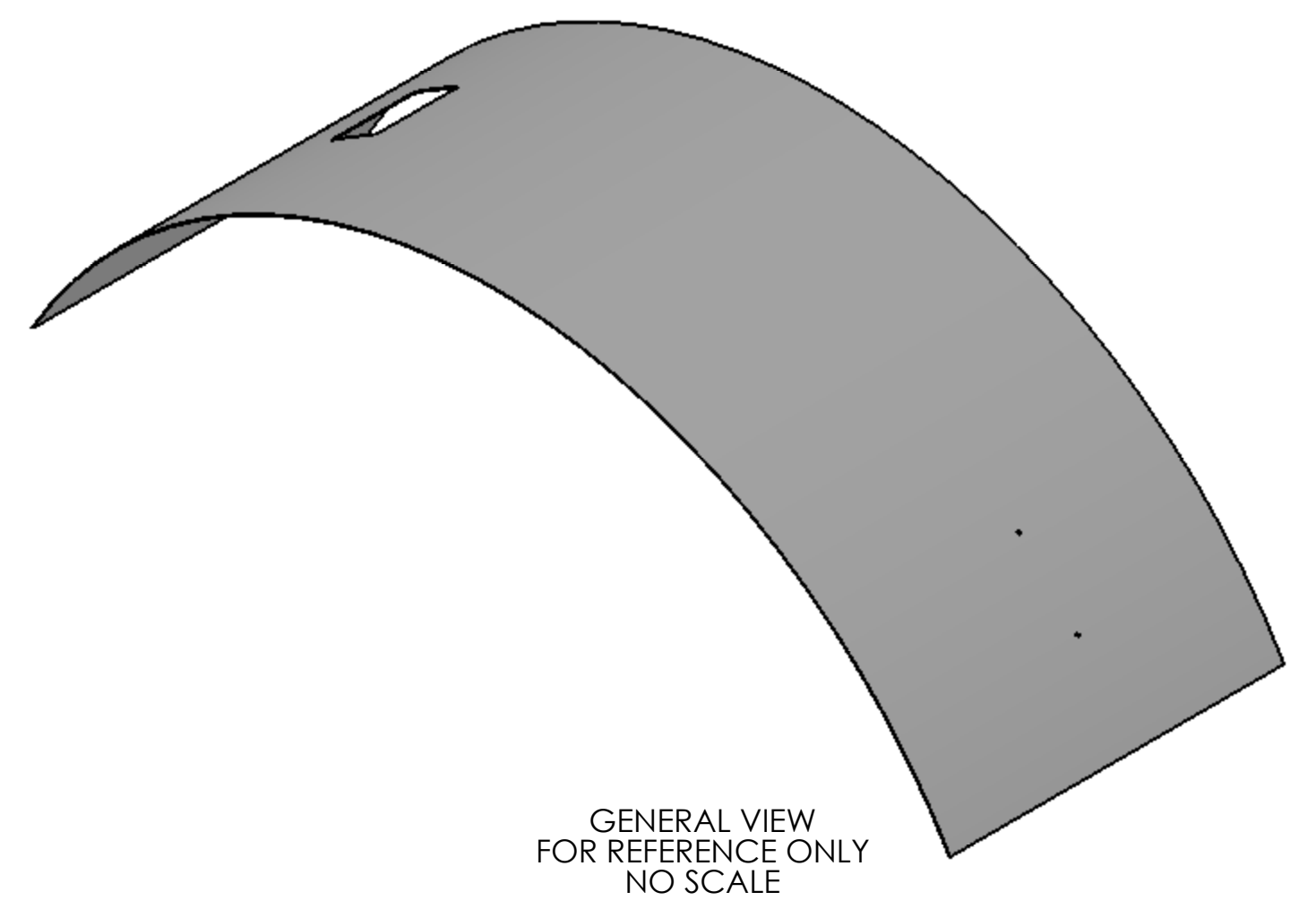
REV.	DATE	DCN #	DRAWING TREE #
v1	03 SEP 2010	E1000360	E1000091
-	-	-	-
-	-	-	-



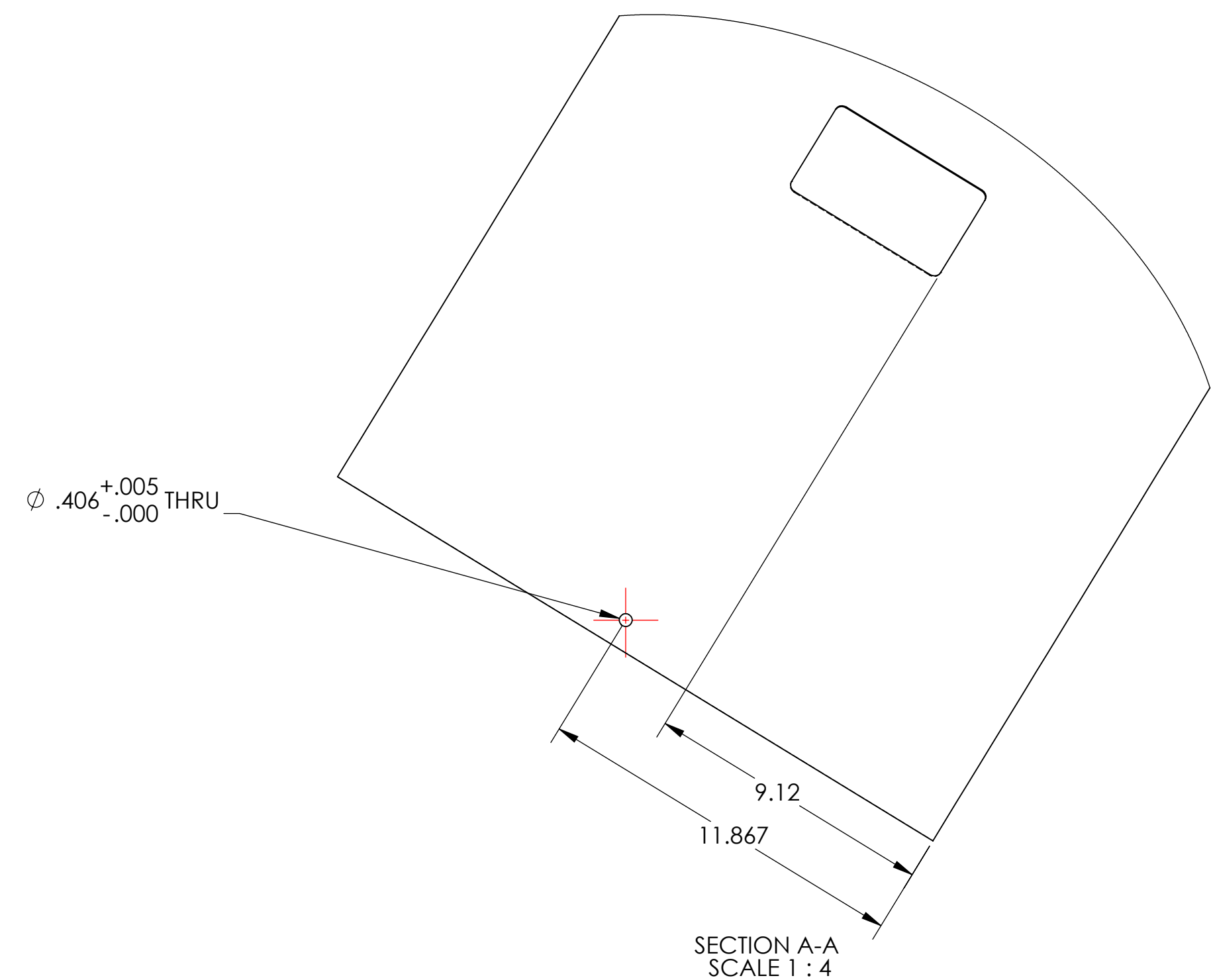
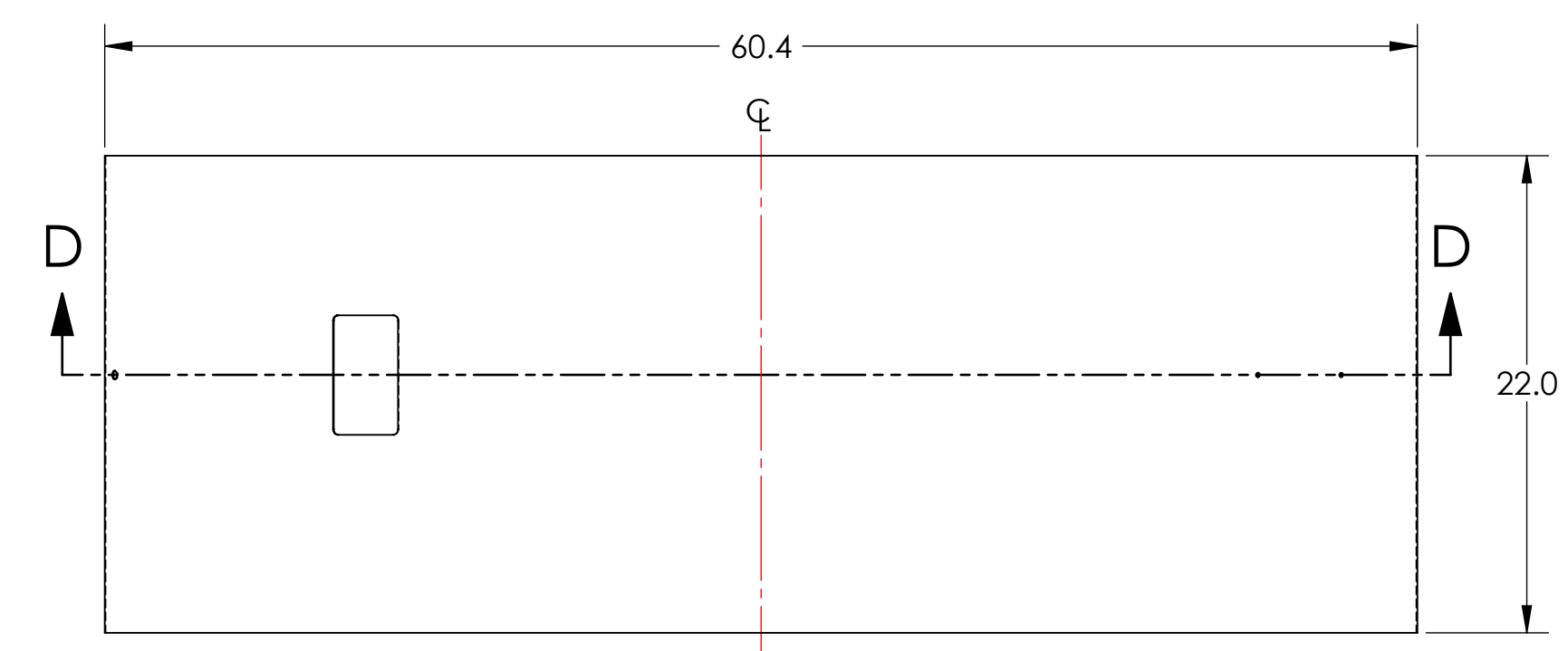
SECTION D-D



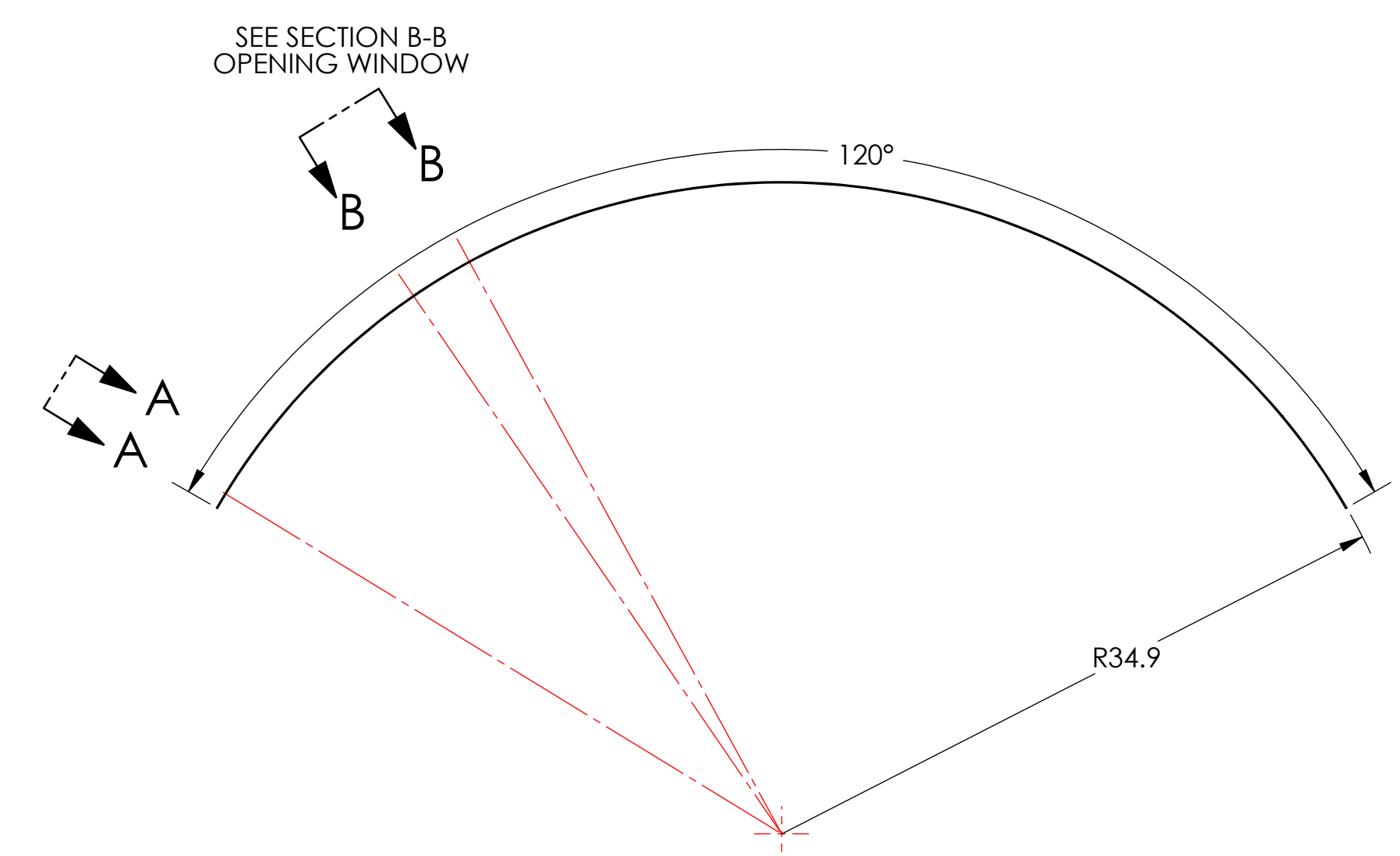
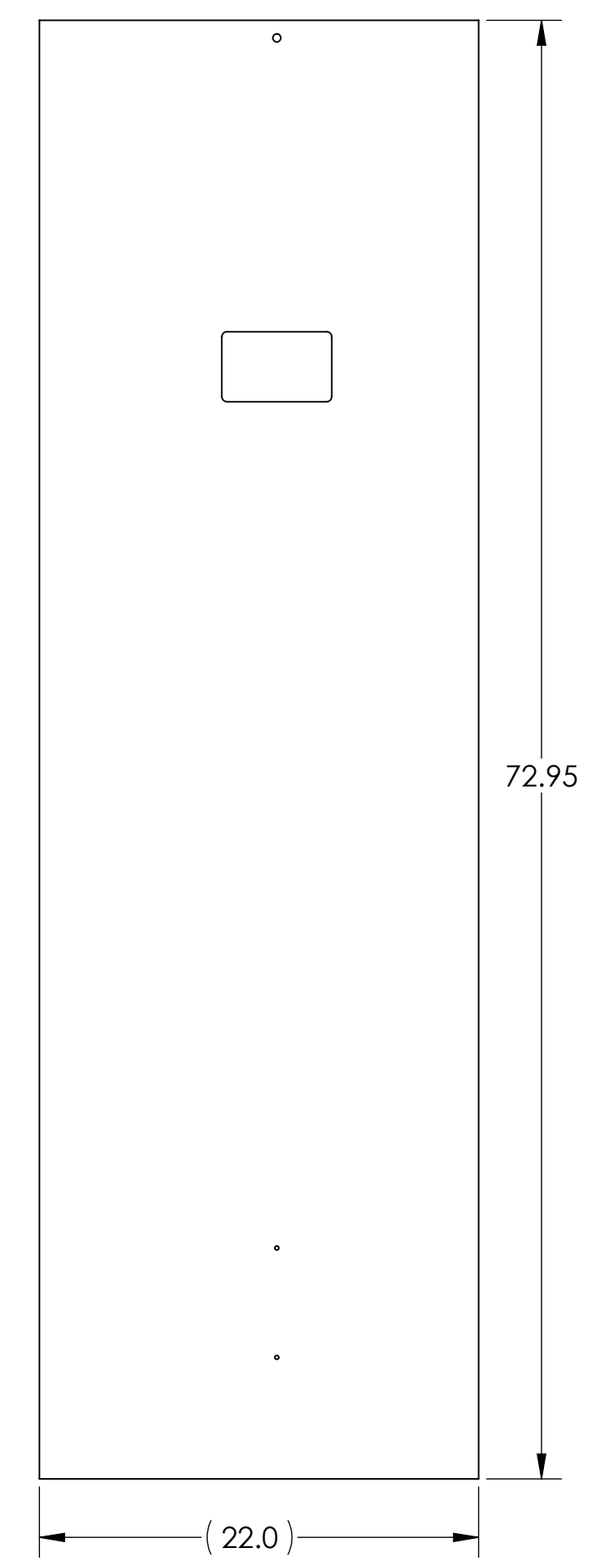
SECTION B-B



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION A-A SCALE 1:4



SEE SECTION B-B OPENING WINDOW

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

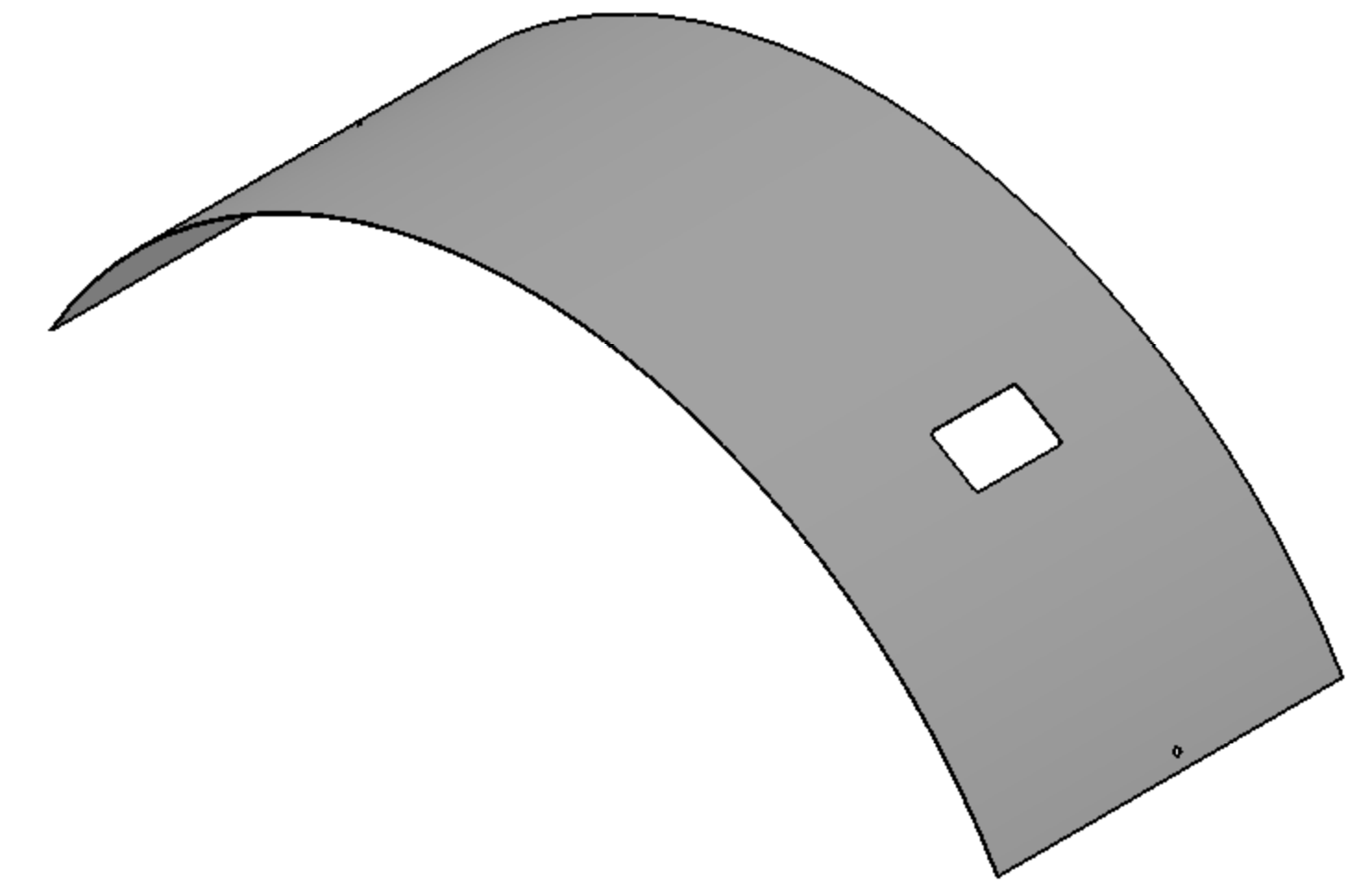
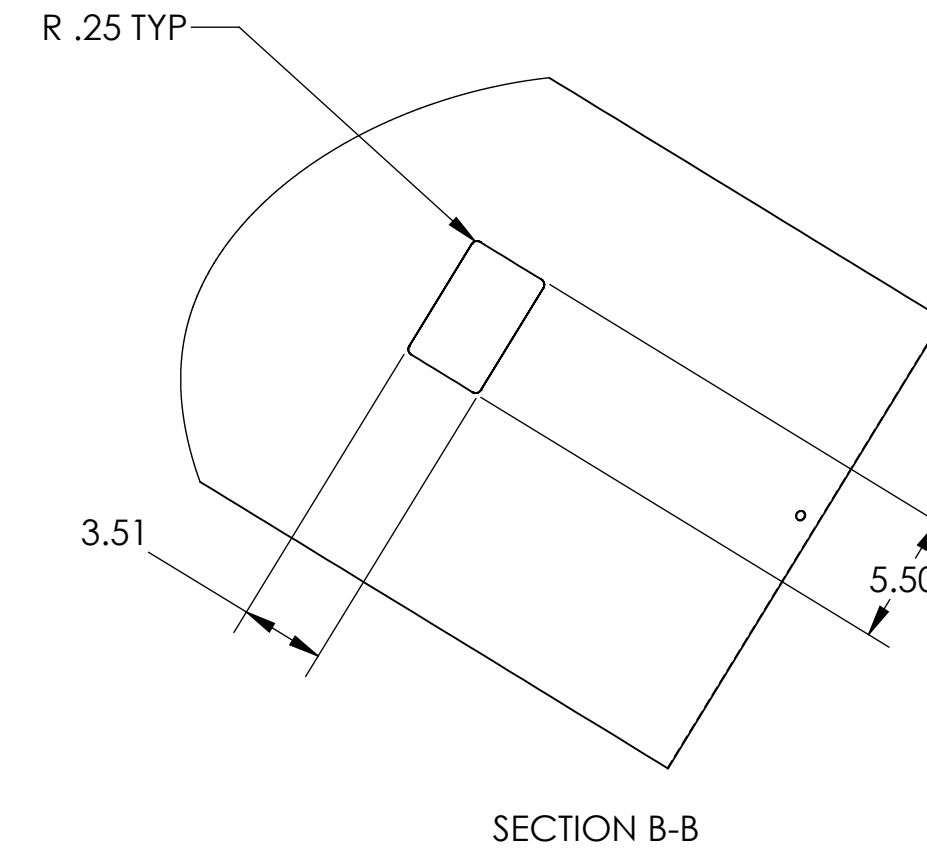
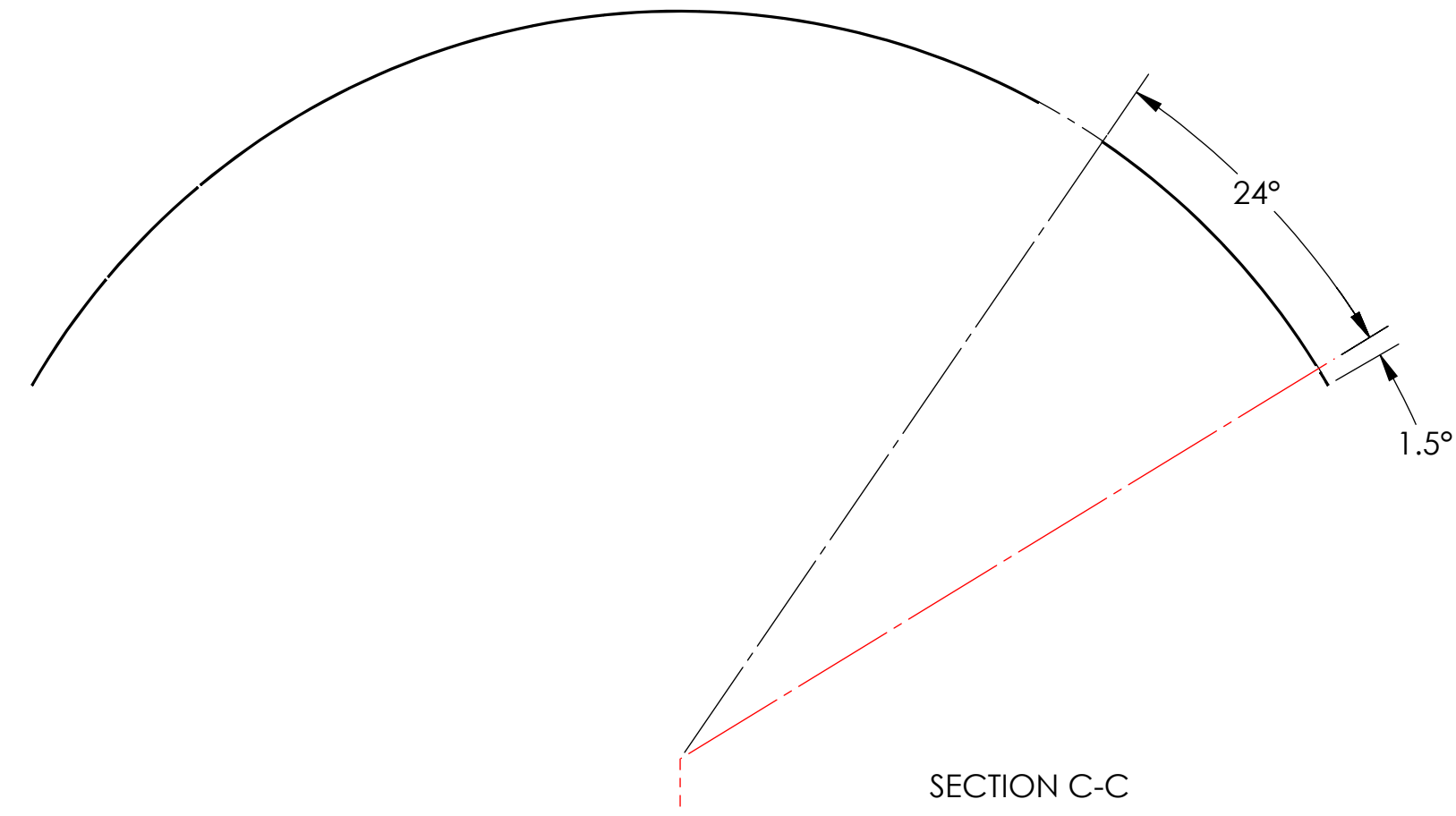
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		RADIAL SEGMENT, RIGHT	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		SYSTEM ADVANCED LIGO		DESIGNER H. KELMAN 17 MAR 2010	
		FINISH ⑥		NEXT ASSY D0902654		DRAFTER TQ. NGUYEN 16 AUG 2010	
						CHECKER M. SMITH	
						APPROVAL D. COYNE	
						SCALE: 1:8 PROJECTION:	
						DWG. NO. D1000559	
						REV. v1	
						SHEET 1 OF 1	

D:\000559.dwg - C:\CO_Mach\Radial_Segment_Right_Part_FDM_REV.X:081_DRAWING_FDM_REV.X:028

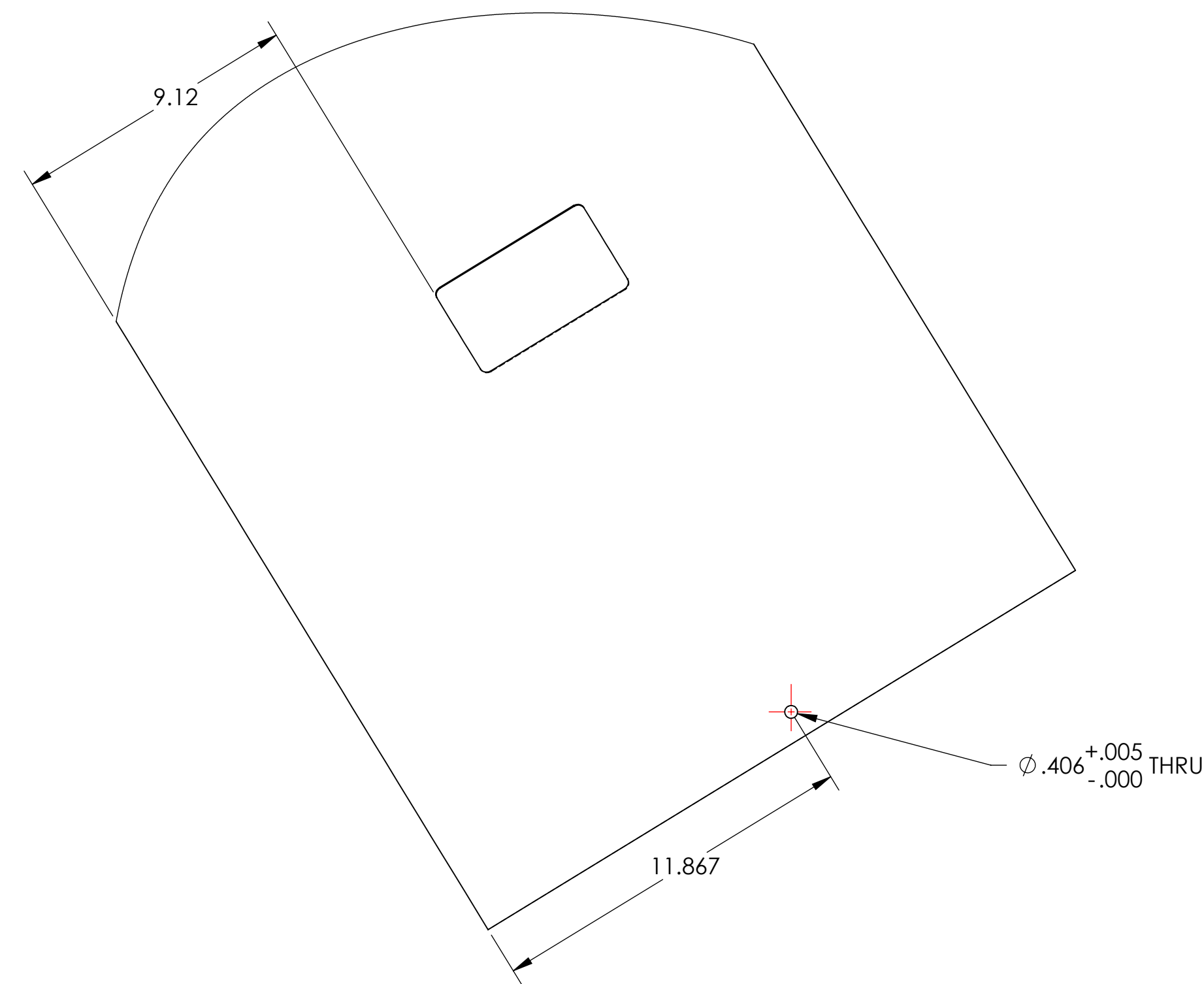
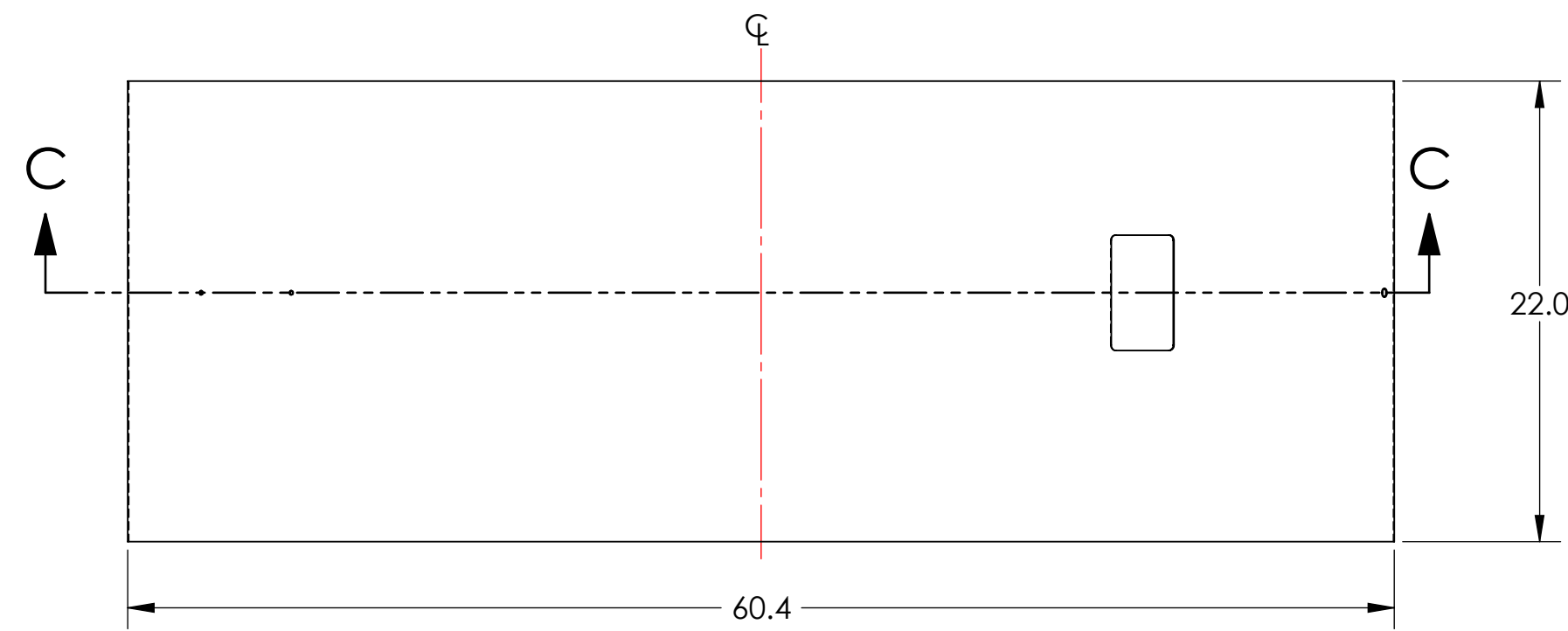
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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

⑥ MATERIAL AS RECEIVED MACHINE FINISH

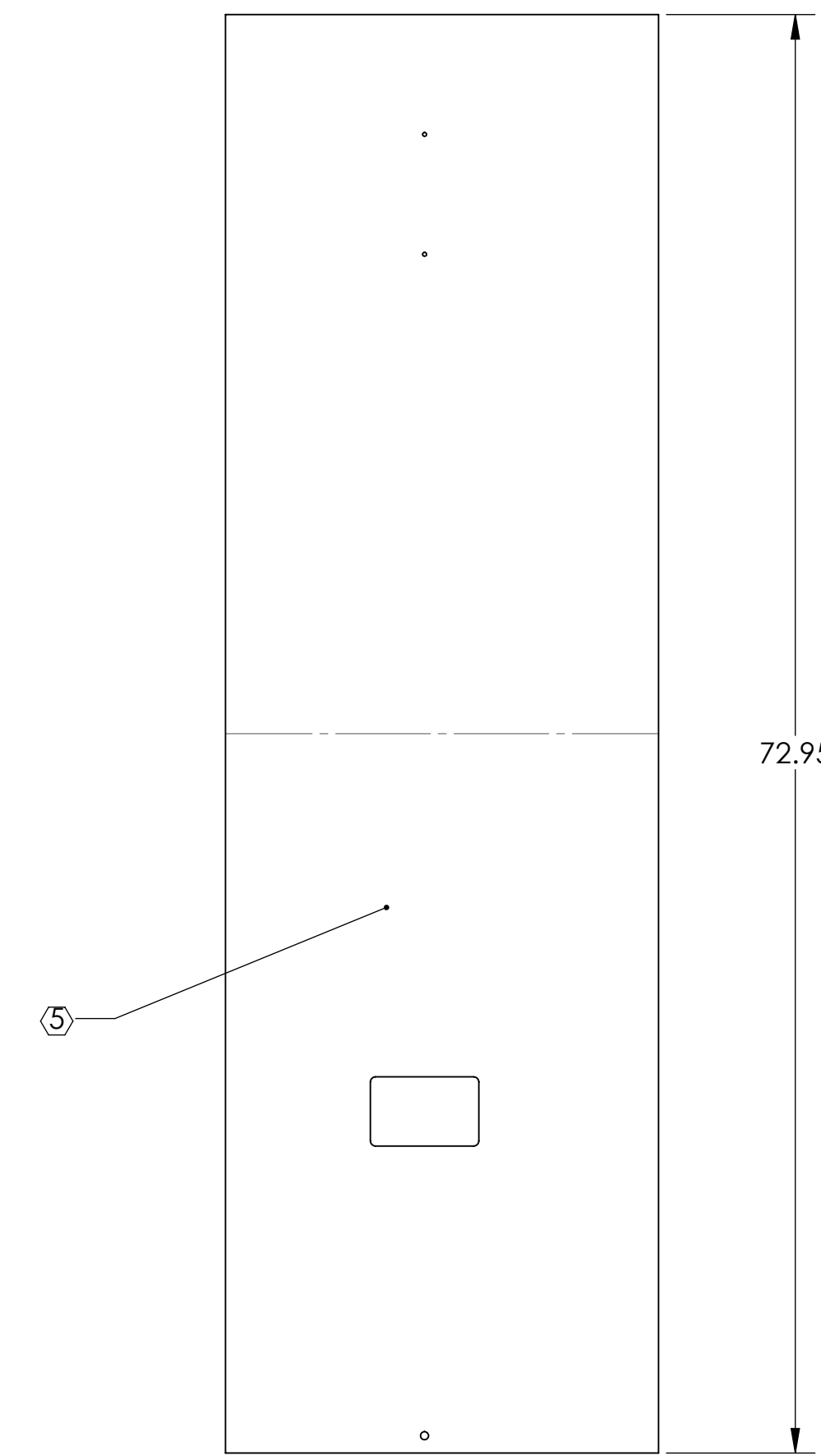
REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-



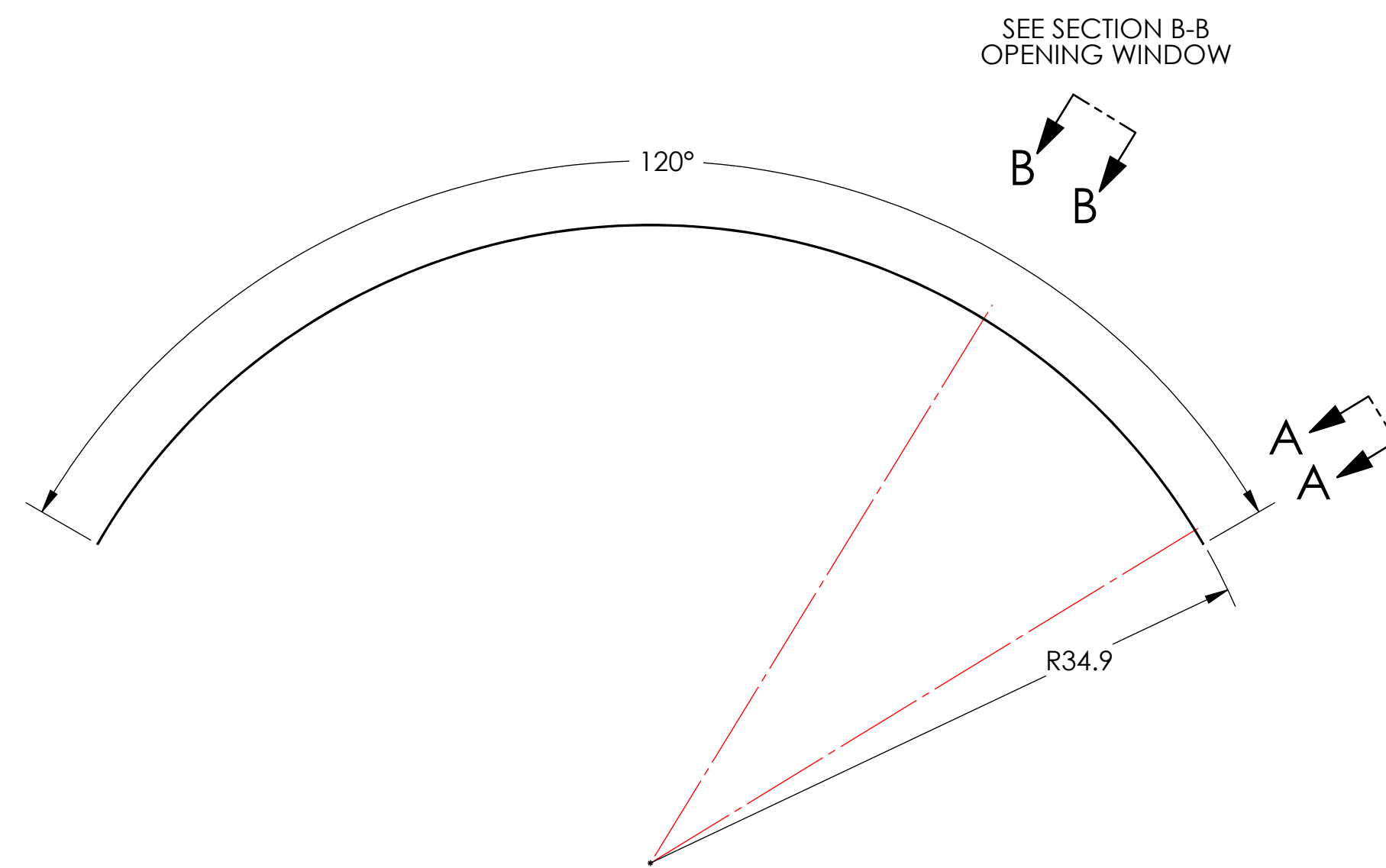
GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION A-A SCALE 1 : 4



FLAT PATTERN



SEE SECTION B-B OPENING WINDOW

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

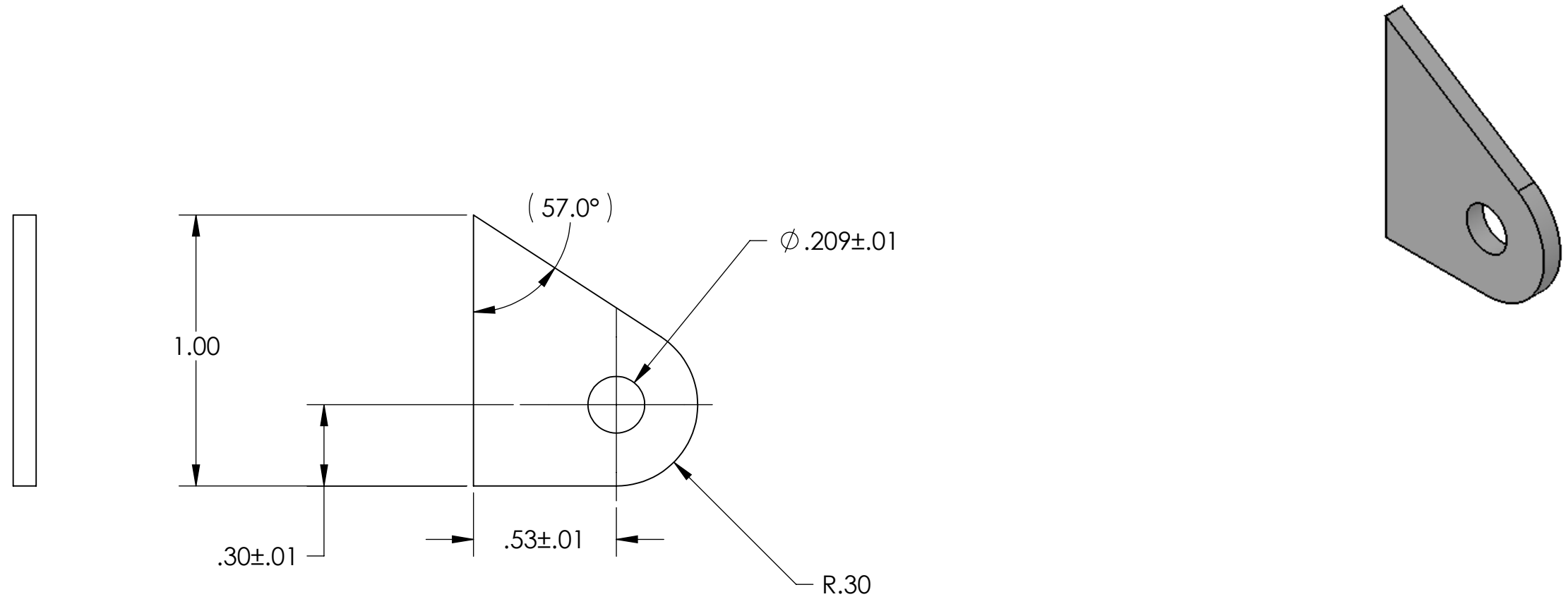
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		RADIAL SEGMENT, LEFT	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		ADVANCED LIGO		DESIGNER H. KELMAN 17 MAR 2010	
		FINISH ⑥		NEXT ASSY D0902656		DRAFTER TQ. NGUYEN 16 AUG 2010	
						CHECKER M. SMITH	
						APPROVAL D. COYNE	
						SCALE: 1:8 PROJECTION:	
						SIZE DWG. NO. D1000558 REV. v1	
						SHEET 1 OF 1	

D:\000558_d\UGO_Monitichl_Cryo_Baffle_Radial Segment_Left.PART.PDM.REV.X.081.DRAWING.PDM.REV.X.009

8 7 6 5 4 3 2 1

NOTES CONTINUED:
 ⑤ BAG AND TAG WITH DRAWING PART NUMBER AND REVISION FOLLOWED BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. EXAMPLE: DXXXXXX-VY, S/N 001.
 ⑥ AS RECEIVED MACHINED FINISH.

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000090-v1
-	-	-	E1000091-v1
-	-	-	E1000367-v1



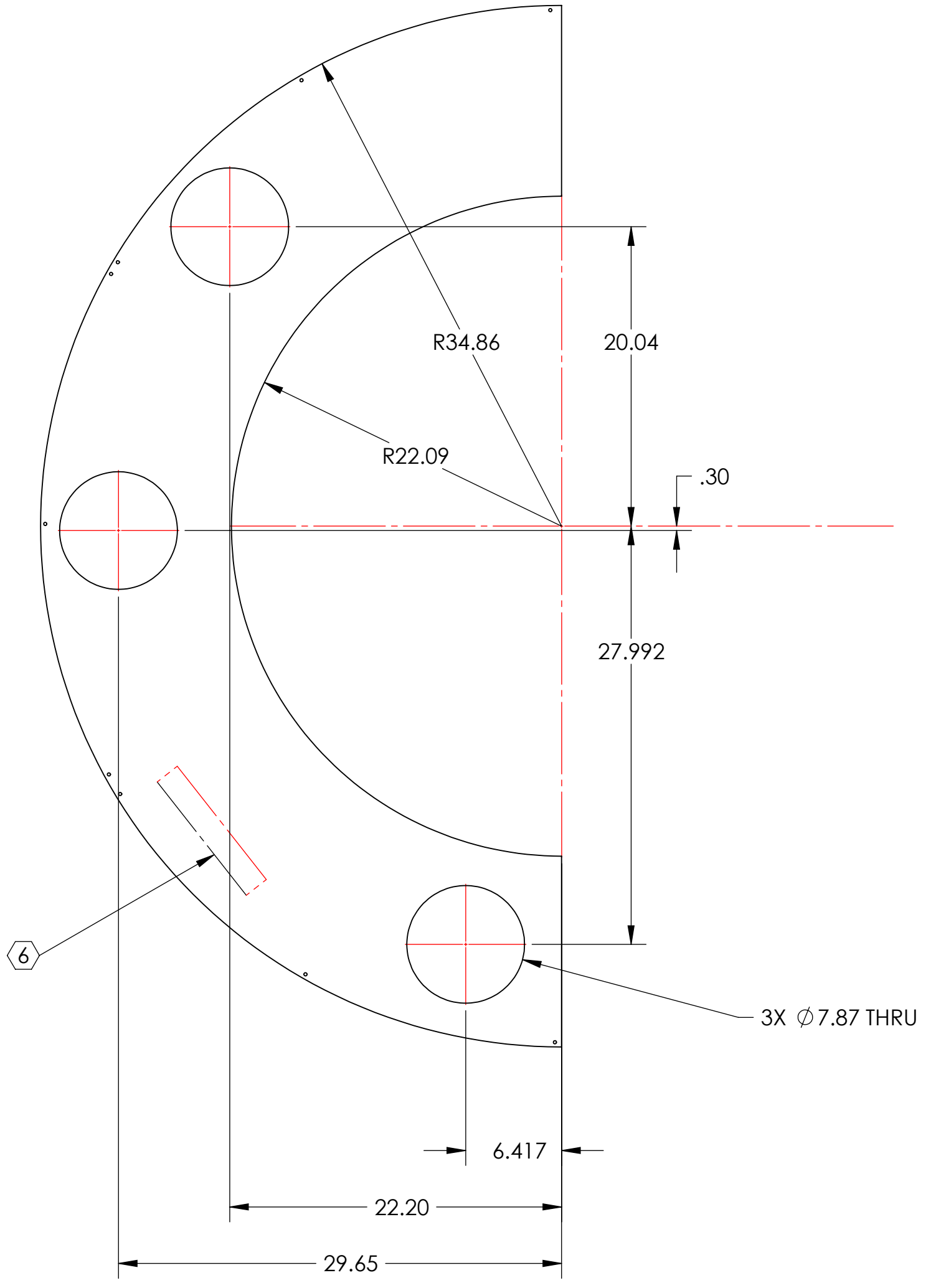
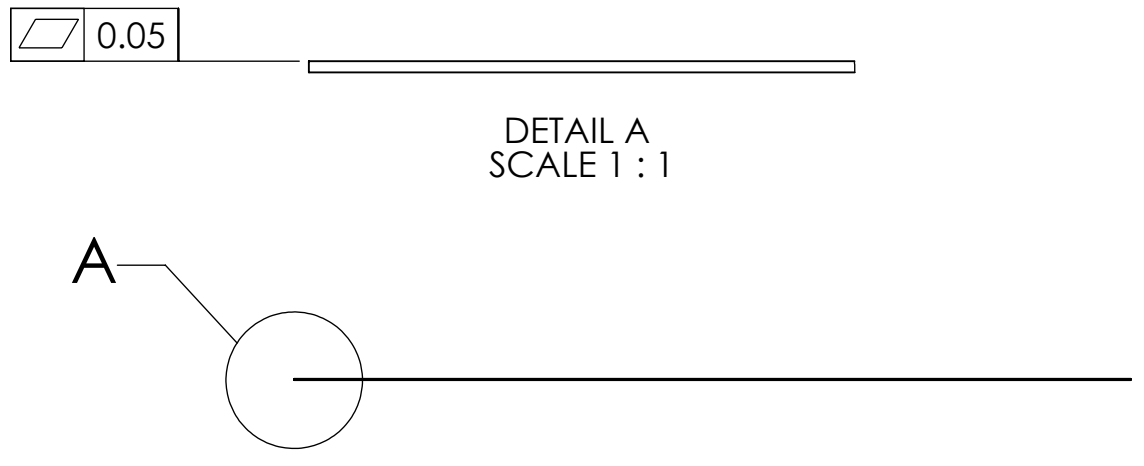
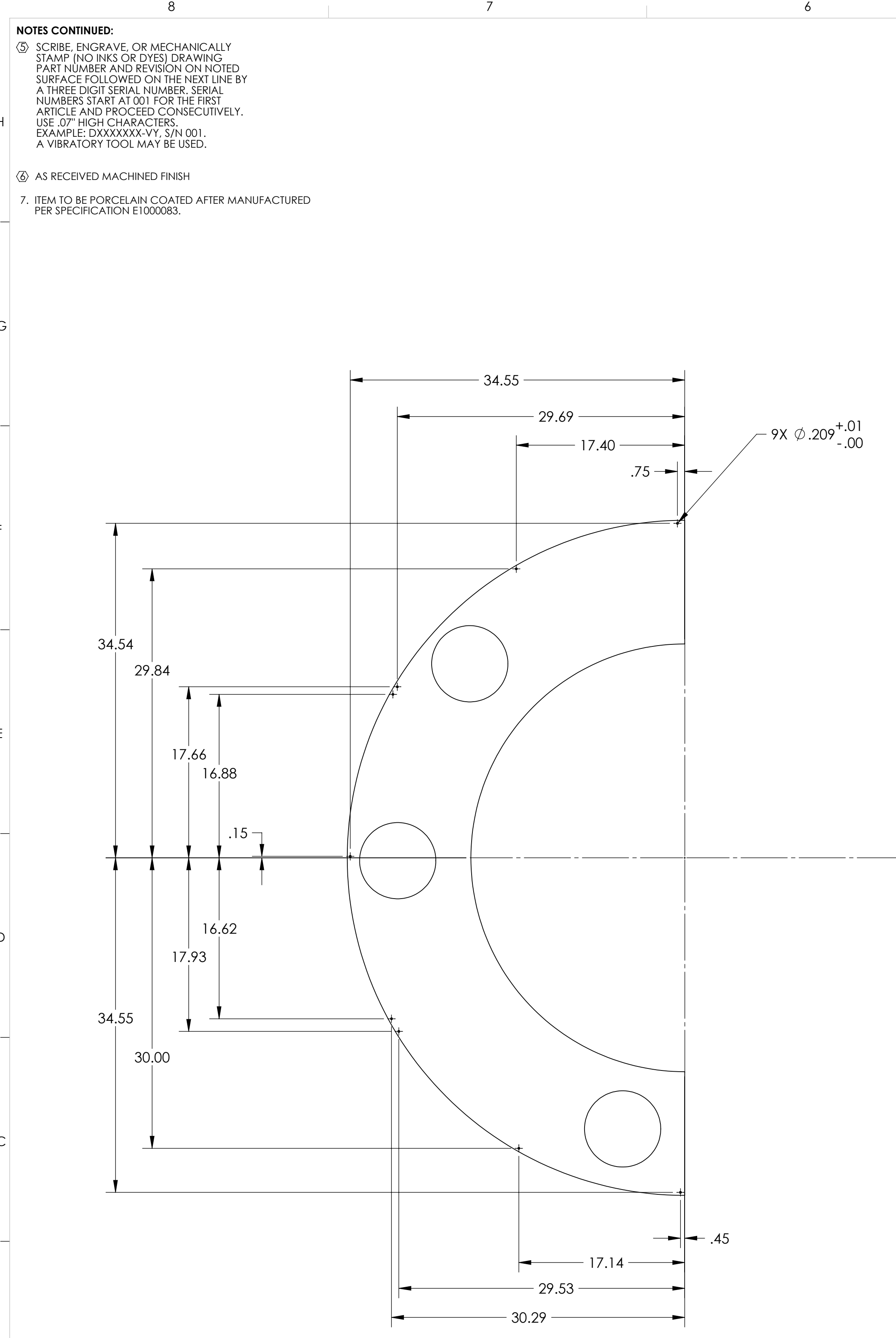
D1000536_d1lgo_Manifold_Cryo_Baffle_Bracket, PART PDM REV: X-022, DRAWING PDM REV: X-011

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES:	2. REMOVE ALL SHARP EDGES, R.02 MIN.
.XX ± .06	3. DO NOT SCALE FROM DRAWING.
.XXX ± .010	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ±1.0°	
MATERIAL	14GA A424 TYPE I STEEL
FINISH	⑥

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		Baffle Brace Bracket	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	H. Kelman
NEXT ASSY	D0902654, D0902655, D1001348	CHECKER		DATE	17 MAR 2010
		APPROVAL		SIZE	DWG. NO.
				B	D1000536
				REV.	v1
				SCALE: 2:1	PROJECTION:
					SHEET 1 OF 1

8 7 6 5 4 3 2 1



REV.	DATE	DCN #	DRAWING TREE #
-	-	E1000360	E1000359-v1
-	-	-	-
-	-	-	-

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: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

⑥ AS RECEIVED MACHINED FINISH

7. ITEM TO BE PORCELAIN COATED AFTER MANUFACTURED PER SPECIFICATION E1000083.

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .06 .XXX ± .010 ANGULAR ± 0.5°		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		PART NAME MANIFOLD-CRYO BAFFLE HALF FACE PLATE, ITMX H1-H2	
MATERIAL 18GA A424 TYPE I STEEL		FINISH ⑥ μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1002061		DESIGNER H. KELMAN 17 MAY 2010		CHECKER TQ, NGUYEN 18 AUG 2010		APPROVAL [Signature]	
SCALE: 1:8		PROJECTION:		SIZE DWG. NO. D D0902657		REV. v1	
				SHEET 1 OF 1			

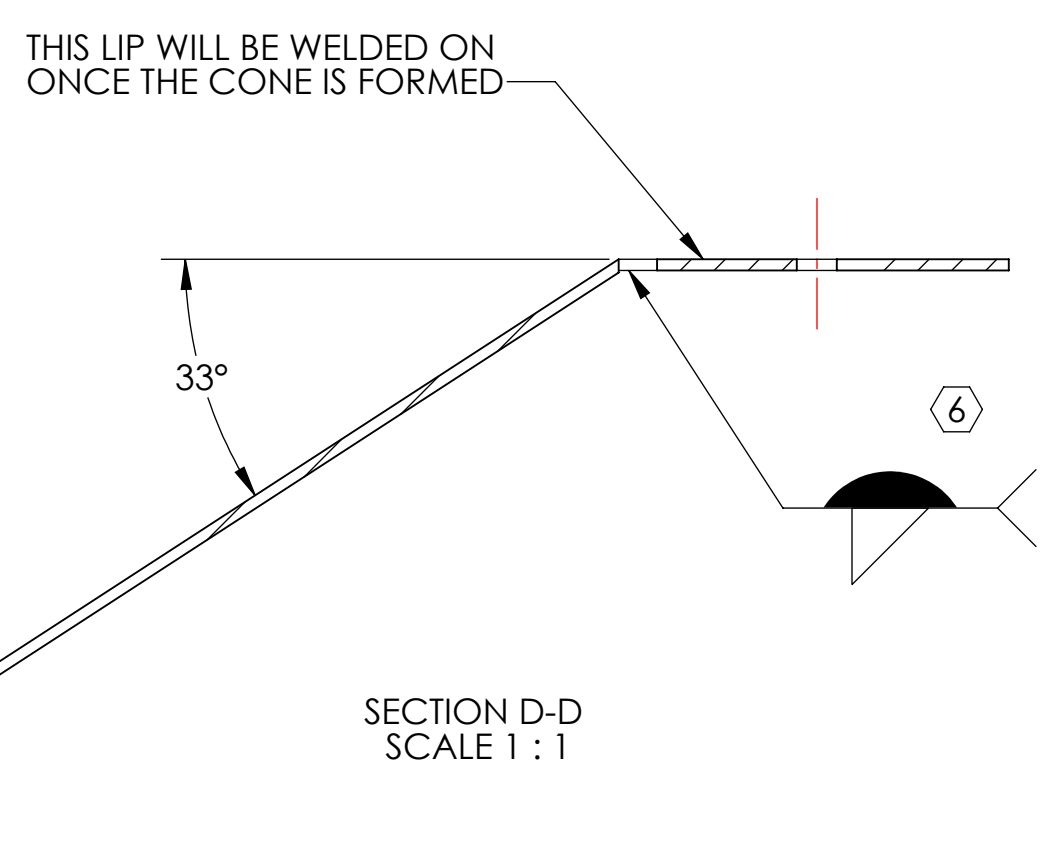
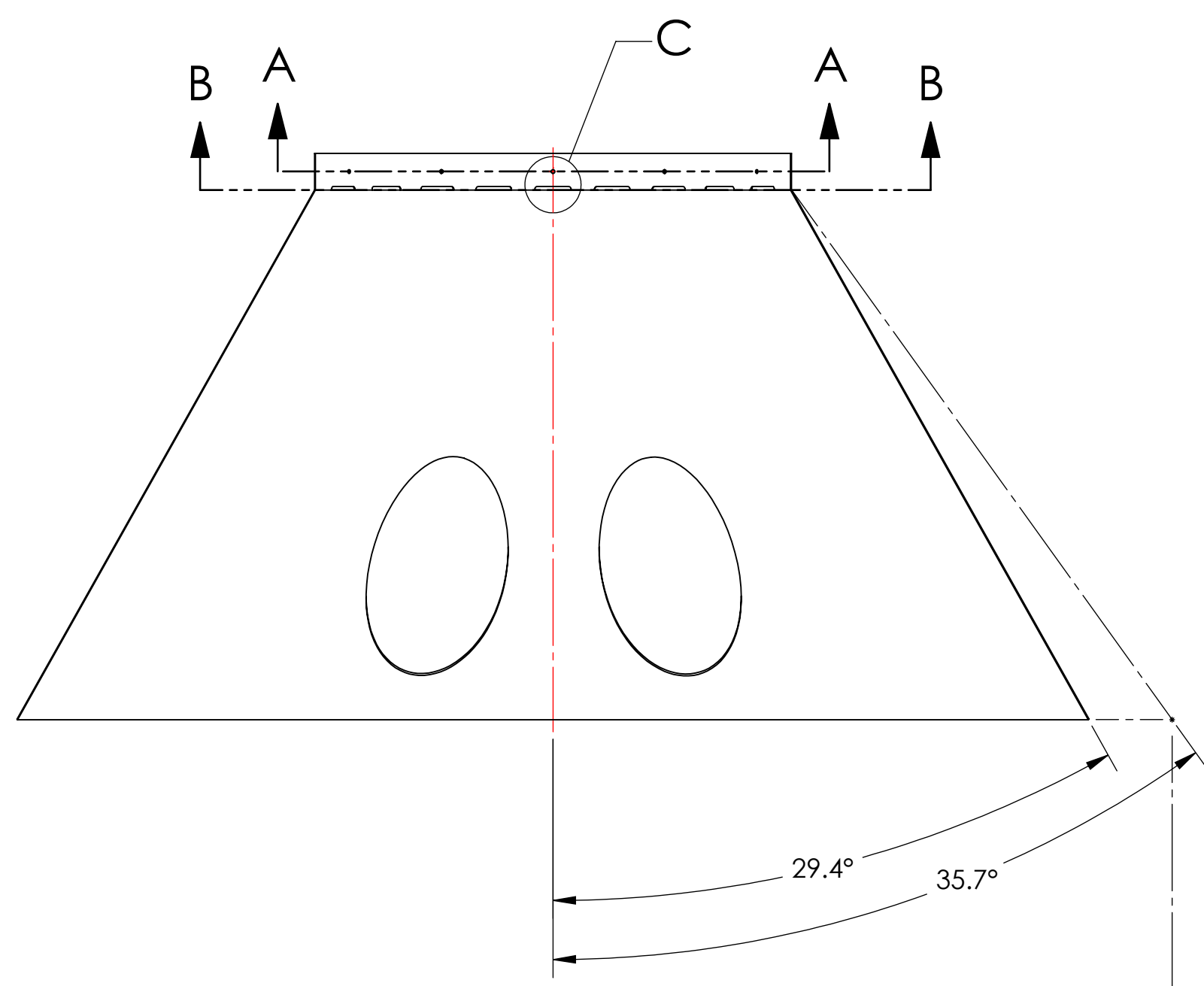
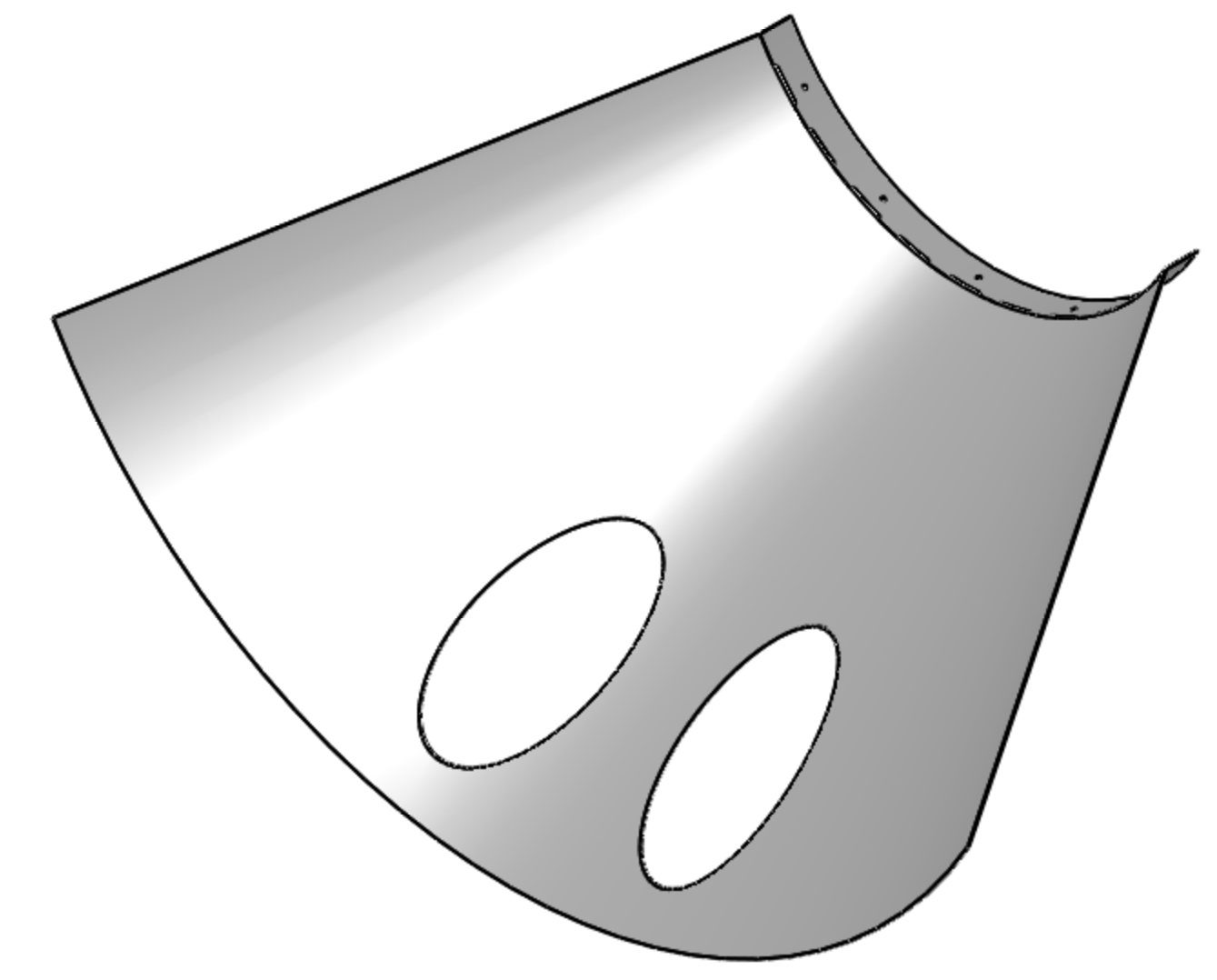
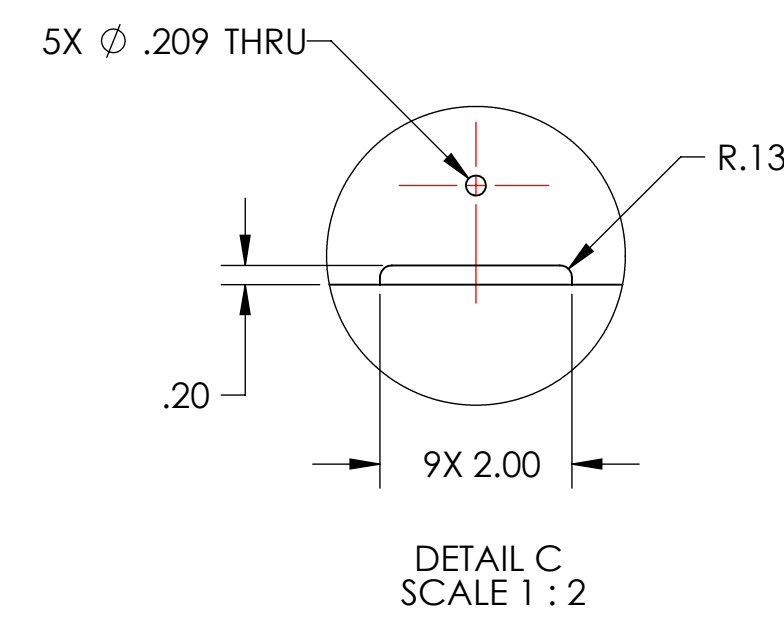
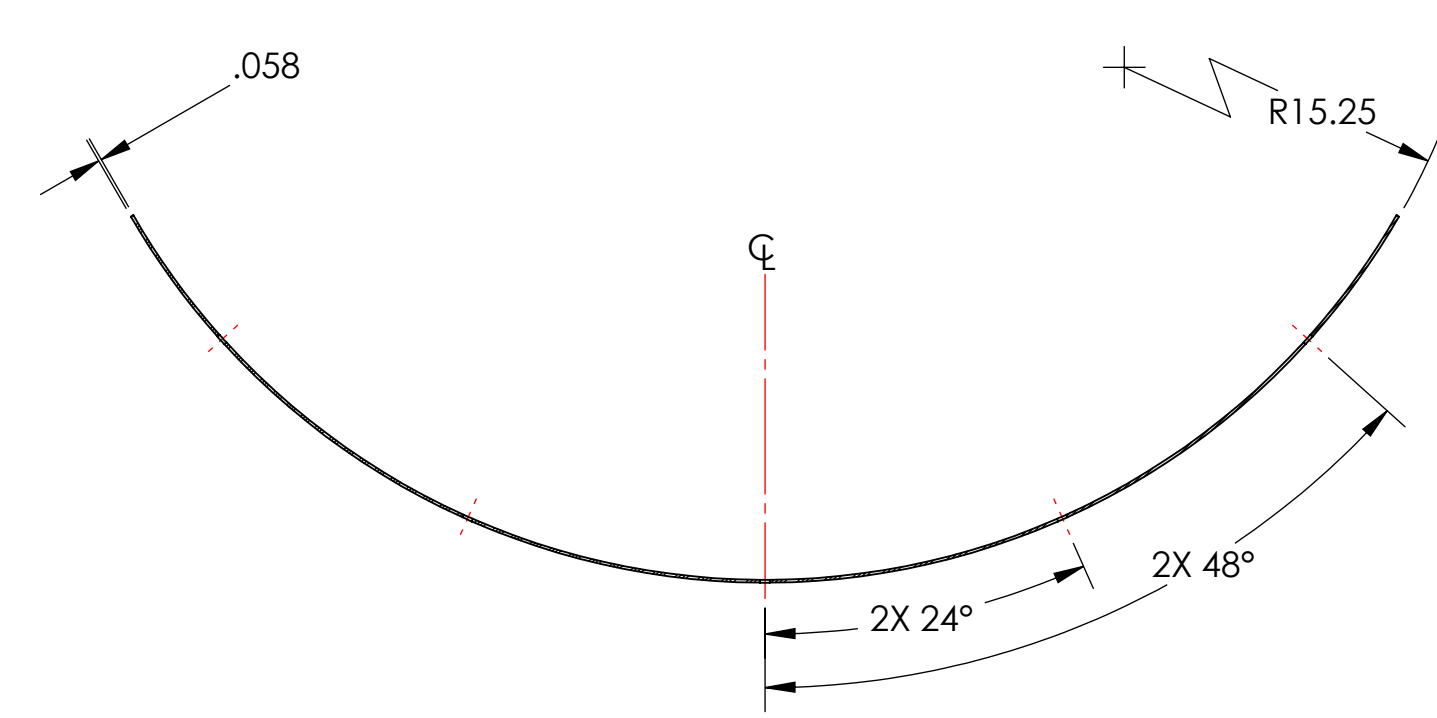
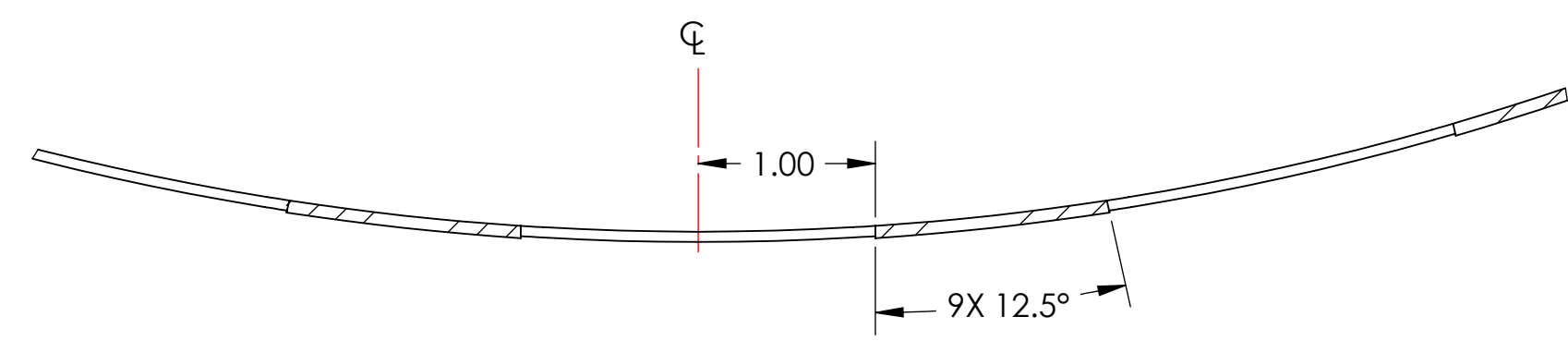
D0902657.dwg; C:\Users\cyc\Baffle_half_Face_Plate_ITMX_H1-H2_PART.PDM.REV.X-014.DRAWING.PDM.REV.X-003

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

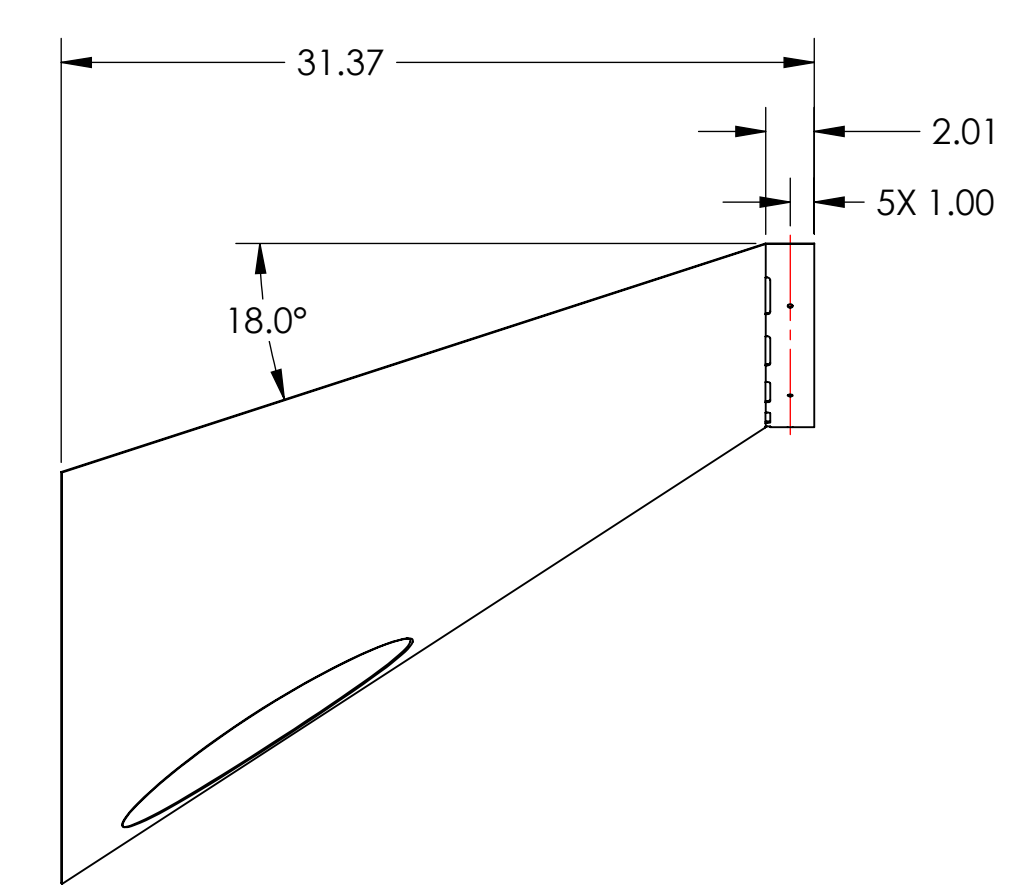
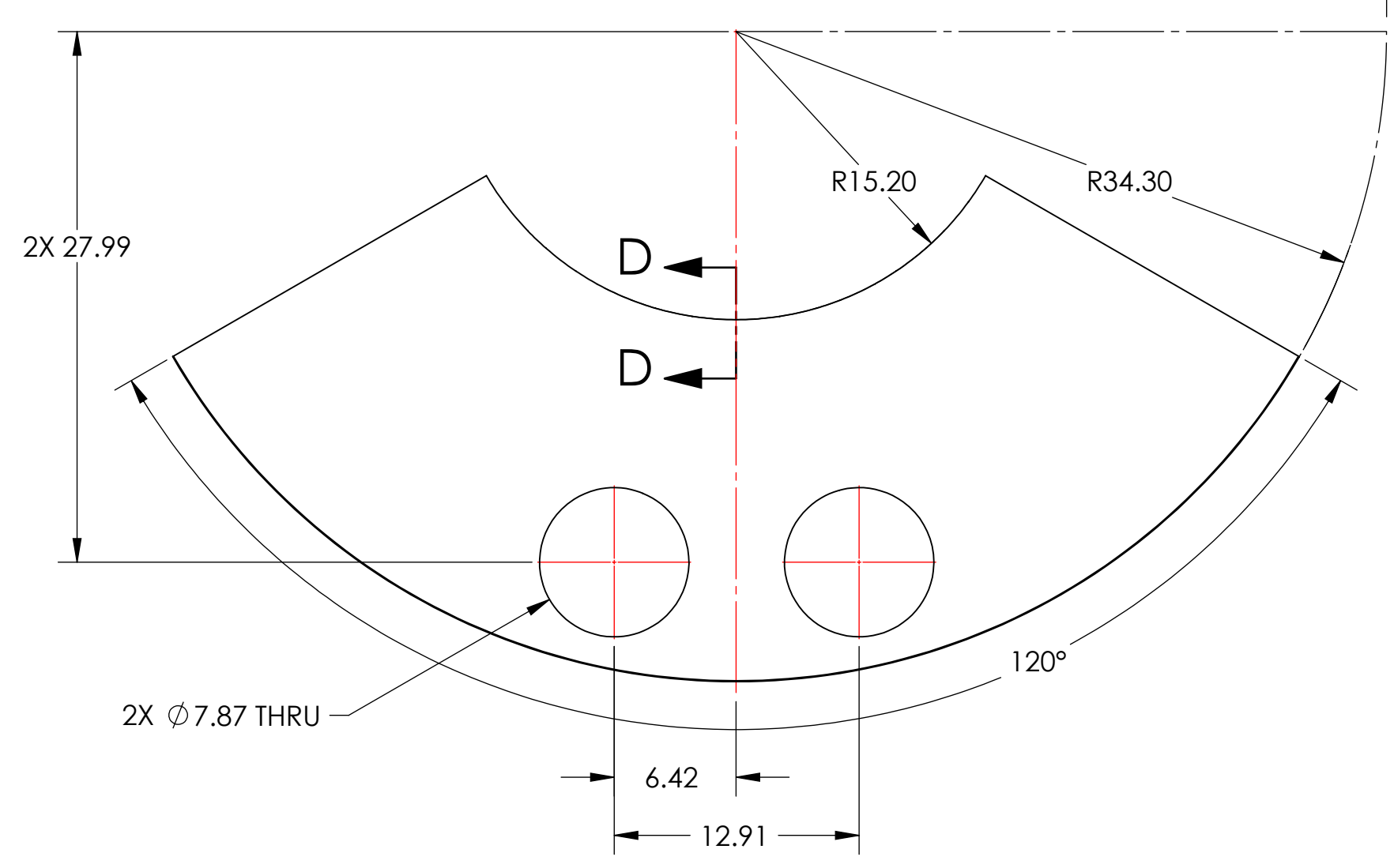
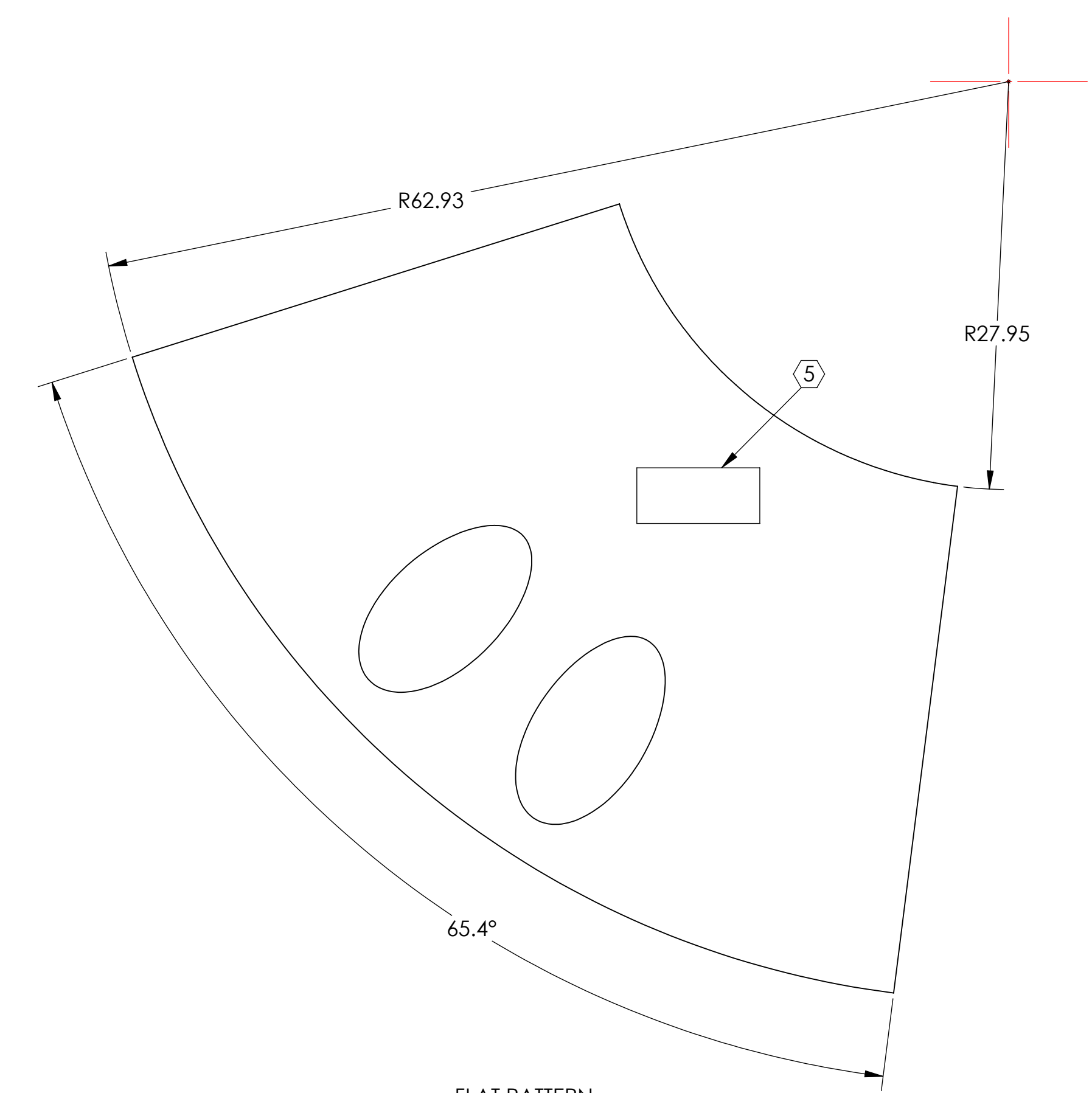
⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000085
-	-	-	-
-	-	-	-



10 PLS

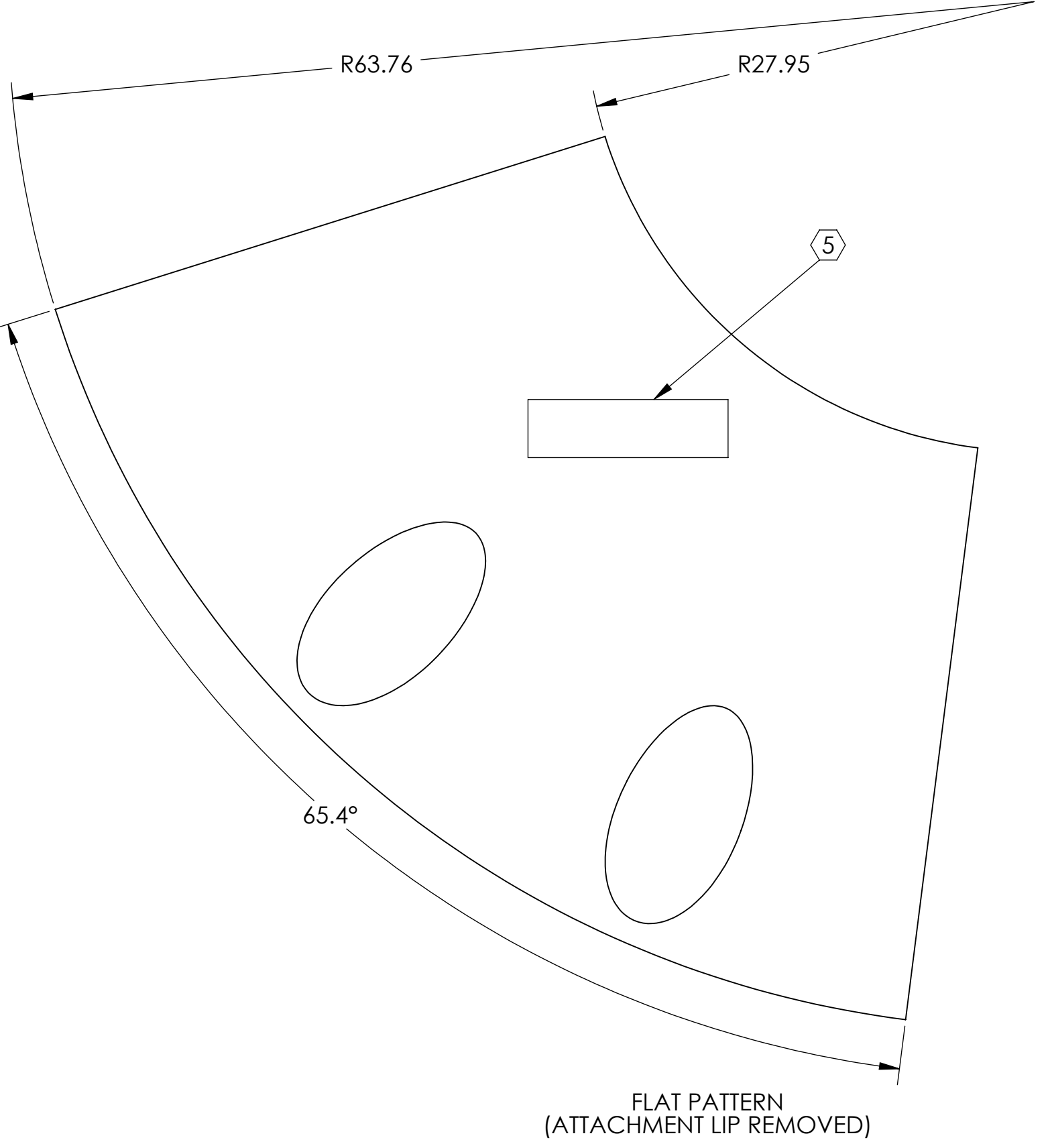
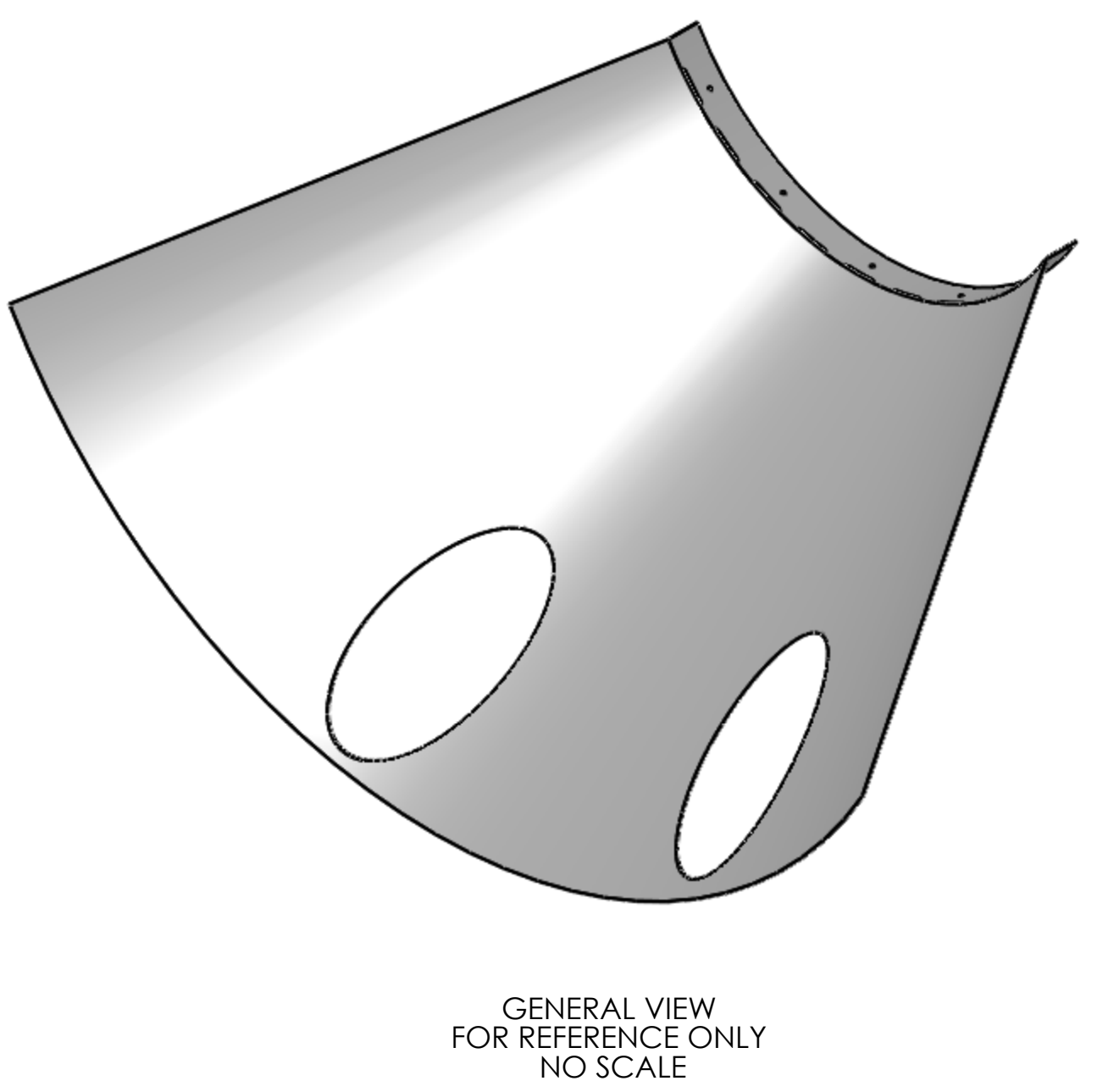
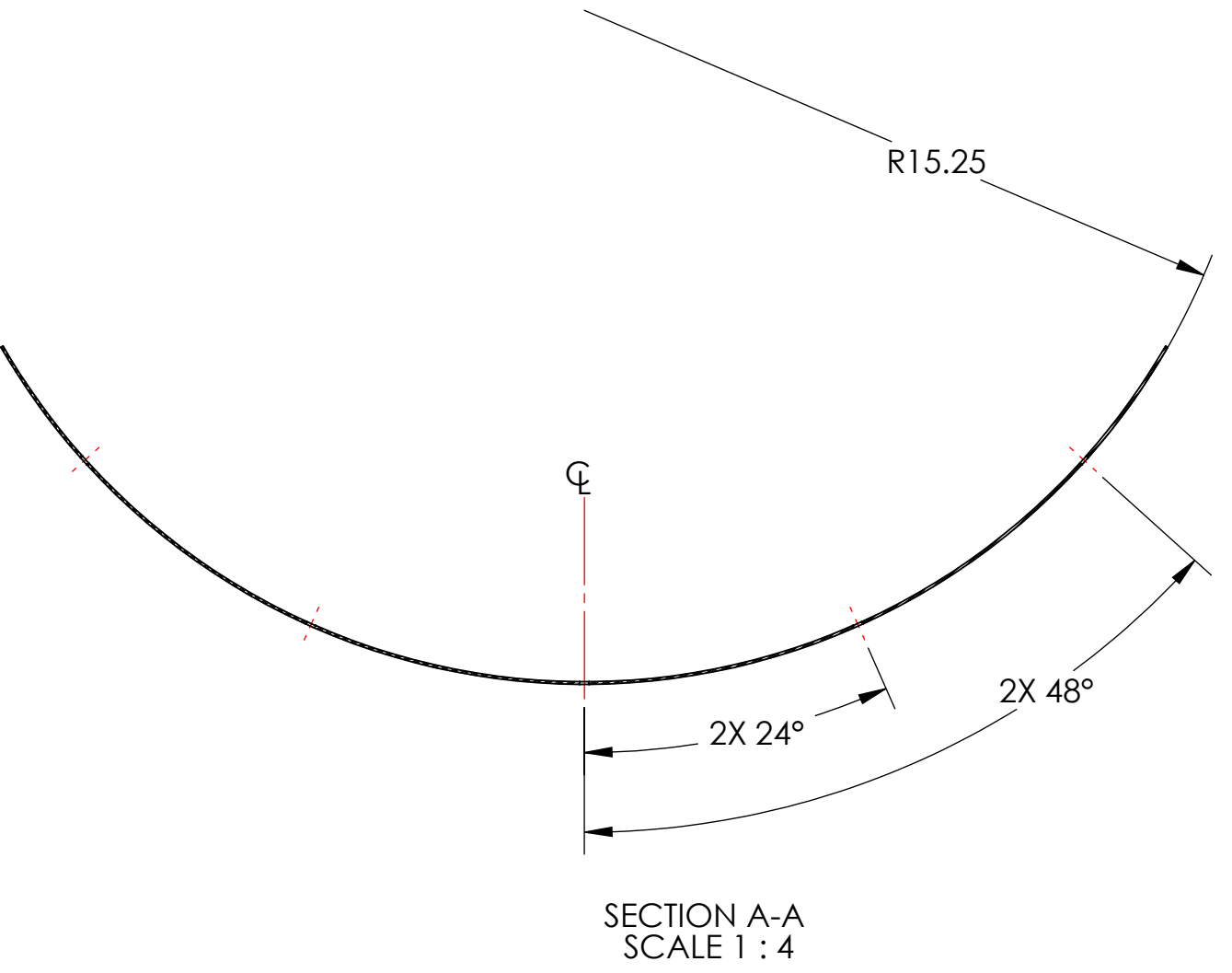
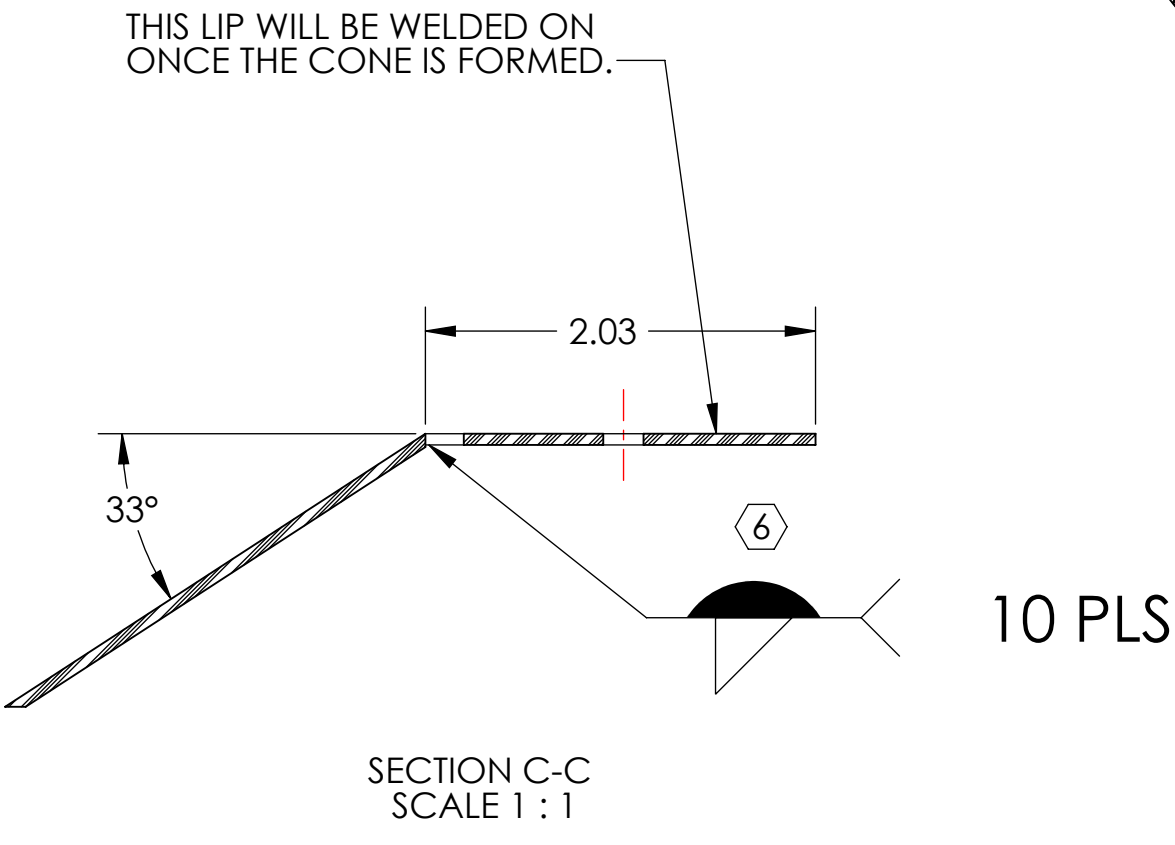
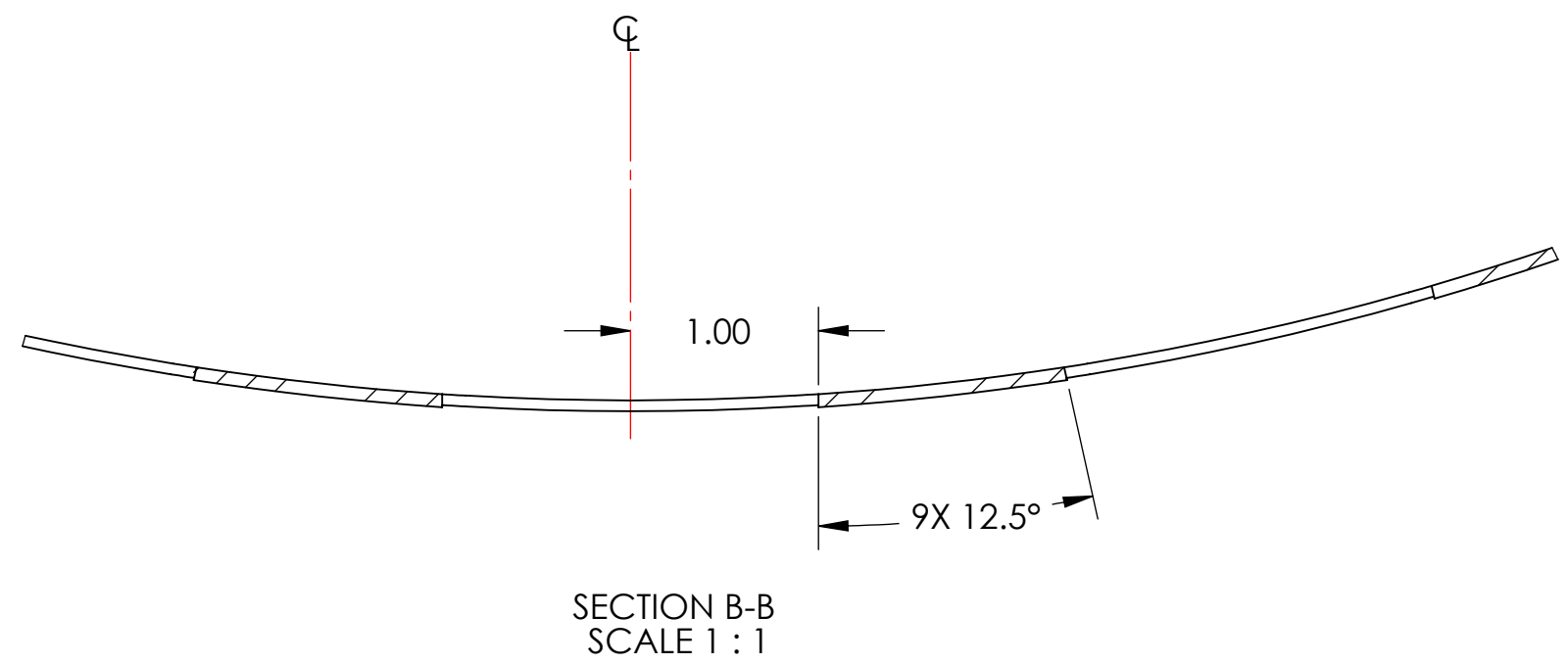
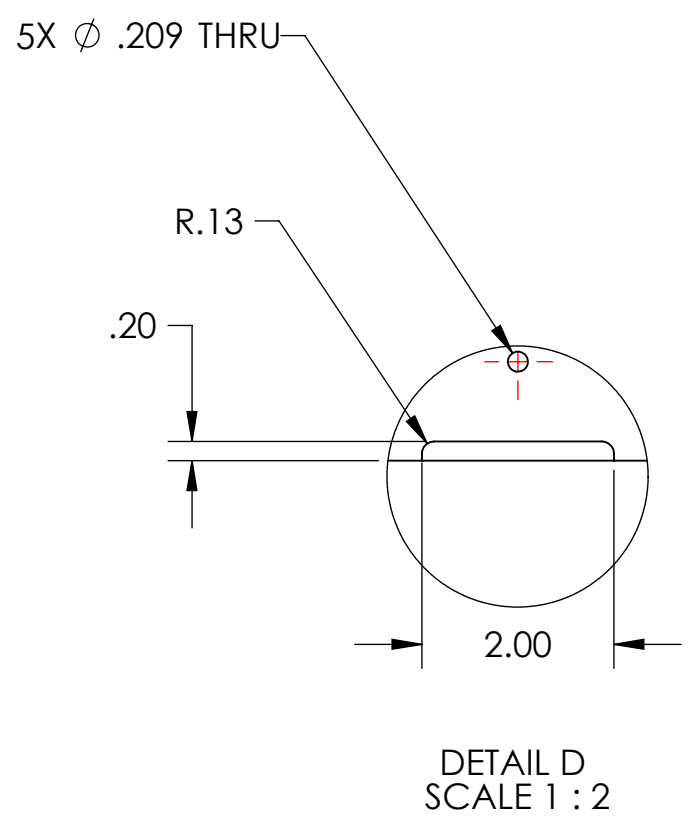
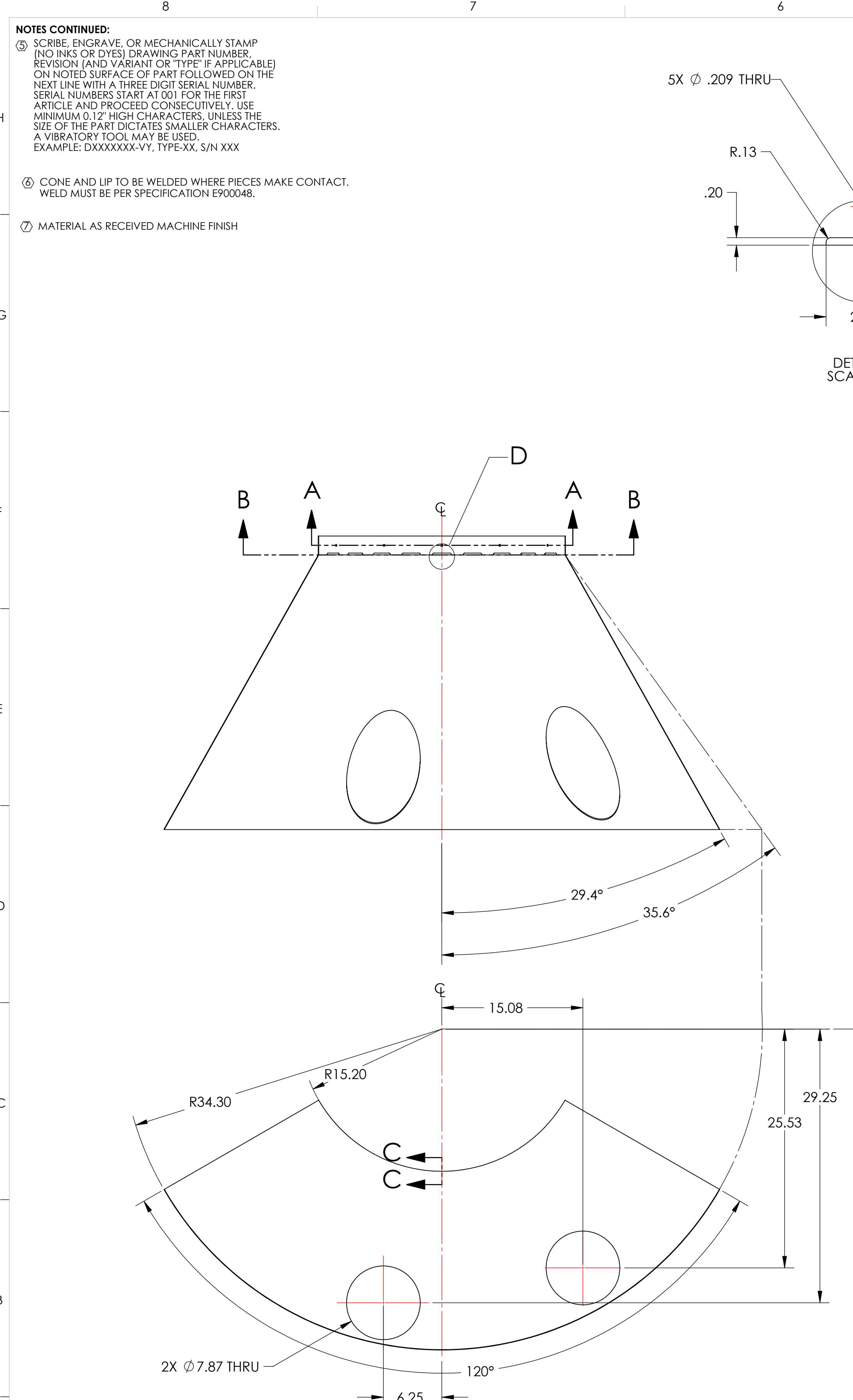


THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902655 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES: .XX ± .06 .XXX ± .010		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	SYSTEM	SUB-SYSTEM
18GA A424 TYPE I STEEL	⑦	ADVANCED LIGO	AOS
ANGULAR ± 0.5°		NEXT ASSY	
		D0902655	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1-H2, BOTTOM	
DESIGNER	H. KELMAN	03-15-10	SIZE	DWG. NO.	
DRAFTER	TQ. NGUYEN	17 AUG 2010			
CHECKER	M. SMITH				
APPROVAL	D. COYNE				
SCALE: 1:8		PROJECTION:		SHEET 1 OF 1	

D0902623.dwg; Manifold_Cryo_Baffle_Inner_Segment; ITMX H1-H2_Bottom; PART PDM REV: X01.5; DRAWING PDM REV: X007



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

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

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELD MUST BE PER SPECIFICATION E900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .06 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	FINISH
18GA A424 TYPE I STEEL	⑦

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D0902656

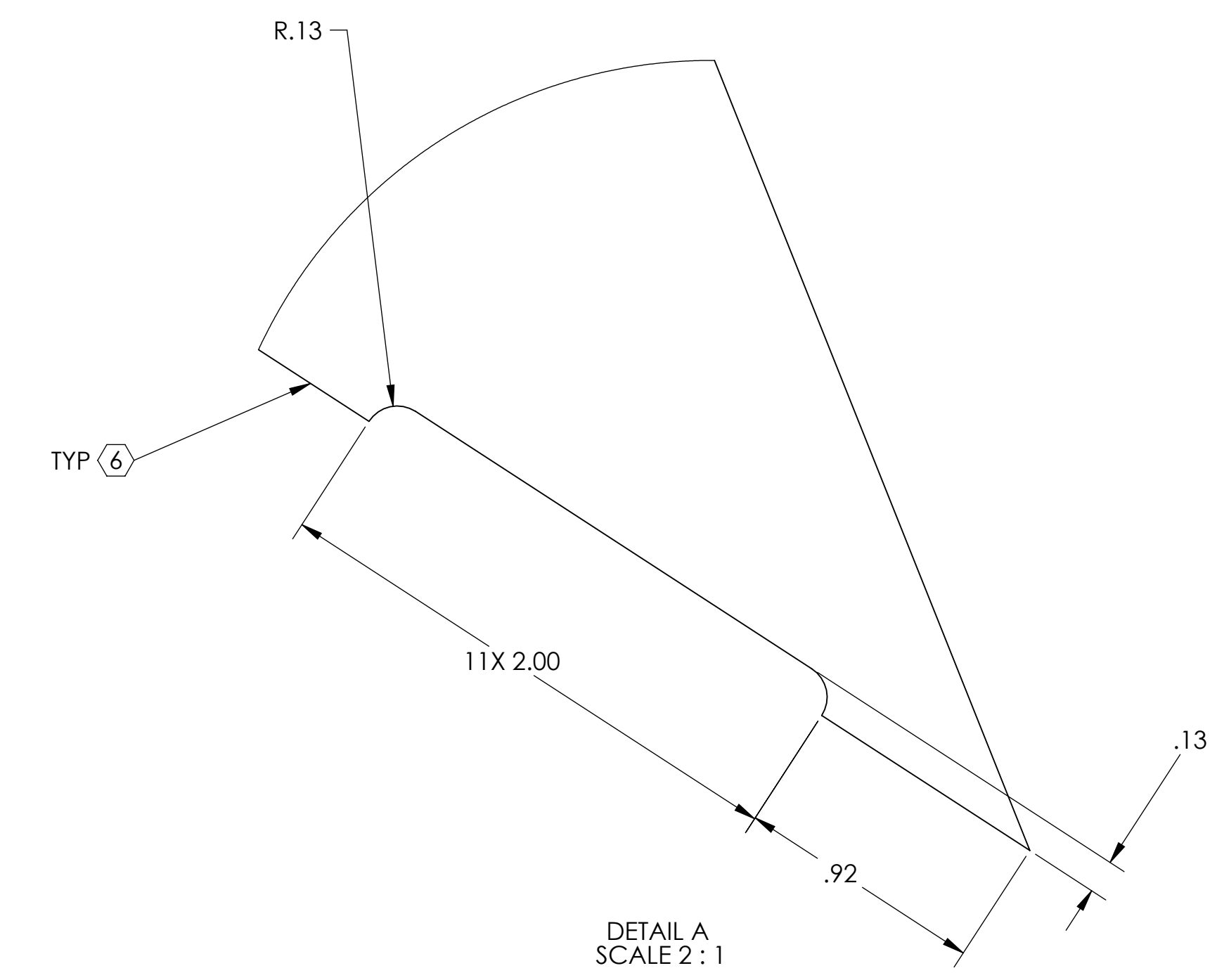
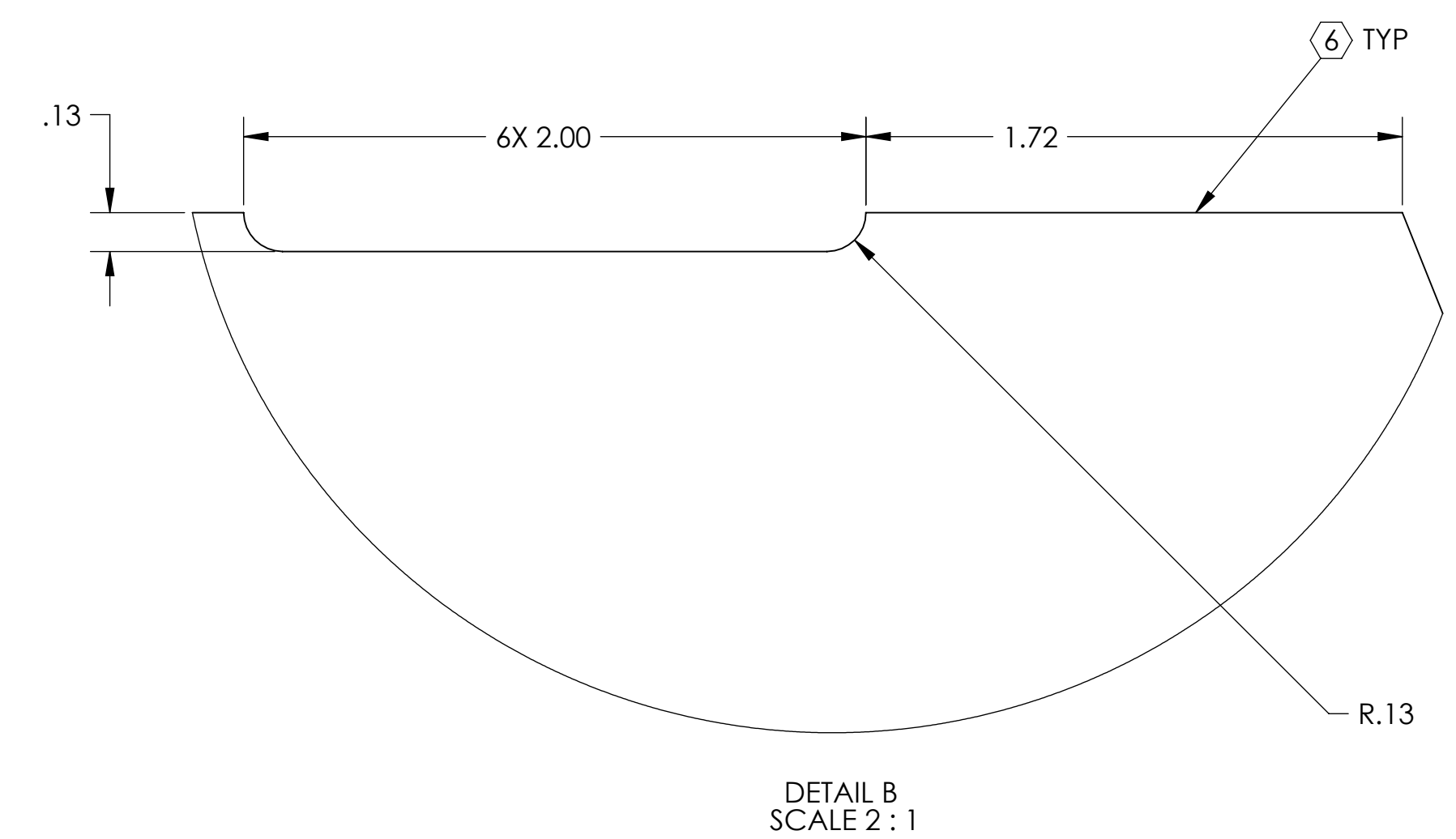
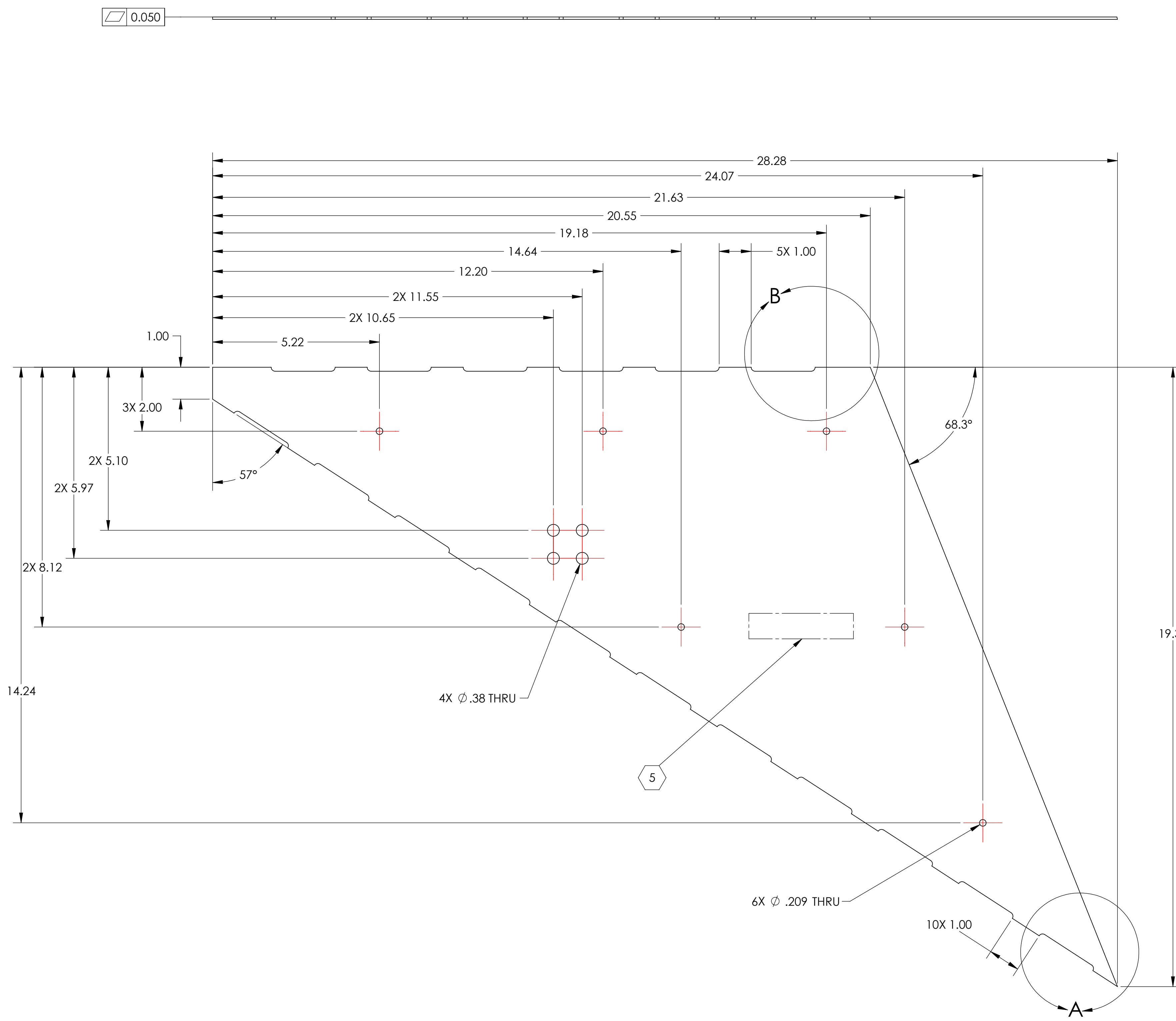
PART NAME				MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT			
DESIGNER	H. KELMAN	12 MAY 2010	SIZE	DWG. NO.	REV.		
DRAFTER	TQ. NGUYEN	17 AUG 2010	D	D0902622	v1		
CHECKER	M. SMITH		SCALE: 1:8	PROJECTION:	SHEET 1 OF 1		
APPROVAL	D. COYNE						

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: DXXXXXX-VV, S/N 001. VIBRATORY TOOL MAY BE USED.

⑥ CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).

⑦ AS RECEIVED MACHINE FINISH.

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000085-v1
-	-	-	E1000090-v1
-	-	-	E1000091-v1



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

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.	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .06 .XXX ± .010 ANGULAR ± 1.0°	MATERIAL 14GA A424 TYPE I STEEL
FINISH ⑦ μinch	

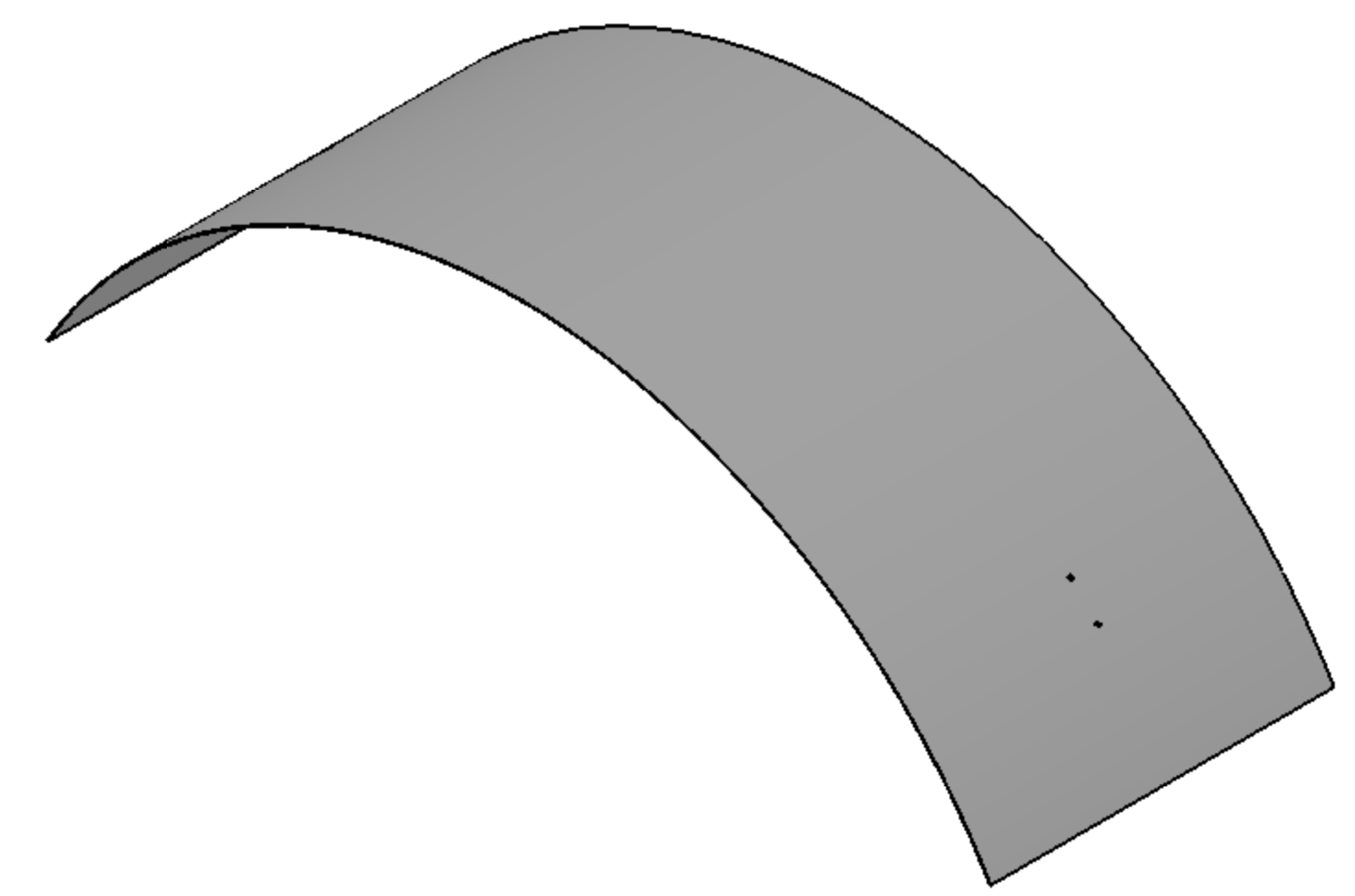
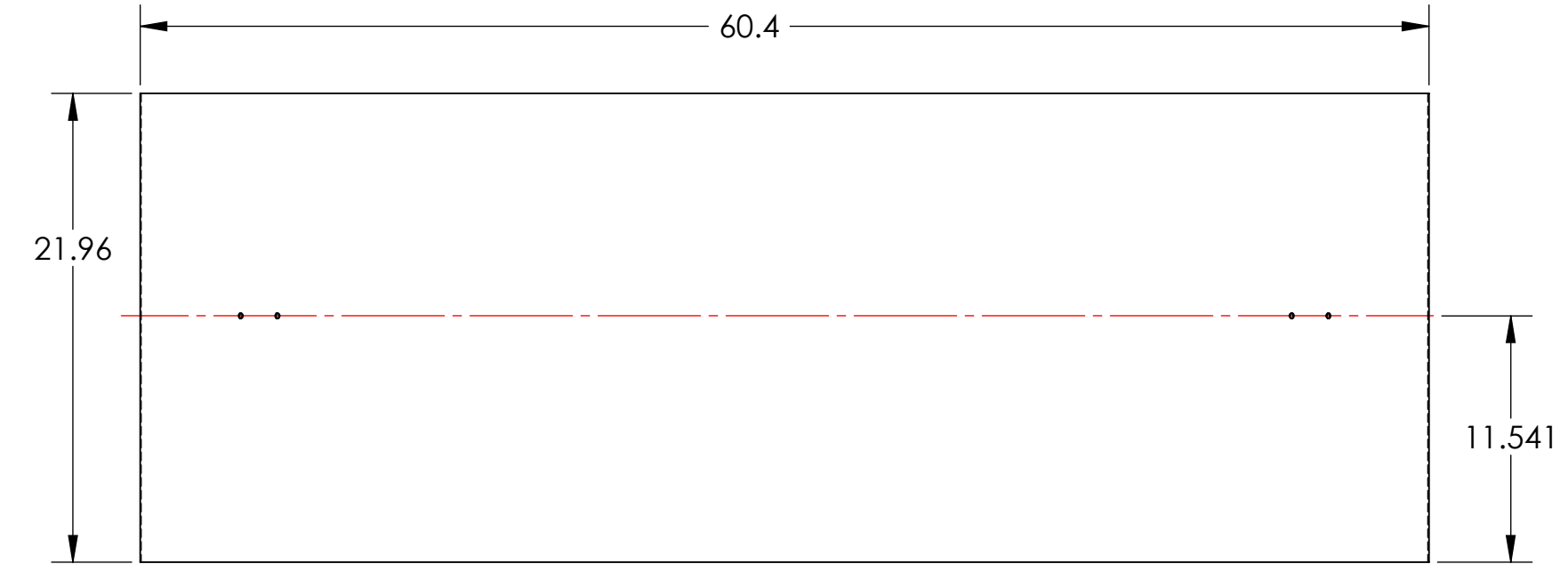
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS
NEXT ASSY D0902654, D0902655, D0902656	

PART NAME Manifold Cryo Baffle Bracket, Right			
DESIGNER H. KELMAN	DATE 17 MAR 2010	SIZE D	DWG. NO. D0902621
DRAFTER TQ. NGUYEN	DATE 16 AUG 2010	SCALE 1:8	PROJECTION FIRST ANGLE
CHECKER	APPROVAL	REV. v1	SHEET 1 OF 1

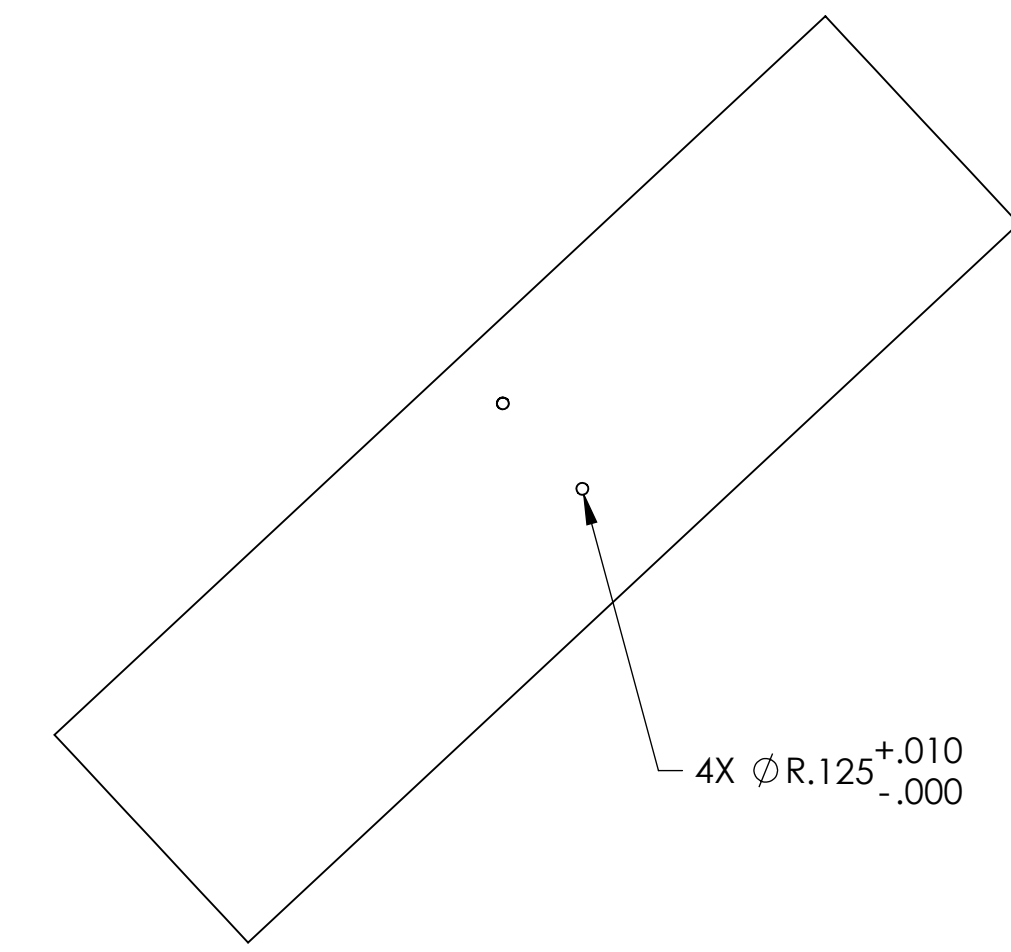
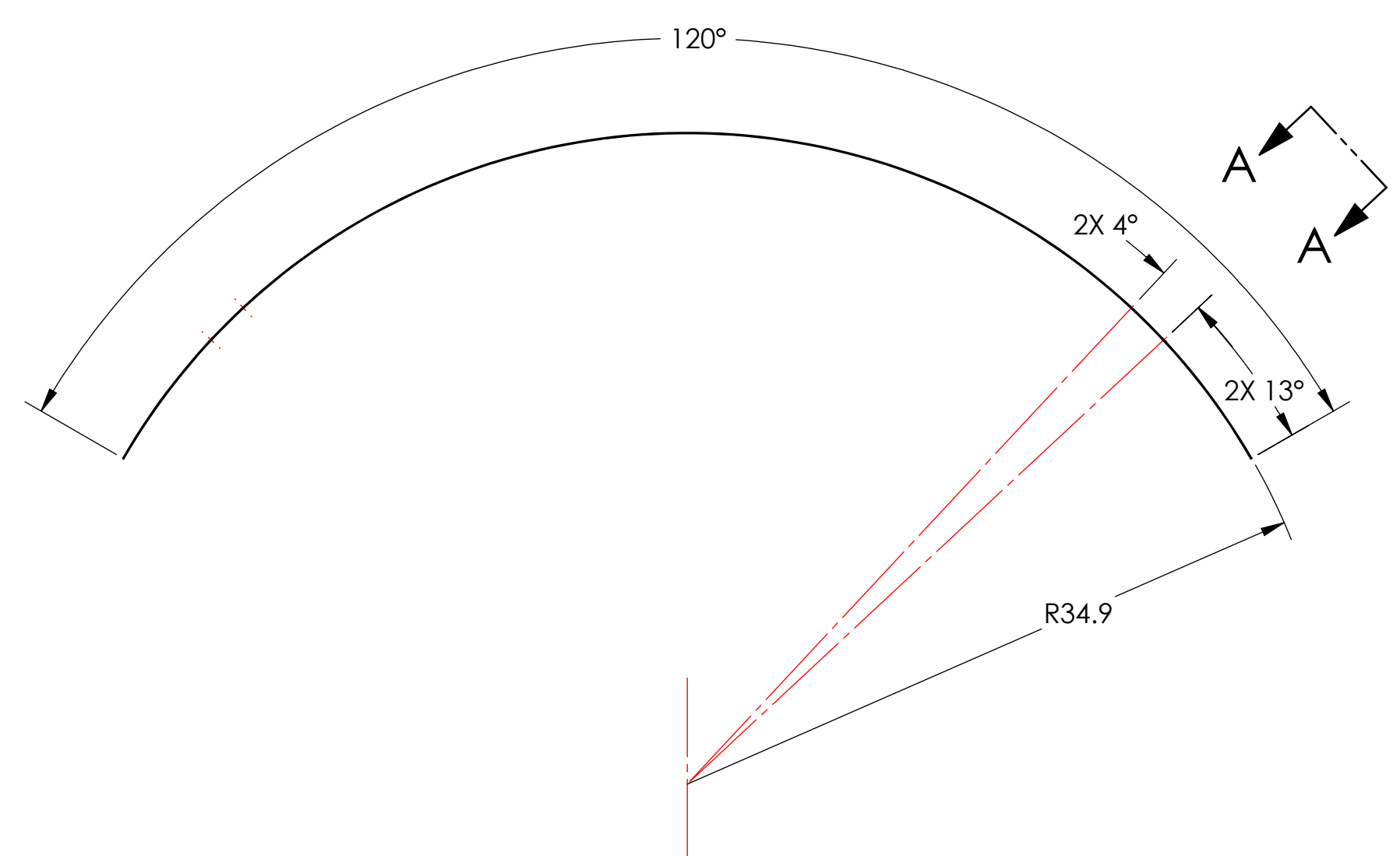
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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

⑥ AS RECEIVED MACHINE FINISH

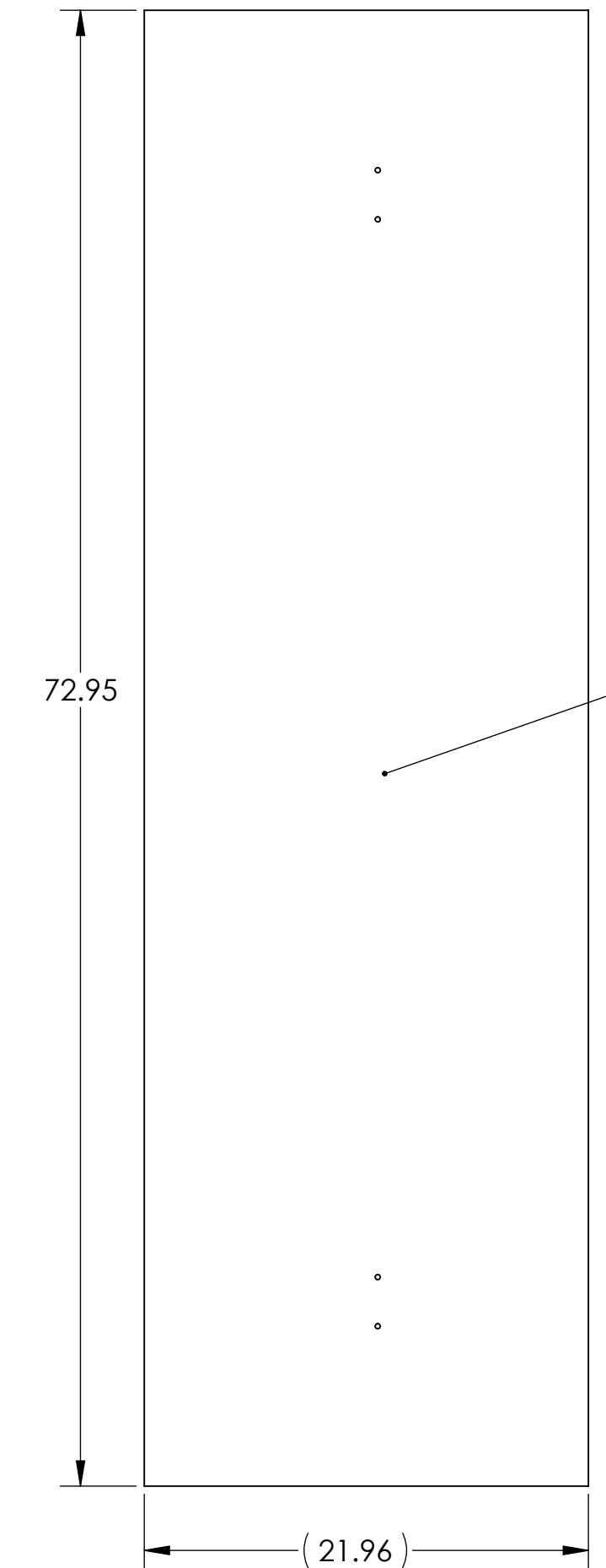
REV.	DATE	DCN #	DRAWING TREE #
V1	03 SEP 2010	E1000360	E1000085
-	-	-	-
-	-	-	-



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION A-A SCALE 1 : 4



FLAT PATTERN

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902655 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .03 .XXX ± .010		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.		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		RADIAL SEGMENT , BOTTOM	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE 1 STEEL FINISH ⑥		NEXT ASSY D0902654		DESIGNER H. KELMAN 17 MAR 2010 SIZE DWG. NO. D0902620 REV. v1	
						DRAFTER TQ. NGUYEN 16 AUG 2010	
						CHECKER M. SMITH	
						APPROVAL D. COYNE SCALE: 1:8 PROJECTION: SHEET 1 OF 1	

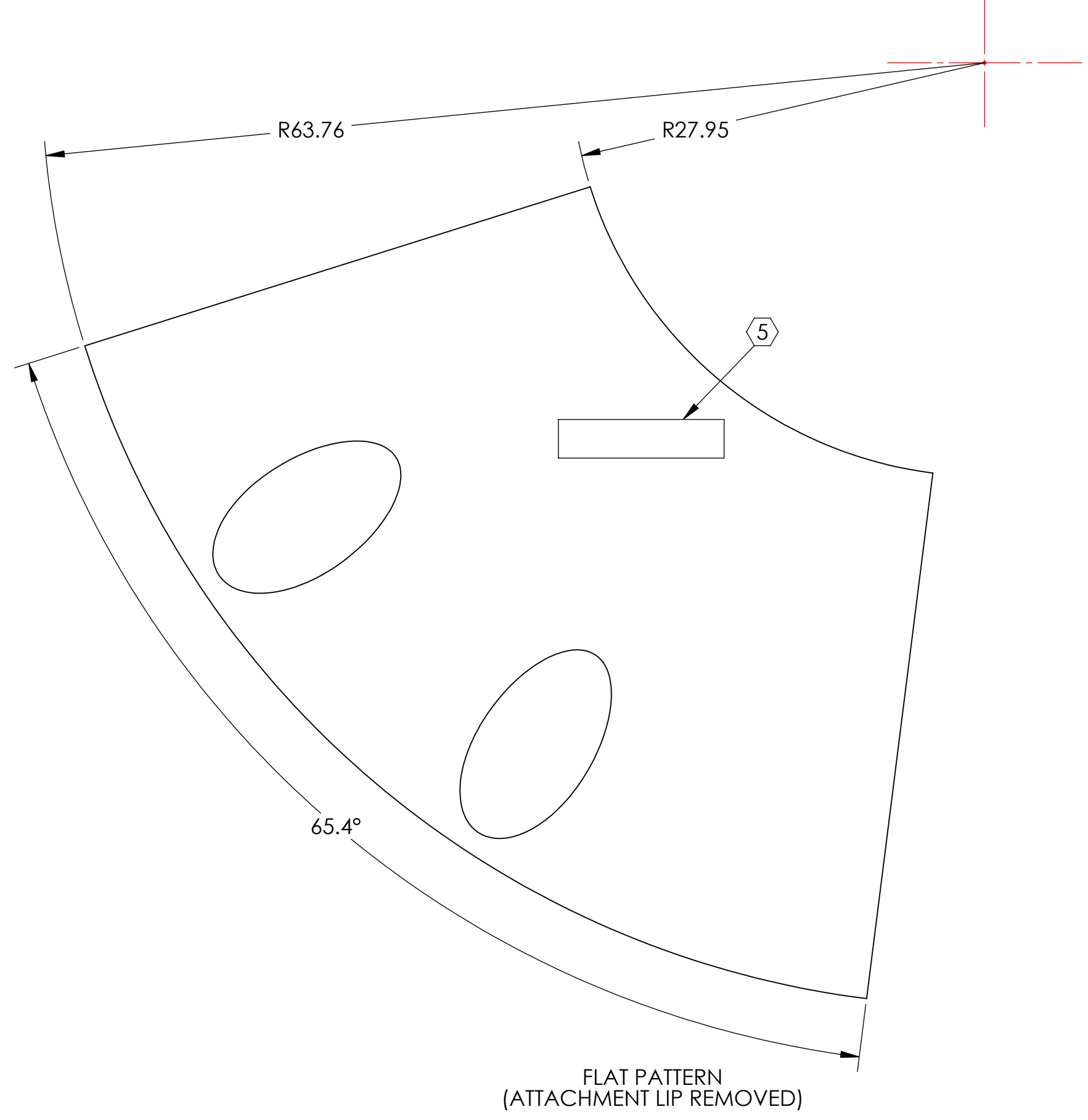
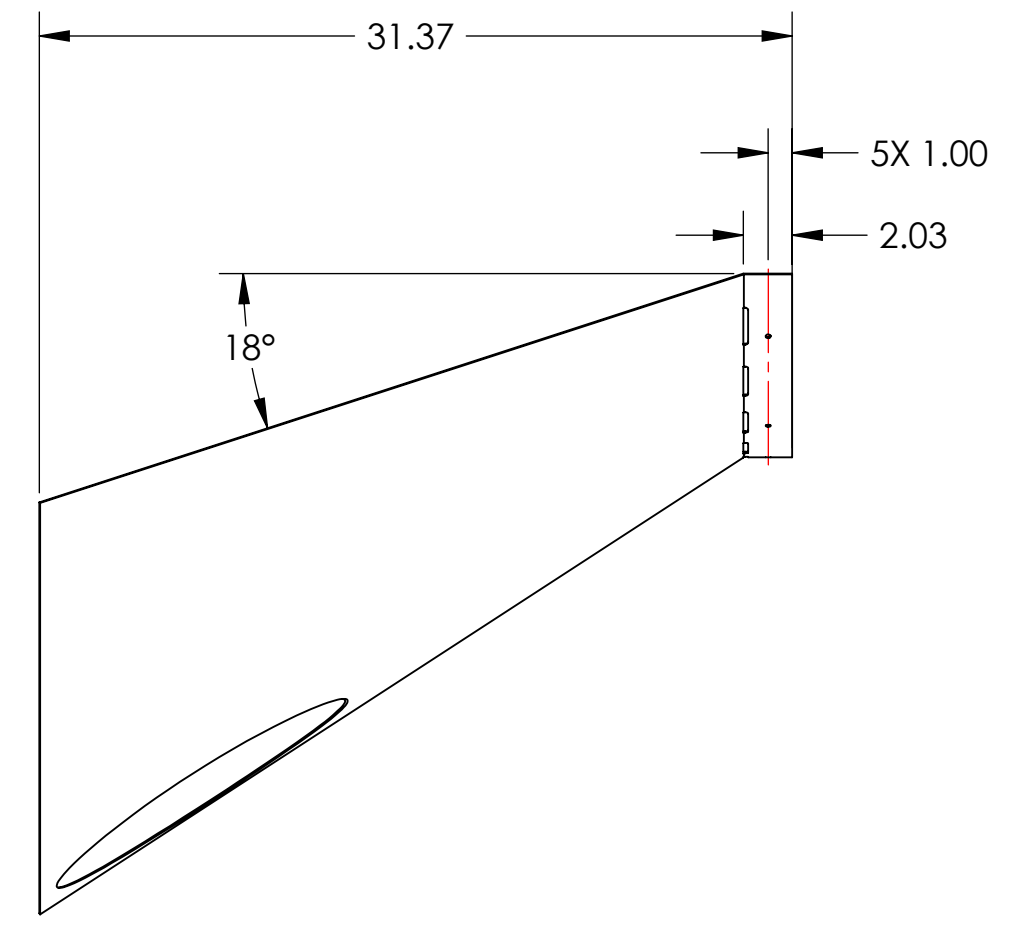
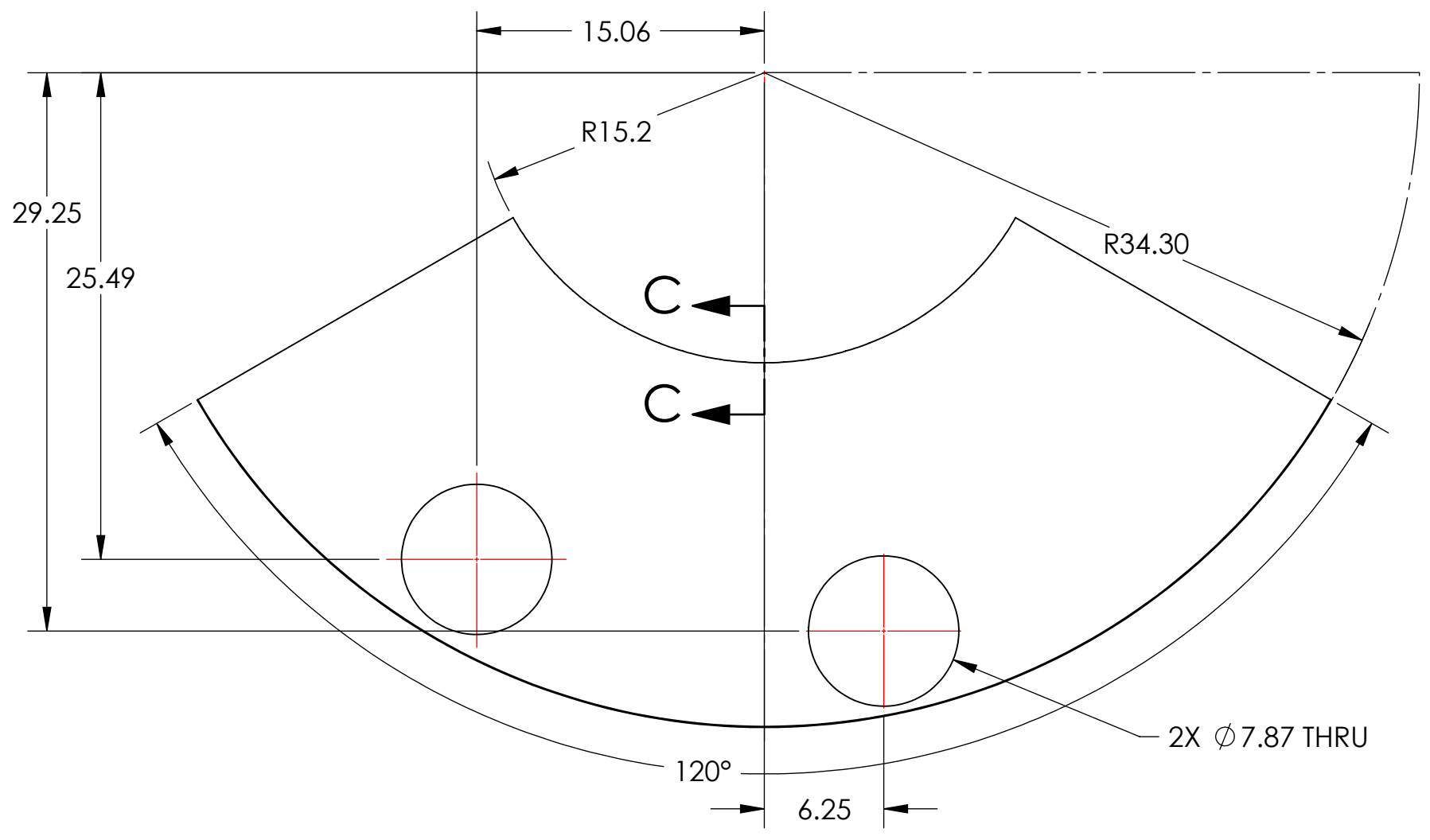
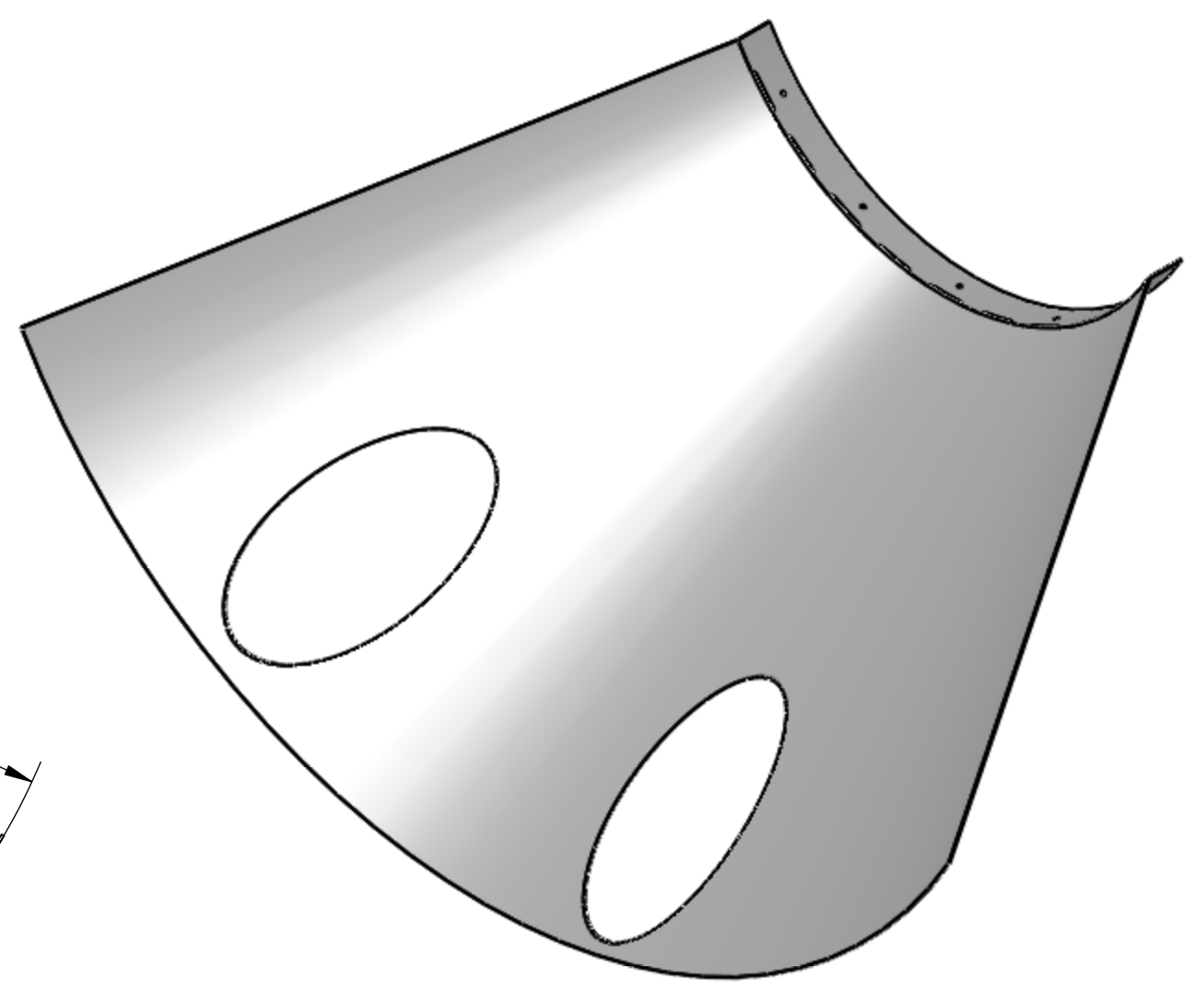
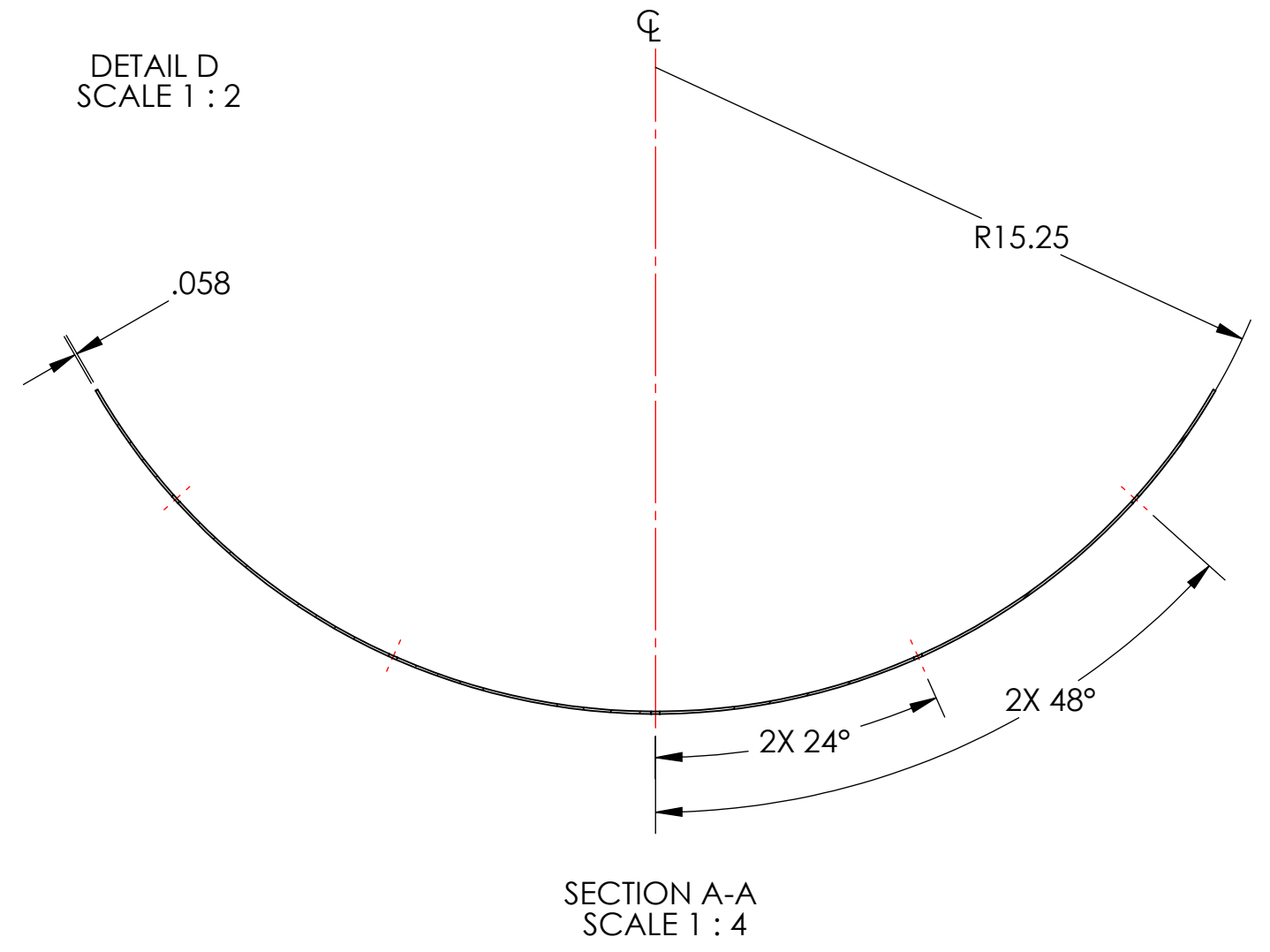
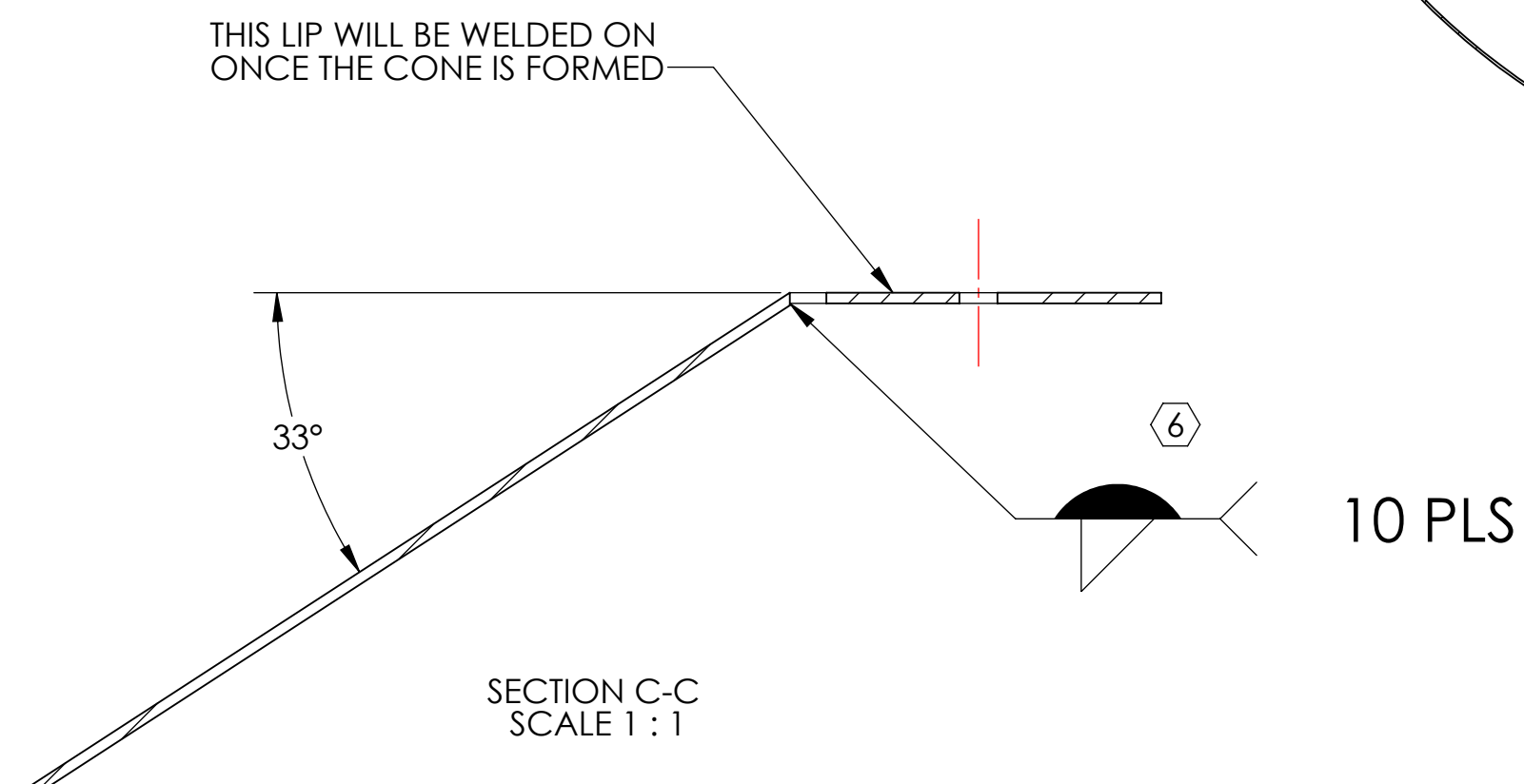
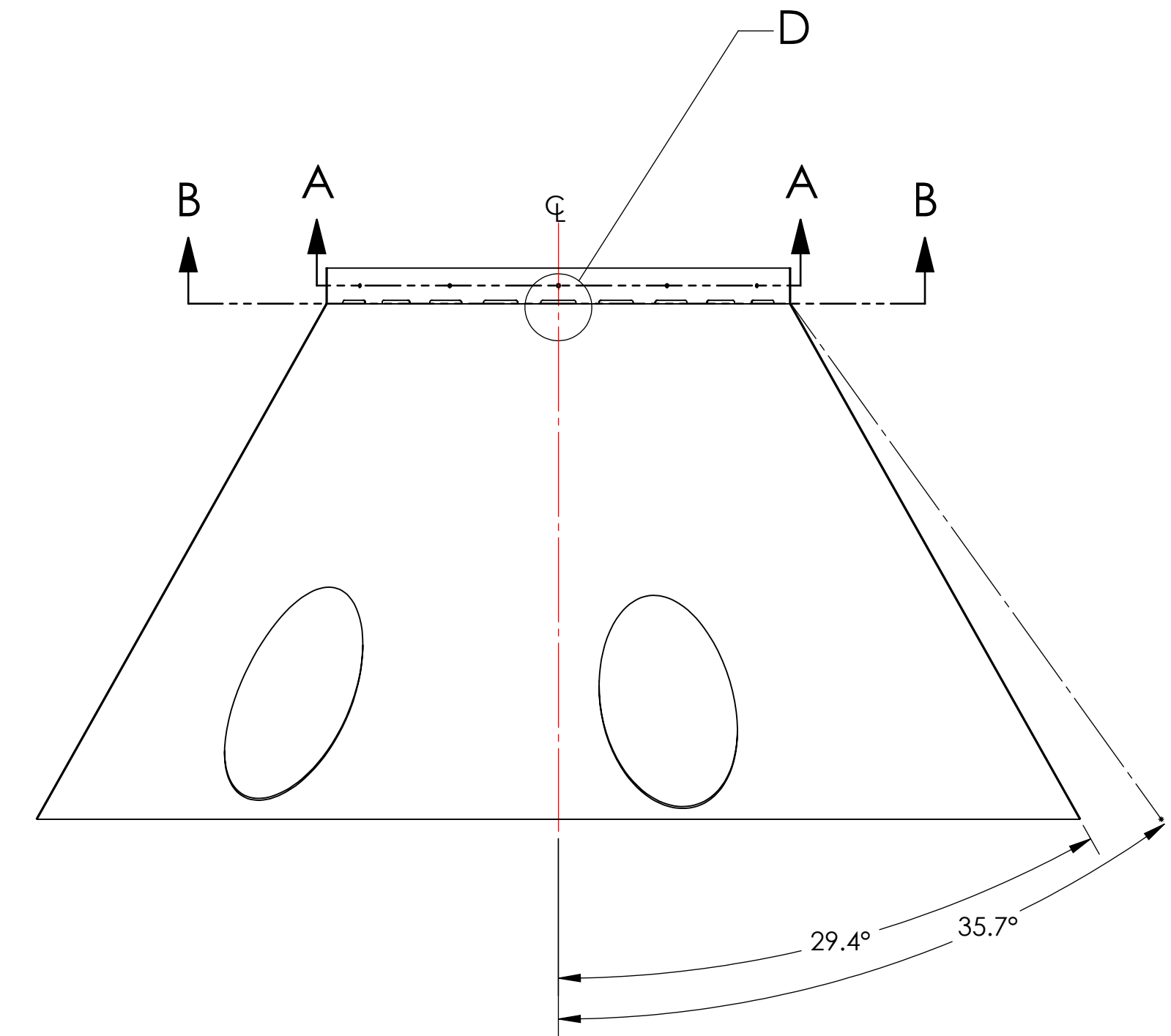
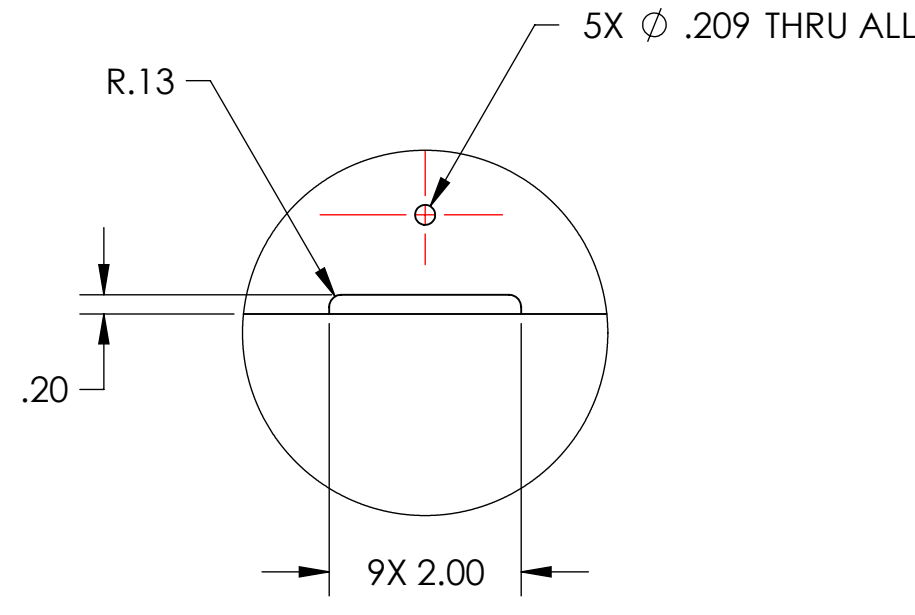
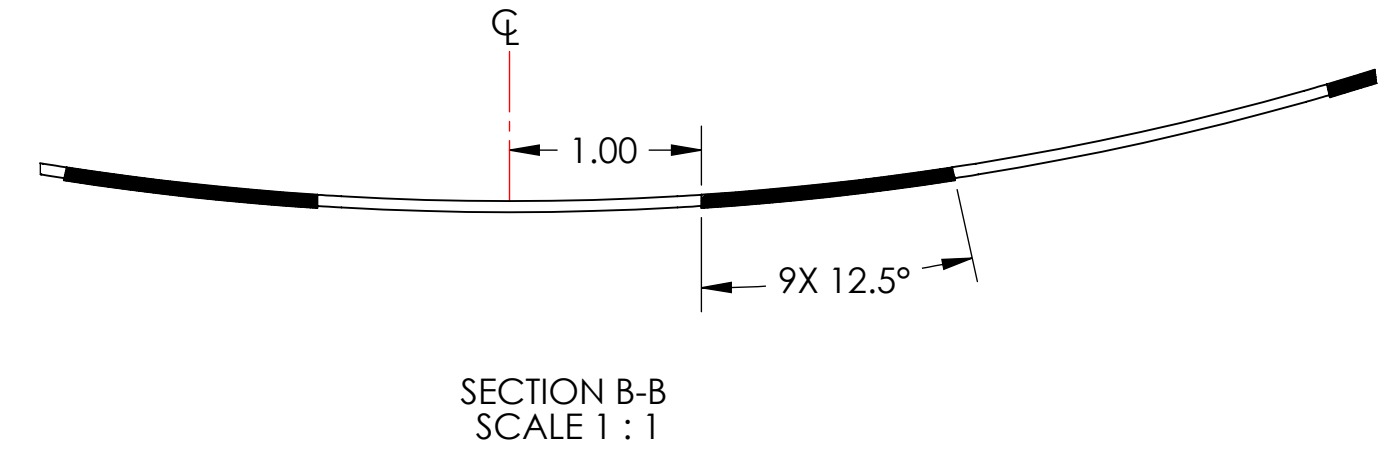
D0902620.dwg; Montfield_Coyne; Radial_Segment; Bottom; PART PDM REV: X-081; DRAWING PDM REV: X-010

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

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	1 SEP 2010	E1000360	E1000091
-	-	-	-
-	-	-	-



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

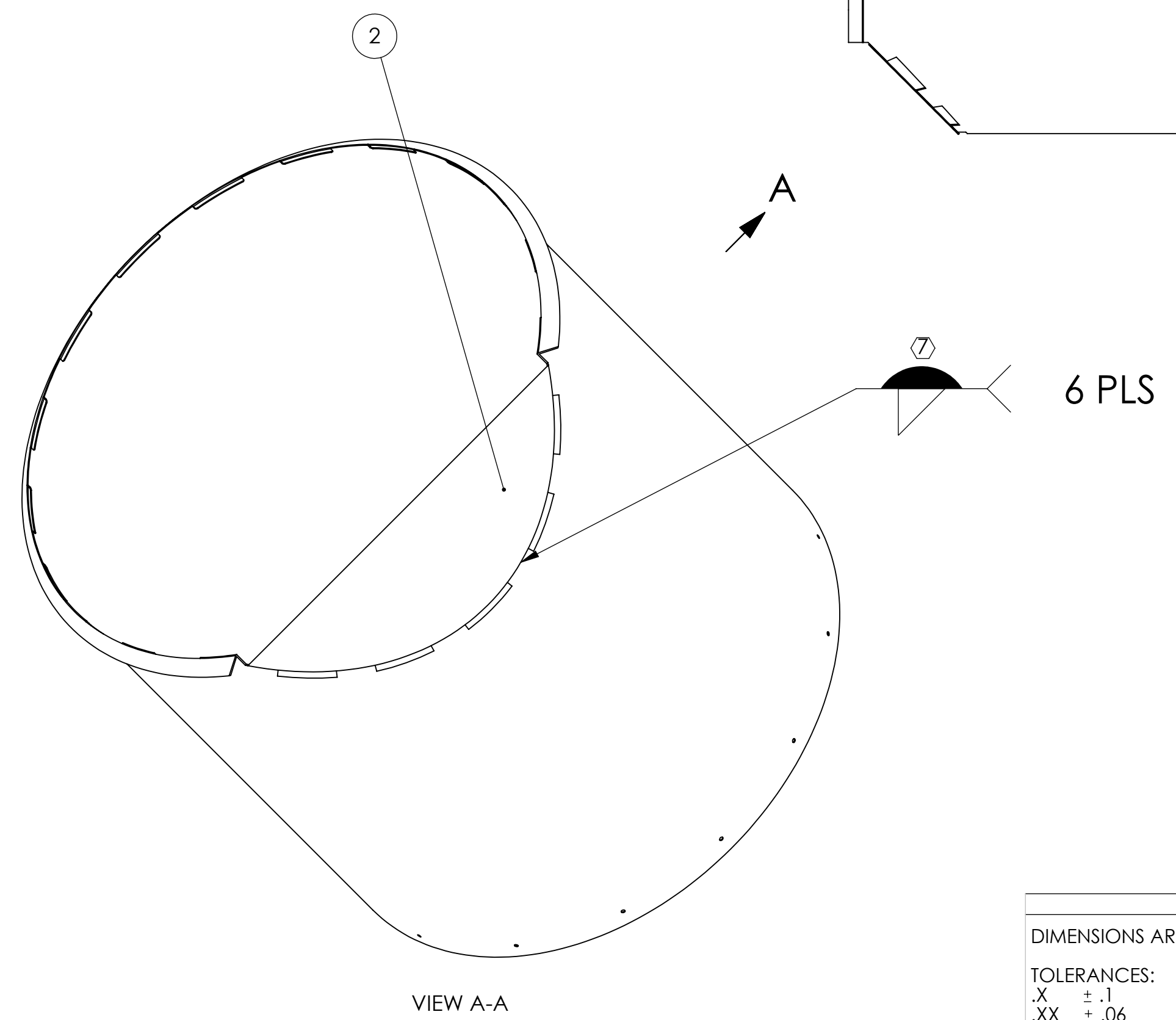
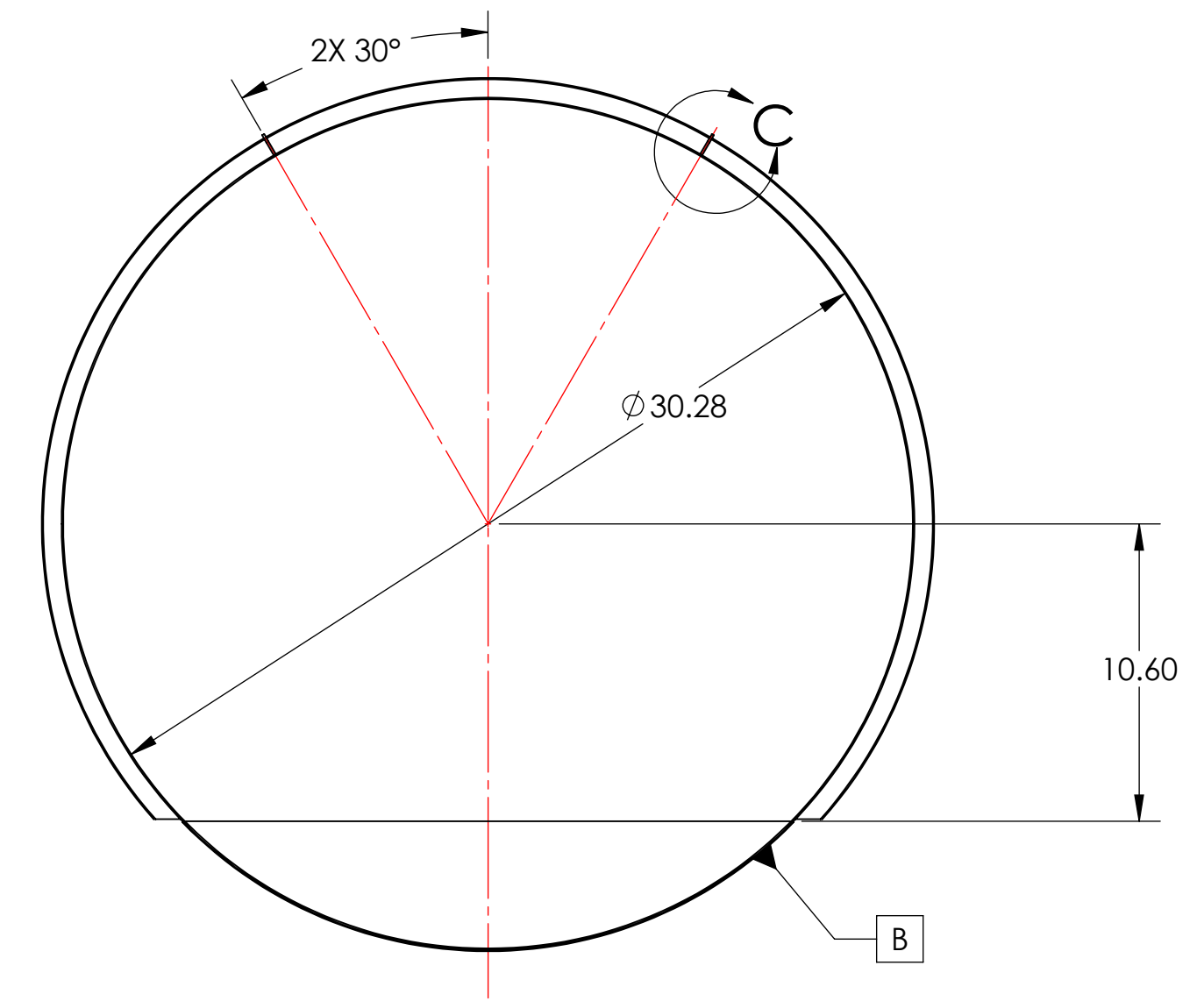
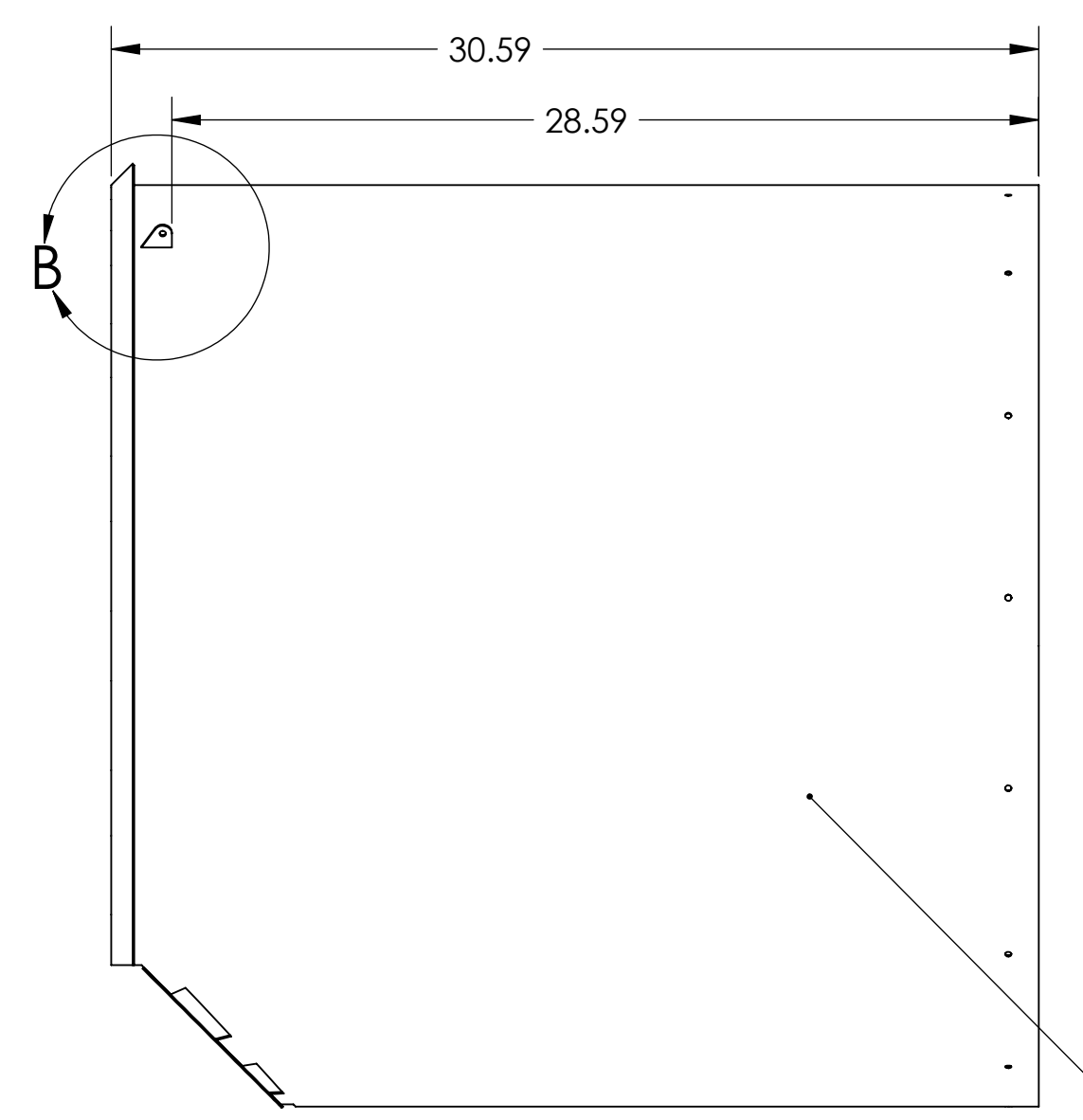
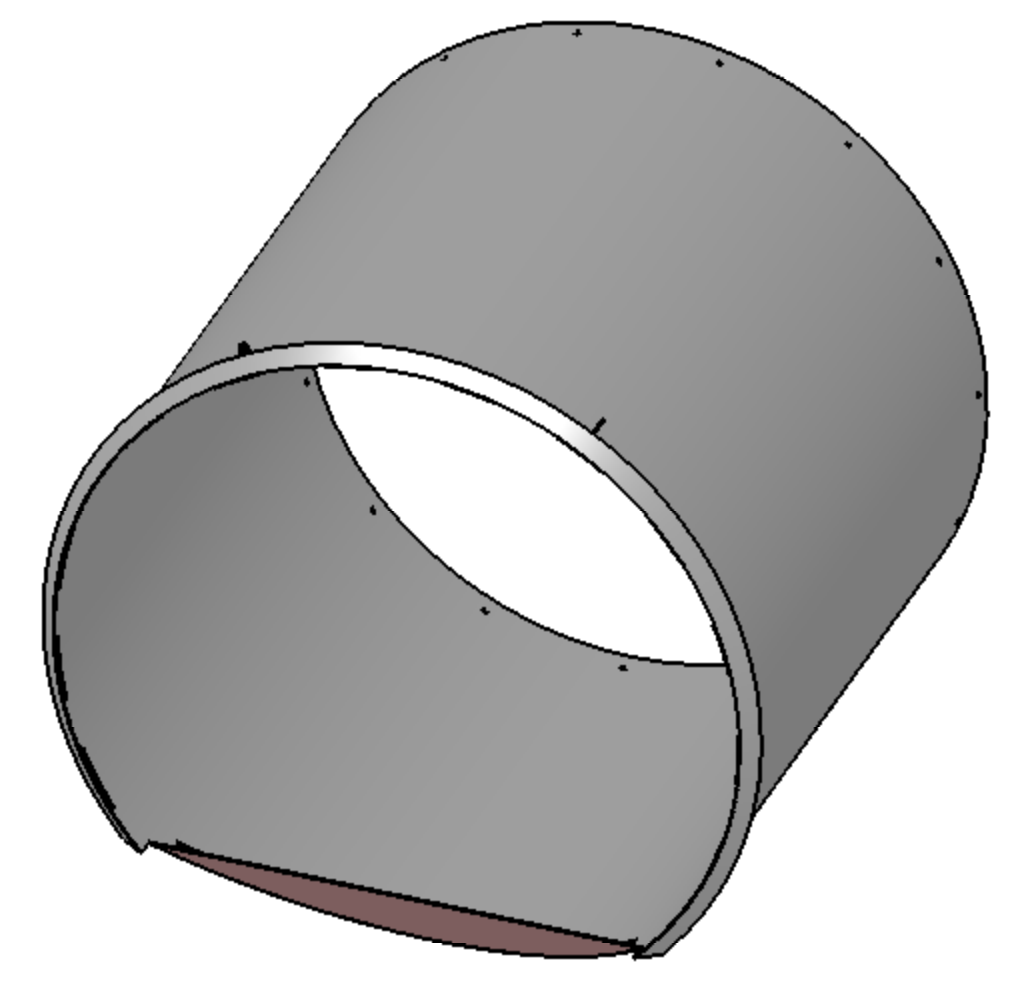
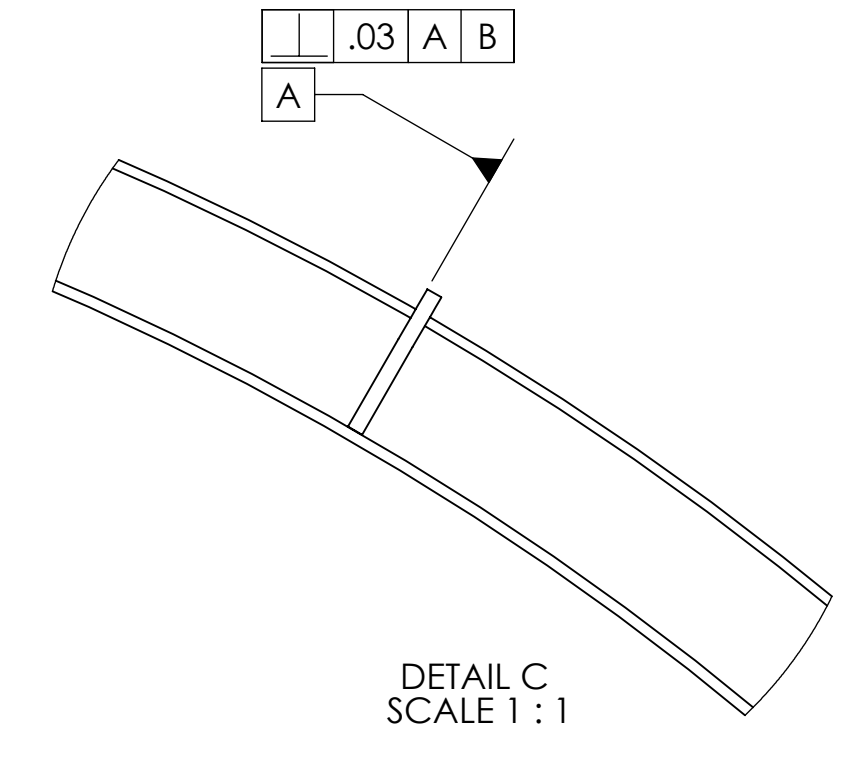
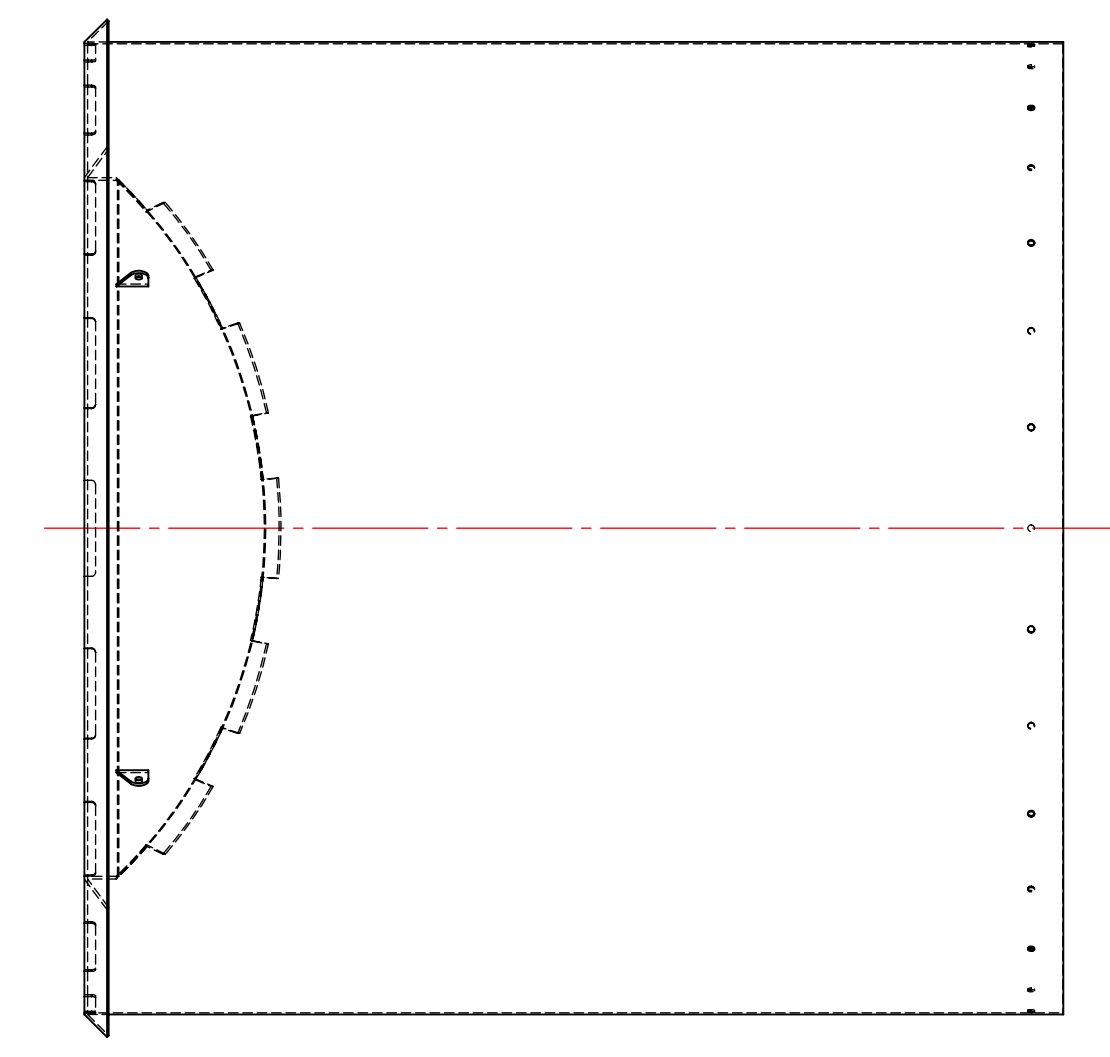
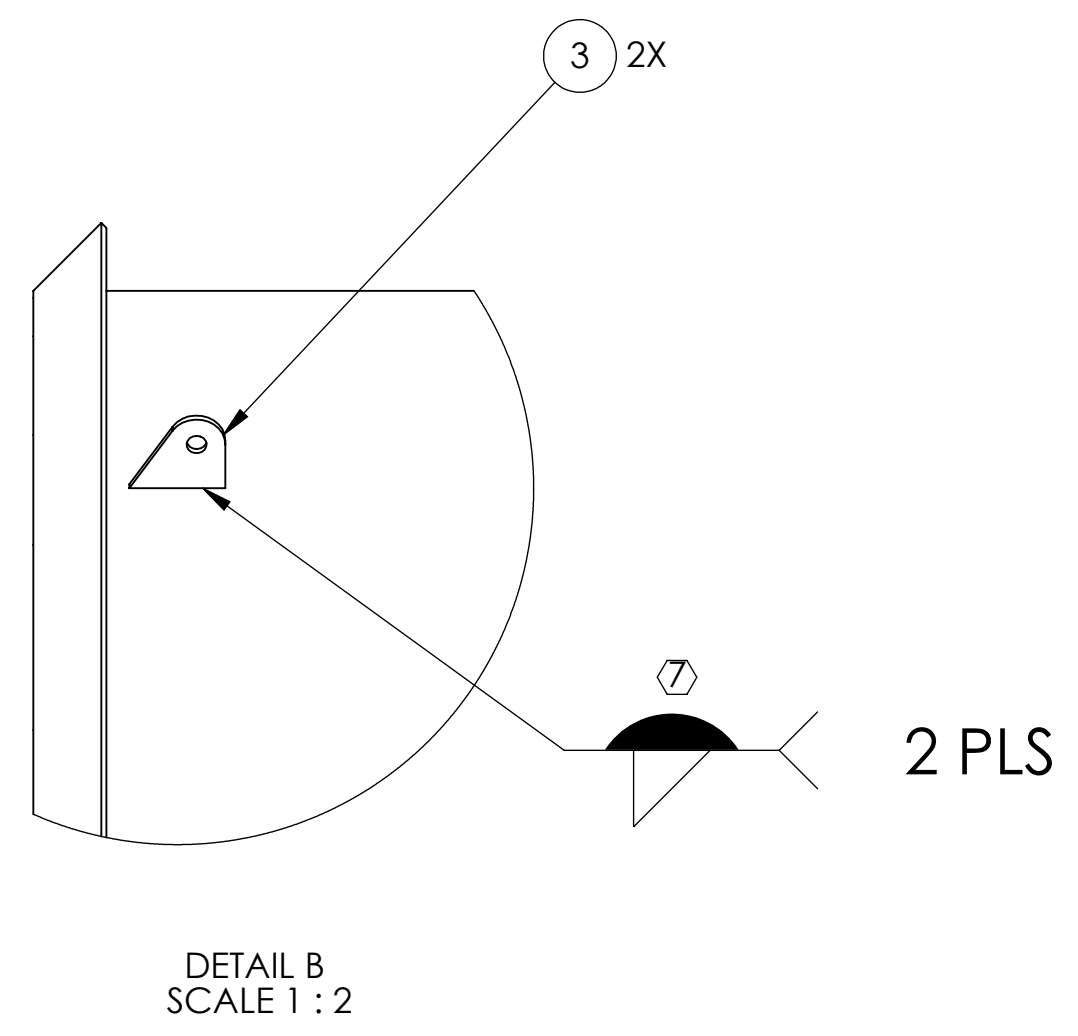
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM		MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, RIGHT	
ANGULAR ±0.5°		MATERIAL		SUB-SYSTEM		DESIGNER	
18GA A424 TYPE I STEEL		FINISH		AOS		H. KELMAN 12 MAY 2010	
		⑦		NEXT ASSY		DRAFTER	
				D0902654		TQ. NGUYEN 17 AUG 2010	
						CHECKER	
						M. SMITH	
						APPROVAL	
						D. COYNE	
						SIZE DWG. NO.	
						D D0902619	
						REV.	
						v1	
						SCALE: 1:8 PROJECTION:	
						SHEET 1 OF 1	

D:\0902619\alUGO_Monfield_Cryo_Baffle_Inner_Segment\ITMX_H1-H2_RIGHT_PART_PDM\REV-X-019_DRAWING_PDM\REV-X-019

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

6. ASSEMBLY WILL BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED.
 7. FILLET WELD WHERE ITEMS 1 & 3 AND 1 & 2 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E 0900048

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	E1000367
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
3	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	2		2
2	D1001018	ELLIPSE SCRAPER BLADE	14GA A424 TYPE I STEEL	1		1
1	D1000570	MANIFOLD-CRYO BAFFLE CYLINDER	18GA A424 TYPE I STEEL	1		1

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 1.0°		MATERIAL N/A		FINISH N/A		PART NAME MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY	
				NEXT ASSY D1002061		DESIGNER H. KELMAN 25 MAY 2010 DRAFTER TQ. NGUYEN 07 SEP 2010 CHECKER M. SMITH APPROVAL D. COYNE	
						SIZE DWG. NO. D D1001348	
						SCALE: 1:6 PROJECTION: SHEET 1 OF 1	

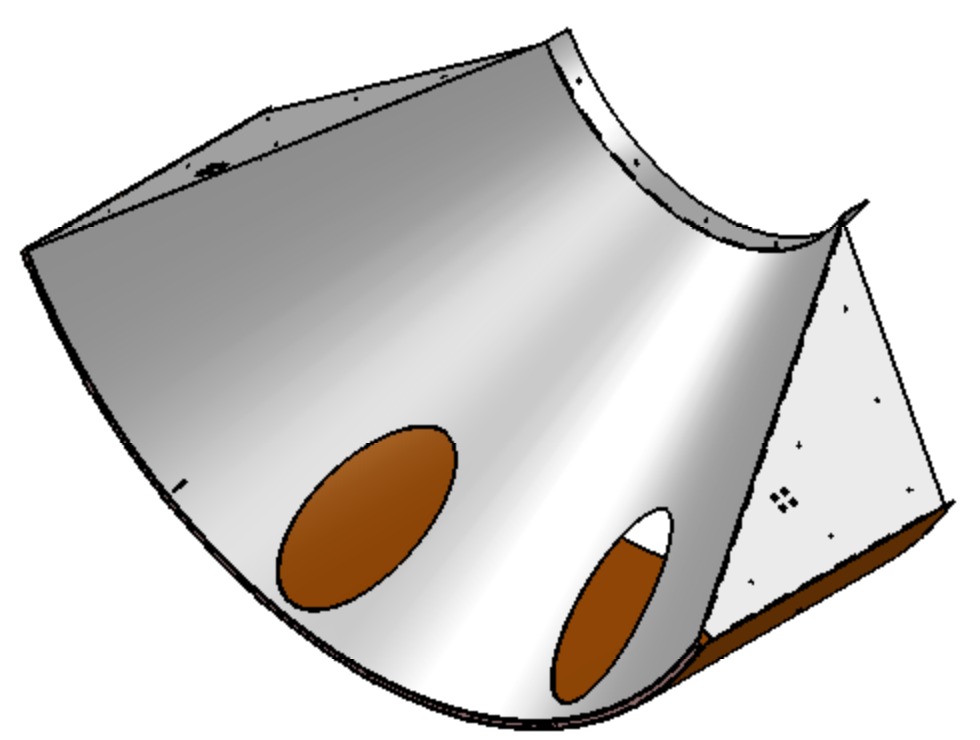
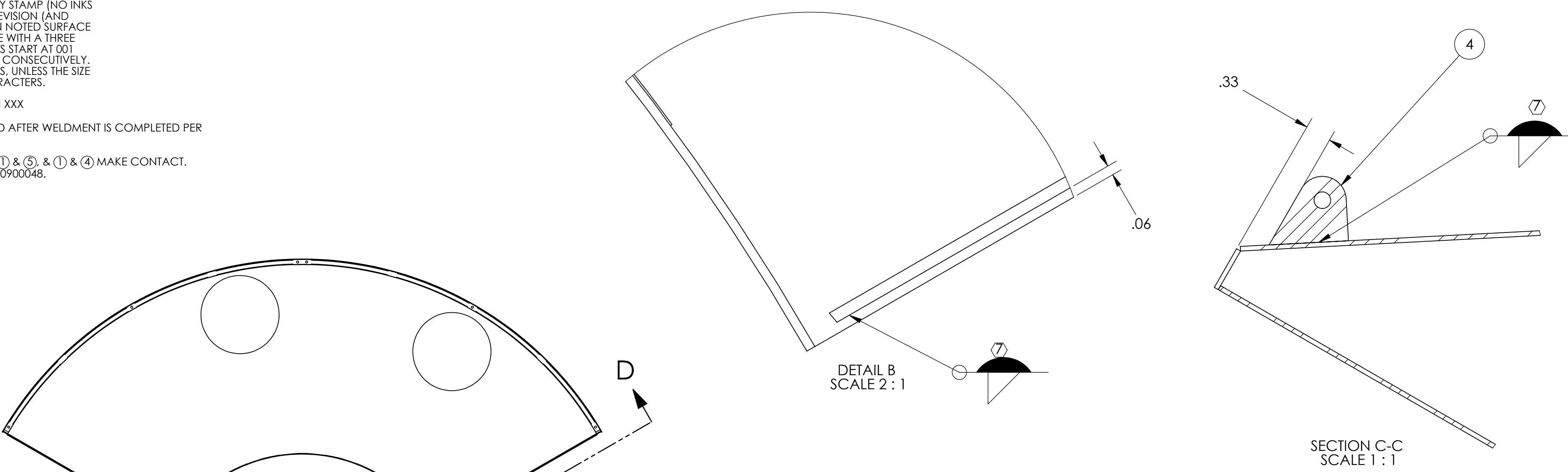
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REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

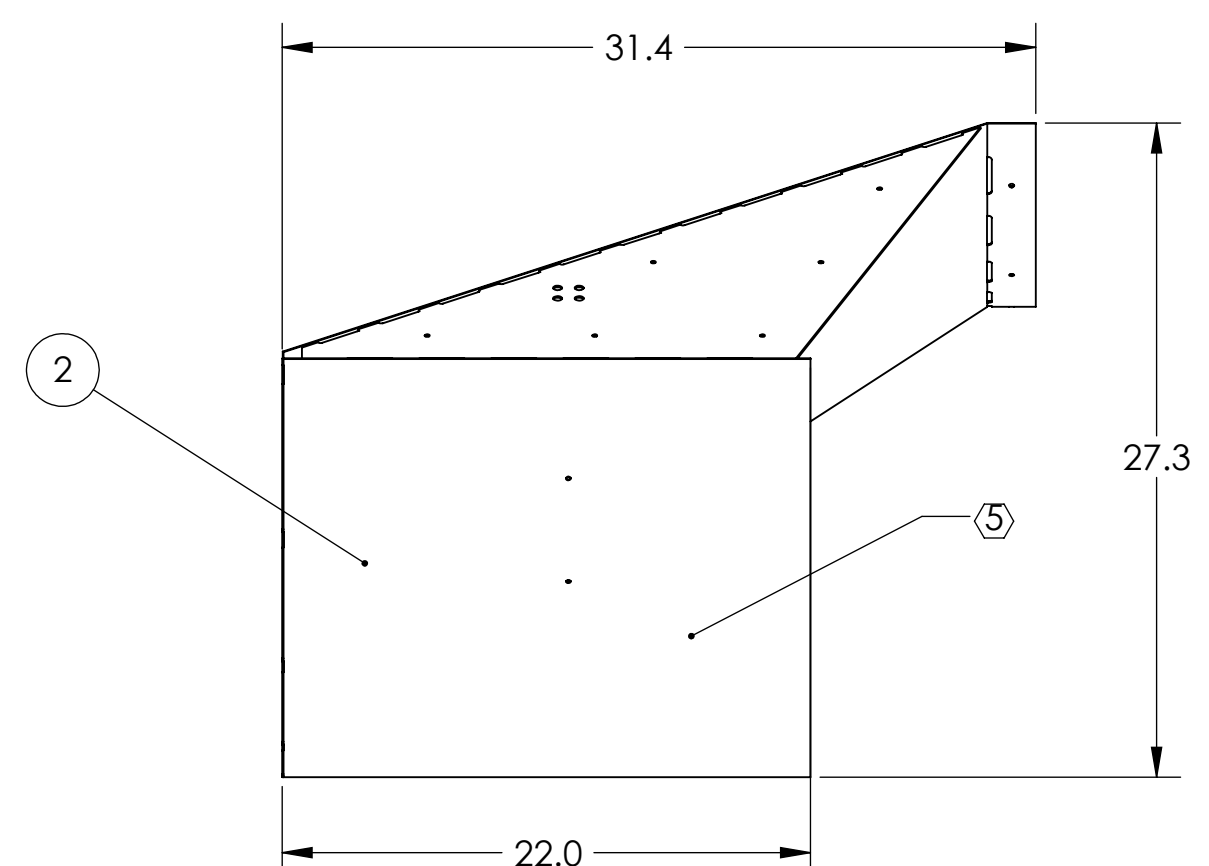
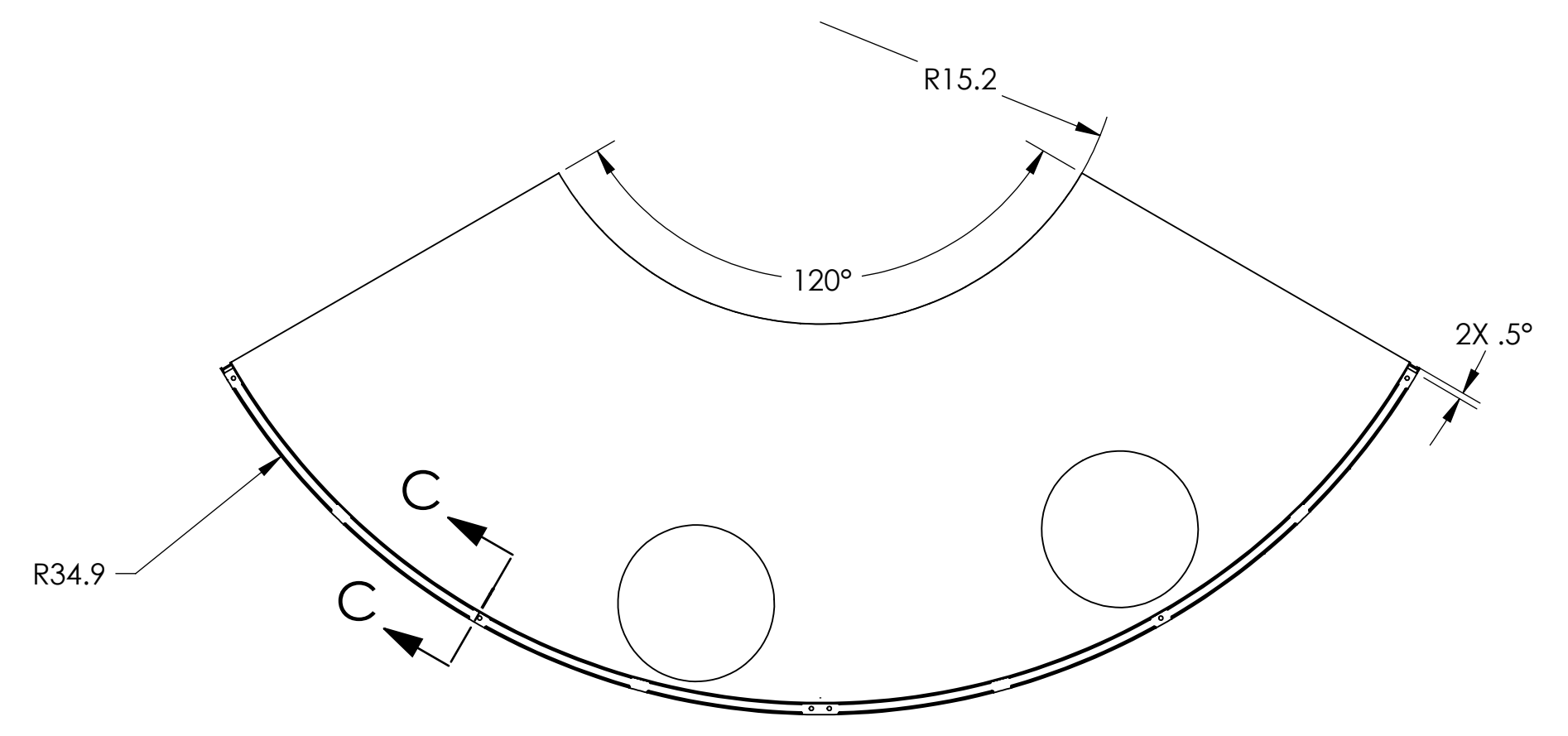
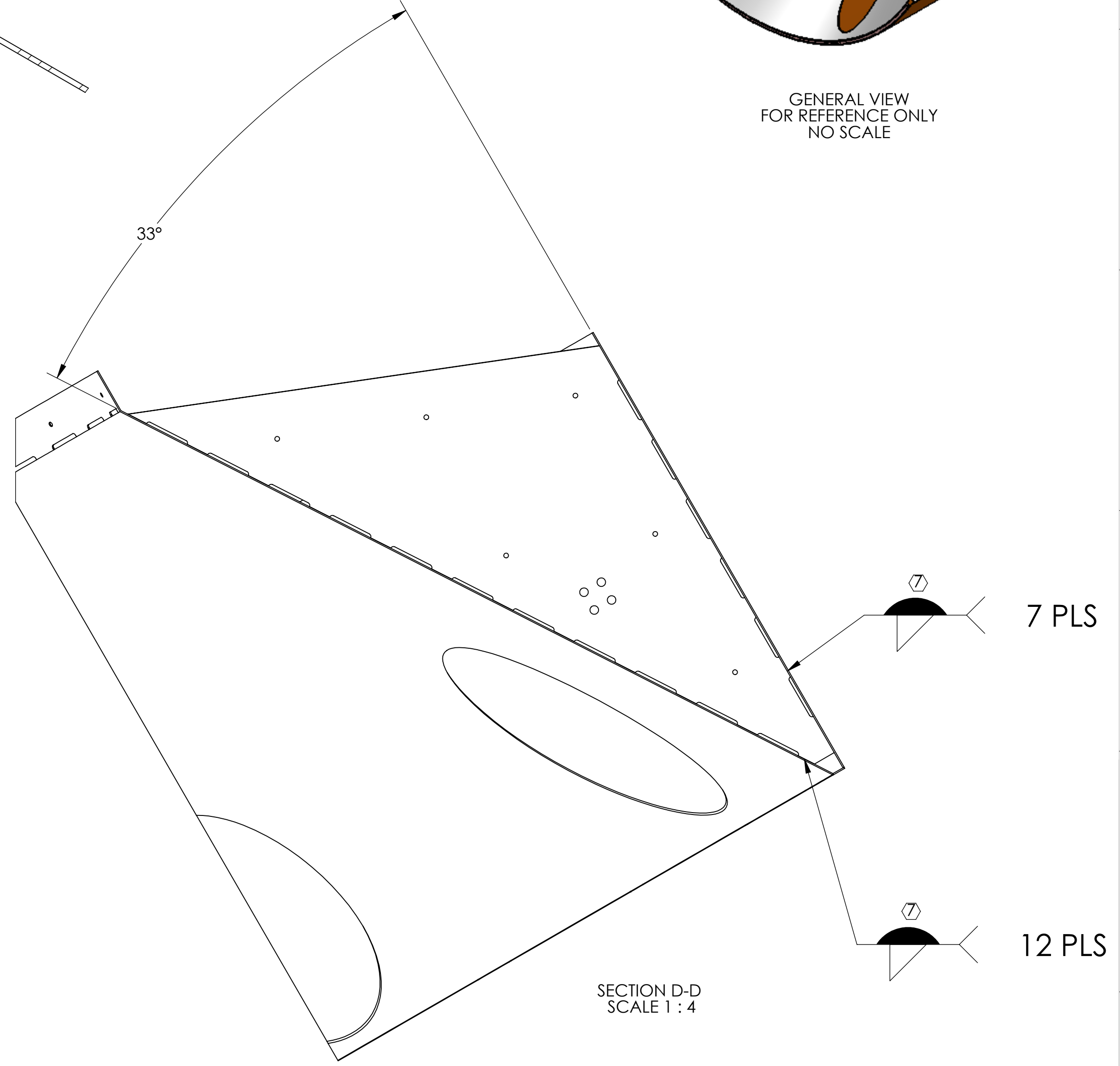
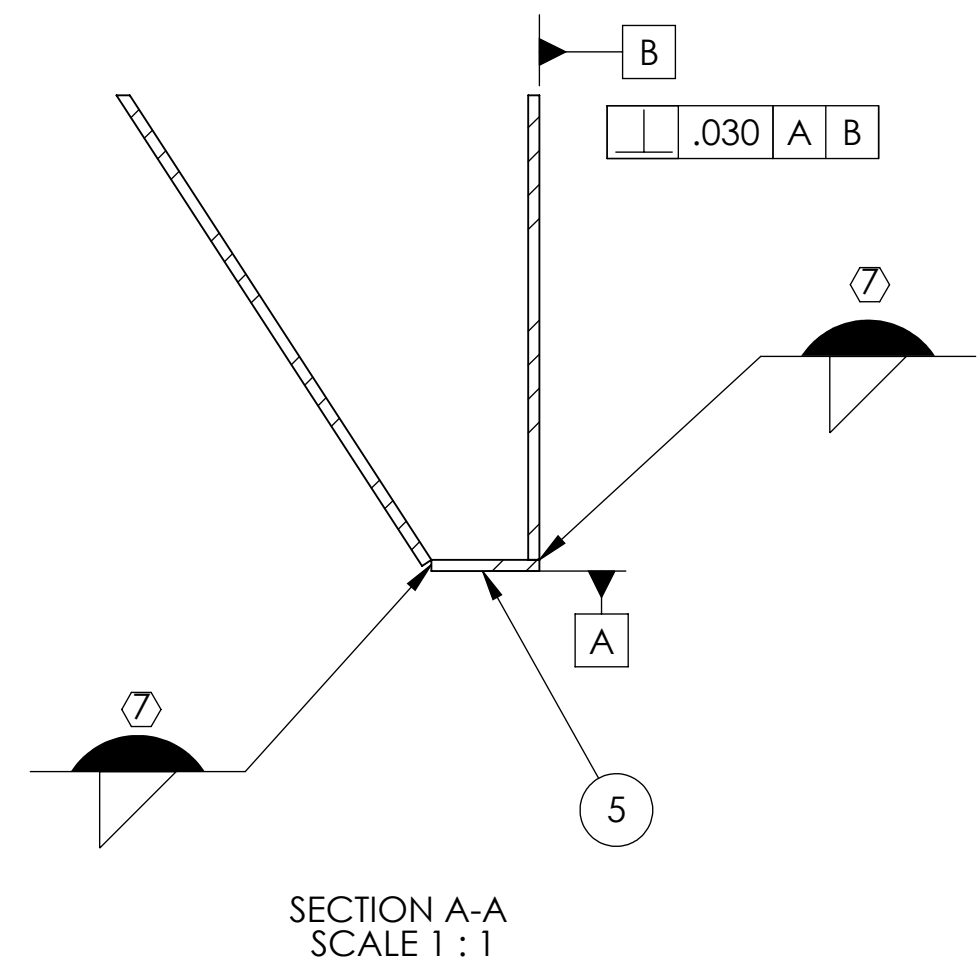
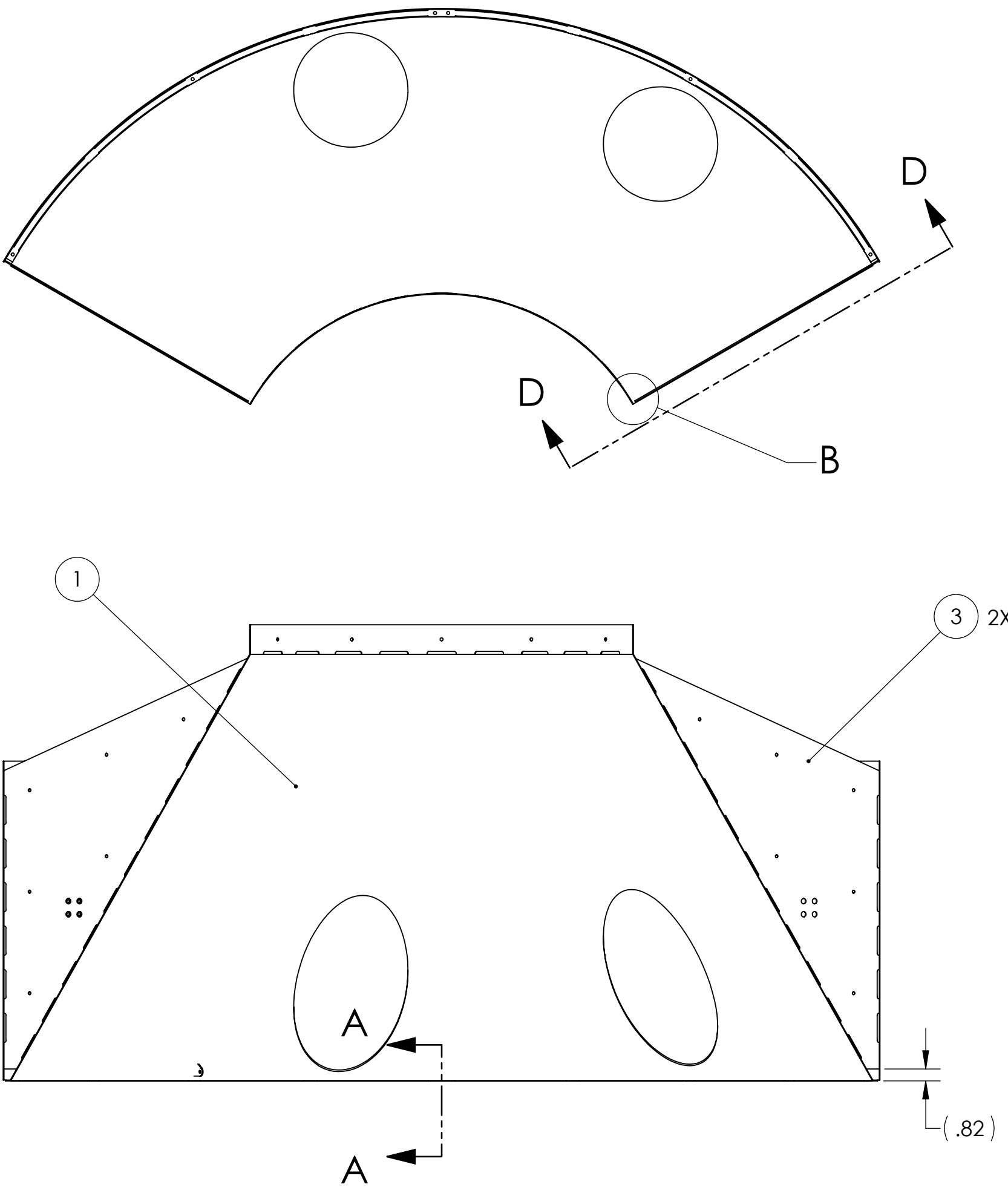
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, & 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
5	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
4	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	1		1
3	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		2
2	D1000558	RADIAL SEGMENT, LEFT	18GA A424 TYPE I STEEL	1		1
1	D0902622	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT	18GA A424 TYPE I STEEL	1		1

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

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.	
MATERIAL	N/A
FINISH	N/A
ANGULAR	± 1.0°

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

PART NAME: MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, LEFT

DESIGNER: H. KELMAN DATE: 20 MAY 2010 SIZE: D DWG. NO.: D0902656 REV.: v1

DRAFTER: TQ. NGUYEN DATE: 07 SEP 2010

CHECKER: M. SMITH

APPROVAL: D. COYNE

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

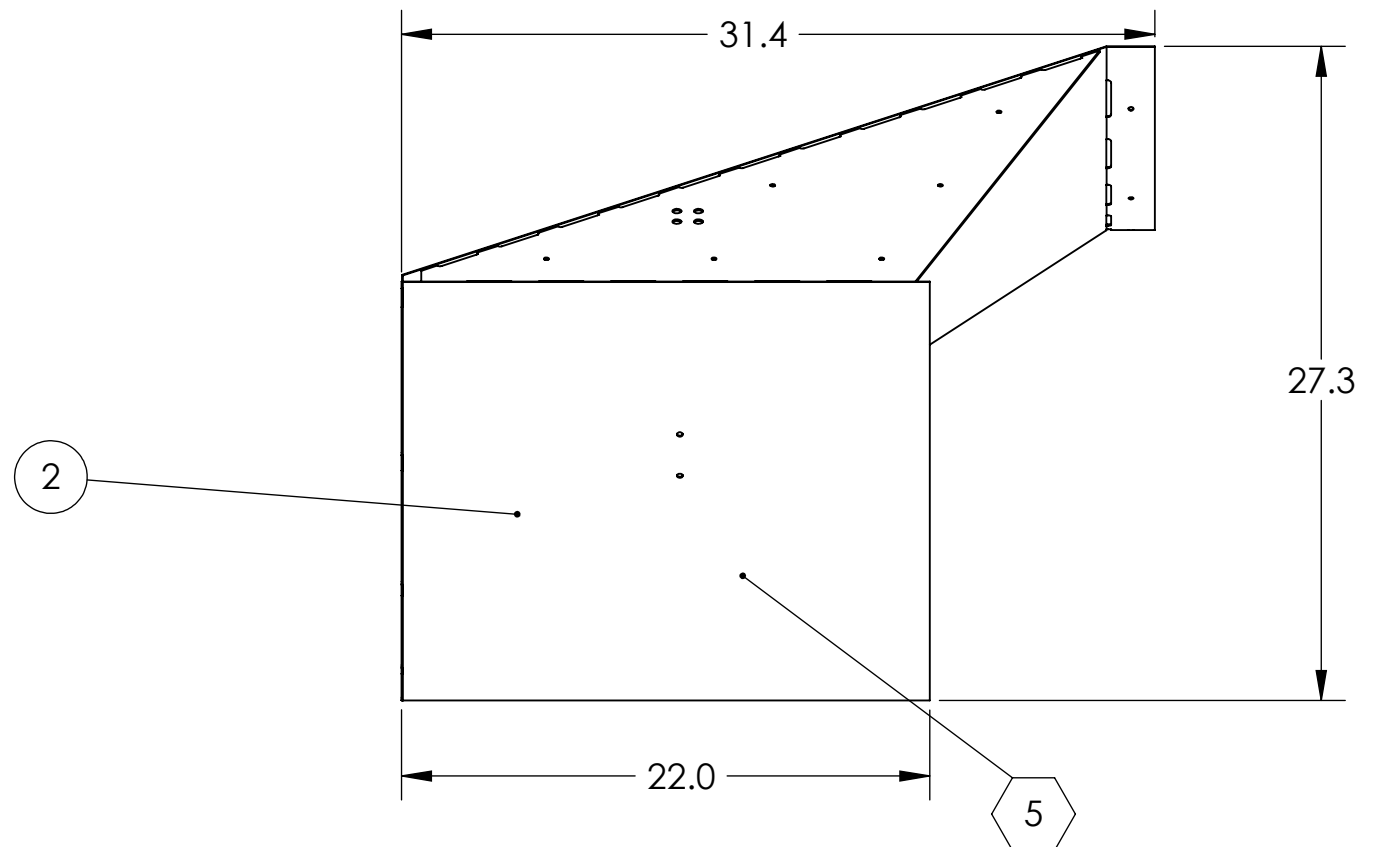
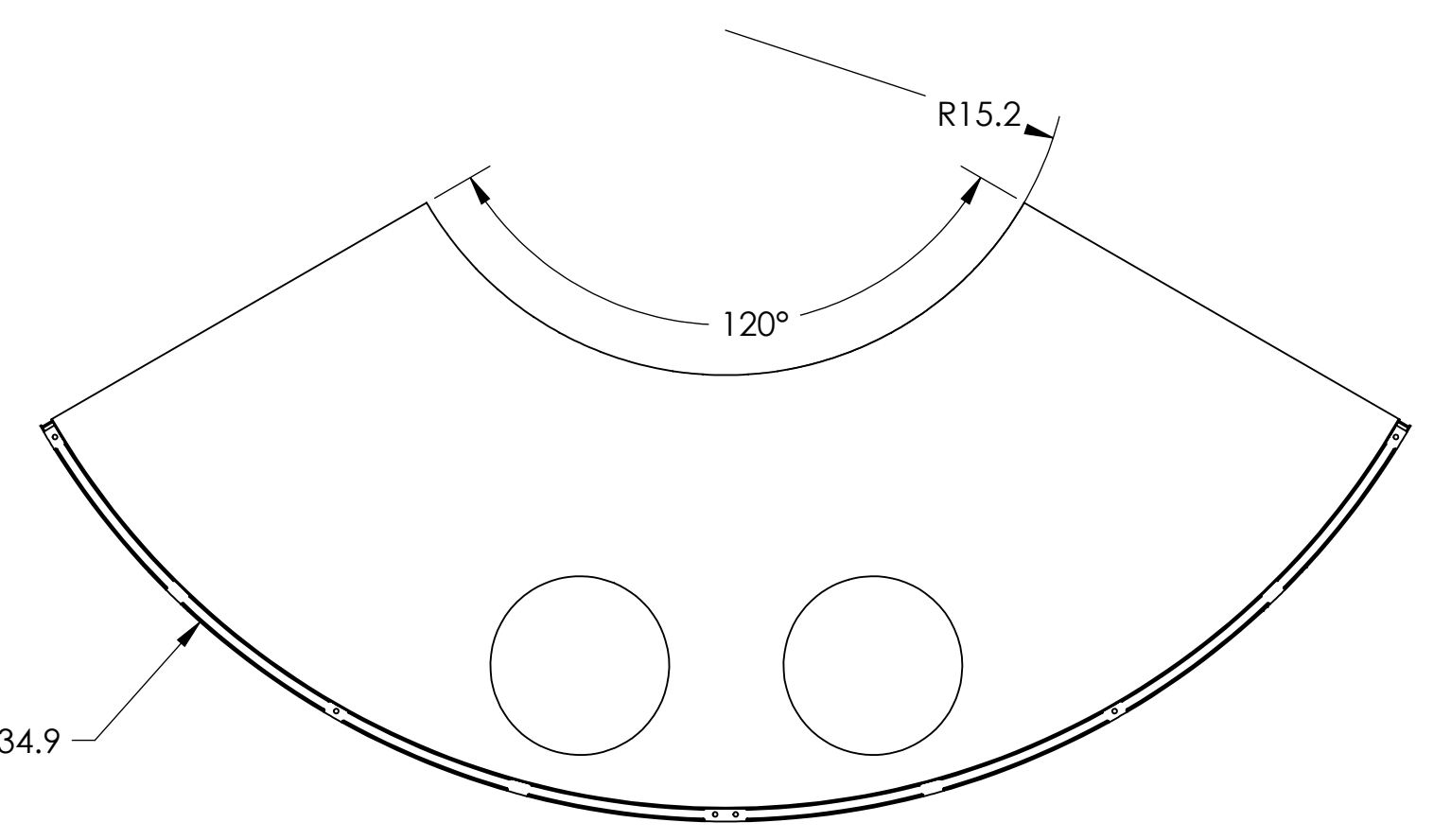
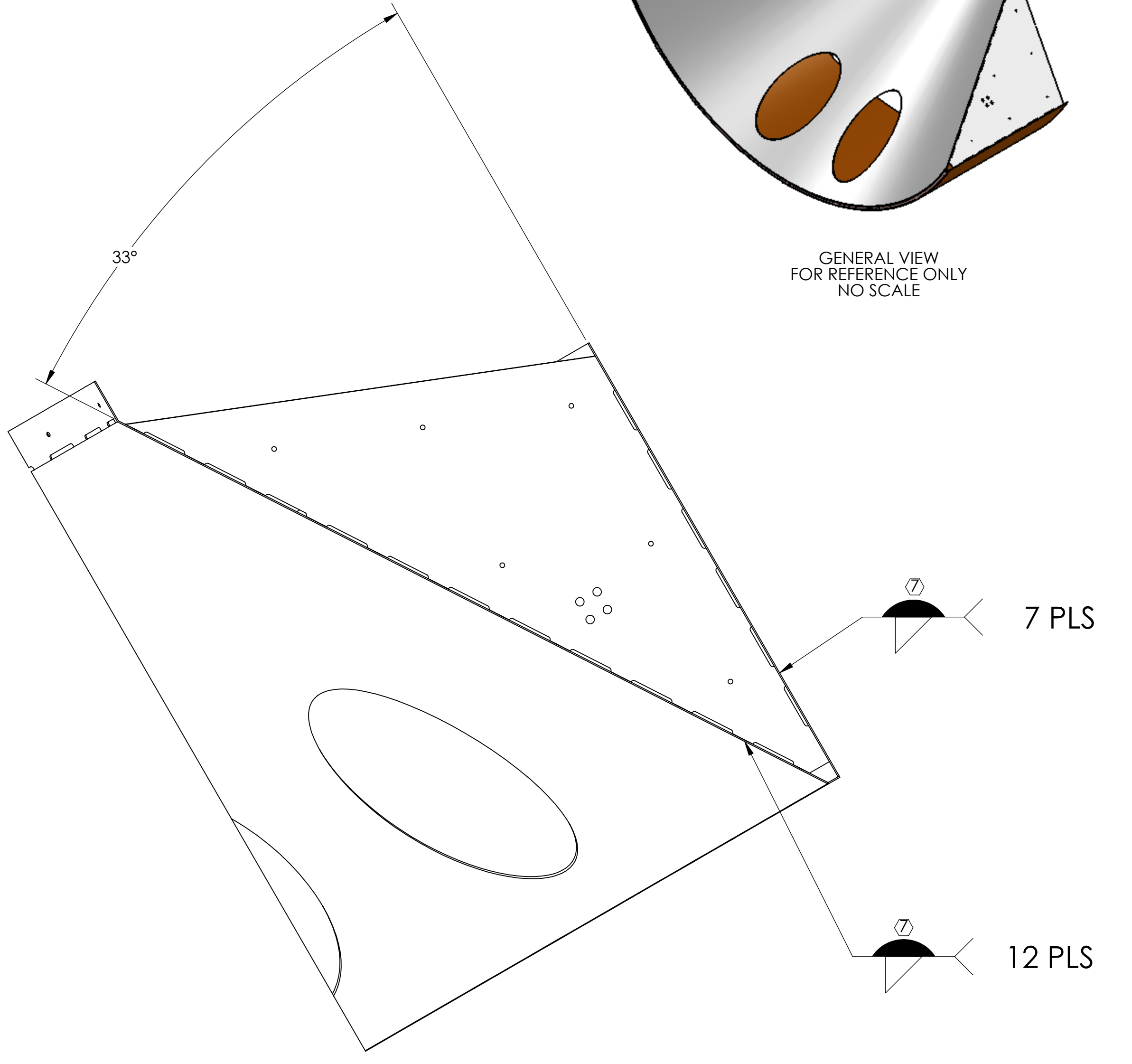
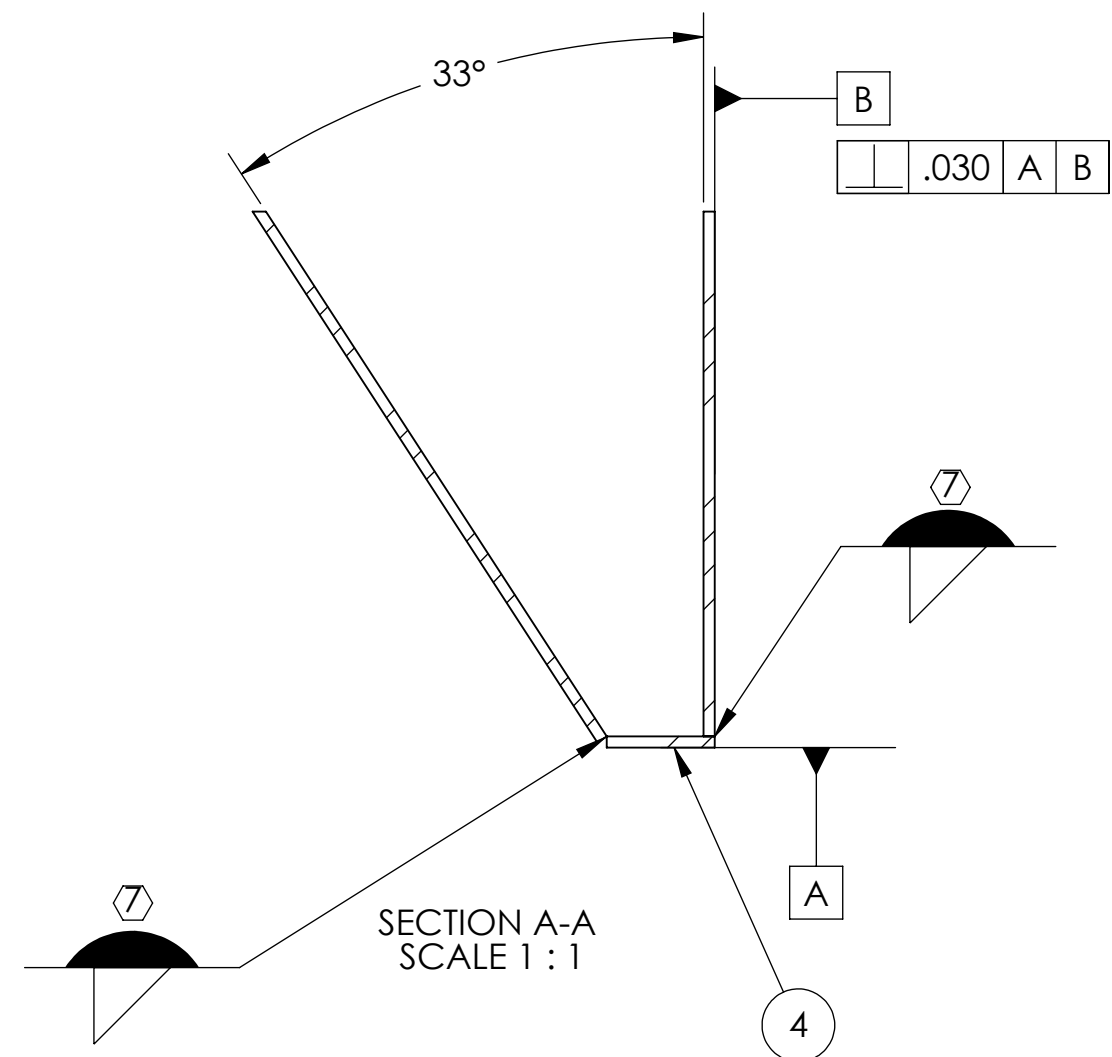
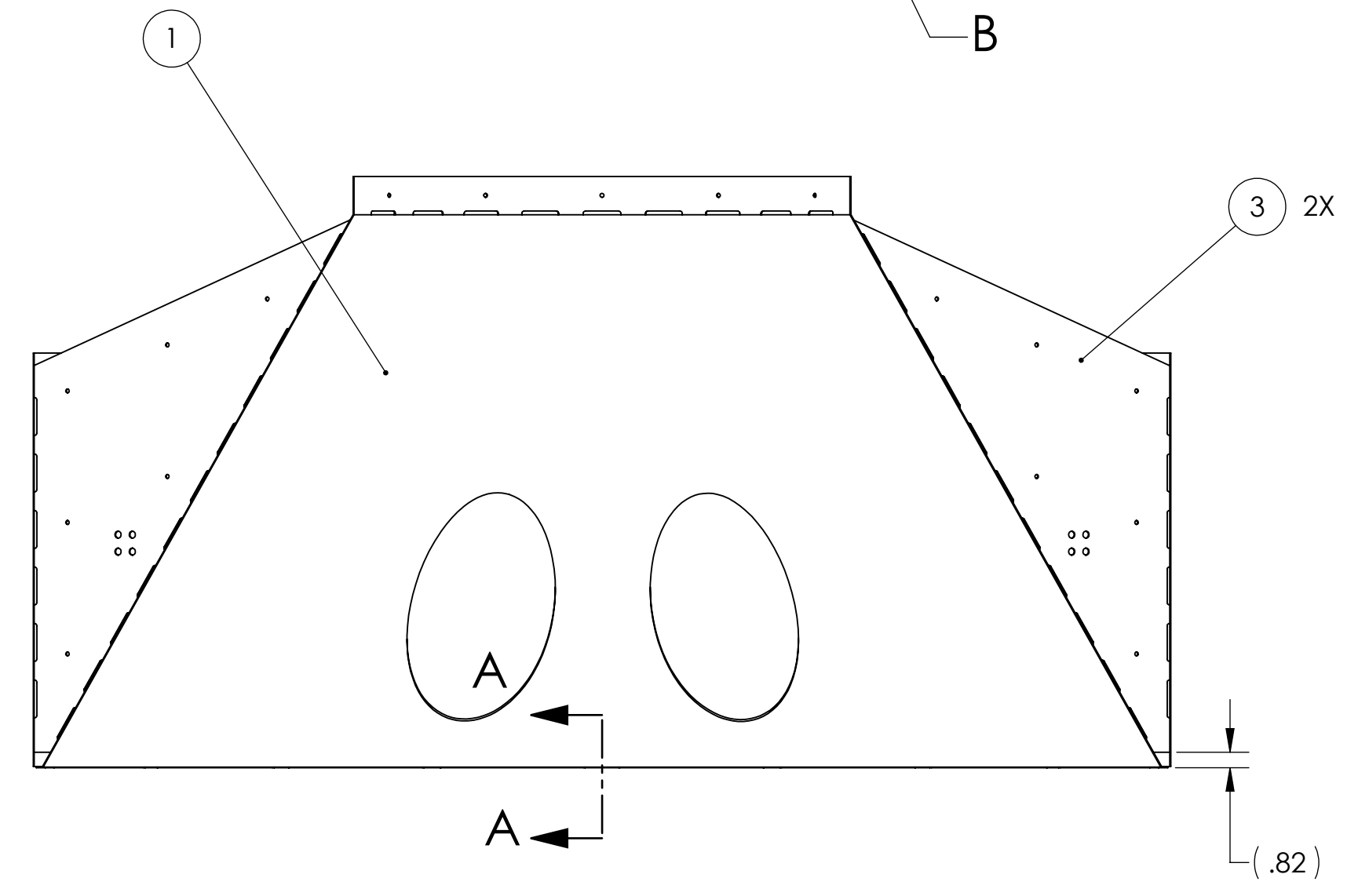
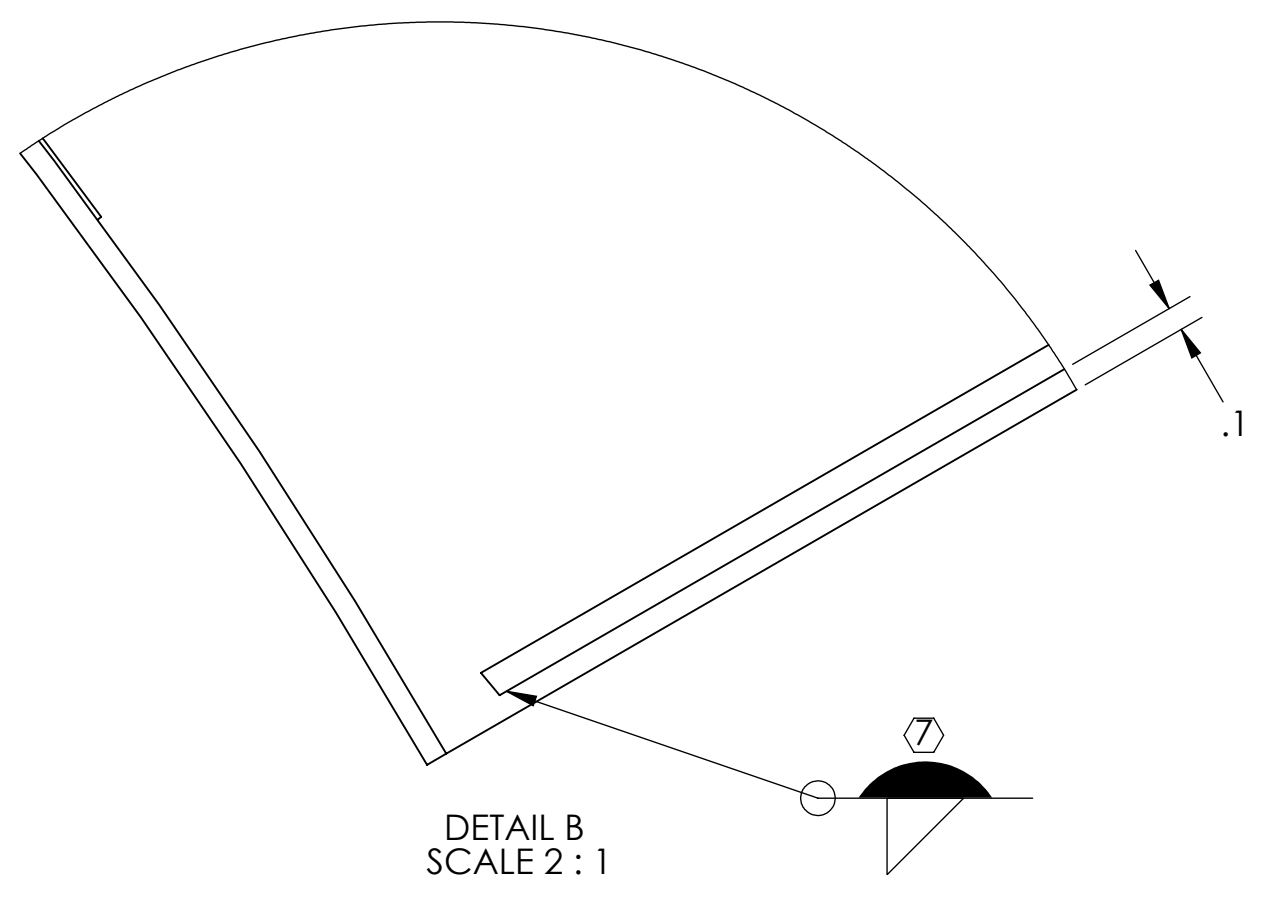
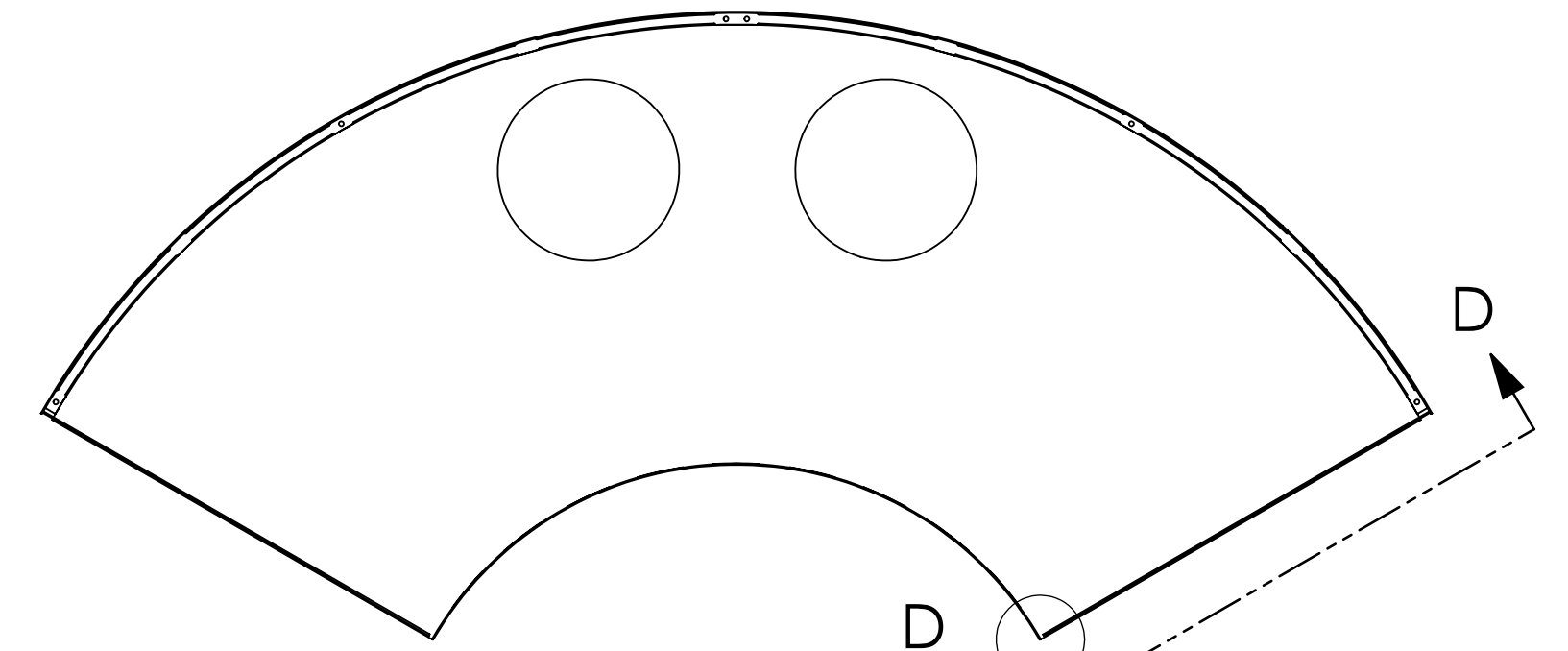
D0902654.dwg; Manifold_Cryo_Baffle_Segment_Subassembly_Weldment; ITMX H1-H2; Left; PART PDM REV: X.032; DRAWING PDM REV: X.010

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000091
-	-	-	-
-	-	-	-

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

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

⑦ FILLET WELDS WHERE ITEMS ① & ③, ① & ⑤, & ① & ④ MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18GA A424 TYPE I STEEL	1		1
1	D0902623	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1-H2, BOTTOM	18GA A424 TYPE I STEEL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	FINISH
A424 TYPE I STEEL	N/A

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D0902061

PART NAME		MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, BOTTOM	
DESIGNER	H. KELMAN	17 MAR 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	003 SEP 2010	D
CHECKER	M. SMITH		D0902655
APPROVAL	D. COYNE		SCALE: 1:8 PROJECTION:
			SHEET 1 OF 1

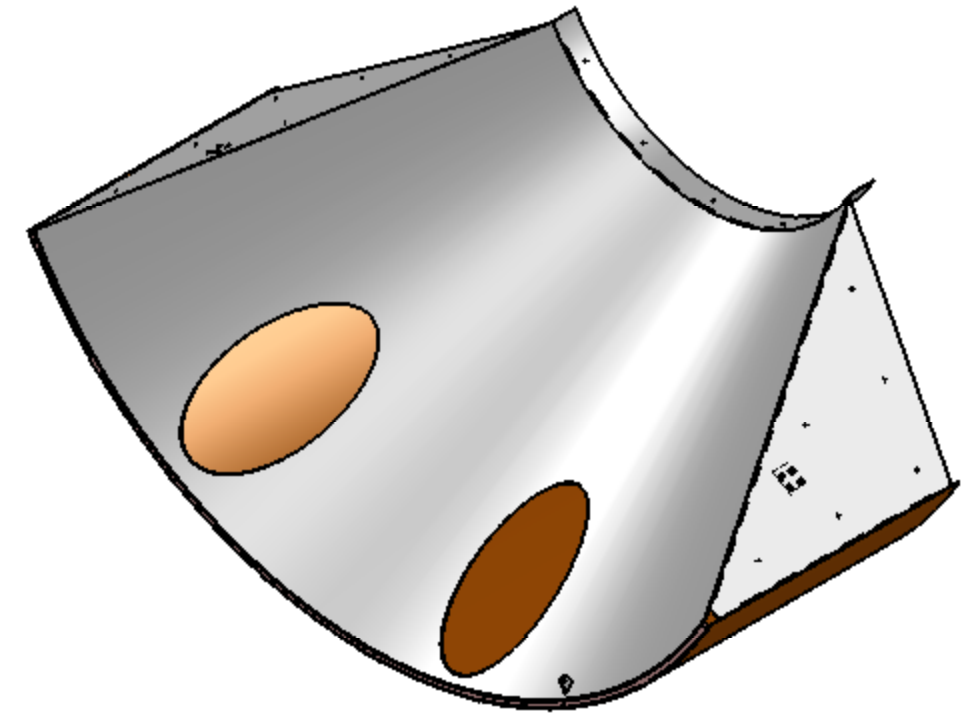
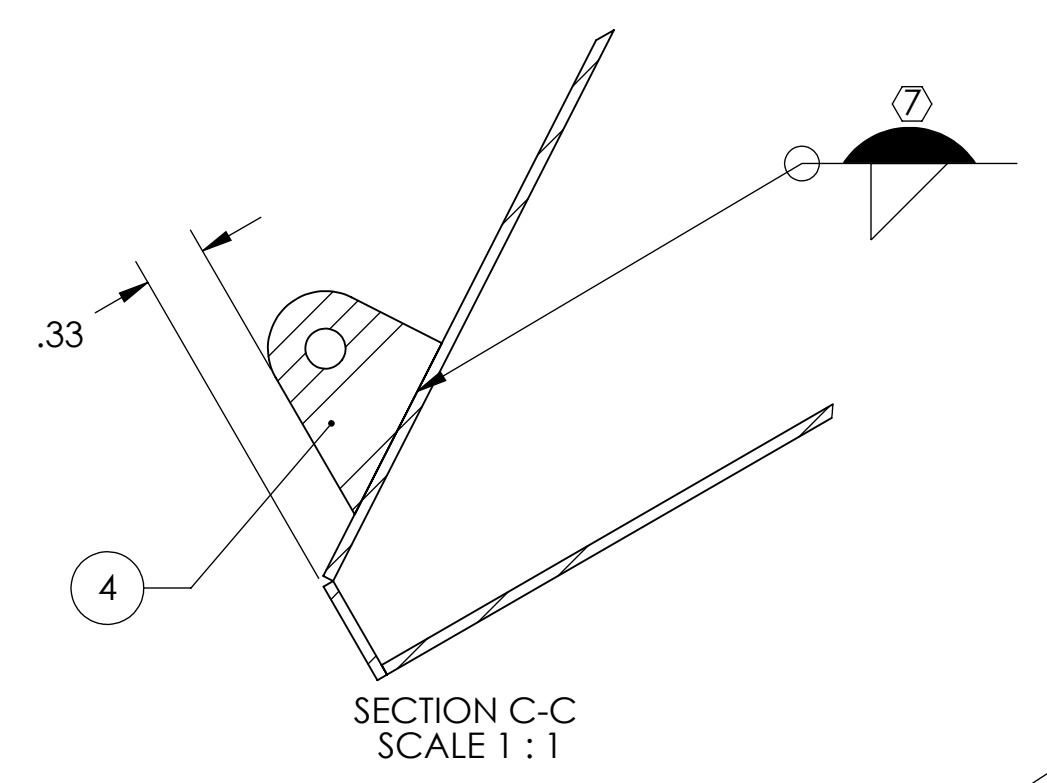
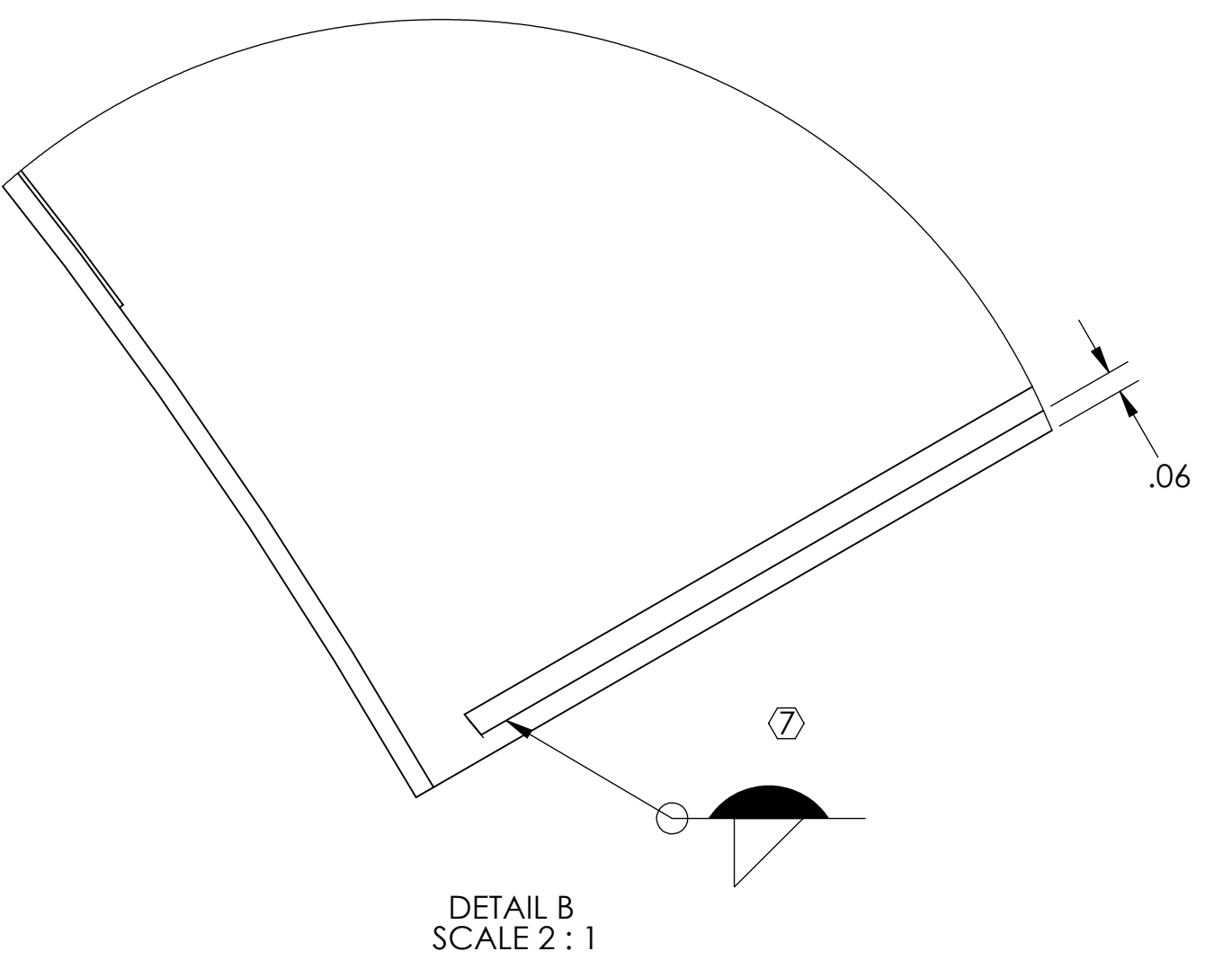
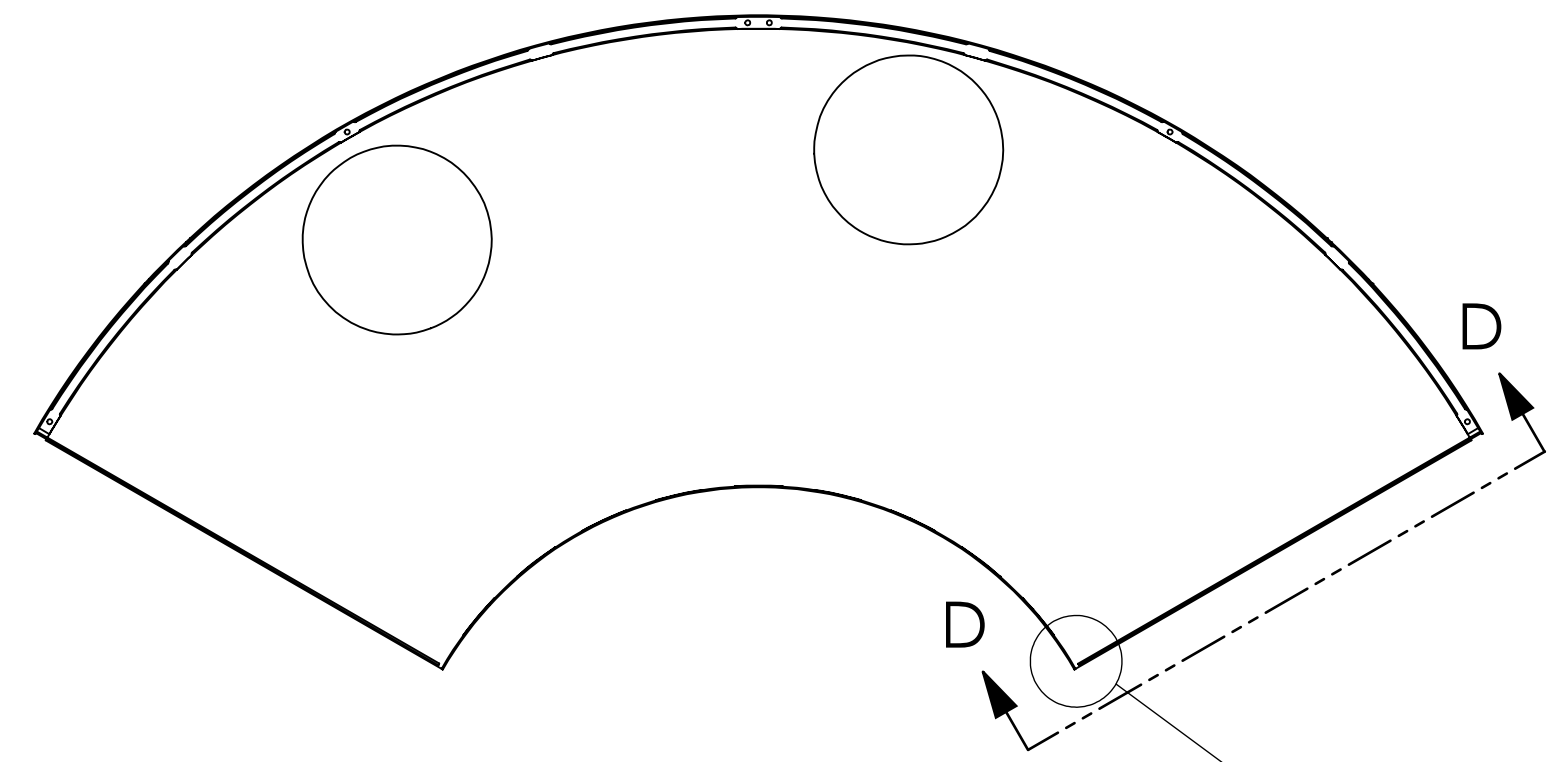
D0902655 at LIGO_Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ITMX_H1-H2_Bottom_PRT_PDM_REV_X033_DRAWING_PDM_REV_X012

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

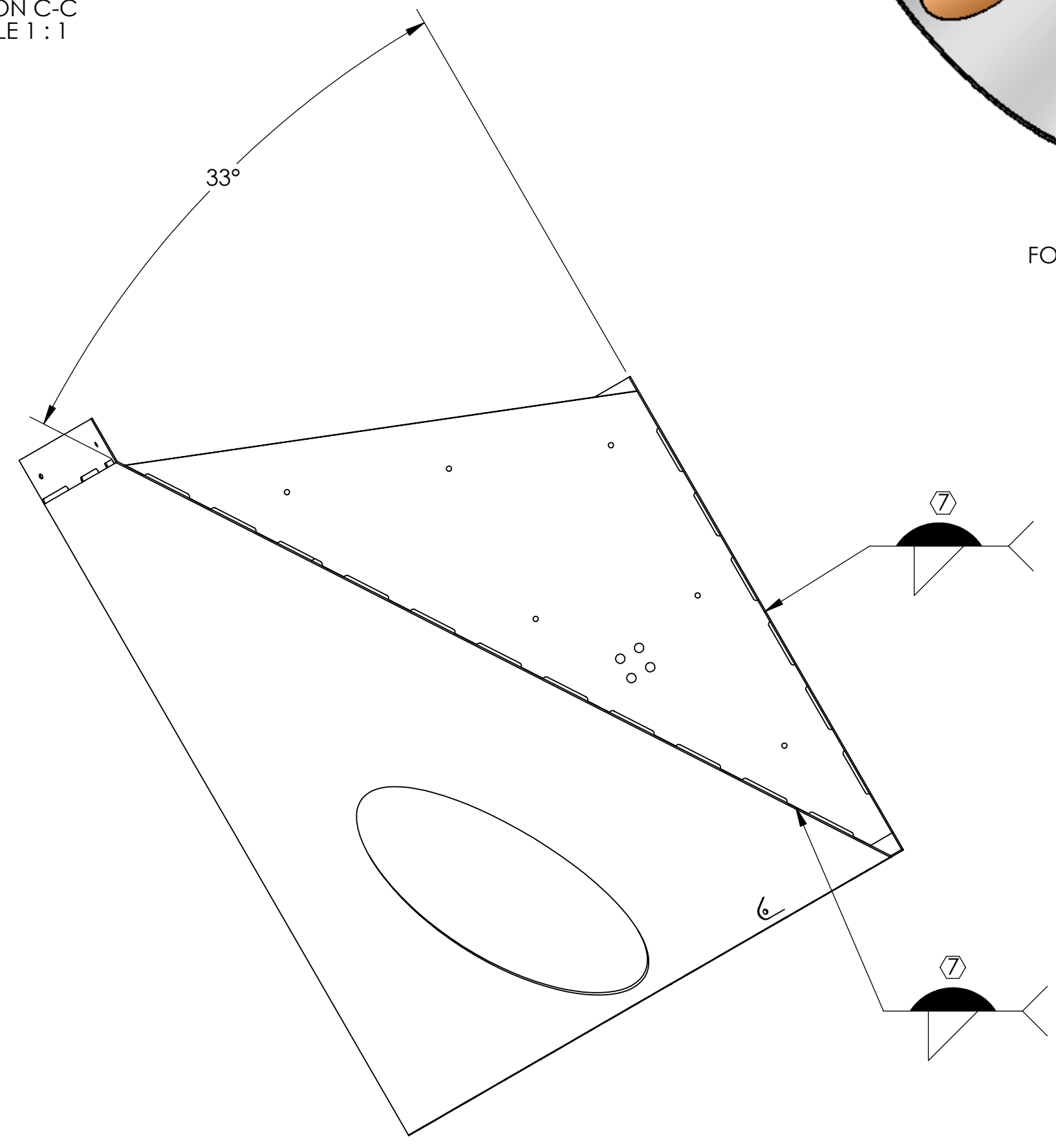
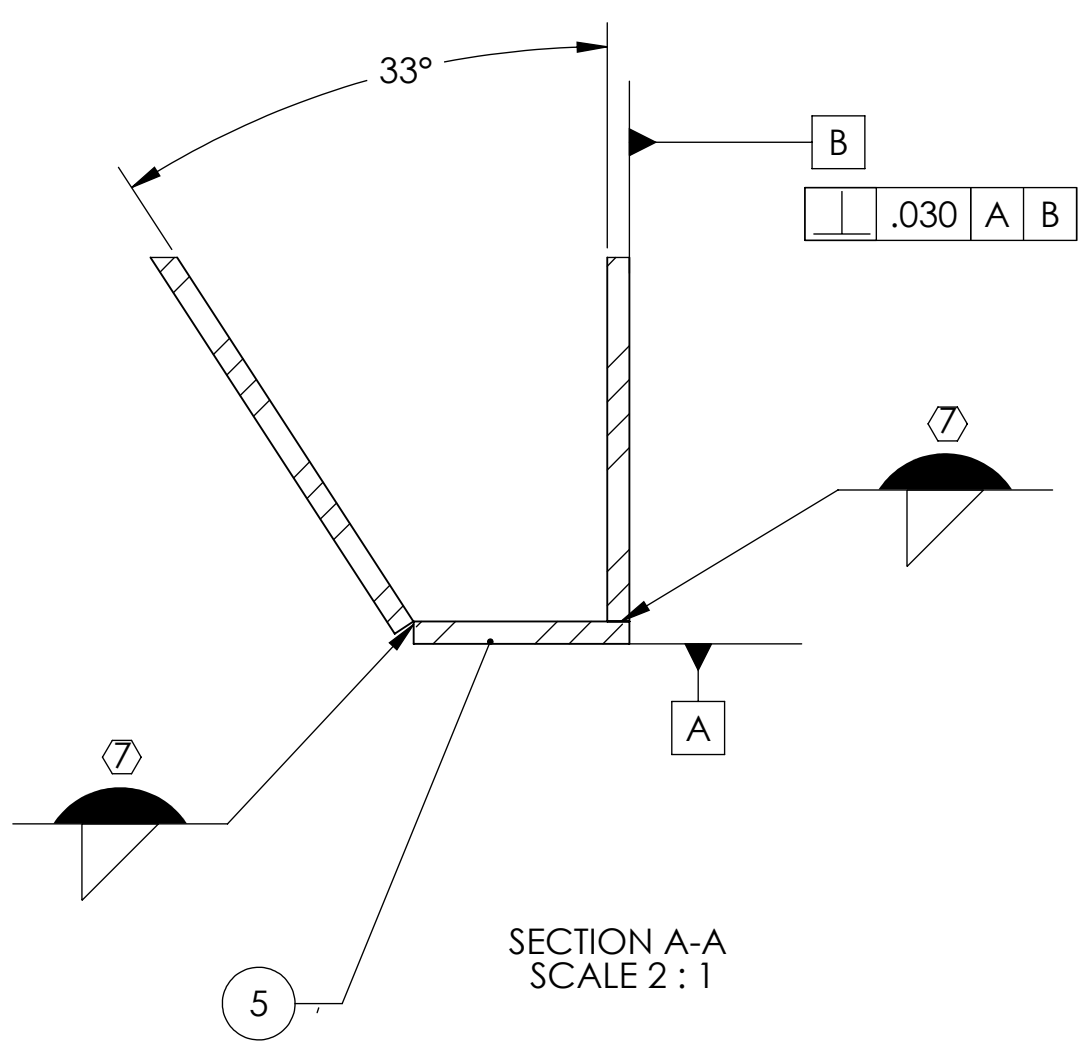
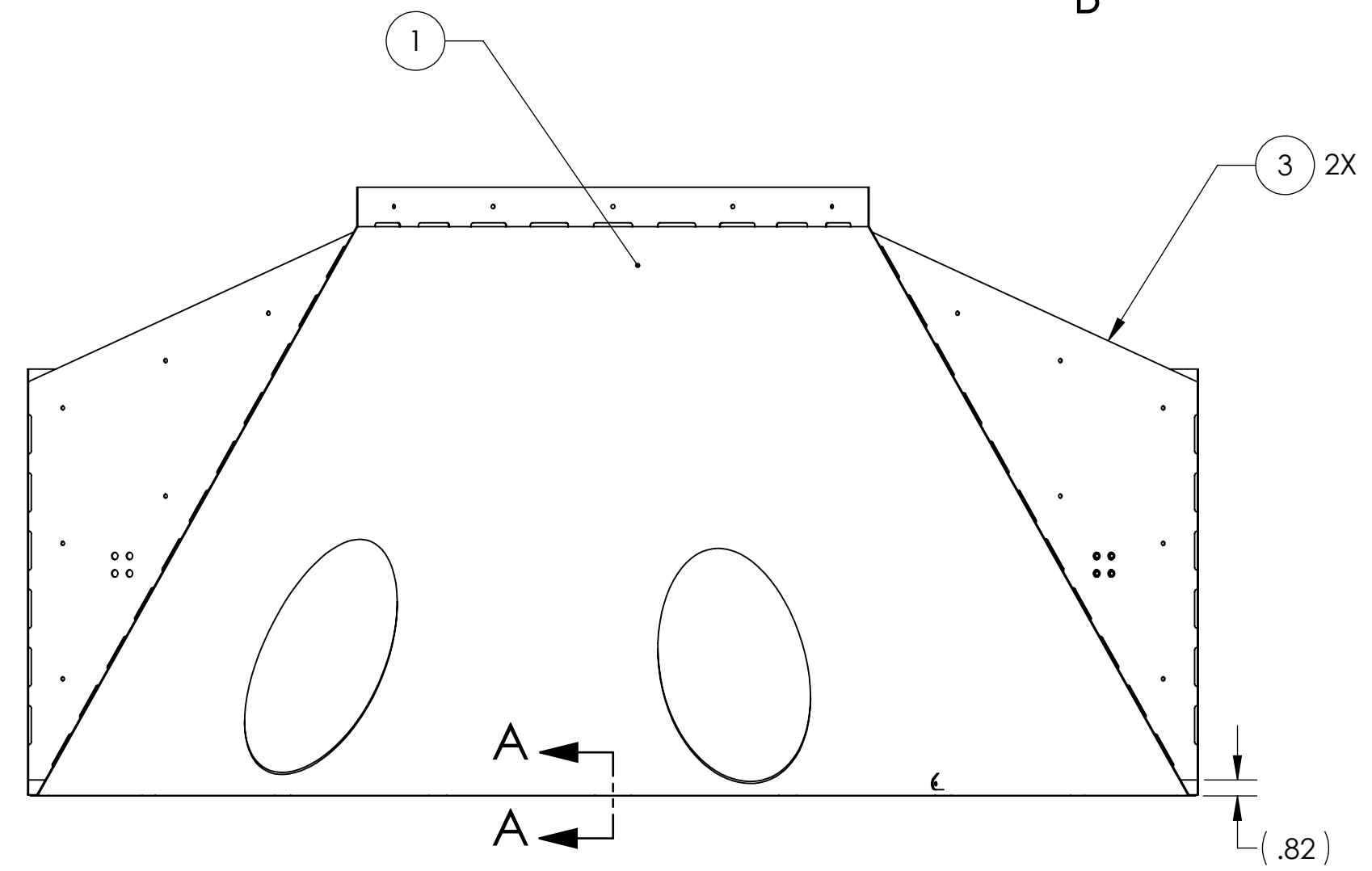
6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

⑦ FILLET WELDS WHERE ITEMS ① & ③, ① & ⑤, & ① & ④ MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000091



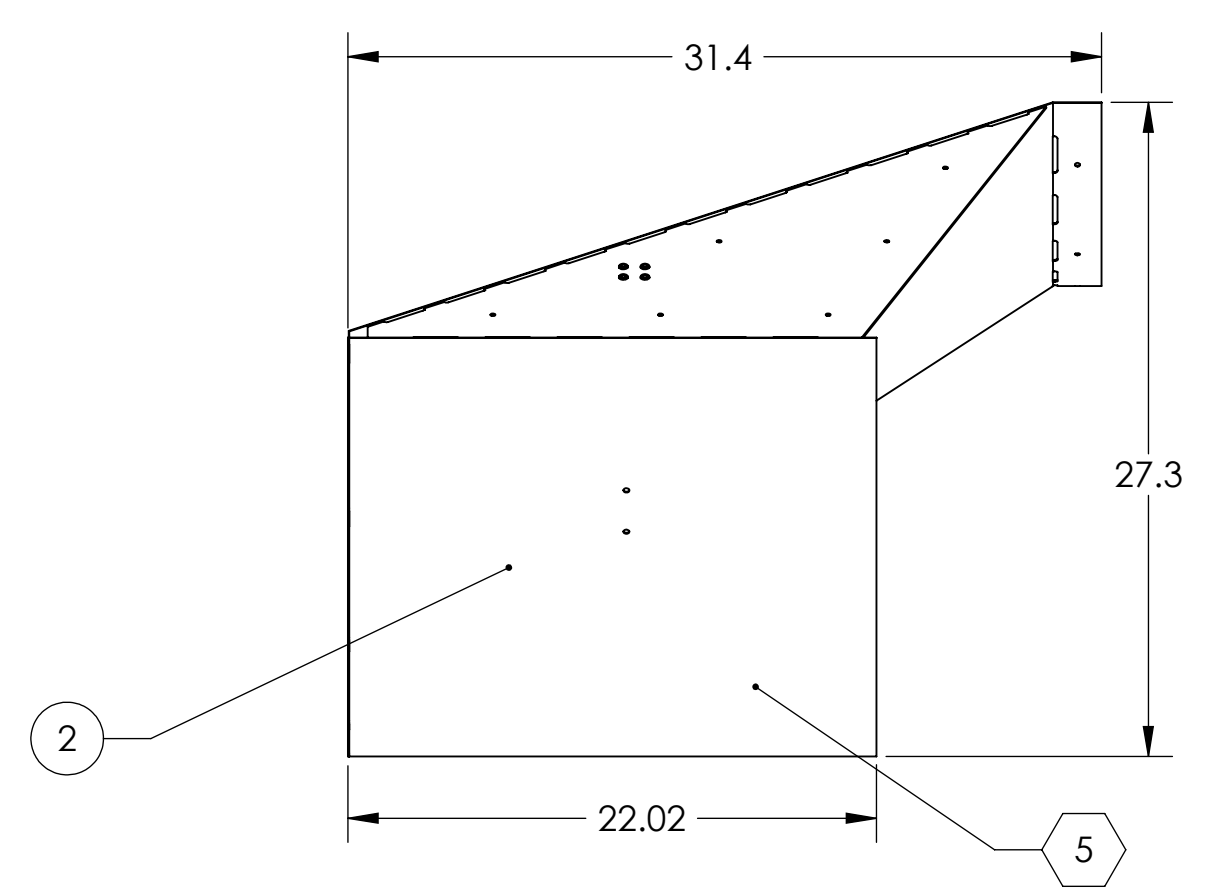
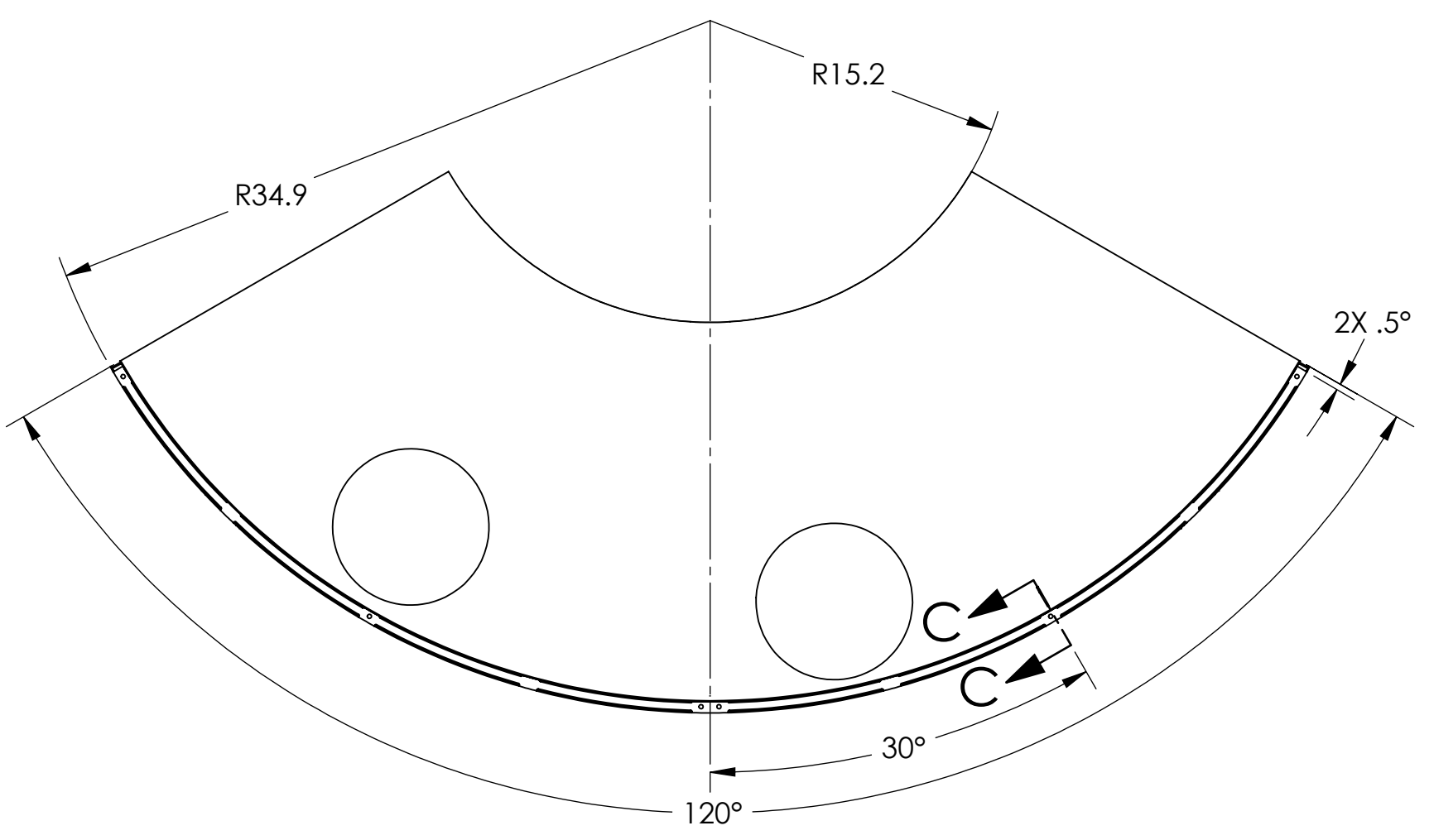
GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION D-D SCALE 1:5

7 PLS

12 PLS



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
5	D1000559	RADIAL SEGMENT, RIGHT	18GA A424 TYPE I STEEL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		0
3	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	1		0
2	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		0
1	D0902619	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, RIGHT	18GA A424 TYPE I STEEL	1		0

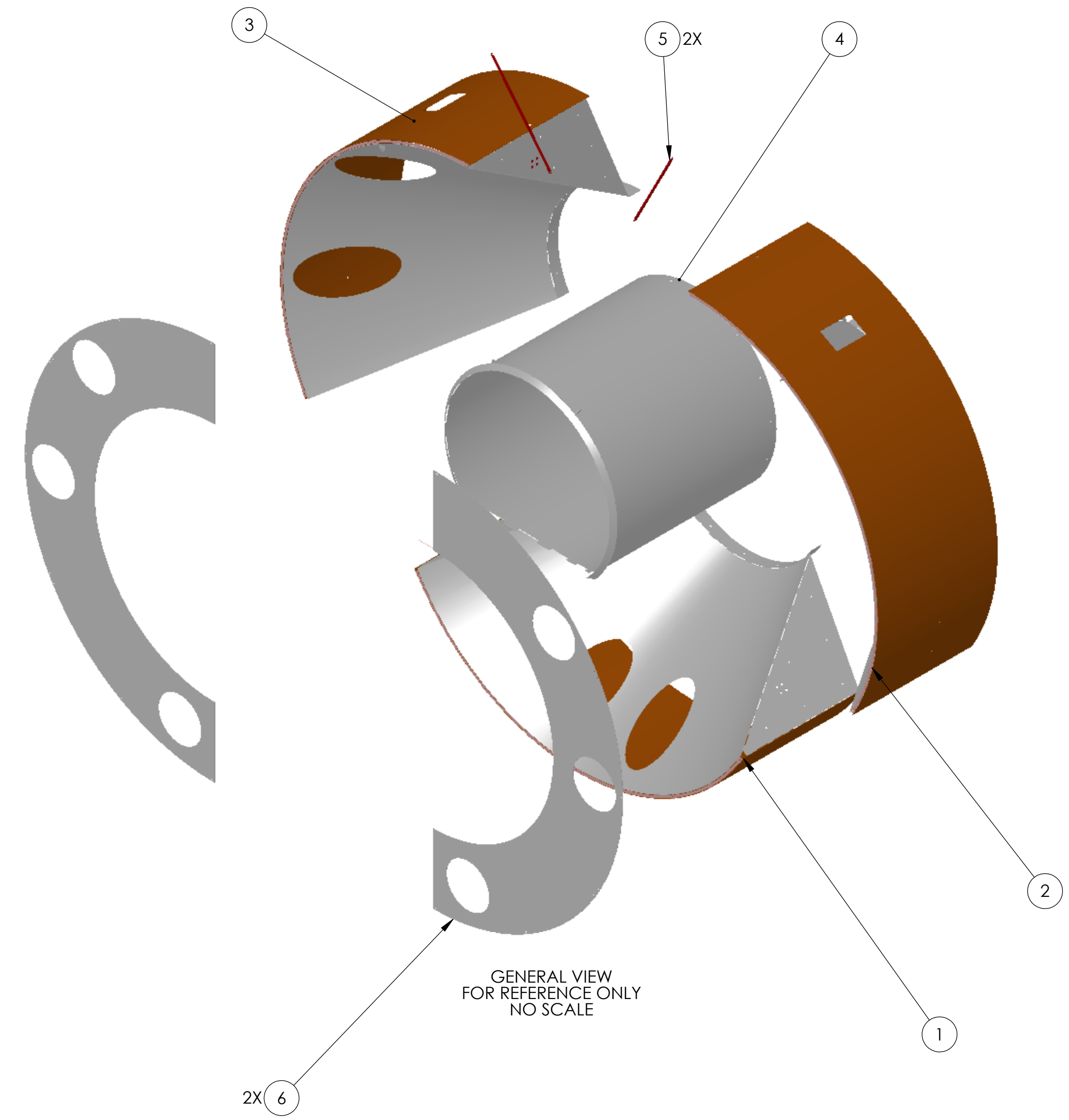
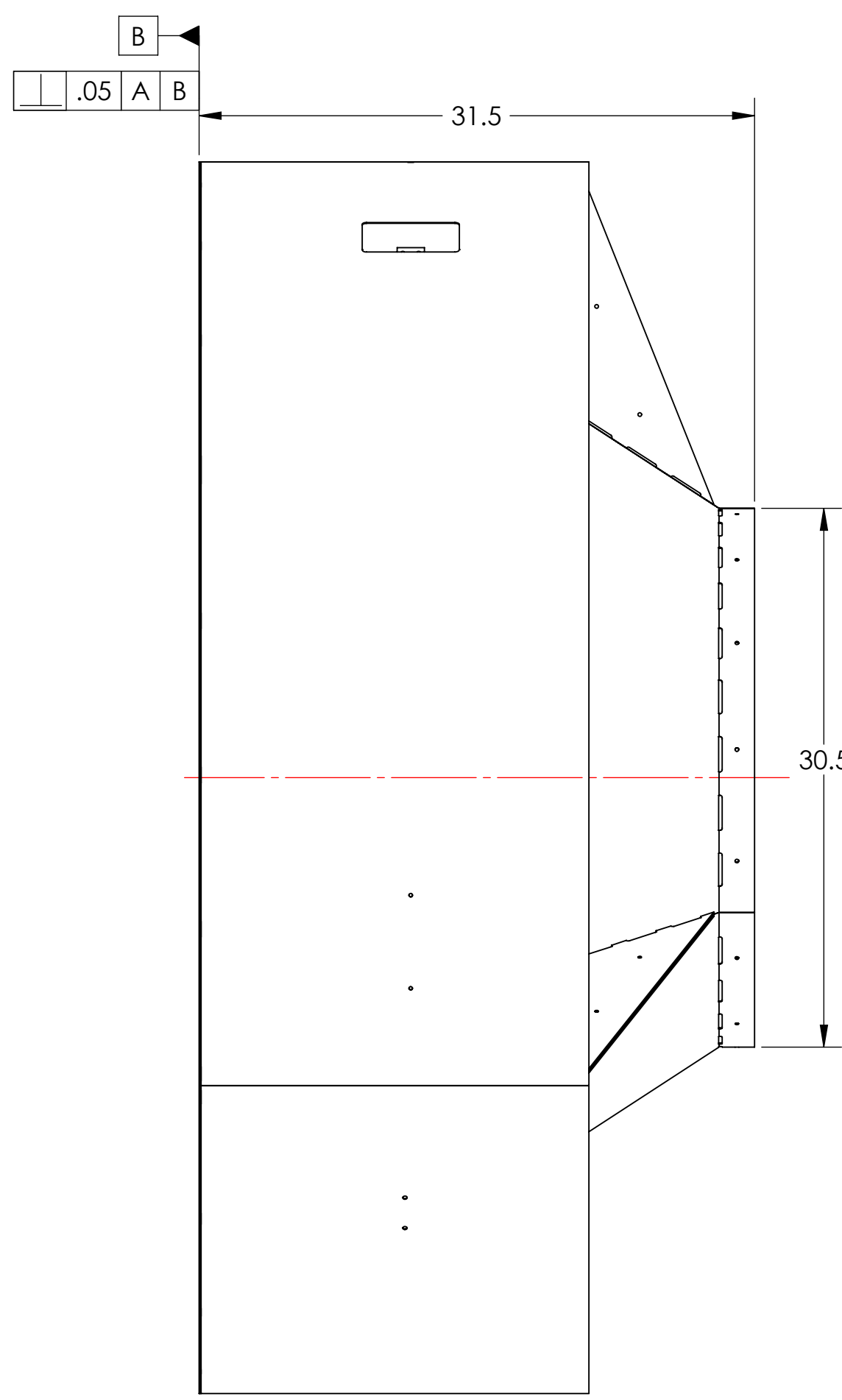
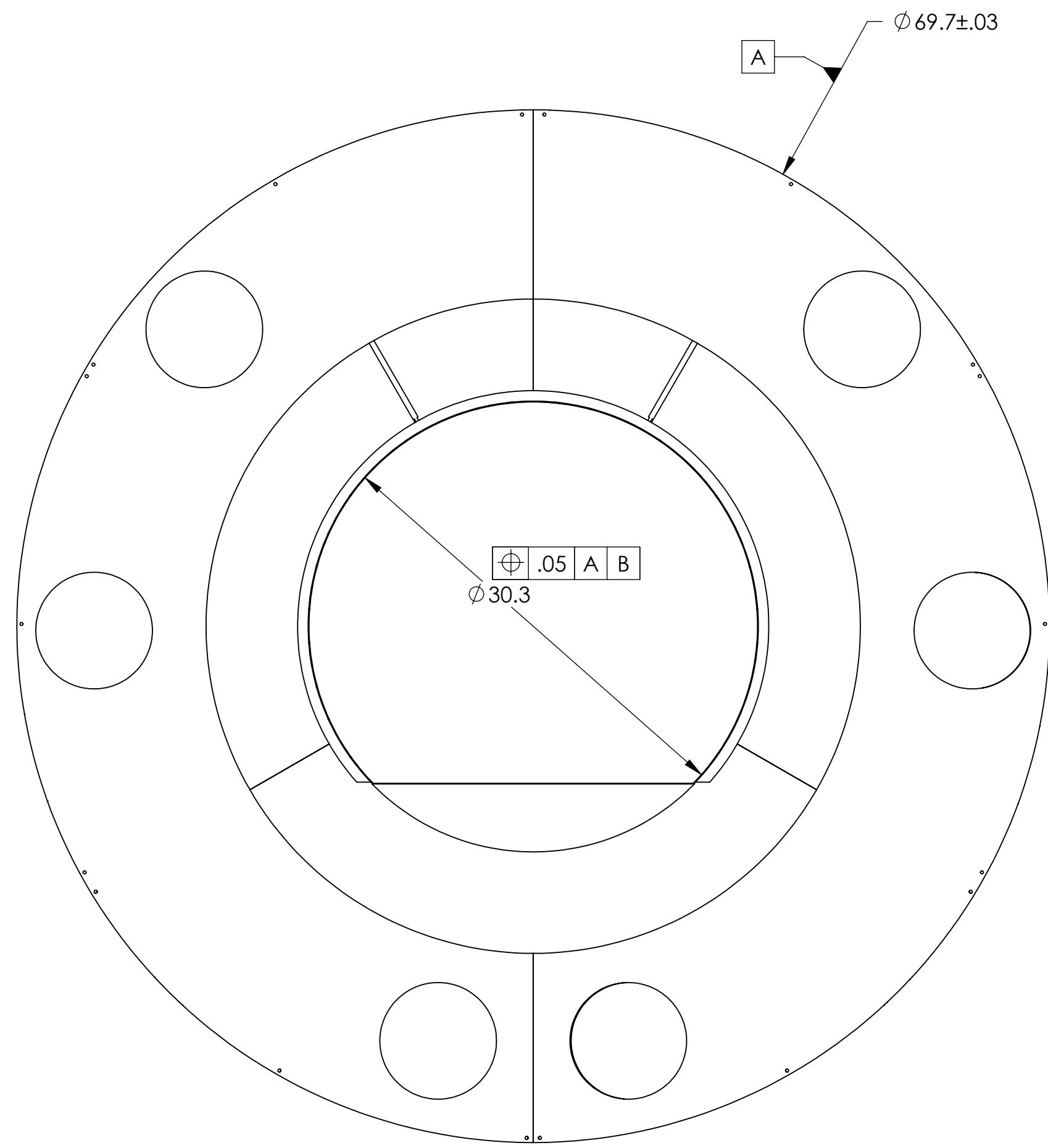
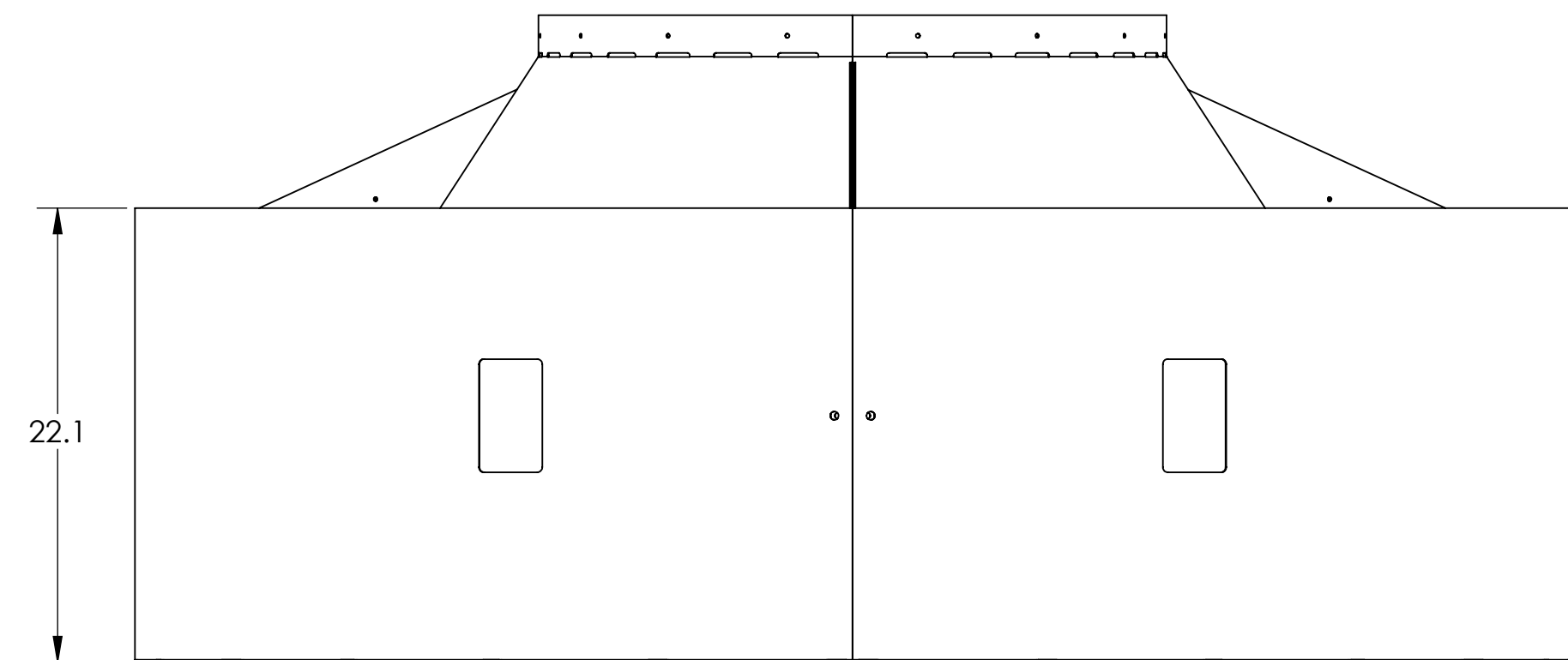
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH	SYSTEM	NEXT ASSY
N/A	⑧	ADVANCED LIGO	D0902061

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, RIGHT	
DESIGNER	H. KELMAN	20 MAY 2010	SIZE DWG. NO.
DRAFTER	TG. NGUYEN	07 SEP 2010	D
CHECKER	M. SMITH		D0902654
APPROVAL	D. COYNE		REV. v1
SCALE: 1:8		PROJECTION:	SHEET 1 OF 1

D:\0902654\01\02_Monfield_Cryo_Baffle_Segment_Subassembly_Weldment_ITMX_H1-H2_Right_PARR_PDM_REV.X-007

NOTES CONTINUED:
5. ASSEMBLY TO BE PERFORMED BY LIGO STAFF.

REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000185
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D0902657	MANIFOLD-CRYO BAFFLE HALF FACE PLATE, ITMX H1-H2	18GA A424 TYPE I STEEL	2		2
5	D1000572	MANIFOLD-CRYO BAFFLE BRACE	304, 316 OR 302 SSSL	2		2
4	D1001348	MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY	N/A	1		1
3	D0902656	MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, LEFT	N/A	1		1
2	D0902654	MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, RIGHT	N/A	1		1
1	D0902655	MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, BOTTOM	N/A	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

PART NAME: WELDMNT ASSY

DESIGNER	H. KELMAN	SIZE	DWG. NO.	REV.
DRAFTER	TQ. NGUYEN	18 AUG 2010	D	D1002061
CHECKER	M. SMITH			v1
APPROVAL	D. COYNE	SCALE: 1:12	PROJECTION:	SHEET 1 OF 1

D1002061_dLIGO_AOS_Manifold-Cryo Baffle_Rotidial Segment Assy_PART_PDM_REV-X-020_DRAWING_PDM_REV-X-008