

PROCESS TRAVELERS

• E990308-00-X

• E990280-00-X

• E990267-01-X

• E990275-02-X

• E990279-01-X

• E990311-00-X

• E990310-00-X

• E990309-00-X

D990443-B-D
 Not in database

D980087-A (c,d)
 D980088-A (c,d)
 D990031-A
 D990032-A
 D990033-A
 not in database

D980087-A-W
 D980088-A-W
 D990031-A-D
 D990032-A-D
 D990033-A-D
 not in database

D980087-A
 D980088-A
 D98990029-B
 D990031-A
 D990032-A
 D990033-A
 not in database

D980450-A-D
 not in database

Complete missing
 not in database

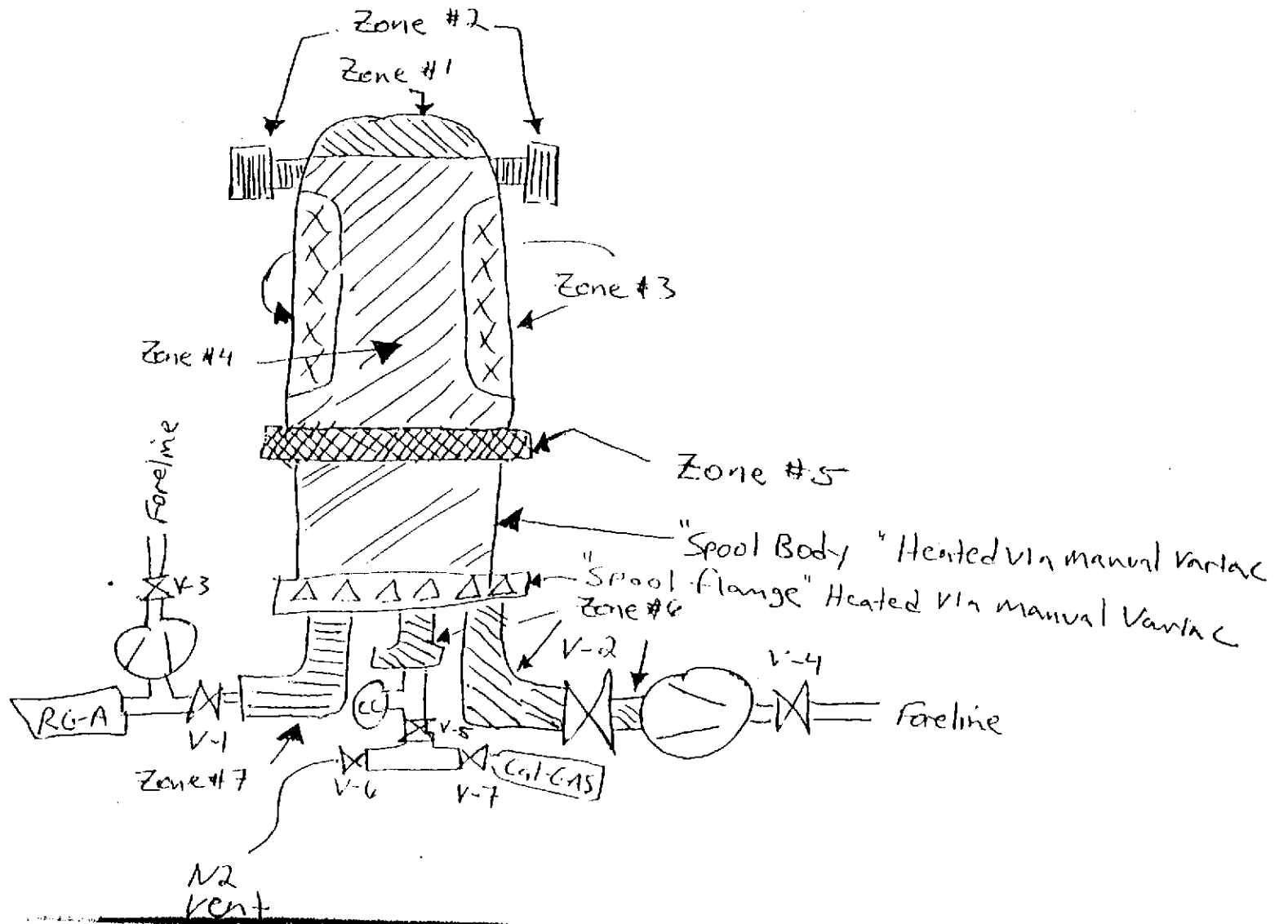
Summary of Vacuum Bake Oven RGA Data Generation

The individual parts which comprise a "load" are cleaned as per LIGO-E960022 or as allowed by waiver(s) and loaded into the bake oven. The oven is pumped down through the main pump "arm" (RGA arm is valved off at this point). A heating profile is programmed and baking of the system begins. A typical "heating profile" consists of ramping up to material type soak temperature, soaking and then ramping down to approximately 70C and soaked. At this point, an RGA background scan is taken, V-1 is opened and an elevated load temperature RGA scan is taken and V-1 closed. This data is entered into a spreadsheet which then calculates what the partial pressures of AMUs 41, 43, 53, 55 and 57 ought to be at room temperature. Following this elevated temperature scan, the load is ramped down to near room temperature. Throughout the baking, temperature data (trendplot) is taken to verify the actual temperatures in the various "zones" of the bake oven system.

Once at near room temperature, another RGA background (V-1 closed) scan is taken. The partial pressures of AMUs 41, 43, 53, 55 and 57 taken from this background scan will get subtracted from the corresponding values measured on the final "Post Bake Scan". Following this scan, V-1 and the cal-gas are opened and V-2 closed. After a 30 min partial pressure equilibration time, a second RGA scan is taken in "amp vs. amu" mode. The calculated pressure of Argon (constituent of the "mixed" calibration gas) is determined and compared (ratio) to the peak amp value recorded for Argon by the RGA scan. This "torr/amp" ratio becomes the Calibration Factor for the given load, converting measured current to pressure.

Finally, the cal-gas is valved out and enough time is allotted to allow all traces of it to be pumped away. A "post-bake" scan is then taken. This post-bake scan data is reviewed as both an analog graph (.rga file extensions) and an ASCII table (.asc file extensions) form. The highest current value between +/- 0.5 AMU of the amu of interest appearing in the ASCII table is entered into a spreadsheet. This spreadsheet then calculates the offgassing rate of AMUs 41, 43, 53, 55 and 57.

Refer to the LHO Bake Oven A logbook for the actual ordered events.



LHO VACUUM BAKE OVEN A: CONTENTS LOAD #52

**TABLE CLAMPS, SERIAL NUMBER D990443-B-098, 049, 033, 072, 043, 093, 100,
106, 114, 035, 101, 128, 045, 031, 065, 024, 122, 044, 111, 084, 066, 083, 081, 059, 080,
090, 131, 135, 061, 138, 069**

CAVITY BEAM DUMP COMPONENTS

**GLASS RETAINING BRACKET, TOP LEFT, SERIAL NUMBER D980087-A-014,
015**

**GLASS RETAINING BRACKET, TOP RIGHT, SERIAL NUMBER D980088-A-
014, 015**

**GLASS RETAINING BRACKET, BOTTOM LEFT, SERIAL NUMBER-D980296-
A-014, 015**

**GLASS RETAINING BRACKET, BOTTOM RIGHT, SERIAL NUMBER
D980297-A-014, 015**

**GLASS RETAINING BRACKET, TOP LEFT, SERIAL NUMBER D980087-A-006,
007, 008**

**GLASS RETAINING BRACKET, TOP RIGHT, SERIAL NUMBER D980088-A-
006, 007, 008**

**GLASS RETAINING BRACKET, BOTTOM LEFT, SERIAL NUMBER D980296-
A-006, 007, 008**

**GLASS RETAINING BRACKET, BOTTOM RIGHT SERIAL NUMBER
D980297-006, 007, 008**

**BEAM DUMP HOUSING TUBE ITMAR1, 2KRMHR3 SERIAL NUMBER
D990252-B-007**

**GLASS RETAINING BRACKET, TOP LEFT, SERIAL NUMBER D980087-A-009,
010, 011**

**GLASS RETAINING BRACKET, TOP RIGHT, SERIAL NUMBER D980088-A-
009, 010, 011**

**GLASS RETAINING BRACKET, BOTTOM LEFT, SERIAL NUMBER D980296-
A-009, 010, 011**

LHO VACUUM BAKE OVEN A LOAD 52 CONTENTS CONT.

GLASS RETAINING BRACKET, BOTTOM RIGHT, SERIAL NUMBER
D980297-A-009, 010, 011

BEAM DUMP FLEX HINGE H_TUBE SERIAL NUMBER D990198-B-009, 015

GLASS RETAINING BRACKET, TOP LEFT, SERIAL NUMBER D980087-A-012,
013

GLASS RETAINING BRACKET, TOP RIGHT, SERIAL NUMBER D980088-A-
012, 013

GLASS RETAINING BRACKET, BOTTOM LEFT, SERIAL NUMBER D980296-
A-012, 013

GLASS RETAINING BRACKET, BOTTOM RIGHT, SERIAL NUMBER
D980297-A-012, 013

FLEX PIVOT PART NUMBER 6032-400 (4ea)

PICK OFF TELESCOPE_APS

#8-32X.50 SCHS (8ea)

#8-32X.75 SCHS (8ea)

¼-20X.50 SCHS (2ea)

#8 FLAT WASHER (8ea)

PLATE, ALIGNMENT TELESCOPE SERIAL NUMBER D980587-B-001

PLATE, ALIGNMENT TELESCOPE SERIAL NUMBER D980588-B-001, 002

BRACKET, ALIGNMENT TELESCOPE SERIAL NUMBER D980589-B-001, 002

TARGET CAMERA MOUNT ASSEMBLY

1/8X.38 DOWELL PART NUMBER 90145A470 (2ea)

#2-56X.38 SHCS PART NUMBER 92196A079 (16ea)

#4-40X.38 SHCS PART NUMBER 92196A109 (8ea)

#4-40X1.00 SHCS PART NUMBER 92196A115 (8ea)

LOAD 52 CONTENTS CONT.

¼-20X.50 SHCS PART NUMBER 92196A537 (1ea)

PLATE, TARGET SUPPORT, LONG SERIAL NUMBER D980572-B-001, 002

PLATE, TARGET SUPPORT, SHORT SERIAL NUMBER D980573-B-001, 002

FRAME, TARGET SERIAL NUMBER D980574-B-001, 002

UNLISTED PART SERIAL NUMBER D980603-B-001, 002, 003, 004

BRACE, CAMERA/TARGET SERIAL NUMBER D980604-B-001, 002, 003, 004

FRONT SUPPORT ASSEMBLY

¼-20X.50 SHCS PART NUMBER 92196A537 (8ea)

¼-20X.75 SHCS PART NUMBER 92196A540 (8ea)

¼-20X1.0 PART NUMBER 92196A542

¼-20X1.5 SHCS PART NUMBER 92196A546 (10ea)

SPHERICAL WASHER PART NUMBER SSPW-1 (16ea)

BAR, VERTICAL, FRONT SUPPORT SERIAL NUMBER D980565-B-001, 002

GUSSET, REAR, FRONT SUPPORT SERIAL NUMBER D980566-B-001, 002

GUSSET, FRONT, FRONT SUPPORT SERIAL NUMBER D980567-B-001, 002

BRACE, HORIZONTAL, FRONT SUPPORT SERIAL NUMBER D980568-B-001

PLATE, BASE FRONT SUPPORT SERIAL NUMBER D980569-B-001

BLOCK, INTERFACE, VERTICLE LOCK SERIAL NUMBER D980570-B-001,
002

PLATE, VERTICLE LOCK, FRONT SUPPORT SERIAL NUMBER D980571-001,
002

¼-20X2.00 THUMBSCREW PART NUMBER 90210A112 (1ea)

#8-32X.38 SHCS PART NUMBER 92196A192 (18ea)

#8-32X.50 SHCS PART NUMBER 92196A195 (2ea)

¼-20X.75 SHCS PART NUMBER 92196A540 (60ea)

LOAD 52 CONTENTS CONT.

SQUARE TUBE, TELESCOPE PARABOLIC ASSEMBLY

#8-32X.38 FHPS, 100 DEGREE PART NUMBER 93085A192 (60ea)

¼ FLAT VENTED WASHER PART NUMBER WFV-25 (60ea)

SHEET, UPPER-SQUARE TUBE SERIAL NUMBER D980546-B-001

SHEET, LOWER, SQUARE TUBE SERIAL NUMBER D980547-B-001

SHEET LEFT, SQUARE BOX SERIAL NUMBER D980548-B-001

SHEET RIGHT, SQUARE BOX SERIAL NUMBER D980549-B-001

**BULKHEAD TITLE PLATE SERIAL NUMBER D980550-B-001, 002, 003, 004,
005**

FRONT PLATE SERIAL NUMBER D980551-B-001

ANGLE, UPPER SERIAL NUMBER D980552-B-001, 002

ANGLE, LOWER LEFT SERIAL NUMBER D980553-B-001

ANGLE, LOWER RIGHT SERIAL NUMBER D980554-B-001

**BLOCK, THUMBSCREW, LATERAL ADJUSTMENT SERIAL NUMBER
D980593-B-001**

BASE, LATERAL ADJUSTMENT SERIAL NUMBER D9805601-B-001

#8-32X.38 SHCS PART NUMBER 92196A192 (6ea)

¼-20X.50 SHCS PART NUMBER 92196A537 (24ea)

**JACKSCREW "C" SERIAL NUMBER 001, 002 PART NUMBER NOT
AVAILABLE**

**SPACER, 2.5X6X0.62, 300 CRESCENT SERIAL NUMBER 001, 002 PART
NUMBER NOT AVAILABLE**

**HORIZONTAL PLATE, JACK STAND SERIAL NUMBER D980595-B-001, 002,
003, 004, 005, 006, 007, 008**

VERTICLE PLATE, JACK STAND SERIAL NUMBER D980596-B-001, 002

GLIDE PLATE, JACK SERIAL NUMBER D980597-B-001, 002

CONTENTS LOAD 52 CONT.

BASE PLATE, JACK SERIAL NUMBER D980598-B-001, 002

BASE, JACK SERIAL NUMBER D980599-B-001, 002

VERTICLE PLATE, SHORT JACK STAND D980600-B-001, 002

MIRROR BOX, TELESCOPE PARABOLIC, ASSEMBLY

¼ FLAT EDGED SPACER WASHER PART NUMBER 90945A761 (3ea)

#8-32X.75 SHCS PART NUMBER 92196A197 (16ea)

¼-20X.75 SHCS PART NUMBER 92196A540 (16ea)

#8 FLAT VENTED WASHER PART NUMBER WFV-08 (32ea)

¼ FLAT VENTED WASHER PART NUMBER WFV-25 (16ea)

#8-32X1.25 SHCS PART NUMBER NOT AVAILABLE (16ea)

¼-20X1.0 FSH, 82 DEGREE PART NUMBER NOT AVAILABLE (3ea)

PLATE, BOTTOM, MIRROR BOX SERIAL NUMBER D98542-B-001

PLATE, TOP, MIRROR BOX SERIAL NUMBER D980543-B-001

PLATE, LEFT, MIRROR BOX SERIAL NUMBER D980544-B-001

PLATE, RIGHT, MIRROR BOX SERIAL NUMBER D980545-B-001

SOCKET PIVOT SERIAL NUMBER D980581-A-001, 002

BAR, TUBE AND BOX, LONG SERIAL NUMBER D980583-B-001, 002

BAR, TUBE AND BOX, SHORT SERIAL NUMBER D98594-B-001, 002

ANGLE, MIRROR BOX SERIAL NUMBER D980619-B-001, 002, 003, 004

BACK PLATE SERIAL NUMBER D990096-B-001

**MIRROR MOUNT ASSEMBLY PRIMARY MIRROR, TELESCOPE
PARABOLIC**

1/8" BALL, ALUMINUM PART NUMBER 34665K29 (3ea)

¼X11/4 SHOULDER SCREW PART NUMBER 90298A544 (3ea)

CONTENTS LOAD 52 CONT.

- ¼ FLAT EDGED SPACER WASHER PART NUMBER 90945A761 (3ea)
- ¼ FLAT WASHER, NAS620C-416 PART NUMBER 90945A761 (6ea)
- #10-24X3/16 CUP PT ST SCREW PART NUMBER 92311A237 (3ea)
- BELLVILLE WASHER PART NUMBER 9713K63 (24ea)
- #10-24X3/4 FSCS PART NUMBER NOT AVAILABLE (6ea)
- #4-40X0.625 SHCS PART NUMBER NOT AVAILABLE (6ea)
- ¼-28X1.0 FSH, 82 DEGREE PART NUMBER NOT AVAILABLE (3ea)
- EXTENSION SPRING PART NUMBER 5967 (2ea)
- 1/8x.38 DOWELL PART NUMBER 90145A470 (4ea)
- #10 WASHER PART NUMBER 90945A741 (3ea)
- #10 WASHER PART NUMBER 90945A741 (3ea)
- ¼ FLAT WASHER, NAS620C-416 PART NUMBER 90945A761 (14ea)
- #8-32X.50 SHCS PART NUMER 92196A196 (4ea)
- #8-32X.75 SHCS PART NUMBER 92196A197 (2ea)
- ¼-20X1.0 SHCS PART NUMER 92196A542 (14ea)
- ¼-20X1.00 HEX BOLT PART NUMBER 92240A542 (8ea)
- #4-40X.38 SHCS SET SCREW PART NUMBER 92311A108 (1ea)
- ¼ FLAT VENTED WASHER PART NUMBER WFV-25 (6ea)
- #10-32X0.50 SPHERICAL END ADJUST SCREW PART NUMBER NOT AVAILABLE (2ea)
- #10-32X0.63 SHCS PART NUMBER NOT AVAILABLE (2ea)
- #4-40X1.25 SHCS PART NUMBER NOT AVAILABLE (3ea)
- 3/8-24X1.0 SHCS PART NUMBER NOT AVAILABLE (4ea)
- 3/8 FLAT WASHER PART NUMBER NOT AVAILABLE (4ea)

CONTENTS LOAD 52 CONT.

COMPRESSION SPRING PART NUMBER NOT AVAILABLE (3ea)

PRIMARY MIRROR MOUNT PLATE SERIAL NUMBER D990097-B-001

**PRIMARY MIRROR MOUNT CLAMP BASE SERIAL NUMBER D990098-B-001,
002, 003**

MIRROR CLAMP SHORT SIDE SERIAL NUMBER D990101-B-001

**MIRROR, CLAMP LONG SIDE SERIAL NUMBER D990102-B-001, 002
SERIAL NUMBER D990444-B-001, 001, 003**

**MIRROR MOUNT ASSEMBLY SECONDARY MIRROR, TELESCOPE
PARABOLIC**

Y-AXIS TOP PLATE SERIAL NUMBER D980314-B-001

X-Y INTERFACE PLATE SERIAL NUMBER D980315-B-001

Y-TOP END PLATE SERIAL NUMBER D980316-B-001, 002

X-AXIS WAY PLATE SERIAL NUMBER D980317-B-001

FLEXURE SPRING BLOCK SERIAL NUMBER D980318-B-001

END PLATE SERIAL NUMBER D980319-B-001, 002

ANGLE PLATE SERIAL NUMBER D980321-B-001

¼-40X0.75 SLOTTED PUSH SCREW SERIAL NUMBER D990448-B (3ea)

REAR CAMERA MOUNT ASSEMBLY

¼ FLAT WASHER, NAS620C-416 PART NUMBER 90945A761 (3ea)

#4-40X.38 SHCS PART NUMBER 92196A108 (2ea)

#8-32X.50 SHCS PART NUMBER 92196A197 (3ea)

#4-40X.38 THUMB SCREW SERIAL NUMBER NOT AVAILABLE (2ea)

SLEEVE ALIGNMENT TELESCOPE SERIAL NUMBER D980576-B-001

REAR SUPPORT ASSEMBLY

1/4X.88 DOWELL PIN PART NUMBER 90145A541 (1ea)

CONTENTS LOAD 52 CONT.

¼ FLAT WASHER, NAS620C-416 PART NUMBER 90945A761 (4ea)

¼-20X.50 SHCS PART NUMBER 92196A537 (26ea)

¼-20X1.0 SHCS PART NUMBER 92196A542 (4ea)

PLATE VERTICLE REAR SUPPORT SERIAL NUMBER D980559-B-001, 002

STIFFNER, VERTICLE REAR SUPPORT SERIAL NUMBER D908560-B-001,
002, 003, 004

BRACE HORIZONTAL REAR SUPPORT SERIAL NUMBER D980561-B-001

PLATE SWIVEL REAR SUPPORT SERIAL NUMBER D980562-B-001

PLATE BASE REAR SUPPORT SERIAL NUMBER D980563-B-001

PLATE VERTICLE LOCK/PIVOT, REAR SUPPORT SERIAL NUMBER
D980564-B-001, 002

PERISCOPE ROD MOUNTS PART NUMBER 148-3410 (2ea)

STAINLESS STEEL 20" POSTS (PERISCOPE) PART NUMBER NOT
AVAILABLE

ETM TELESCOPE MIRROR BRACKET SPACER

SPACER, MIRROR BRACKET SERIAL NUMBER D990450-A-001, 002

¼-20X1.5 SHCS PART NUMBER NOT AVAILABLE (2ea)

¼ VENTED WASHER PART NUMBER WFV-25 (2ea)

2KETM PO BEAM_BEAM DUMP

POST MIRROR MOUNT BRACKET SERIAL NUMBER D990009-A-001

BLACK GLASS, 2.4 SQUARE SERIAL NUMBER D9900445-A-001

CLAMP SERIAL NUMBER D990446-A-001, 002, 003, 004

POST, ETM BEAM DUMP HOLLOW SERIAL NUMBER D990447-A-001

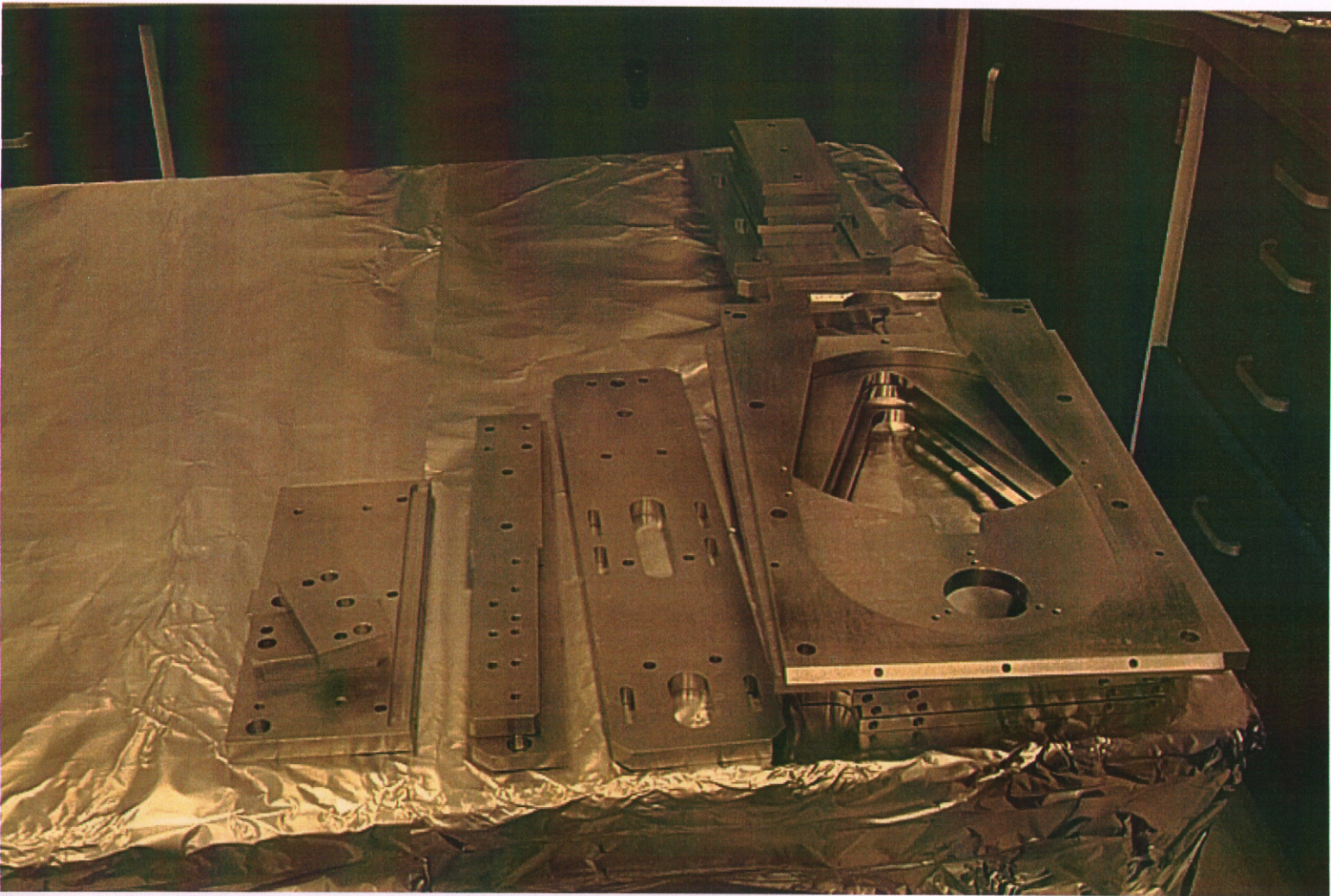
BASE, ROD MOUNT, LONG SERIAL NUMBER D990453-A-001

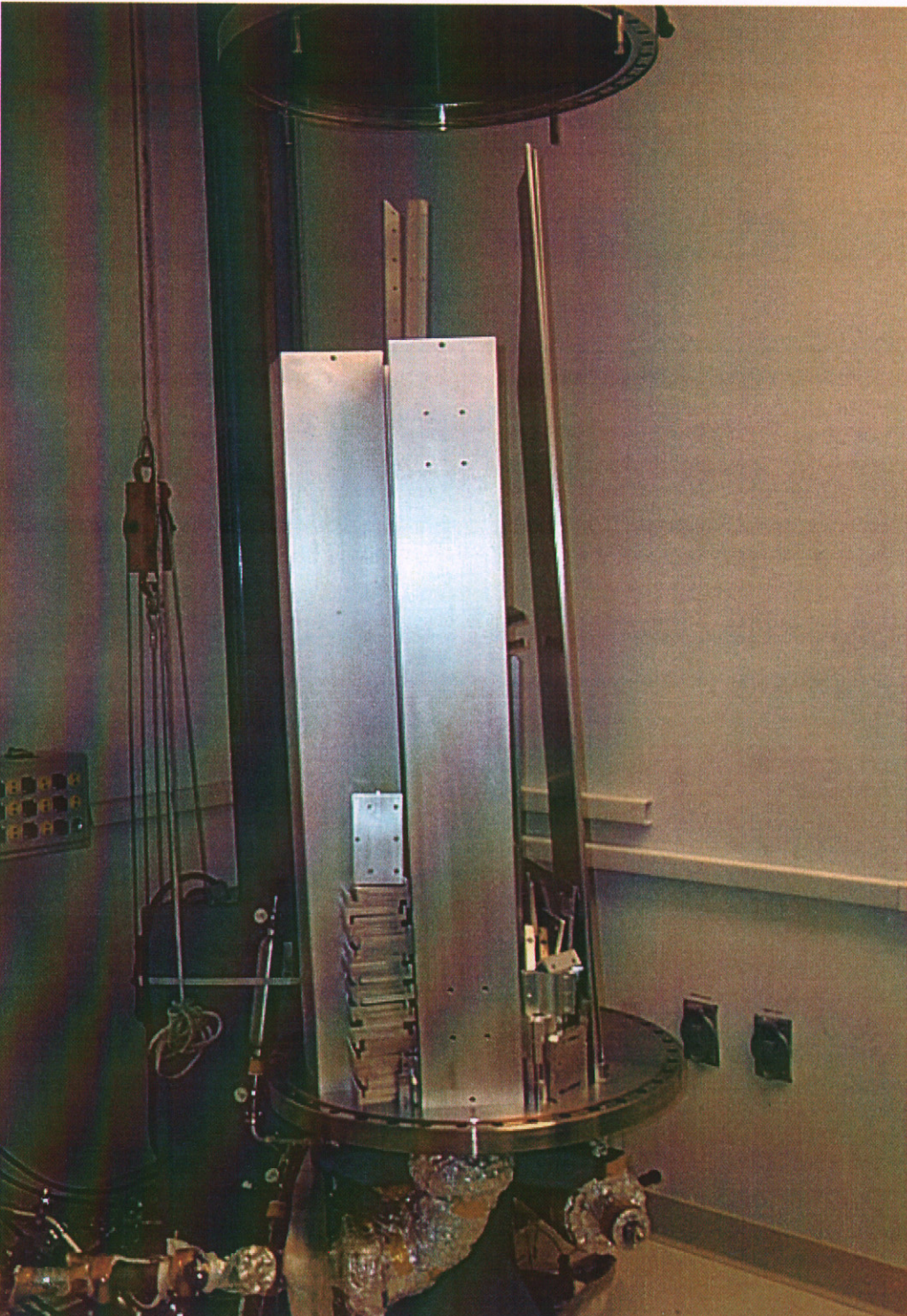
¼-20X0.50 SHCS PART NUMBER NOT AVAILABLE (4ea)

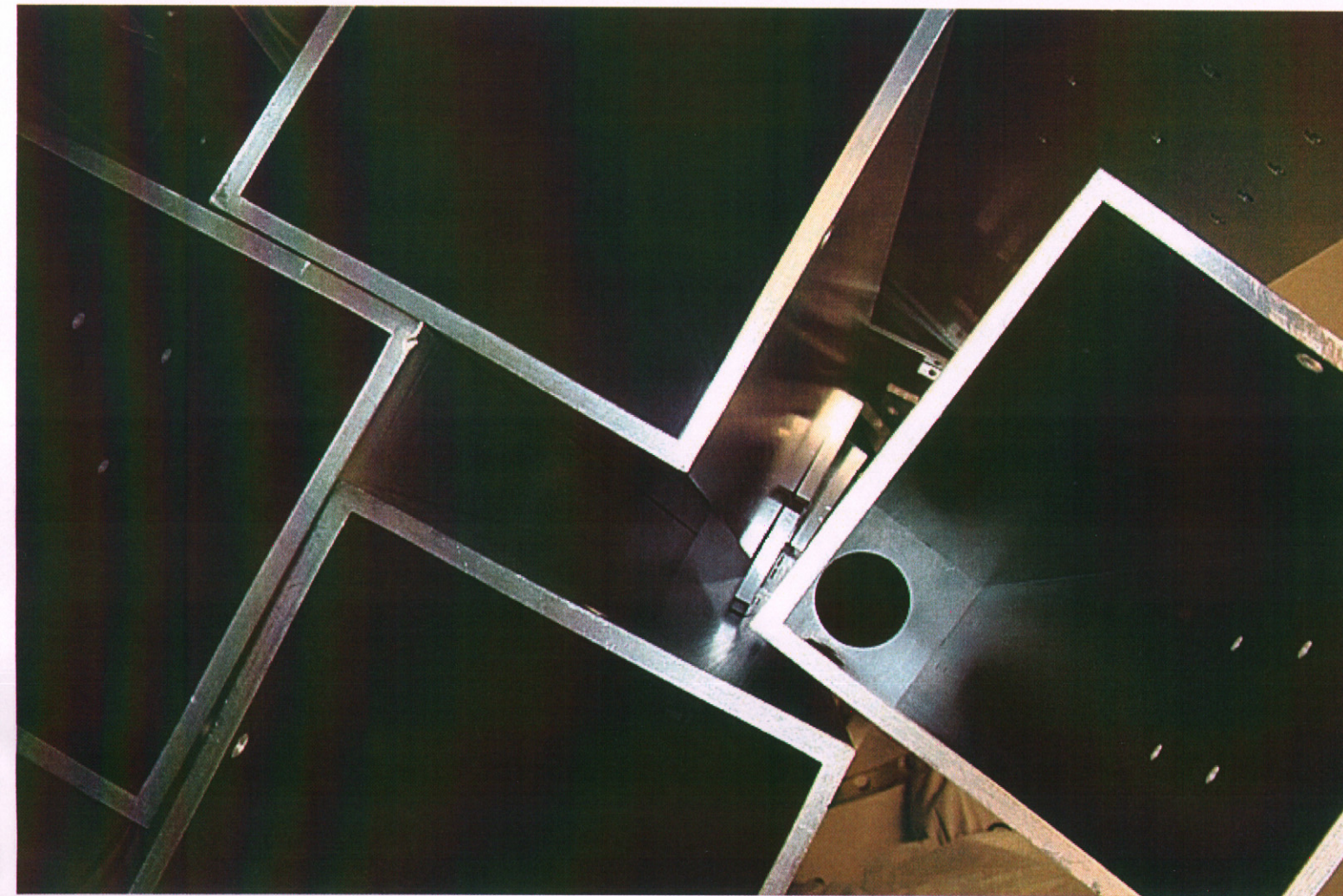
CONTENTS LOAD 52 CONT.

#8-32X0.63 SHCS PART NUMBER NOT AVAILABLE (4ea)









LIGO PROCESS TRAVELER

DCC Number: **E990308-00-X**
 Date Prepared: **8/6/99**

Originator		Cognizant Engineer		Ext./Phone#	Project	Account Number
Michael Smith		Michael Smith		2062	COS	5F515

Dwg/Part Number	Rev	Part Description	Serial Number	Qty
D990443	B	clamp, table	020-150	130

Used In (next higher assembly):

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake		LHO	per LIGO-E960022	B. Weaver	8/30/99
5	Control Point		LHO	Review/approve RGA: VBO Load# <u>52</u> scan # <u>0826996.262</u> VBO Load# <u>54</u> scan # <u>0830936.262</u> VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ Note: attach RGA scan(s) to this traveler.	B. Weaver <i>BEW</i>	8/14/99

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.

LIGO PROCESS TRAVELER

DCC Number: E990308-00-X

#	Operation	Start Date	Work Area	Instructions			Name/ Initials	Date Comp.
6	Box for shipment to LLO & CIT		Valley Engravers					
				No.	Qty per package	Part		
				1	20	clamps		
				2	120	clamps		
				3	10	clamps		
				(see also qty. for each shipping destination below)				

LIGO PROCESS TRAVELER

DCC Number: **E990308-00-X**

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.																							
7	Ship		Valley Engravers																										
		<table border="1"> <thead> <tr> <th rowspan="2">No.</th> <th colspan="3">Ship Qty.</th> <th rowspan="2">Part Description</th> </tr> <tr> <th>LHO</th> <th>LLO</th> <th>CIT</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>20</td> <td></td> <td></td> <td>clamps</td> </tr> <tr> <td>2</td> <td>120</td> <td></td> <td></td> <td>clamps</td> </tr> <tr> <td>3</td> <td></td> <td></td> <td>10</td> <td>clamps</td> </tr> </tbody> </table>			No.	Ship Qty.			Part Description	LHO	LLO	CIT	1	20			clamps	2	120			clamps	3			10	clamps		
No.	Ship Qty.			Part Description																									
	LHO	LLO	CIT																										
1	20			clamps																									
2	120			clamps																									
3			10	clamps																									
		LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8																										
		LLO:	Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8																										
END: Go to Traveler associated with next higher assembly processing																													

Special Instructions (Handling/Packaging Constraints, Remarks, etc.) or Notes:

DATE	NAME	DESCRIPTION
8/6/99	Mike Smith	Attention: Betsy Weaver, hold cleaned baked parts for use by COS.
8/20	B. Weaver	S/N 098, 049, 033, 072, 043, 093, 100, 106, 114, 035 101, 120, 089, 045, 031, 065, 024, 122, 044, 111, 084 066, 088, 081, 059, 080, 090, 131, 135, 061, 138, 069 Baked in VBO Load 52.
8/30	B. Weaver	Rest of clamps baked in VBO Load 54.

LIGO PROCESS TRAVELER

DCC Number: **E990308-00-X**
Date Prepared:

Table 1: ACTION ITEMS CON'T.

DATE	NAME	DESCRIPTION

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.

LIGO PROCESS TRAVELER

LLD Copy

DCC Number: **E990280-00-X**
 Date Prepared: **7/8/99**

Originator Michael Smith	Cognizant Engineer Michael Smith	Ext./Phone# 2062	Project COS	Account Number 5F515
-----------------------------	-------------------------------------	---------------------	----------------	-------------------------

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	Sent to I.L.O.	VBO Load 52	Sent to I.L.O. 9/3
Beam Dump Assemblies, LBSC2											
D980087	A	"glass retaining bracket, top left, cavity BD"	014, 015	2	1					2	2
D980088	A	"glass retaining bracket, top right, cavity BD"	014, 015	2	1					2	2
D980092	A	"glass plate 1, cavity BD"		2							
D980093	A	"glass plate 2, cavity BD"		2							
D980289	B	"glass mounting plate 1, cavity BD"	014, 015	2		2			2		
D980292	B	"glass mounting plate 2, cavity BD"	012, 014	2	2	2			2		
D980296	A	"glass retaining bracket, bottom left, cavity BD"	014, 015	2	1					2	2
D980297	A	"glass retaining bracket, bottom right cavity BD"	014, 015	2	1					2	2
D980348	B	"side plate, cavity BD"	004, 024, 029, 030	4		4			4		
D980378	B	"Stiffener Block, cavity BD"	003, 009	2	2	2			2		
D980685	A	"clamp, plate beam dump"		8							
D990028	A	Beam Dump Flex Hinge Tongue	016-019	4	4	4			4		
D990029	A	Beam Dump Flex Hinge Clevis	006, 007, 018, 004	4				4	4		
D990030	A	Beam Dump Flex Hinge Tee	017-020	4			4		4		
D990031	A	Beam Dump Flex Hinge Saddle	016-019	4							
			** See Note								
D990032	A	Beam Dump Flex Hinge Attach	007, 008, 018, 019	4			4		4		
D990033	A	Beam Dump Flex Hinge Adapter	** See Note	4							
D990140	D	Beam Dump Housing Plate	011, 013	2							
D990149	C	"Cavity Beam Dump, Mounting Bracket Angle "	011, 019	4	2	2					

V.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.

LIGO PROCESS TRAVELER

DCC Number: **E990280-00-X**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	Sent to LLO	VBO Load 52	Sent to LLO 9/3
D990150	B	"Cavity Beam Dump, Mounting Bracket Gusset "	018, 019, 015, 010	4	4		4		4		
D990151	B	"Cavity Beam Dump, Mounting Bracket Backplate 1"	010-013	4			4		4		
D990152	C	"Cavity Beam Dump, Mounting Bracket Backplate 2"	009, 015, 018, 019	4			4		4		
D990198	B	Beam Dump Flex Hinge H_tube	013, 014, 016, 017	4					4		
D990199	A	Beam Dump Flex Hinge Low Strap	018, 019, 010, 011	4	3	3	1		4		
D990200	A	Beam Dump Flex Hinge Backup	023, 024, 033, 034, 037, 038, 009, 031	8		6	2		6		
D990201	A	Beam Dump Flex Hinge Cap	021-025, 033, 034, 036	8	8	8			8		
D990202	B	Beam Dump Flex Hinge Top Strap	004, 017-019	4		1	3		4		
D990207	B	"rail, plate beam dump"	007, 010, 013, 014	4	4	4			4		
D990218	B	"glass, plate beam dump"		2							
D990222	A	Beam Dump Housing Tube 2KBSAR3		0							
D990223	C	Beam Dump Housing Tube 2KFM		0							
D990225	D	"Beam Dump Housing Tube 4KITMIIR3, 4KITMIIR4"		0							
D990236	B	"backplate_offset, plate beam dump"		0							
D990240	B	"backplate, plate beam dump"		0							
D990252	B	"Beam Dump Housing Tube ITMARI,2KRMIR3"	002, 004	2					2		
D990253	A	Extension Tube	001, 002	2					2		
D990335	A	"Beam Dump Flex Hinge H_tube, 2KITMXAR4 "		0							
D990336	A	"Beam Dump Flex Hinge H_tube, 2KITMYAR4"		0							
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		24							24

LIGO PROCESS TRAVELER

DCC Number: **E990280-00-X**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	Sent to L.L.O	VBO Load 52	Sent to L.L.O 9/3
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		32							*60
93615A355		#10-24 X 0.75 LOW HD SCS		24							48
92196A245		#10-24 X 0.75 SHCS		32							*50
WFV-06		#6 X 0.016 THK FLAT VENTED WASHER		32							*60
92196A144		#6-32 X .25 SHCS		32							*50
WFV-08		#8 FLAT VENTED WASHER		68							*80
92185A194		#8-32 X .50 SHCS		68							*100
91500A194		#8-32 X .500 FHPS		36							72
91944A450		0.406ID X 0.88OD X 0.25 THK SPHER WASH		16							16
92141A029		1/4 FLAT WASHER		56							100
N-2520-A		1/4-20 HEX NUT AG/SS		16							20
93615A410		1/4-20 X .500 LOW HEAD SOCKET SCREW		8							*50
92196A540		1/4-20 X 0.75 SHCS		48							78
92196A542		1/4-20 X 1.00 SHCS		32							*100
C-2016-NA		"1/4-20 X 1.00 SHCS, AG/SS"		40							*60
92196A544		1/4-20 X 1.25 SHCS		16							*100
C-2820-NA		"1/4-28 X 1.25 SHCS, AG/SS"		24							30
91950A031		3/8 X 0.063 FLAT WASHER		6							12
WFV-38		3/8 X 0.032 THK FLAT VENTED WASHER		42							72
N-3816-A		3/8-16 HEX NUT, AG/SS		4							6
94804A320		3/8-16 HEX NUT		8							16
TOP-1616-NA		3/8-16 X 1.00 SOCKT SET SCRW-OVL. PT AG/SS see traveler # E990324		8							16
90585A626		3/8-16 X 1.25 FLT HD CAP SCREW		8							12
92186A626		3/8-16 X 1.25 HEX HD SCREW		16							40
C-1620-NA		"3/8-16 X 1.25 SHCS, AG/SS"		8							
92186A630		3/8-16 X 1.75 HEX HD SCREW		4							10

LIGO PROCESS TRAVELER

DCC Number: **E990280-00-X**
 Date Prepared: **7/8/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	Sent to LLO	VBO Load 52	Sent to LLO 9/3
92196A630		3/8-16 X 1.75 SHCS		12							12
92186A999		3/8-16 X 7.00 HEX HD SCREW	NA (baked in load 38-OKed by Stan W.)	16					18		
099-966-12-20x		BERYLLIUM-CU GND STRP	NA (baked in load 38-OKed by Stan W.)	8					8		
6032-400		Flex Pivot		8							
Used In (next higher assembly):		D990230, BSC Beam dump Installation, top assembly									

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake		LHO	per LIGO-E960022	K. Ryan	SEE NEXT PAGE

NOTE: A copy of this traveler must be submitted to the DCC each time the original is shipped with the associated parts and when the traveler has been completed.

LIGO PROCESS TRAVELER

DCC Number: **E990280-00-X**

Date Prepared: **7/8/99**

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.													
5	Control Point (93) (46)	7.1.99 7.20.99	LHO	Review/approve RGA: VBO Load# 43 scan # <u>REJECTED</u> VBO Load# 46 scan # <u>072699C.RGA</u> VBO Load# 48 scan # <u>080399C.RGA</u> VBO Load# 50 scan # <u>081099C.RGA</u> VBO Load# 52 scan # <u>082099C.RGA</u> VBO Load# scan # _____	K. Ryan <i>REW</i> <i>REW</i> <i>REW</i> <i>REW</i>	7/29/99 8/10/99 8/10/99 9/14/99													
	Box for shipment to LLO	8/11 9/7	PARTIAL PARTIAL	Ship in LIGO-provided container <table border="1"> <thead> <tr> <th>No.</th> <th>Qty per package</th> <th>Part</th> </tr> </thead> <tbody> <tr> <td>ALL</td> <td></td> <td>BEAM DUMP PARTS</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table> (see also qty. for each shipping destination below)	No.	Qty per package	Part	ALL		BEAM DUMP PARTS				<i>REW</i> <i>REW</i>	8/12 9/7				
No.	Qty per package	Part																	
ALL		BEAM DUMP PARTS																	
7	Ship			<table border="1"> <thead> <tr> <th rowspan="2">No.</th> <th colspan="3">Ship Qty.</th> <th rowspan="2">Part Description</th> </tr> <tr> <th>LHO</th> <th>LLO</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td>all</td> <td></td> <td>beam dump parts</td> </tr> </tbody> </table> LHO: Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump DSC8	No.	Ship Qty.			Part Description	LHO	LLO	Other			all		beam dump parts		
No.	Ship Qty.			Part Description															
	LHO	LLO	Other																
		all		beam dump parts															

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.

LIGO PROCESS TRAVELER

DCC Number: E990280-00-X
 Date Prepared: 7/8/99

ACTION ITEMS:

Table 1:

DATE	NAME	DESCRIPTION
8/5/99	Betsy Weaver	Clavis' D990029-006,007,004,018 were sent out for rework for modification as per: NOM# E99023-B/D990029-B. Received back 8/4. Being baked here.
8/12/99	Betsy Weaver	Sending the parts listed above in far R-hand column attention: Jonathan Kern @ LLO. The 8 tubes (D990198, D990252, & D990253's) will need to be cleaned & baked, as per the instructions attached. I will send all fasteners & missing parts separately (being baked here).
8/12/99	Betsy Weaver	Parts D990031 s/n 016-019 & D990033 s/n 006,007,012,013 were sent out for rework & will be sent to LLO separately.
9/3/99	Betsy Weaver	* Parts "sent to LLO 9/3" Need to be cleaned & baked as per E960022. (This partial shipment sent 9/7). Place all other listed, cleaned & baked hardware with the other stored B.O. LBSC2 stuff.
9/3/99	Betsy Weaver	Staple this "copy" of traveler to the original traveler, upon receipt @ LLO.

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.

X-POP3-Rcpt: bweaver@apex
Date: Thu, 22 Jul 1999 12:12:31 -0700
From: Dennis Coyne <coyne@ligo.caltech.edu>
Organization: Caltech/LIGO
X-Mailer: Mozilla 3.01Gold (Win95; I)
To: Betsy Weaver <weaver_b@ligo.caltech.edu>
CC: Stan Whitcomb <stan@acrux.ligo.caltech.edu>, Mike Smith <smith@acrux.ligo.caltech.edu>, Bartie Rivera <rivera_b@ligo-wa.caltech.edu>
Subject: Re: cleaning

VBC LOAD 48

Betsy,

You should clean as follows (E960022-05 except since the parts are too large to ultrasonically clean, I've tailored the cleaning):

1) clean with Liquinox first (solution per E960022-05) and using a rubbing/scrubbing action (i.e. not just rinsing the liquinox over the surfaces). All holes must be cleaned with a brush (stainless steel, phosphor-bronze preferred, but nylon is acceptable). It is ESSENTIAL that the liquinox NOT dry before being rinsed with DI water.

2) Thoroughly rinse with DI water. All surfaces and holes must be rinsed THOROUGHLY.

3) Rinse & rub (with gloved hand only) all surfaces with either methanol or isopropal alcohol. Squirt the solvent into all holes.

4) Blow dry with clean, filtered air or N2, or allow to dry on a clean bench. Do not leave exposed for longer than about 15 minutes, before covering with UHV foil.

With regard to cleaning the lens, please see Stan for a confirmation, but I believe the rule that we operate under is that if all surfaces are polished, then an optics cleaning and wetting test is adequate and no baking is required. However, if the sides of the optic are not polished (as I suspect is the case for the ETM optics), then it should be cleaned and baked and re-cleaned. However, please confirm this with Stan and he may grant a waiver if he examines the surface condition of the optics.

Dennis

Betsy Weaver wrote:

>

> Hi Dennis-

>

> Two cleaning questions for you:

>

> 1. We just received the aluminum load (COS) from the etching company.

> How should we clean them here, before baking them? (They are

- > obviously too large to put in the ultrasonic cleaner...)
- >
- > 2. Mike has one large and two small lenses that are going to be
- > used in the ETM Telescope Assembly. If they wet well during cleaning,
- > do they really need to be baked? A while ago, Stan told me that the
- > small steering mirrors for IO and COS did not need to be baked, as the oven
- > would just make them dirtier, because they wetted so well during cleaning.
- > Is this the same for the lenses? If they do need to be baked, can I put
- > them in
- > the next load with the one Large Optic?
- >
- > Thanks-
- > Betsy

-
Dennis Coyne (Detector Installation Manager)
LIGO Laboratory, Caltech, Physics Department
626.395.2034 @CIT / 225.686.3168 @Livingston / 509.372.8166 @Hanford
cell 626.695.8350

LIGO PROCESS TRAVELER

DCC Number: **E990267-01-X**
 Date Prepared: **6/30/99**

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Michael Smith	Michael Smith	2062	COS	5F515

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40 6/ 28	VBO load 41 7/1	VBO load 43 7/ 12	VBO load 46 7/ 26	VBO load 48 7/	VBO Load 50	VBO Load 52
		Beam Dump Assemblies, BSC4									
D980087	A	"glass retaining bracket, top left, cavity BD"	006-008	3	3		3				3
D980088	A	"glass retaining bracket, top right, cavity BD"	006-008	3	3		3				3
D980092	A	"glass plate 1, cavity BD"		3							
D980093	A	"glass plate 2, cavity BD"		3							
D980289	B	"glass mounting plate 1, cavity BD"	006-008	3	3						
D980292	B	"glass mounting plate 2, cavity BD"	007,008,015	3	2		1	1			
D980296	A	"glass retaining bracket, bottom left, cavity BD"	006-008	3	3		3				3
D980297	A	"glass retaining bracket, bottom right cavity BD"	006-008	3	3		3				3
D980348	B	"side plate, cavity BD"	012-017	6	5	1					
D980378	B	"Stiffener Block, cavity BD"	006-008	3	3						
D980685	A	"clamp, plate beam dump"		12							
D990028	A	Beam Dump Flex Hinge Tongue	004, 005, 006, 007, 010, 015	6	1	3	2	2			
D990029	A	Beam Dump Flex Hinge Clevis	005, 008-012	6	1		1	5		1 (011)	
D990030	A	Beam Dump Flex Hinge Tee	005-010	6	6			6			
D990031	A	Beam Dump Flex Hinge Saddle	004-009	6		4		2			
D990032	A	Beam Dump Flex Hinge Attach	004-006, 009-011	6		4		2			
D990033	A	Beam Dump Flex Hinge Adapter	004, 005, 008-010, 014	6		6					
D990140	D	Beam Dump Housing Plate	012, 014	3				3			
D990149	C	"Cavity Beam Dump, Mounting Bracket Angle "	005-008	4	1			3			
D990150	B	"Cavity Beam Dump, Mounting Bracket Gusset "	005-008	4	4						

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.

LIGO PROCESS TRAVELER

DCC Number: E990267-01-X

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40 6/ 28	VBO load 41 7/1	VBO load 43 7/ 12	VBO load 46 7/ 26	VBO load 48 7/	VBO Load 50
D990151	B	"Cavity Beam Dump, Mounting Bracket Backplate 1"	005-008	4	4					
D990152	C	"Cavity Beam Dump, Mounting Bracket Backplate 2"	005-008	4	4					
D990198	B	Beam Dump Flex Hinge H_tube	007,010, 005, 003	4	1	2			1	
D990199	A	Beam Dump Flex Hinge Low Strap	004-009	6	1	5				
D990200	A	Beam Dump Flex Hinge Backup	016-018, 020-022, 010-015	12	2	10				
D990201	A	Beam Dump Flex Hinge Cap	007-017, 019	12	2	2		8		
D990202	B	Beam Dump Flex Hinge Top Strap	005-010	6	1	4		1		
D990207	B	"rail, plate beam dump"	003-006, 008, 009	6		6				
D990218	B	"glass, plate beam dump" other traveler	NA	3			3	3		
D990222	A	Beam Dump Housing Tube 2KBSAR3		0						
D990223	C	Beam Dump Housing Tube 2KFM		0						
D990225	D	"Beam Dump Housing Tube 4KITMHR3,4KITMHR4"		0						
D990236	B	"backplate_offset, plate beam dump"		0						
D990240	B	"backplate, plate beam dump"		2	1					
D990252	B	"Beam Dump Housing Tube ITMARI,2KRMHR3"	001,005,007	3	1	2	1			
D990253	A	Extension Tube	003	1			1		1	
D990335	A	"Beam Dump Flex Hinge H_tube, 2KITMXAR4 " η	001	1			1		1	
D990336	A	"Beam Dump Flex Hinge H_tube, 2KITMYAP4" X	002	1			1		1	
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		24	24					
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		4	4					
92196A245		#10-24 X 0.75 SHCS		4	4					
93615A355		#10-24 X 0.75 LOW HD SCS		24	24					
WFV-06		#6 X 0.016 THK FLAT VENTED WASHER		4	4					
92196A144		#6-32 X .25 SHCS		4	4					
WFV-08		#8 FLAT VENTED WASHER		102	102					

LIGO PROCESS TRAVELER

DCC Number: E990267-01-X

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40 6/ 28	VBO load 41 7/1	VBO load 43 7/ 12	VBO load 46 7/ 26	VBO load 48 7/
92185A194		#8-32 X .50 SHCS		102	102				
91500A194		#8-32 X .500 FHPS		54	54				
91944A450		0.406ID X 0.88OD X 0.25 THK SPHER WASH		24	24				
92141A029		1/4 FLAT WASHER		48	48				
92141A029		1/4 FLAT WASHER		36	36				
N-2520-A		1/4-20 HEX NUT		24	24				
93615A410		1/4-20 X .500 LOW HEAD SOCKET SCREW		12	12				
92196A540		1/4-20 X 0.75 SHCS		48	48				
92196A540		1/4-20 X 0.75 SHCS		24	24				
92196A542		1/4-20 X 1.00 SHCS		48	48				
C-2016-NA		"1/4-20 X 1.00 SHCS, AG/SS"		48	48				
C-2016-NA		"1/4-20 X 1.00 SHCS, AG/SS"		12	12				
92196A544		1/4-20 X 1.25 SHCS		24	24				
C-2820-NA		"1/4-28 X 1.25 SHCS, AG/SS"		36	36				
91950A031		3/8 X 0.063 FLAT WASHER		3	3				
91950A031		3/8 X 0.063 FLAT WASHER		6	6				
WFV-38		3/8 X0.032 THK FLAT VENTED WASHER		3	3				
WFV-38		3/8 X0.032 THK FLAT VENTED WASHER		32	32				
WFV-38		3/8 X0.032 THK FLAT VENTED WASHER		8	8				
94804A320		3/8-16 HEX NUT		8	8				
N-3816-A		3/8-16 HEX NUT		6	6				
TOP-1616-NA		3/8-16 X 1.00 SOCKT SET SCRW-OVL PT AG/SS		12	12				
90585A626		3/8-16 X 1.25 FLT HD CAP SCREW		8	8				
92186A626		3/8-16 X 1.25 HEX HD SCREW		16	16				
C-1620-NA		"3/8-16 X 1.25 SHCS, AG/SS"		12	12				
92186A630		3/8-16 X 1.75 HEX HD SCREW		6	6				

LIGO PROCESS TRAVELER

DCC Number: **E990267-01-X**
 Date Prepared: **6/30/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40 6/ 28	VBO load 41 7/1	VBO load 43 7/ 12	VBO load 46 7/ 26	VBO load 48 7/ 26
92196A630		3/8-16 X 1.75 SHCS		18	18				
92186A999		3/8-16 X 7.00 HEX HD SCREW		16	16				
099-966-12-20x		BERYLLIUM-CU GND STRP		12	12				
6.32-400		Flex Pivot		12	12				

Used In (next higher assembly): **D990230, BSC Beam dump Installation, top assembly**

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	Vacuum Bake		LHO	per LIGO-E960022	K. Ryan	
4	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
5	Control Point	6/24/99 6/28/99 7/6/99 7/10/99	LHO	Review/approve RGA: VBO Load# 40 scan # 062899C.RGA VBO Load# 41 scan # 070299C.RGA VBO Load# 43 scan # Rejected VBO Load# 46 scan # 072699C.RGA VBO Load# 48 scan # 080599C.RGA VBO Load# 50 scan # 081099C.RGA VBO Load# 52 scan # 082699C.RGA Note: attach RGA scan(s) to this traveler.	K. Ryan B.W B.W B.W B.W	7/28/99 8/10/99 8/10/99 9/14/99

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.

LIGO PROCESS TRAVELER

DCC Number: **E990267-01-X**
 Date Prepared: **6/30/99**

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.																			
	Box for shipment to LHO			Ship in LIGO-provided container <table border="1"> <thead> <tr> <th>No.</th> <th>Qty per package</th> <th>Part</th> </tr> </thead> <tbody> <tr> <td>ALL</td> <td></td> <td>BSC4 BEAM DUMP PARTS</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table> (see also qty. for each shipping destination below)	No.	Qty per package	Part	ALL		BSC4 BEAM DUMP PARTS															
No.	Qty per package	Part																							
ALL		BSC4 BEAM DUMP PARTS																							
7	Ship			<table border="1"> <thead> <tr> <th rowspan="2">No.</th> <th colspan="3">Ship Qty.</th> <th rowspan="2">Part Description</th> </tr> <tr> <th>LHO</th> <th>LLO</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td></td> <td>all</td> <td></td> <td></td> <td>BSC4 beam dump parts</td> </tr> </tbody> </table> <table border="1"> <tr> <td></td> <td>LHO:</td> <td>Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8</td> </tr> <tr> <td></td> <td>LLO:</td> <td>Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8</td> </tr> </table>	No.	Ship Qty.			Part Description	LHO	LLO	Other		all			BSC4 beam dump parts		LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8		LLO:	Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8		
No.	Ship Qty.			Part Description																					
	LHO	LLO	Other																						
	all			BSC4 beam dump parts																					
	LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8																							
	LLO:	Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8																							
END: Go to Traveler associated with next higher assembly processing																									

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.

LIGO PROCESS TRAVELER

DCC Number: E990267-01-X

Date Prepared: 6/30/99

Special Instructions (Handling/Packaging Constraints, Remarks, etc.) or Notes:

Attention: Betsy Weaver, Jonathan Kern, hold cleaned and baked parts for COS assembly
VBO Load 43 - Rejected Scan. Dennis Coyne sent all stainless steel items to be electropolished and all aluminum items to LNL anodizing to be etched, from this load. 7/15 B. Weaver
Parts received back from etching and polishing companies. Re-cleaned as per Dennis' email attached. 7/23 B. Weaver
S/N 006-008 of parts D980087, D980088, D980296, D980297 sent back to Spacecraft Specialists, Inc. for rework. They were rushed during manufacturing these parts, and therefore forgot to finish. 7/21 B. Weaver
6 D990030, 1 D990252 tubes sent to Electropolisher/etcher for recleaning even though they had been baked at LHO & passed. - Dennis thought they looked suspect to dirt! 8/2 - B. Weaver
Claris D990029-011 sent out for rework to make modification as per D990029-B 8/4 - B. Weaver DCN: E990273-B 7/9
Side plate D980348 s/n 014 sent to Brockman Mfg. for rework - holes made into slots to compensate for low clearance. B. Weaver 9/10

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.

X-POP3-Rcpt: bweaver@apex
Date: Thu, 22 Jul 1999 12:12:31 -0700
From: Dennis Coyne <coyne@ligo.caltech.edu>
Organization: Caltech/LIGO
X-Mailer: Mozilla 3.01Gold (Win95; I)
To: Betsy Weaver <weaver_b@ligo.caltech.edu>
CC: Stan Whitcomb <stan@acrux.ligo.caltech.edu>,
Mike Smith <smith@acrux.ligo.caltech.edu>,
Bartie Rivera <rivera_b@ligo-wa.caltech.edu>
Subject: Re: cleaning

VBO LOAD 48

Betsy,

You should clean as follows (E960022-05 except since the parts are too large to ultrasonically clean, I've tailored the cleaning):

1) clean with Liquinox first (solution per E960022-05) and using a rubbing/scrubbing action (i.e. not just rinsing the liquinox over the surfaces). All holes must be cleaned with a brush (stainless steel, phosphor-bronze preferred, but nylon is acceptable). It is ESSENTIAL that the liquinox NOT dry before being rinsed with DI water.

2) Thoroughly rinse with DI water. All surfaces and holes must be rinsed THOROUGHLY.

3) Rinse & rub (with gloved hand only) all surfaces with either methanol or isopropal alcohol. Squirt the solvent into all holes.

4) Blow dry with clean, filtered air or N2. or allow to dry on a clean bench. Do not leave exposed for longer than about 15 minutes, before covering with UHV foil.

With regard to cleaning the lens, please see Stan for a confirmation, but I believe the rule that we operate under is that if all surfaces are polished, then an optics cleaning and wetting test is adequate and no baking is required. However, if the sides of the optic are not polished (as I suspect is the case for the ETM optics), then it should be cleaned and baked and re-cleaned. However, please confirm this with Stan and he may grant a waiver if he examines the surface condition of the optics.

Dennis

Betsy Weaver wrote:

>

> Hi Dennis-

>

> Two cleaning questions for you:

>

> 1. We just received the aluminum load (COS) from the etching company.

> How should we clean them here, before baking them? (They are

- > obviously too large to put in the ultrasonic cleaner...)
- >
- > 2. Mike has one large and two small lenses that are going to be
- > used in the ETM Telescope Assembly. If they wet well during cleaning,
- > do they really need to be baked? A while ago, Stan told me that the
- > small steering mirrors for IO and COS did not need to be baked, as the oven
- > would just make them dirtier, because they wetted so well during cleaning.
- > Is this the same for the lenses? If they do need to be baked, can I put
- > them in
- > the next load with the one Large Optic?
- >
- > Thanks-
- > Betsy

--

Dennis Coyne (Detector Installation Manager)
LIGO Laboratory, Caltech, Physics Department
626.395.2034 @CIT / 225.686.3168 @Livingston / 509.372.8166 @Hanford
cell 626.695.8350

LIGO PROCESS TRAVELER

DCC Number: **E990275-02-X**
 Date Prepared: **7/8/99**

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Michael Smith	Michael Smith	2062	COS	5F515

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40	VBO load 41	VBO load 43	VBO load 46	VBO load 48	VBO load 52
Beam Dump Assemblies, BSC7										
D980087	A	"glass retaining bracket, top left, cavity BD"	009-011	3			3			3
D980088	A	"glass retaining bracket, top right, cavity BD"	009-011	3			3			3
D980092	A	"glass plate 1, cavity BD"		3						3
D980093	A	"glass plate 2, cavity BD"		3						
D980289	B	"glass mounting plate1, cavity BD"	009-011	3		3				
D980292	B	"glass mounting plate2, cavity BD"	007, 009, 013	3	1	2				
D980296	A	"glass retaining bracket, bottom left, cavity BD"	009-011	3			3			3
D980297	A	"glass retaining bracket, bottom right cavity BD"	009-011	3			3			3
D980348	B	"side plate, cavity BD"	018-023	6	3	3				
D980378	B	"Stiffener Block, cavity BD"	010-012	3		3				
D980685	A	"clamp, plate beam dump"		4						
D990028	A	Beam Dump Flex Hinge Tongue	008, 009	2			2	2		
D990029	B	Beam Dump Flex Hinge Clevis	013, 014	2				2		
D990030	A	Beam Dump Flex Hinge Tee	011, 012	2				2		
D990031	A	Beam Dump Flex Hinge Saddle	011, 012	2				2		
D990032	A	Beam Dump Flex Hinge Attach	012, 013	2				2		
D990033	A	Beam Dump Flex Hinge Adapter	016, 017	2				2		
D990140	D	Beam Dump Housing Plate	005-007	3		3				
D990149	C	"Cavity Beam Dump, Mounting Bracket Angle "	016-018	3			3	3		
D990150	B	"Cavity Beam Dump, Mounting Bracket Gusset "	009, 011, 012	3			3		3	
D990151	B	"Cavity Beam Dump, Mounting Bracket Backplate 1"	014, 017, 018	3		3				
D990152	C	"Cavity Beam Dump, Mounting Bracket Backplate 2"	011, 014, 013	3		2			1	
D990198	B	Beam Dump Flex Hinge H_tube	009, 015	2						2

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.

LIGO PROCESS TRAVELER

DCC Number: **E990275-02-X**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40	VBO load 41	VBO load 43	VBO load 46	VBO load 48
D990199	A	Beam Dump Flex Hinge Low Strap	013, 015	2		2			
D990200	A	Beam Dump Flex Hinge Backup	026, 028-030	4		4			
D990201	A	Beam Dump Flex Hinge Cap	020, 026, 027, 029	4		4			
D990202	B	Beam Dump Flex Hinge Top Strap	015, 016	2				2	
D990207	B	"rail, plate beam dump"	010, 012	2		2			
D990218	B	"glass, plate beam dump"		1				1	
D990222	A	Beam Dump Housing Tube 2KBSAR3		0					
D990223	C	Beam Dump Housing Tube 2KFM	003, 004	2			2		2
D990225	D	"Beam Dump Housing Tube 4KITMHR3, 4KITMHR4"	002	1			1		1
D990236	B	"backplate_offset, plate beam dump"		1					
D990240	B	"backplate, plate beam dump"		0					
D990252	B	"Beam Dump Housing Tube ITMARI,2KRMHR3"		0					
D990253	A	Extension Tube		0					
D990335	A	"Beam Dump Flex Hinge H_tube, 2KITMXAR4 "		0					
D990336	A	"Beam Dump Flex Hinge H_tube, 2KITMYAR4"		0					
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		22	22				
93615A355		#10-24 X 0.75 LOW HD SCS		18	18				
92196A245		#10-24 X 0.75 SHCS		4	4				
WFV-06		#6 X 0.016 THK FLAT VENTED WASHER		4	4				
92196A144		#6-32 X .25 SHCS		4	4				
WFV-08		#8 FLAT VENTED WASHER		102	102				
92185A194		#8-32 X .50 SHCS		102	102				
91500A194		#8-32 X .500 FHPS		54					
91944A450		0.406ID X 0.88OD X 0.25 THK SPHER WASH		8					
92141A029		1/4 FLAT WASHER		20					

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO load 40	VBO load 41	VBO load 43	VBO load 46	VBO load 48
N-2520-A		1/4-20 HEX NUT		8					
93615A410		1/4-20 X .500 LOW HEAD SOCKET SCREW		4	4				
92196A540		1/4-20 X 0.75 SHCS		16	16				
92196A542		1/4-20 X 1.00 SHCS		16	16				
C-2016-NA		"1/4-20 X 1.00 SHCS, AG/SS"		20	20				
92196A544		1/4-20 X 1.25 SHCS		8	8				
C-2820-NA		"1/4-28 X 1.25 SHCS, AG/SS"		12	12				
91950A031		3/8 X 0.063 FLAT WASHER		5	5				
WV-38		3/8 X0.032 THK FLAT VENTED WASHER		33	33				
N-3816-A		3/8-16 HEX NUT, AG/SS		2	2				
94804A320		3/8-16 HEX NUT		6	6				
TOP-1616-NA		3/8-16 X 1.00 SOCKT SET SCRW-OVL PT AG/SS		4	4				
90585A626		3/8-16 X 1.25 FLT HD CAP SCREW		6	6				
92186A626		3/8-16 X 1.25 HEX HD SCREW		12	12				
C-1620-NA		"3/8-16 X 1.25 SHCS, AG/SS"		4	4				
92186A630		3/8-16 X 1.75 HEX HD SCREW		6	6				
92196A630		3/8-16 X 1.75 SHCS		6	6				
92186A999		3/8-16 X 7.00 HEX HD SCREW		12	12				
099-966-12-20x		BERYLLIUM-CU GND STRP		12	12				
6032-400		Flex Pivot		4	4				

Used In (next higher assembly):	D990230, BSC Beam dump Installation, top assembly

LIGO PROCESS TRAVELER

DCC Number: **E990275-02-X**
 Date Prepared: **7/8/99**

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean	6/18	LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake	↓	LHO	per LIGO-E960022	K. Ryan	←
5	Control Point	06-24-99 06-28-99 07-06-99 07-20-99	LHO	Review/approve RGA:s VBO Load# <u>40</u> scan # <u>0628990.RGA</u> VBO Load# <u>41</u> scan # <u>0705990.RGA</u> VBO Load# <u>43</u> scan # <u>REJECTED</u> VBO Load# <u>46</u> scan # <u>0726990.RGA</u> VBO Load# <u>48</u> scan # <u>0803990.RGA</u> VBO Load# <u>52</u> scan # <u>0824990.RGA</u> VBO Load# _____ scan # _____ Note: attach RGA scan(s) to this traveler.	K. Ryan SEW SEW SEW	7/28/99 8/10/99 9/14/99

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.

LIGO PROCESS TRAVELER

DCC Number: **E990275-02-X**
 Date Prepared: **7/8/99**

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.																			
	Box for shipment to LHO			Ship in LIGO-provided container <table border="1"> <thead> <tr> <th>No.</th> <th>Qty per package</th> <th>Part</th> </tr> </thead> <tbody> <tr> <td>ALL</td> <td></td> <td>BSC7 BEAM DUMP PARTS</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table> (see also qty. for each shipping destination below)	No.	Qty per package	Part	ALL		BSC7 BEAM DUMP PARTS															
No.	Qty per package	Part																							
ALL		BSC7 BEAM DUMP PARTS																							
7	Ship			<table border="1"> <thead> <tr> <th rowspan="2">No.</th> <th colspan="3">Ship Qty.</th> <th rowspan="2">Part Description</th> </tr> <tr> <th>LHO</th> <th>LLO</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td></td> <td>all</td> <td></td> <td></td> <td>BSC7 beam dump parts</td> </tr> </tbody> </table> <table border="1"> <tr> <td></td> <td>LHO:</td> <td>Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8</td> </tr> <tr> <td></td> <td>LLO:</td> <td>Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8</td> </tr> </table>	No.	Ship Qty.			Part Description	LHO	LLO	Other		all			BSC7 beam dump parts		LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8		LLO:	Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8		
No.	Ship Qty.			Part Description																					
	LHO	LLO	Other																						
	all			BSC7 beam dump parts																					
	LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8																							
	LLO:	Attn: Jonathan Kern LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8																							
END: Go to Traveler associated with next higher assembly processing																									

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.

LIGO PROCESS TRAVELER

DCC Number: **E990275-02-X**
 Date Prepared: **7/8/99**

ACTION ITEMS:

Table 1:

DATE	NAME	DESCRIPTION
7/20	B. Weaver	S/N 009-011 of parts D980087, D980088, D980296, and D980297 were sent back to Spacecraft Spec. for rework, as we noticed that these parts had not been manufactured completely.
7/15	B. Weaver	V60 Load 43 was Rejected due to bad scan - as a result of not clean enough parts. Dennis Coyne sent all parts from this load (plus some) to be electropolished ^(S.S) or etched. ^(AI)
7/23	B. Weaver	Parts received back from etching & polishing companies. Recleaned large parts as per attached email.

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.

Table 1:

X-POP3-Rcpt: bweaver@apex
Date: Thu, 22 Jul 1999 12:12:31 -0700
From: Dennis Coyne <coyne@ligo.caltech.edu>
Organization: Caltech/LIGO
X-Mailer: Mozilla 3.01Gold (Win95; I)
To: Betsy Weaver <weaver_b@ligo.caltech.edu>
CC: Stan Whitcomb <stan@acrux.ligo.caltech.edu>, Mike Smith <smith@acrux.ligo.caltech.edu>, Bartie Rivera <rivera_b@ligo-wa.caltech.edu>
Subject: Re: cleaning

VBO LOAD 48

Betsy,

You should clean as follows (E960022-05 except since the parts are too large to ultrasonically clean. I've tailored the cleaning):

- 1) clean with Liquinox first (solution per E960022-05) and using a rubbing/scrubbing action (i.e. not just rinsing the liquinox over the surfaces). All holes must be cleaned with a brush (stainless steel, phosphor-bronze preferred, but nylon is acceptable). It is ESSENTIAL that the liquinox NOT dry before being rinsed with DI water.
- 2) Thoroughly rinse with DI water. All surfaces and holes must be rinsed THOROUGHLY.
- 3) Rinse & rub (with gloved hand only) all surfaces with either methanol or isopropal alcohol. Squirt the solvent into all holes.
- 4) Blow dry with clean, filtered air or N2, or allow to dry on a clean bench. Do not leave exposed for longer than about 15 minutes, before covering with UHV foil.

With regard to cleaning the lens, please see Stan for a confirmation, but I believe the rule that we operate under is that if all surfaces are polished, then an optics cleaning and wetting test is adequate and no baking is required. However, if the sides of the optic are not polished (as I suspect is the case for the ETM optics), then it should be cleaned and baked and re-cleaned. However, please confirm this with Stan and he may grant a waiver if he examines the surface condition of the optics.

Dennis

Betsy Weaver wrote:

- >
- > Hi Dennis-
- >
- > Two cleaning questions for you:
- >
- > 1. We just received the aluminum load (COS) from the etching company.
- > How should we clean them here, before baking them? (They are

- > obviously too large to put in the ultrasonic cleaner...)
- >
- > 2. Mike has one large and two small lenses that are going to be
- > used in the ETM Telescope Assembly. If they wet well during cleaning,
- > do they really need to be baked? A while ago, Stan told me that the
- > small steering mirrors for IO and COS did not need to be baked, as the oven
- > would just make them dirtier, because they wetted so well during cleaning.
- > Is this the same for the lenses? If they do need to be baked, can I put
- > them in
- > the next load with the one Large Optic?
- >
- > Thanks-
- > Betsy

--

Dennis Coyne (Detector Installation Manager)
LIGO Laboratory, Caltech, Physics Department
626.395.2034 @CIT / 225.686.3168 @Livingston / 509.372.8166 @Hanford
cell 625.695.8350

LIGO PROCESS TRAVELER

DCC Number: **E990279-01-X**
 Date Prepared: **7/8/99**

Originator		Cognizant Engineer			Ext./Phone#			Project		Account Number		
Michael Smith		Michael Smith			2062			COS		5F515		

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 40	VBO Load 41	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	VBO Load 52	VBO Load 54
Beam Dump Assemblies, WBSC2												
D980087	A	"glass retaining bracket, top left, cavity BD"	012-013	2			2				2	
D980088	A	"glass retaining bracket, top right, cavity BD"	012-013	2			2				2	
D980092	A	"glass plate 1, cavity BD"		2								
D980093	A	"glass plate 2, cavity BD"		2								
D980289	B	"glass mounting plate1, cavity BD"	012-013	2		2						
D980292	B	"glass mounting plate2, cavity BD"	010-011	2		2	2					
D980296	A	"glass retaining bracket, bottom left, cavity BD"	012-013	2			2				2	
D980297	A	"glass retaining bracket, bottom right cavity BD"	012-013	2			2				2	
D980348	B	"side plate, cavity BD"	025-028	4		4						
D980378	B	"Stiffener Block, cavity BD"	013-014	2		2						
D980685	A	"clamp, plate beam dump"		8								
D990028	A	Beam Dump Flex Hinge Tongue	011-014	4				4				
D990029	B	Beam Dump Flex Hinge Clevis	015-017, 019	4				4		1 (019)		
D990030	A	Beam Dump Flex Hinge Tee	013-016	4			3	4				
D990031	A	Beam Dump Flex Hinge Saddle	013-015, 010	4			4	3	1			
D990032	A	Beam Dump Flex Hinge Attach	014 017	4			4	4				
D990033	A	Beam Dump Flex Hinge Adapter	018, 015, 011	4		3						
D990140	D	Beam Dump Housing Plate	009, 010	2		2						
D990149	C	"Cavity Beam Dump, Mounting Bracket Angle "	010, 012, 014, 015	4			4	4				

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.

LIGO PROCESS TRAVELER

DCC Number: **E990279-01-X**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 40	VBO Load 41	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	VBO Load 52	VBO Load 54
D990150	B	"Cavity Beam Dump, Mounting Bracket Gusset "	013, 014, 016, 017	4			4		4			
D990151	B	"Cavity Beam Dump, Mounting Bracket Backplate 1"	009, 015, 019 016	4			4		4			
D990152	C	"Cavity Beam Dump, Mounting Bracket Backplate 2"	016, 017 010, 012	4			4		4			
D990198	B	Beam Dump Flex Hinge H_tube	008, 011, 006	4								3
D990199	A	Beam Dump Flex Hinge Low Strap	012, 014, 016, 017	4				4				
D990200	A	Beam Dump Flex Hinge Backup	007, 008, 025, 027, 035, 036 019, 032	8			8		8			
D990201	A	Beam Dump Flex Hinge Cap	030, 032, 038, 035, 018, 028, 031,037	8			8	8				
D990202	B	Beam Dump Flex Hinge Top Strap	011-014	4			4	4				
D990207	B	"rail, plate beam dump"	015-018	4			3		4			
D990218	B	"glass, plate beam dump"		2								
D990222	A	Beam Dump Housing Tube 2KBSAR3		0								
D990223	C	Beam Dump Housing Tube 2KFM		0								

LIGO PROCESS TRAVELER

DCC Number: **E990279-01-X**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 40	VBO Load 41	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	VBO Load 52	VBO Load 54
D990225	D	"Beam Dump Housing Tube 4KITMHR3, 4KITMHR4"		0								
D990236	B	"backplate_offset, plate beam dump"		0								
D990240	B	"backplate, plate beam dump"		0								
D990252	B	"Beam Dump Housing Tube ITMARI,2KRMIIR3"		2								
D990253	A	Extension Tube	004, 005	2			1		1(004)			1(005)
D990335	A	"Beam Dump Flex Hinge H_tube, 2KITMXAR4 "		0								
D990336	A	"Beam Dump Flex Hinge H_tube, 2KITMYAR4"		0								
WFV-10		#10 X 0.31 THK FLAT VENTED WASHER		32								
93615A355		#10-24 X 0.75 LOW HD SCS		24	24							40
92196A245		#10-24 X 0.75 SHCS		8	8							
WFV-06		#6 X 0.016 THK FLAT VENTED WASHER		8								
92196A144		#6-32 X .25 SHCS		8	8							40
WFV-08		#8 FLAT VENTED WASHER		68	48							
92185A194		#8-32 X .50 SHCS		68	68							20
91500A194		#8-32 X .500 FHPS		36	36							
91944A450		0.406ID X 0.88OD X 0.25 THK SPHER WASH		16	16							
92141A029		1/4 FLAT WASHER		32	32							
N-2520-A		1/4-20 HEX NUT		16	16							
93615A410		1/4-20 X .500 LOW HEAD SOCKET SCREW		16	16							
92196A540		1/4-20 X 0.75 SHCS		48	48							
92196A542		1/4-20 X 1.00 SHCS		32	32							
C-2016-NA		"1/4-20 X 1.00 SHCS, AG/SS"		40	20							
92196A544		1/4-20 X 1.25 SHCS		16	16							20
C-2820-NA		"1/4-28 X 1.25 SHCS, AG/SS"		24	24							
91950A031		3/8 X 0.063 FLAT WASHER		6	6							
WFV-38		3/8 X 0.032 THK FLAT VENTED WASHER		42	42							
94804A320		3/8-16 HEX NUT		8	8							

LIGO PROCESS TRAVELER

DCC Number: **E990279-01-X**
 Date Prepared: **7/8/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	VBO Load 40	VBO Load 41	VBO Load 43	VBO Load 46	VBO Load 48	VBO Load 50	VBO Load 52
N-3816-A		"3/8-16 HEX NUT, AG/SS"		4	4						
TOP-1616-NA		3/8-16 X 1.00 SOCKT SET SCRW-OVL PT AG/SS		8	8						
90585A626		3/8-16 X 1.25 FLT HD CAP SCREW		8	8						
92186A626		3/8-16 X 1.25 HEX HD SCREW		16	16						
C-1620-NA		"3/8-16 X 1.25 SHCS, AG/SS"		8	8						
92186A630		3/8-16 X 1.75 HEX HD SCREW		4	4						
92196A630		3/8-16 X 1.75 SHCS		12	12						
92186A999		3/8-16 X 7.00 HEX HD SCREW		16	16						
099-966-12-20x		BERYLLIUM-CU GND STRP		8	8						
6032-400		Flex Pivot		8							4

Used In (next higher assembly): D990230, BSC Beam dump Installation, top assembly

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean	6/18	LHO	per LIGO-E960022, as applicable	B. Weaver	
3	Vacuum Bake	SEE NEXT PAGE	LHO	per LIGO-E960022	K. Ryan	SEE NEXT PAGE
4	Wrap and Bag		LHO	per LIGO-E960022	B. Weaver	

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.

LIGO PROCESS TRAVELER

DCC Number: E990279-01-X

Date Prepared: 7/8/99

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.													
5	Control Point	6-24-99 6-28-99 07-06-99 07-20-99	LHO	Review/approve RGA: VBO Load# 40 scan # <u>060899C.RGA</u> VBO Load# 41 scan # <u>070299C.RGA</u> VBO Load# 43 scan # <u>RESERVED</u> VBO Load# 46 scan # <u>072699C.RGA</u> VBO Load# 48 scan # <u>080399C.RGA</u> VBO Load# 50 scan # <u>081099C.RGA</u> VBO Load# 52 scan # <u>082099C.RGA</u> Note: attach RGA scan(s) to this traveler. <u>VBO LOAD 54</u>	K. Ryan KRW KRW KRW KRW KRW	7/28/99 8/10/99 8/10/99 9/14/99													
	Box for shipment to LHO			Ship in LIGO-provided container <table border="1"> <thead> <tr> <th>No.</th> <th>Qty per package</th> <th>Part</th> </tr> </thead> <tbody> <tr> <td>ALL</td> <td></td> <td>BEAM DUMP PARTS</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table> (see also qty. for each shipping destination below)	No.	Qty per package	Part	ALL		BEAM DUMP PARTS									
No.	Qty per package	Part																	
ALL		BEAM DUMP PARTS																	
7	Ship																		
				<table border="1"> <thead> <tr> <th rowspan="2">No.</th> <th colspan="3">Ship Qty.</th> <th rowspan="2">Part Description</th> </tr> <tr> <th>LHO</th> <th>LLO</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td></td> <td>all</td> <td></td> <td></td> <td>beam dump parts</td> </tr> </tbody> </table>	No.	Ship Qty.			Part Description	LHO	LLO	Other		all			beam dump parts		
No.	Ship Qty.			Part Description															
	LHO	LLO	Other																
	all			beam dump parts															
			LHO:	Attn: Betsy Weaver, COS LIGO Hanford Observatory (LHO) Specific Purpose: beam dump BSC8															
			LLO:	Attn: Jonathan Row LIGO Livingston Observatory (LLO) Specific Purpose: beam dump BSC8															
			N.B.: A copy of this traveler must be submitted to the DCC each time the original is shipped with the LIGO Livingston Observatory (LLO) has been completed.																

Special Instructions (Handling/Packaging Constraints, Remarks, etc.) or Notes:

Attention: Betsy Weaver, Jonathan Kern, hold cleaned and baked parts for COS assembly

LIGO PROCESS TRAVELER

DCC Number: **E990279-01-X**
 Date Prepared: **7/8/99**

ACTION ITEMS:

Table 1:

DATE	NAME	DESCRIPTION
7/20	B. Weaver	S/N 012-013 of parts D980087, D980088, D980296, and D980297 were sent back to Spacecraft Spec. for rework, as we found that they had not been manufactured completely.
7/15	B. Weaver	V60 Load #43 - Rejected due to bad scan. Dennis Coyne sent all parts from this load (plus some) to be electropolished or etched for better cleaning.
7/23	B. Weaver	Parts received back from polishing/etching companies. - Re-cleaned as per Dennis C.'s email (attached).
8/5/99	B. Weaver	Clearis D990029 s/n-019 was sent out for modification as per DCN#: E990273-B / D990029-B. Rec. back - 8/4.
9/10/99	B. Weaver	D980348 s/n 027 & 028 Sent to Brookman Mfg. for rework - holes made into slots to compensate for low clearance.

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.

Table 1:

DATE	NAME	DESCRIPTION

X-POP3-Rcpt: bweaver@apex
Date: Thu, 22 Jul 1999 12:12:31 -0700
From: Dennis Coyne <coyne@ligo.caltech.edu>
Organization: Caltech/LIGO
X-Mailer: Mozilla 3.01Gold (Win95; I)
To: Betsy Weaver <weaver_b@ligo.caltech.edu>
CC: Stan Whitcomb <stan@acrux.ligo.caltech.edu>,
Mike Smith <smith@acrux.ligo.caltech.edu>,
Bartie Rivera <rivera_b@ligo-wa.caltech.edu>
Subject: Re: cleaning

VBO LOAD 48

Betsy,

You should clean as follows (E960022-05 except since the parts are too large to ultrasonically clean, I've tailored the cleaning):

1) clean with Liquinox first (solution per E960022-05) and using a rubbing/scrubbing action (i.e. not just rinsing the liquinox over the surfaces). All holes must be cleaned with a brush (stainless steel, phosphor-bronze preferred, but nylon is acceptable). It is ESSENTIAL that the liquinox NOT dry before being rinsed with DI water.

2) Thoroughly rinse with DI water. All surfaces and holes must be rinsed THOROUGHLY.

3) Rinse & rub (with gloved hand only) all surfaces with either methanol or isopropal alcohol. Squirt the solvent into all holes.

4) Blow dry with clean, filtered air or N2, or allow to dry on a clean bench. Do not leave exposed for longer than about 15 minutes, before covering with UHV foil.

With regard to cleaning the lens, please see Stan for a confirmation, but I believe the rule that we operate under is that if all surfaces are polished, then an optics cleaning and wetting test is adequate and no baking is required. However, if the sides of the optic are not polished (as I suspect is the case for the ETM optics), then it should be cleaned and baked and re-cleaned. However, please confirm this with Stan and he may grant a waiver if he examines the surface condition of the optics.

Dennis

Betsy Weaver wrote:

- >
- > Hi Dennis-
- >
- > Two cleaning questions for you:
- >
- > 1. We just received the aluminum load (COS) from the etching company.
- > How should we clean them here, before baking them? (They are

- > obviously too large to put in the ultrasonic cleaner...)
- >
- > 2. Mike has one large and two small lenses that are going to be
- > used in the ETM Telescope Assembly. If they wet well during cleaning,
- > do they really need to be baked? A while ago, Stan told me that the
- > small steering mirrors for IO and COS did not need to be baked, as the oven
- > would just make them dirtier, because they wetted so well during cleaning.
- > Is this the same for the lenses? If they do need to be baked, can I put
- > them in
- > the next load with the one Large Optic?
- >
- > Thanks-
- > Betsy

--
Dennis Coyne (Detector Installation Manager)
LIGO Laboratory, Caltech, Physics Department
626.395.2034 @CIT / 225.686.3168 @Livingston / 509.372.8166 @Hanford
cell 626.695.8350

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**
 Date Prepared: **8/9/99**

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Michael Smith	Michael Smith	2062	COS	5F515

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 49	VBO Load 52	VBO Load
		Pick Off Telescope_APS						
D980628	B	"front baffle, beam dump assy, BD BSAR1P/3P"		0				
D980555	B	"Brkt., End Baffle"		0				
D980558	B	"Bar, Lower - End Baffle"		0				
D980607	B	"Bar, Spring Strip Mounting"		0				
D980608	B	"Bar, Spring Strip Retainer"		0				
D980614	B	"Bar, Left - End Baffle Long"		0				
D980615	B	"Bar, Right - End Baffle Long"		0				
D980655	B	"forward camera mount, assy"		1				
116-0080	.	LASER MOUNT (Black Anodized) - CLASS B		1				
92196A194	.	#8-32 X .50 SHCS		8	8		8	
92196A197	.	#8-32 X .75 SHCS		4	8		8	
92196A537	.	1/4-20 X .50 SHCS		2	2		2	
98019A325	.	#8 FLAT WASHER		8	8		8	
D980587	B	Plate, alignment telescope	001	1	1		1	
D980588	B		001, 002	2	2		2	
D980589	B	Bracket, alignment telescope	001, 002	2	2		2	
D980656	B	"target camera mount, assy"		1				
90145A470	.	1/8 X .38 DOWELL		4	2		2	
92196A079	.	#2-56 X .38 SHCS		16	16		16	
92196A109	.	#4-40 X .38 SHCS		8	8		8	
92196A115	.	#4-40 X 1.00 SHCS		8	8		8	
92196A537	.	1/4-20 X .50 SHCS		1	1		1	
D980572	B	Plate, target support, long	001, 002	2	2		2	

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.

LIGO PROCESS TRAVELER

DCC Number: E990311-00-X

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 49	VBO Load 52	VBO Load
D980573	• B	Plate, target support, short	001, 002	2	2		2	
D980574	• B	Frame, target	001, 002	2	2		2	
D980575	• B	Target - <i>Airbake</i>		2	2			
D980603	• B							
D980604	• B	Brace, camera/target	001-004	4	4		4	
D980621	B	"front support, assy"		1			4	
92196A537	•	1/4-20 X .50 SHCS		8	8		8	
92196A540	•	1/4-20 X .75 SHCS		8	8		8	
92196A542	•	1/4-20 X 1.0 SHCS		2	2		2	
92196A546	•	1/4-20 X 1.5 SHCS		10	10		10	
SSPW-1	•	SPHERICAL WASHER		16	16		16	
D980565	• B	"Bar, Vert., Front Support"	001, 002	2	2		2	
D980566	• B	"Gusset, Rear, Front Support"	001, 002	2	2		2	
D980567	• B	"Gusset, Front, Front Support"	001, 002	2	2		2	
D980568	• B	"Brace, Horiz., Front Support"	001	1	1		1	
D980569	• B	"Plate, Base Front Support"	001	1	1		1	
D980570	• B	"Block, Interface, Vert. Lock"	001, 002	2	2		2	
D980571	• B	"Plate, Vertical Lock, Front Support"	001, 002	2	2		2	
90210A112	•	1/4-20 X 2.00 THUMBSCREW		1	1		1	
92196A192	•	#8-32 X .38 SHCS		18	18		18	
92196A195	•	#8-32 X .50 SHCS		2	2		2	
92196A540	•	1/4-20 X .75 SHCS		60	60		60	
D980622	B	"square tube, telescope parabolic, assy"		1				
93085A192	•	"#8-32 X .38 FHPS, 100 DEG"		60	60		60	
WFV-25	•	1/4 FLAT VENTED WASHER		60	60		60	
D980546	• B	"Sheet, Upper-Sq. Tube"	001	1	1		1	

LIGO PROCESS TRAVELER

DCC Number: E990311-00-X

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 49	VBO Load 52	VBO Load
D980547	B	"Sheet, Lower, Sq. Tube"	001	1	1		1	
D980548	B	"Sheet Left, Sq. Box"	001	1	1		1	
D980549	B	"Sheet Right, Sq. Box"	001	1	1		1	
D980550	B	Bulkhead - Title Plate	001-005	5	5		5	
D980551	B	Front Plate	001	1	1		1	
D980552	B	"Angle, Upper"	001, 002	2	2		2	
D980553	B	"Angle, Lower, Left"	001	1	1		1	
D980554	B	"Angle, Lower, Right"	001	1	1		1	
D980593	B	Block, thumbscrew, lateral adjustment	001	1	1		1	
D980601	B	"Base, lateral adjustment"	001	1	1		1	
D980658	B	" jackstand, assy "		1				
5201		TRANSFER PLATE		2				
6111K61		SWIVEL LEVELING MOUNTS		2				
92196A192		#8-32 X .38 SHCS		6	6		6	
92196A537		1/4-20 X .50 SHCS		24	24		24	
		JACKSCREW 'C'	001, 002	2	2		2	
		"SPACER, 2.5X6X0.62, 300 CRES"	001, 002	2	2		2	
D980595	B	Horizontal plate, jack stand	001-008	8	8		8	
D980596	B	Vertical plate, jack stand	001, 002	2	2		2	
D980597	B	Glide plate, jack	001, 002	2	2		2	
D980598	B	Base plate, jack	001, 002	2	2		2	
D980599	B	Base, jack	001, 002	2	2		2	
D980600	B	Vertical plate, short jack stand	001, 002	2	2		2	
D980623	B	" mirror box, telescope parabolic, assy "		1				
90945A761		1/4 FLAT EDGED SPACER WASHER		3	3		3	
92196A197		#8-32 X .75 SHCS		16	16		16	

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**
 Date Prepared: **8/9/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 49	VBO Load 52	VBO Load
92196A540	.	1/4-20 X .75 SHCS		16	16		16	
WFV-08	.	#8 FLAT VENTED WASHER		32	32		32	
WFV-25	.	1/4 FLAT VENTED WASHER		16	16		16	
	.	#8-32 X 1.25 SHCS		16	16		16	
	.	"1/4-20 X 1.0 FSH, 82 DEG"		3	3		3	
D980541	B			1				
D980542	. B	"Plate, Bottom Mirror Box"	001	1	1		1	
D980543	. B	"Plate, Top, Mirror Box"	001	1	1		1	
D980544	. B	"Plate, Left, Mirror Box"	001	1	1		1	
D980545	. B	"Plate, Right, Mirror Box"	001	1	1		1	
D980581	B A	"Socket, Pivot"	001, 002	2	2		2	
D980583	. B	"Bar, Tube and Box, long"	001, 002	2	2		2	
D980594	. B	"Bar, Tube and Box, short"	001, 002	2	2		2	
D980619	. B	"Angle, Mirror Box"	001-004	4	4		4	
D990096	B	Back Plate	001	1	1		1	
D980626	B	"mirror mount assy primary mirror, telescope para- bolic"		1				
34665K29	.	"1/8 BALL, AL"		3	3		3	
90298A544	.	1/4 X 1 1/4 SHLDR SCR		3	3		3	
90945A761	.	1/4 FLAT EDGED SPACER WASHER		3	3		3	
90945A761	.	"1/4 FLAT WASHER, NAS620C-416"		6	6		6	
92311A237	.	#10-24 X 3/16 CUP PT ST SCR		3	3		3	
9713K63	.	Bellville Washer		24	24		24	
	.	#10-24 X 3/4 FSCS		6	6		6	
	.	#4-40 X 0.625 SHCS		6	6		6	
	.	"1/4-28 X 1.0 FSH, 82 DEG"		3	3		3	
5967	.	EXTENSION SPRING		2	2		2	

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.

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**

Date Prepared: **8/9/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO	VBO	VBO
						Load	Load	Load
90145A470		1/8 X .38 DOWELL		4	4	49	52	
90945A741		#10 WASHER		3	3		3	
90945A741		#10 WASHER		2	2		3	
90945A761		"1/4 FLAT WASHER, NAS620C-416"		14	14		14	
92196A196		#8-32 X .50 SHCS		4	4		4	
92196A197		#8-32 X .75 SHCS		2	2		2	
92196A542		1/4-20 X 1.0 SHCS		14	14		14	
92240A542		1/4-20 X 1.00 HEX BOLT		8	8		8	
92311A108		#4-40 X .38 SET SCREW		1	1		1	
WFV-25		1/4 FLAT VENTED WASHER		6	6		6	
		#10-32 X 0.50 SPHERICAL END ADJ SCREW		2	2		2	
		#10-32 X 0.63 SHCS		2	2		2	
		#4-40 X 1.25 SHCS		3	3		3	
		3/8 FLAT WASHER		4	4		4	
		3/8-24X1.0 SHCS		4	4		4	
		COMPRESSION SPRING		3	3		3	
D990097	B	Primary Mirror Mount Plate	001	1	1		1	
D990098	B	Primary Mirror Mount Clamp Base	001,002,003	3	3		3	
D990099	B	"Mirror Screw, Primary"		3				
D990101	B	Mirror Clamp Short Side	001	1	1		1	
D990102	B	Mirror Clamp long Side	001,002	2	2		2	
D990444	B		001,002,003	3	3		3	
D980625	B	"mirror mount assy secondary mirror, telescope parabolic"		1				
D980314	B	Y-Axis Top Plate	001	1	1		1	
D980315	B	X-Y Interface Plate	001	1	1		1	
D980316	B	Y-Top end Plate	001,002	2	2		2	

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.

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**

Date Prepared: **8/9/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load	VBO Load	VBO Load
D980317	B	X-Axis Way Plate	001	1	1	49	52	
D980318	B	Flexure Spring Block	001	1	1		1	
D980319	B	Flexure	001	1	1		1	
D980320	B	End Plate	001, 002	2	2		2	
D980321	B	Angle Plate	001	1	1		1	
D980578	B	"Threaded Rod, secondary mirror"		2				
D990100	B	"Mirror Screw, Base Primary"		3				
D990104	B	"Secondary Mirror, Clamp"		3				
D990443	B			2				
D990448	B	1/4-40 X 0.75 SLOTTED PUSH SCREW		3	3		3	
D980657	B	rear camera mount assy		1				
90945A761	.	"1/4 FLAT WASHER, NAS620C-416"		3	3		3	
92196A108	.	#4-40 X .38 SHCS		2	2		2	
92196A197	.	#8-32 X .50 SHCS		3	3		3	
98019A325	.	#8 FLAT WASHER		3	3		3	
		#4-40 X .38 THUMB SCREW		2	2		2	
D980576	B	"Sleeve, Alignment telescope"	001	2	1		1	
D980620	B	"rear support, assy"		1				
90145A541	.	"1/4" X .88 DOWEL PIN"		1	1		1	
90945A761	.	"1/4 FLAT WASHER, NAS620C-416"		4	4		4	
92196A537	.	1/4-20 X .50 SHCS		26	26		26	
92196A542	.	1/4-20 X 1.0 SHCS		4	4		4	
D980559	B	Plate Vert. Rear Support	001, 002	2	2		2	
D980560	B	"Stiffener, Vert., Rear Support"	001-004	4	4		4	
D980561	B	Brace Horz. Rear Support	001	1	1		1	
D980562	B	Plate Swivel Rear Support	001	1	1		1	
D980563	B	Plate Base Rear Support	001	1	1		1	

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.

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**
 Date Prepared: **8/9/99**

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 49	VBO Load 52	VBO Load
D980564	B	"Plate Vert. Lock/Pivot, Rear Support"	001, 002	2	2		2	
D980580	B	"Set Screw, Pivot"		2				
D980582	B	"Pin, Pivot"		2				
E980129		"par primary mirror, s polarization, APS"	#4650-00	1	1	1		
E980130		"par secondary mirror, s polarization, APS"	#4550-00	1	1	1		
14B-3410		Rod Mounts (Periscope)		2			2	
		Stainless Steel 20" Post (Periscope)		1			1	

Used In (next higher assembly): D980620, Assy, rear support; D980621, Assy, front support; D980622, Assy, square tube; D980623, Assy, mirror box; D980625, Assy, 2nd mirror nest; D980626, Assy, primary mirror nest; D980655, Assy, forward camera mount; D980656, Assy, target/camera mount; D980657, Assy, rear camera mount; D980658, Assy, jackstand;

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake	8-3-99	LHO	per LIGO-E960022	K. Ryan B. 2002	8-6-99

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.

LIGO PROCESS TRAVELER

DCC Number: **E990311-00-X**
 Date Prepared: **8/9/99**

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.									
5	Control Point	8-3-99 8-16-99	LHO	Review/approve RGA: scan # <u>080647C-2C1A</u> VBO load 49 (2 min) scan # <u>080299C-2C1A</u> VBO load 52 scan # _____ scan # _____ scan # _____ scan # _____ scan # _____	K. Ryan /E/C/	8/11/99 9/14/99									
	Box for shipment to LHO			Note: attach RGA scan(s) to this traveler. <table border="1" data-bbox="863 634 1570 857"> <thead> <tr> <th>No.</th> <th>Qty per package</th> <th>Part</th> </tr> </thead> <tbody> <tr> <td>ALL</td> <td></td> <td>PO telescope parts</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table> <p>(see also qty. for each shipping destination below)</p>	No.	Qty per package	Part	ALL		PO telescope parts					
No.	Qty per package	Part													
ALL		PO telescope parts													

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.

LIGO PROCESS TRAVELER

DCC Number: **E990310-00-X**
 Date Prepared: **8/9/99**

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Michael Smith	Michael Smith	2062	COS	5F515

Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load	VBO Load
		ETM Tel Mirror Bracket Spacer				52	
D990450	A	Spacer, Mirror Bracket		2	2	2	
		1/4-20 x 1.5 SHCS		2	2	2	
WFV-25		1/4 vented washer		2	2	2	

Used In (next higher assembly): D990053, ETM Telescope

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake		LHO	per LIGO-E960022	B. Weaver	

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.

LIGO PROCESS TRAVELER

DCC Number: E990310-00-X

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.												
5	Control Point		LHO	Review/approve RGA: VBO Load# <u>52</u> scan # <u>080030000</u> VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ VBO Load# _____ scan # _____ Note: attach RGA scan(s) to this traveler.	B. Weaver <i>BW</i>	8/30/99 9/14/99												
6	Box for shipment to LLO		CIT	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;">No.</th> <th style="width: 15%;">Qty per package</th> <th style="width: 75%;">Part</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">all</td> <td style="text-align: center;">spacer assy</td> </tr> <tr> <td> </td> <td> </td> <td> </td> </tr> <tr> <td> </td> <td> </td> <td> </td> </tr> </tbody> </table> <p style="text-align: center;">(see also qty. for each shipping destination below)</p>	No.	Qty per package	Part	1	all	spacer assy							K. Mailand	
No.	Qty per package	Part																
1	all	spacer assy																

LIGO PROCESS TRAVELER

DCC Number: **E990310-00-X**

Date Prepared:


DATE	NAME	DESCRIPTION

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.

LIGO PROCESS TRAVELER

DCC Number: **E990309-00-X**
 Date Prepared: **8/6/99**

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Michael Smith	Michael Smith	2062	COS	5F515

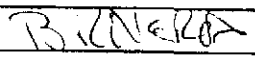
Dwg/Part Number	Rev	Part Description	Serial Number	Qty	Rec.	VBO Load 50	VBO Load 52
D990451	A	2K ETM PO Beam_Beam Dump					
D990009	A	Post Mirror Mount Bracket 	001	1	1		1
D990445	A	Black Glass, 2.4 Square	001	1	1		1
D990446	A	Clamp	001 - 004	4	4		4
D990447	A	Post, ETM Beam Dump ~27" Hollow (Al)	001	1	1		1
D990453	A	Base, Rod Mount, Long	001	1	1	1	
		1/4-20 x 0.50 SHCS		4	4		4
		#8-32 x 0.63 SHCS		4	4		4

Used In (next higher assembly):	D990451 2K ETM PO Beam_Beam Dump
---------------------------------	----------------------------------

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.

Process Flow:

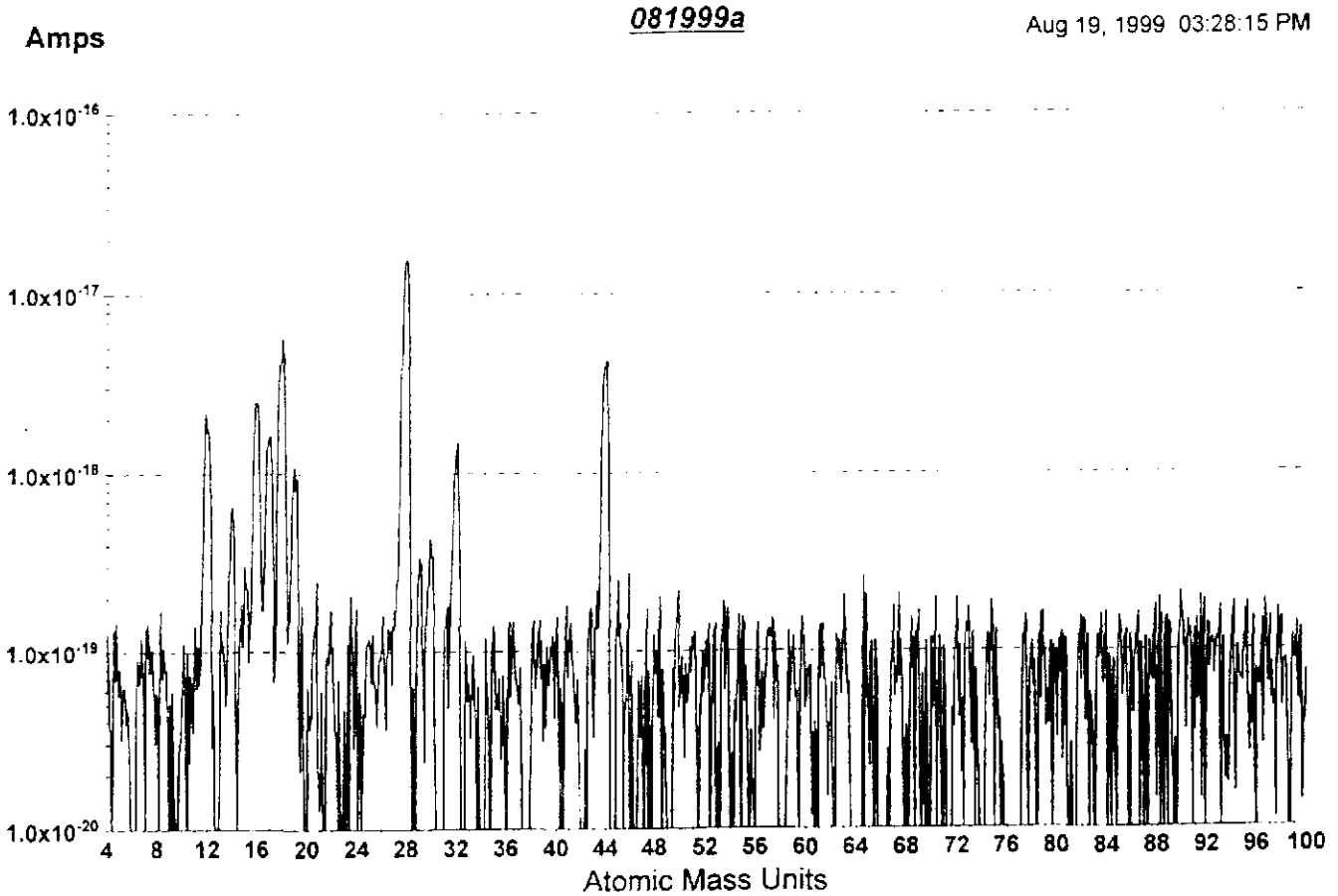
#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake		LHO	per LIGO-E960022 	B. Weaver	

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.

LHO VACUUM BAKE OVEN A LOAD #52 ELEVATED TEMPERATURE BACKGROUND

SCAN

V-I Closed

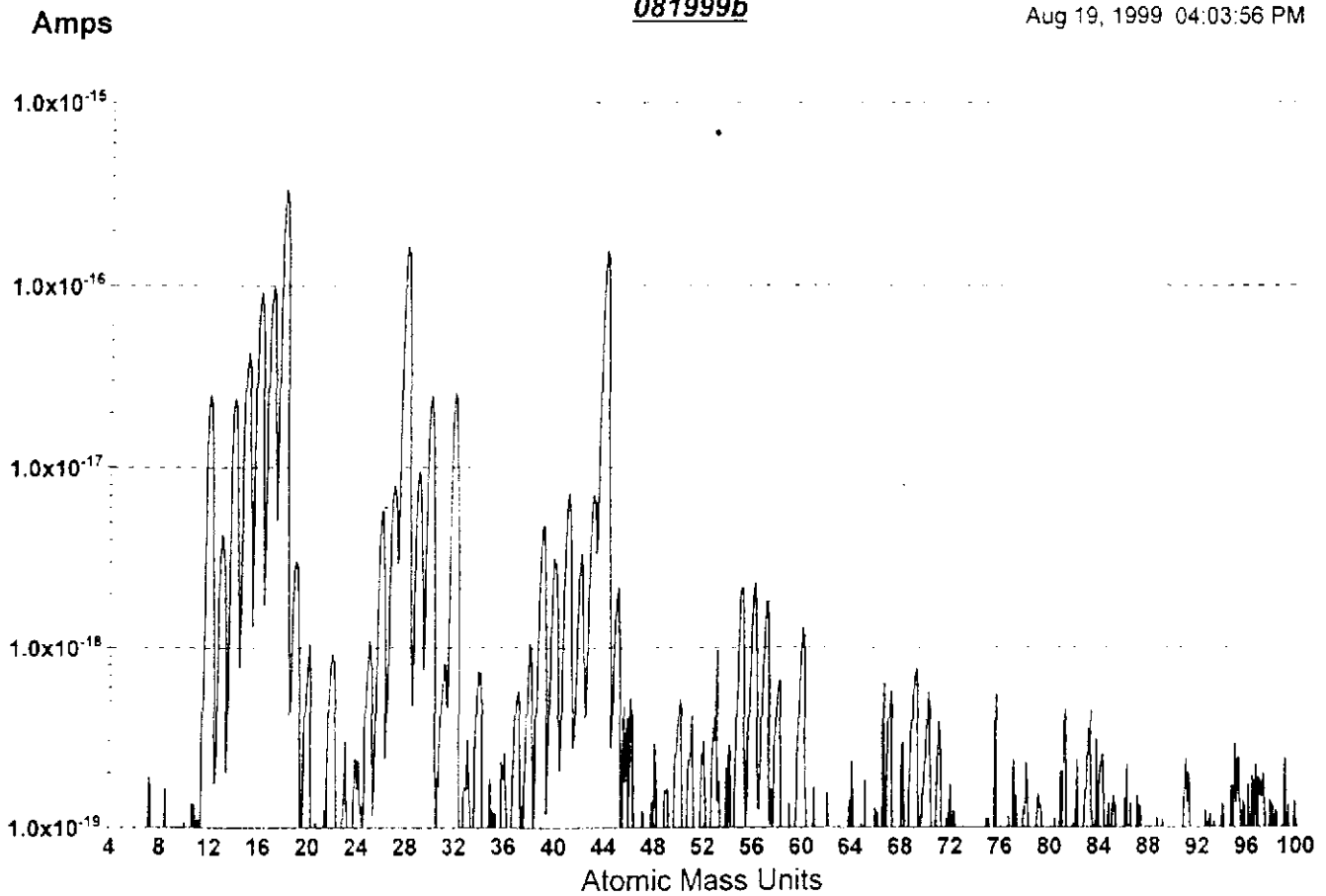


LHO VACUUM BAKE OVEN A LOAD #52 ELEVATED TEMPERATURE SCAN

V-1 Open, Cal-Gas and V-2 Closed, 64°C

081999b

Aug 19, 1999 04:03:56 PM



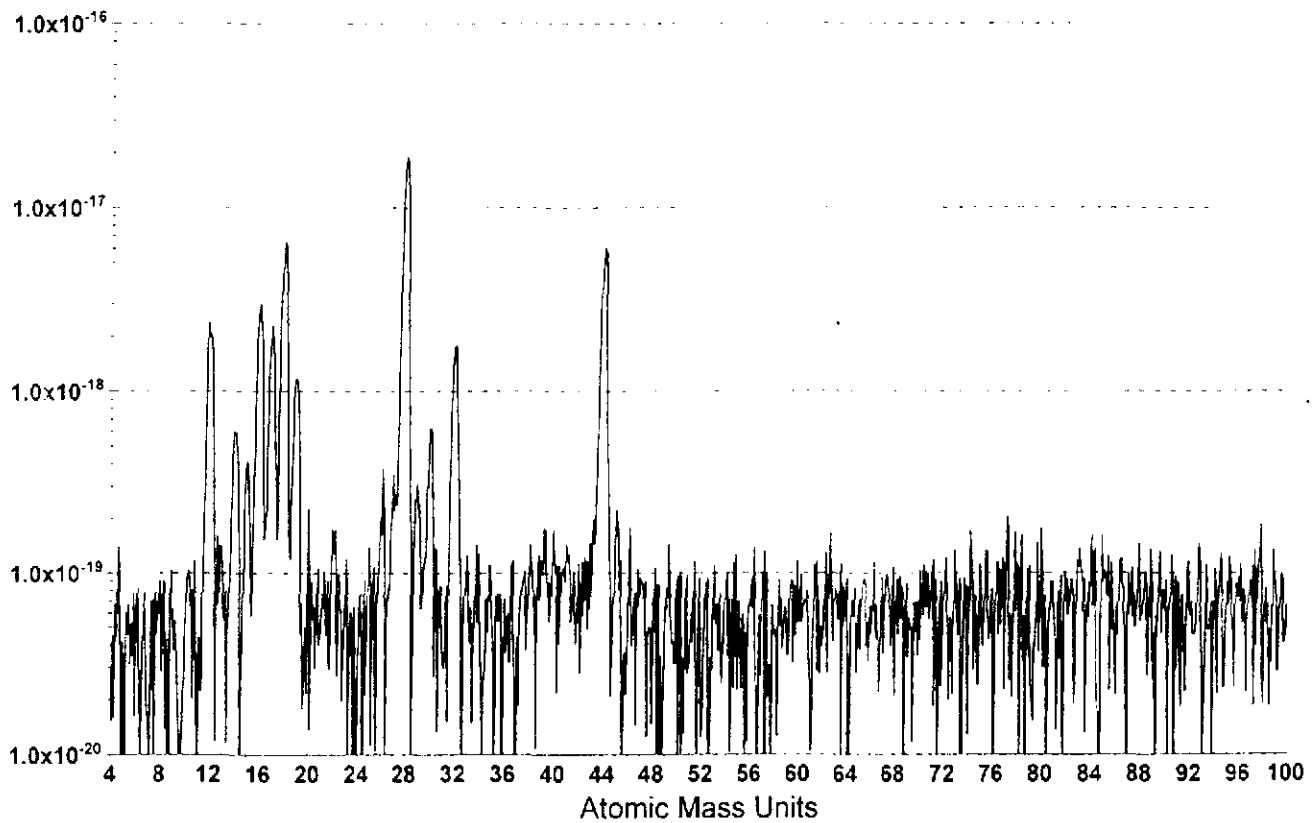
LHO Vacuum Bake Oven A Load #52 RGA Background

V-I Closed, Room Temp

Amps

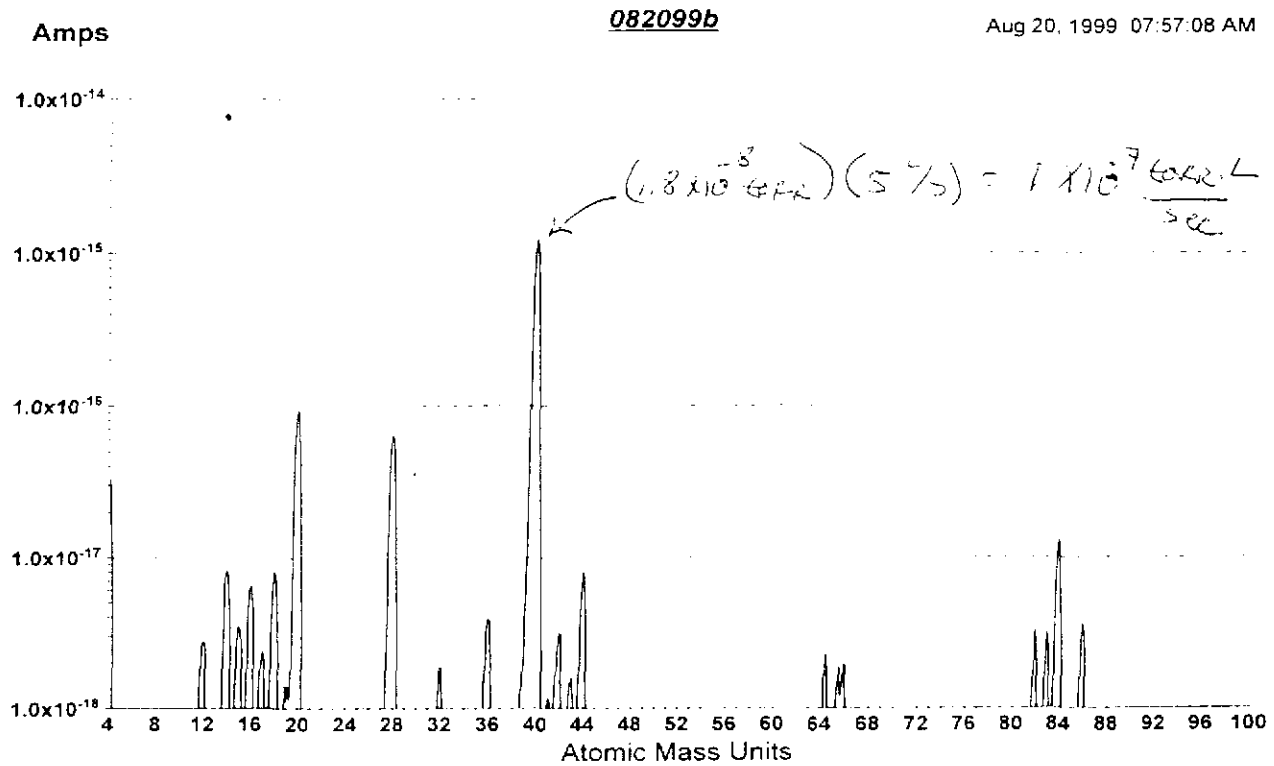
082099a

Aug 20, 1999 07:22:55 AM



LHO Vacuum Bake Oven A Load #52 Calibration

V-1 and cal-gas open V-2 closed in pressure equilibrium at room temperature



CF defined as $P_{\text{calc}(40)} / I_{\text{meas}(40)}$

$$P_{\text{calc}(40)} = (\text{leak rate}) / (\text{pump speed}) = (1.1\text{E-}7 \text{ torr} \cdot \text{L}/\text{sec})(0.86) / (5 \text{ L}/\text{sec}) = 1.8\text{E-}8 \text{ torr}$$

$$I_{\text{meas}(40)} = 1\text{E-}15 \text{ amps}$$

$$\text{CF} = (1.8\text{E-}8 \text{ torr}) / (1\text{E-}15 \text{ amps}) = 2\text{E}7 \text{ torr}/\text{amps}$$

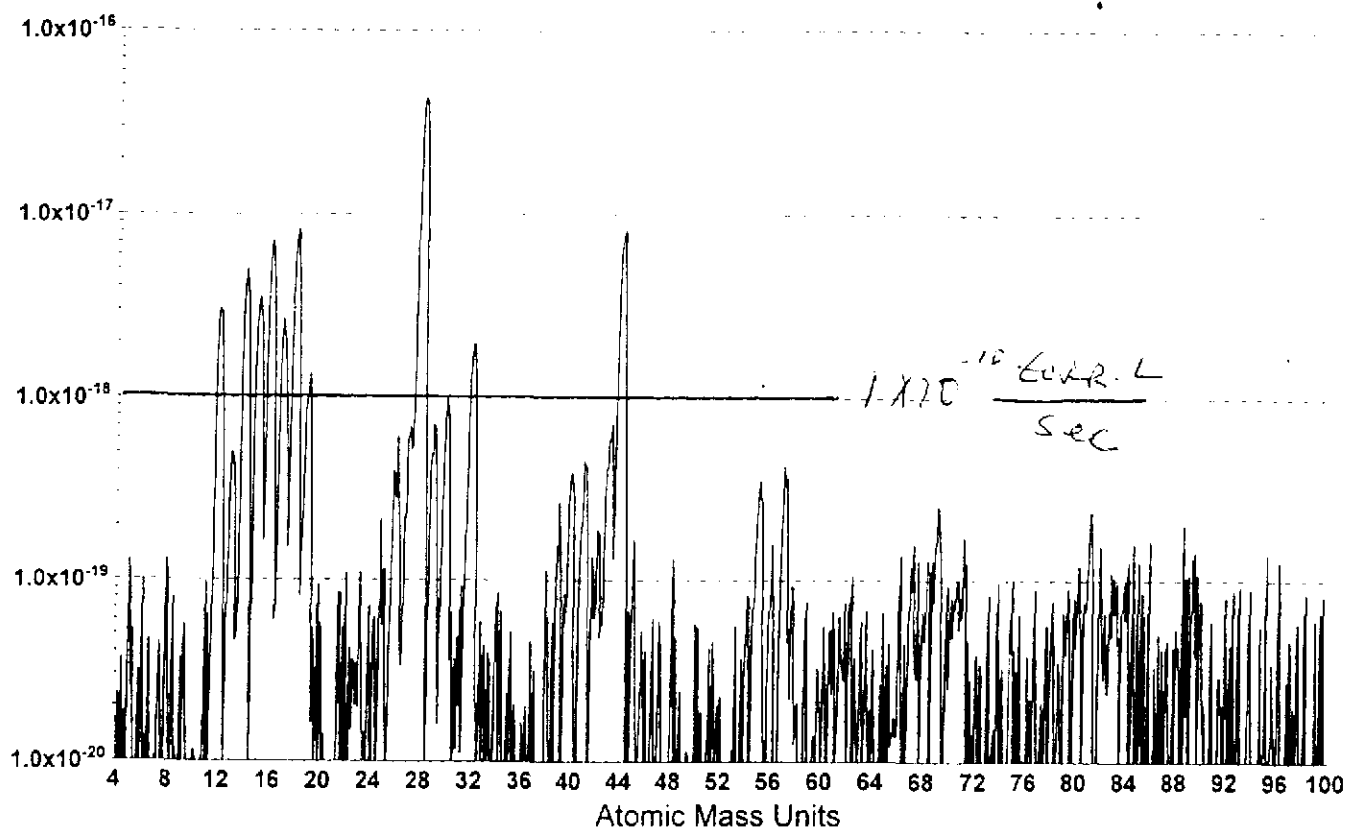
LHO Vacuum Bake Oven A Load #52 Post-Bake Scan Room Temp

V-1 Open, Cal-Gas and V-2 Closed

Amps

082099c

Aug 20, 1999 08:31:04 AM



LHO Bake Oven A Load # 52

1st Order Desorption Outgassing Rate Estimates using $Q_{low} = SP_{low} = SP_{high} [e^{-(E_s/kT_{high})}] / [e^{-(E_s/kT_{low})}]$

Number of units in bake load	Pump Speed (L/sec)	AMU	RGA background current (amps)	RGA current (amps) @ T_{high}	Calibration Factor CF (torr/amps)	T_{high} (K)	T_{low} (K)	E_s/k	Extrapolated outgassing rate (torr*L/sec) @ T_{low}
1	5	41	1.40E-19	4.50E-19	2.00E+07	3.37E+02	2.97E+02	13000	1.72E-13
1	5	43	2.00E-19	7.20E-19	2.00E+07	3.37E+02	2.97E+02	8000	2.13E-12
1	5	53	1.10E-19	below noise	2.00E+07	3.37E+02	2.97E+02	13000	below noise
1	5	55	1.20E-19	3.50E-19	2.00E+07	3.37E+02	2.97E+02	15000	5.73E-14
1	5	57	1.30E-19	3.70E-19	2.00E+07	3.37E+02	2.97E+02	15000	5.98E-14

X-POP3-Rcpt: brivera@apex
X-Sender: stan@127.0.0.1
X-Mailer: QUALCOMM Windows Eudora Light Version 3.0.5 (32)
Date: Wed, 08 Sep 1999 12:28:56 -0700
To: "Bartie J. Rivera" <rivera_b@ligo-wa.caltech.edu>
From: Stan Whitcomb <stan@ligo.caltech.edu>
Subject: Re: load 52

Right, I remember. You may consider this email my formal approval, and I will sign any paperwork next week.

stan

At 11:56 AM 9/8/99 -0700, you wrote:

>
>Hello Stan,
>
>Hope you are feeling better. I am just writing
>a reminder because load 52's post bake scan
>was approved in the lab off the computer screen, so
>I never got a signiture on the documentation and it took
>me forever to reconstruct the events surrounding this load.
>The load contained Betsy's cos structures and was "borderline"
>passing. This load was so "borderline" that you had suggested we
>follow it with a 200C bake to "clean up" the oven.
>
>I just wanted to drop a line to remind.
>
>Thanks
>Bartie
>
>