



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

DCN No. E010056-00-W

SHEET 1 OF 1

3/22/01

DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
LIGO-E000460-00-W	<u>Small Optic Process Traveler Form</u>	A

CHANGE DESCRIPTION (FROM/TO): Rev. change from 00 to A.

Initial Release

REASON FOR CHANGE: Initial Release

ACTION: Incorporate change Attach DCN to drawing(s) Other action (specify):

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION (X=incl. docs)																					
<input checked="" type="checkbox"/> No hardware affected (record change only) <input type="checkbox"/> List S/Ns which comply already: <input type="checkbox"/> List S/Ns to be reworked or scrapped: <input type="checkbox"/> List S/Ns to be built with this change: <input type="checkbox"/> List S/Ns to be retested per this change: <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<table border="0"> <tr> <td></td> <td>Barish</td> <td>Coles</td> </tr> <tr> <td>X Coyne</td> <td>Lazzarini</td> <td>Lindquist</td> </tr> <tr> <td>Raab</td> <td>X Sanders</td> <td>Shoemaker</td> </tr> <tr> <td>Stapfer</td> <td>Tyler</td> <td>Weiss</td> </tr> <tr> <td>Whitcomb</td> <td>Sadowicz</td> <td></td> </tr> <tr> <td>X Cook</td> <td></td> <td></td> </tr> <tr> <td>X Ottaway</td> <td></td> <td></td> </tr> </table>		Barish	Coles	X Coyne	Lazzarini	Lindquist	Raab	X Sanders	Shoemaker	Stapfer	Tyler	Weiss	Whitcomb	Sadowicz		X Cook			X Ottaway		
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X Ottaway																						

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (If yes, enter Change Request number)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: B. Weaver	<i>B. Weaver</i> 3/22/01		
TASK LEADER: D. Ottaway	<i>D. Ottaway</i> 3/22/01		
GROUP LEADER: D. Coyne			
DCC RELEASE: <i>Linda Weaver</i>	4.02.01		

LIGO SMALL OPTIC PROCESS TRAVELER Form E000460-A-W

DCC Number:

E -00-X

Date Prepared:

Originator		Cognizant Engineer		Ext./Phone#
Optic Dwg/Part Number	Rev	SOS Description		Serial Number

Process Flow:

Any deviation from procedures must be approved and noted below

#	Operation/Instructions (Comments)	1st time			2nd time		
		Name/ Initials	Start Date	End Date	Name/ Initials	Start Date	End Date
1	Clean and inspect optic per E990034						
2	Determine guide rod groove position and cement wire standoff and wire rod in place per E970037						
3	Cure Epoxy for 6-12 hrs. with a heat lamp.						
4	Remove part from fixture and visually inspect.						
5	Align part on appropriate gripper magnet standoff fixture (right or left) and cement face magnets and side magnets.						
6	Air bake epoxy for 2 hrs. at 100 degrees C						
7	Remove fixture and visually inspect part.						
11	Hang, balance optic, locate and epoxy wire standoff per (SOS) E970037; complete QC worksheet LIGO-E970080-00-D						
12	Cure epoxy with a heat lamp for 6-12 hrs.						
13	Remove from structure tower - CO2 blow optic						

N.B.: A copy of this traveler must be submitted to the DCC each time the original is shipped with the associated part(s) and when the traveler has been completed.

#	Operation/Instructions (Comments)	1st time			2nd time		
		Name/ Initials	Start Date	End Date	Name/ Initials	Start Date	End Date
14	Vacuum bake per E960022 VBO Load#___ scan#_____ VBO Load#___ scan#_____ VBO Load#___ scan#_____ VBO Load#___ scan#_____						
16	Perform "razor blade" test to bonds. If any failures, record which bond failed						
17	Match 5 Sensor/Actuator heads. 1. 2. 3. 4. 5.						

NOTES:

Indicate location of failed bonds, if any. As reference, indicate the position of the wire rod and wire standoff on Figure 1

Figure 1

