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**Ribbon/Fibre Length
Budget**

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Table of Contents

1 Introduction3

1.1 Purpose and Scope3

1.2 Version history3

2 Overview.....3

3 Operation details.....4

3.1 Fuse.....5

3.2 Pulling.....5

3.3 Profiling.....5

3.4 Strength testing6

3.5 Flexure correction; cutting and welding6

3.6 Ear position8

3.7 Ear bonding jig.....9

4 Implications for ear bonding..... 10

5 Appendix: CAD analysis of ribbon neck..... 10

5.1 Ribbon profile..... 10

5.2 CAD model 11

5.3 Analysis at default welding point..... 13

5.4 Flexure length as a function of welding point 14

1 Introduction

1.1 Purpose and Scope

In the quad noise prototype, the test mass must hang with its vertical centre line a specific distance below that of the penultimate mass: τ_{13} in the nomenclature of the Matlab/Mathematica models. Also, the effective flexure points of the ribbons must be inset by distances d_3 and d_4 from the mass centre lines. To meet these constraints will require careful length budgeting at all stages from ribbon production, though ribbon characterization and bonding of ears, to welding of ribbons.

1.2 Version history

6/10/07: Pre-rev-00 draft #1. Basic description of desired sequence to get feedback.

8/22/07: Pre-rev-00 draft #2. Details of ear bonding calculations added.

8/27/07: Pre-rev-00 draft #3. Flexure correction calculation.

8/27/07: Pre-rev-00 draft #4. Extended flexure correction calculation exploring effect of different dweld values. This is the version that was used at LASTI for the initial round of ear bonding. Turned out to contain errors in Table 2 and Figure 14, but fortunately was correct in the all-important Table 3. Released retrospectively as Rev. -00 in view of its historic importance.

9/3/07: Pre-rev-00 draft #5. Rework of Table 2, Table 3 and Figure 14 to include preliminary results from Phil Willems. Should have been a pre-rev-01 draft.

9/14/07: Rev-01. Revised flexure calculation with better constraints at the simulated welding points. Added Phil Willems as author.

2 Overview

The following section gives a list of the operations that need to be considered in the length budget.

A fused silica slide is mounted with adhesive into two roughly cylindrical “holsters” to form a “fuse”. At the time of writing, the jig to do this already exists, and the dimensions of the fuse are taken to be fixed.

The holsters of the fuse are hooked into roughly U-shaped “master pulling clamps” which accompany the fuse for much of the rest of the processing and allow tension to be applied to the slide.

The fuse in the master pulling clamps is mounted into a frame comprising two “mount plates” and two “hanger plates”, held apart by two “bracing bars”. The bracing bars support and protect the slide by keeping the mount plates in a fixed relationship while they are attached to the carriages of the pulling machine. Micrometers on the mount plates allow them to conform to any slight departure from coplanarity of the attachment surfaces of the carriages. When the micrometers have been adjusted and the fasteners have been tightened, the bracing bars are removed. (This is possibly overkill and may be revisited in favour of just moving the holsters.)

A high power CO₂ laser beam is aimed at a TBD position on the slide and the pull is started. The lower carriage moves up very slowly to feed fresh slide material into the heating zone, and the

upper carriage moves up at 25 times the rate to draw out a ribbon of approximately 1/5 both the width and thickness of the slide. After a TBD amount of travel, the laser is shut off and the pull is stopped.

The master pulling clamps are joined by two rather longer bracing bars (still being designed), removed from the pulling machine, and transferred to the profiler. (Again, this is possibly overkill and may be revisited.) One clamp is attached to the “base cartridge” at the bottom, and the other to the “alignment boss” at the top. The bracing bars are removed, and the ribbon is put under just enough tension (?) to hold it straight.

The profiler takes front and side pictures of the ribbon at regular intervals along the length and stitches them together to form width and thickness profiles.

After the profiling, the tension is relieved, the bracing bars are refitted (?), and the ribbon is transferred to the proof/bounce tester. There it is checked that the ribbon can withstand the required tension including safety factor, and the bounce mode frequency is measured with a reference mass so that the net longitudinal stiffness can be determined. After characterization, the pulling clamps are removed (?) and the ribbon is hung in a desiccator until needed.

For a representative sample of ribbons, the effective flexure point is calculated for each end, using the profiler data. Since it may not be possible for the profiler to capture the end of the fuse or another reference mark in a fixed relationship to it, it may be necessary to work relative to some feature of one or both necks that is easily recognizable from the profile data, e.g., the point where the width of the ribbon is half that of the slide. A relative position for the ribbon neck and ear is chosen that puts the flexure point a convenient distance off the tip of the ear for a typical ribbon.

The length of the pull is tuned such that the effective flexure points will be the required distance apart after allowing for the stretch of the ribbon under load.

The ears are bonded to the side of the masses. The flat on the side of each mass has a scribe line indicating the vertical centre, and the tip of the ear is located at a suitable offset from it to put the flexure point at the prescribed d_3/d_4 value.

The slide is scored and snapped in two places so as to extract the central ribbon section plus two tags long enough to give the right amount of overlap with the flats on the ears.

The test mass and penultimate masses are loaded into the lower structure at the heights that they will eventually hang at. The test mass is then raised by the amount of stretch that the ribbons will have under load, so that the tags on the untensioned ribbon can be placed against the ears and held in place until welding with a slight pressure from a sprung finger or the like (yet to be designed).

After all the ribbons are welded, the test mass is lowered a small distance to put a slight tension on the ribbons, which are then heated to correct any slight difference in length.

The test mass is lowered to its final hanging level and then forced a small distance further down to check that the welded ribbons can support the full load with the desired safety factor.

3 Operation details

3.1 Fuse

A ribbon fabrication slide of thickness t_{slide} , width w_{slide} and length d_{slide} is cemented into two “holsters” to form a “fuse”. Each end of the slide is inserted a distance d_{holster} , so the net length between holster inside faces is $d_{\text{fuse}} = d_{\text{slide}} - 2*d_{\text{holster}}$.

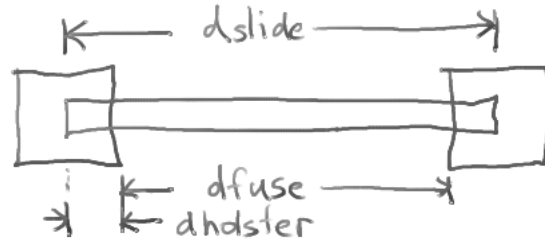


Figure 1: A “fuse” created from a slide and two “holsters”

3.2 Pulling

The fuse is installed between pulling clamps on the carriages of the pulling machine. A high power CO_2 laser is aimed at a spot d_{laser} from the bottom holster inside face. After the silica softens, the top carriage is moved upwards a distance d_{draw} to draw out a ribbon, while the bottom carriage moves up a somewhat lower distance d_{feed} to feed fresh material into the heating zone. The ratio of the carriage speeds will be approximately $r_{\text{carriage}} = d_{\text{draw}}/d_{\text{feed}} = 18.9$, so as to reduce the slide by a factor of $5/1.15 = 4.35$ in each direction. After the pull the holster inside faces are a distance $d_{\text{pulled}} = d_{\text{fuse}} + d_{\text{draw}} - d_{\text{feed}}$ apart.

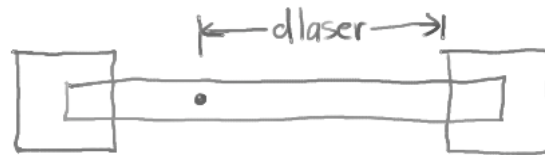


Figure 2: Pulling – before

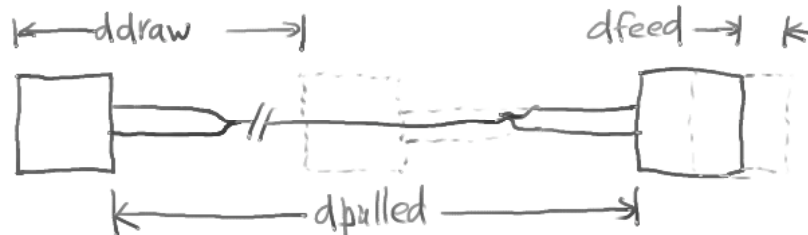


Figure 3: Pulling – after

3.3 Profiling

The ribbon is transferred, still in the holsters, to the profiler where the width and thickness profiles are measured. It is placed under very modest tension, enough to hold it straight but not change the overall length significantly from d_{pulled} . Because the profiler head cannot move down all the way to the bottom holster (and could not focus on it in any case) it is convenient to do subsequent calculations relative to the two points where the ribbon is half the thickness of the slide. The half-

thickness points are chosen because they are easy to identify accurately both in the profiler data and manually using a loupe with a graticle. Although as just noted the individual distances of the reference points from the holster inside faces are unlikely to be significant separately, we give them names d_{half1} and d_{half2} . (Here and subsequently we adopt the convention that names ending in 1 denote quantities describing the end of the ribbon to be used at the top near the penultimate mass, and symbol names ending in 2 indicate the bottom or test mass end.)

The remainder, $d_{ribbon} = d_{pulled} - d_{half1} - d_{half2}$ is an adequate approximation to the length of the ribbon for the purposes of calculating the stretch under load.

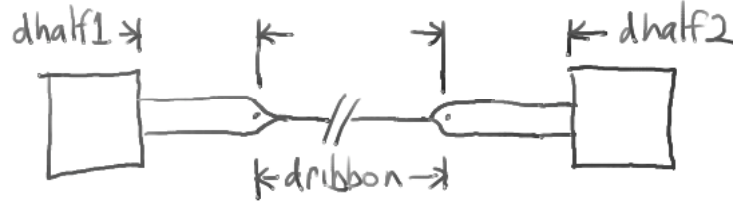


Figure 4: Profiling reference points

3.4 Strength testing

The longitudinal stiffness of the slide/ribbon

$$k_{ribbon} = \frac{Y}{\int_0^{d_{pulled}} \frac{1}{A(l)} dl}$$

where Y is the Young's modulus of silica and $A(l)$ is the cross-section as a function of length. Assuming that nearly all the stretch occurs in the central section of length d_{ribbon} stretches, this becomes

$$k_{ribbon} \approx \frac{Y * t_{slide} * w_{slide}}{d_{ribbon} * r_{carriage}}$$

The a priori value will be replaced as soon as possible by a measured value based either on the DC stretch for the proof mass, $k_{proof} = m_{proof} * g / d_{proof}$, or on the vertical mode frequency with the bounce test mass, $k_{bounce} = m_{bounce} * (2\pi f)^2$.

3.5 Flexure correction; cutting and welding

Since it is unlikely to be feasible to weld the delicate ribbon directly to an ear, some of the taper between the slide and ribbon sections will need to be allowed to protrude off the ear. The point on the slide level with the end of the ear is the welding point, and the distance from the reference point to the welding point is d_{weld1} or d_{weld2} . The distance from the welding point to the flexure point is the d_{flex1} or d_{flex2} . The distance in the opposite direction to the end of the lap section is d_{lap1} or d_{lap2} . A cutter needs to be designed to score and snap the slide at a distance $d_{cut1} = d_{weld1} + d_{lap1}$ or $d_{cut2} = d_{weld2} + d_{lap2}$ from the reference points.

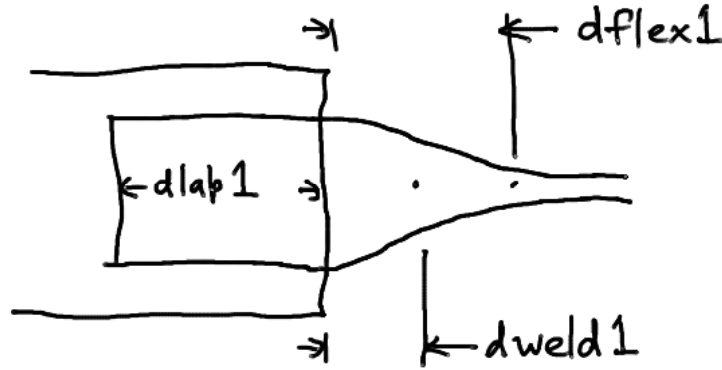


Figure 5: Welding and flexure points – top end

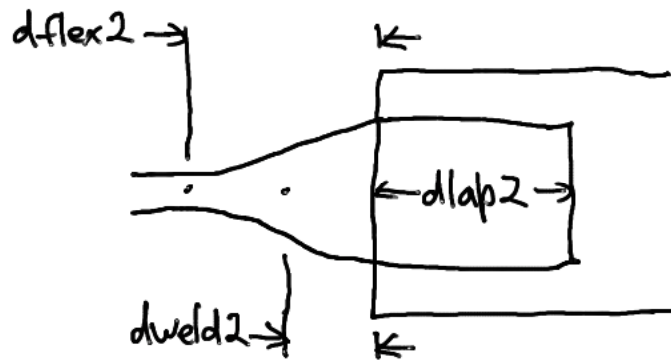


Figure 6: Welding and flexure points – bottom end

Unfortunately, $dflex_{1/2}$ is not a single number for a particular ribbon profile but depends on $dweld_{1/2}$. The general form of the dependence is as shown in Figure 7.



Figure 7: Dependence of dflex on dweld

For large positive $dweld_{1/2}$, i.e., for a large section of slide off the end of the ear, the flexure point increases at approximately the same rate because the slide is stiff. Conversely, for negative $dweld_{1/2}$, i.e., for the ribbon welded directly to the end of the ear, the flexure point is a small constant distance off the end (circa 0.3 mm) because the ribbon is thin and uniform. The final value will be in the roll-off region between the two simple regimes, so it will be necessary to plot the entire graph and read off the appropriate value when the smallest feasible $dweld_{1/2}$ is determined.

3.6 Ear position

The conceptual design calls for the flexure point at the top end of the ribbon to be $d3 = 1$ mm below the COM of the penultimate mass, and for the one at the bottom to be $d4 = 1$ mm above the COM of the optic. (These names are from the Matlab/Mathematica models and so do not follow the “1”/“2” convention.) The vertical COM for a wedged optic with flats is

$$zCOM = \frac{(-wabv + wafv) \left((tf^2 + 6 tr^2) \sqrt{-tf^4 + 4 tf^2 tr^2} + 24 tr^4 \text{ArcCsc} \left[\frac{tr}{\sqrt{-\frac{tf^2}{4} + tr^2}} \right] \right)}{24 tx \left(\sqrt{-tf^4 + 4 tf^2 tr^2} + 4 tr^2 \text{ArcCsc} \left[\frac{tr}{\sqrt{-\frac{tf^2}{4} + tr^2}} \right] \right)}$$

where tx is the thickness, tr is the radius, tf is the length of the flats and $wafv$ and $wabv$ are the slopes of the front and back faces, with positive meaning increasing x (towards the front) for increasing z (up). That is, a top-heavy wedge ($zCOM > 0$) has $wabv < 0$ and/or $wabh > 0$. The LASTI test mass has a $10^\circ \pm 5^\circ$ wedge, so $zCOM = 0.106$ mm, and the final ETM will probably have a 30° wedge, so $zCOM = +0.318$ mm. The penultimate masses are unwedged(?).

The value of $zCOM$ in the previous paragraph is relative to the axis of the barrel of the optic. This can be identified by scribe lines called out to be placed halfway up each flat. We define the distance from the tip of the ear to the scribe line to be $d\text{ear}1$ or $d\text{ear}2$. The distance from the scribe line to the COM is $dCOM1$ or $dCOM2$. For symmetry we choose the sign convention for $dCOM1$ to match $d3$ (but opposite to $dCOM2$, $d4$ and the formula for $zCOM$ above), i.e., positive down.

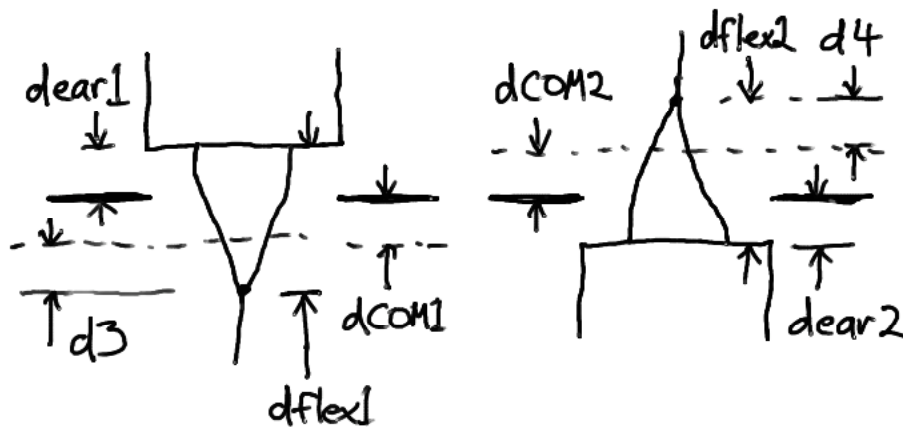


Figure 8: Ear positions

This implies

$$dflex1 = dear1 + dCOM1 + d3$$

and

$$dflex2 = dear2 + dCOM2 + d4$$

3.7 Ear bonding jig

The ear bonding jig clamps lightly to the side of the penultimate mass or optic and holds the ears in the correct position for bonding. It can be slid up or down to allow for different positions. On each side of the jig is a slot through which the scribe mark on the flat can be seen. Aligning the scribe marks on the flat with ones next to the slots centres the jig on the flat, which is approximately the correct position. In this neutral position the tips of the ears are a distance $d_{jig} = 2.25$ mm from the scribe height.

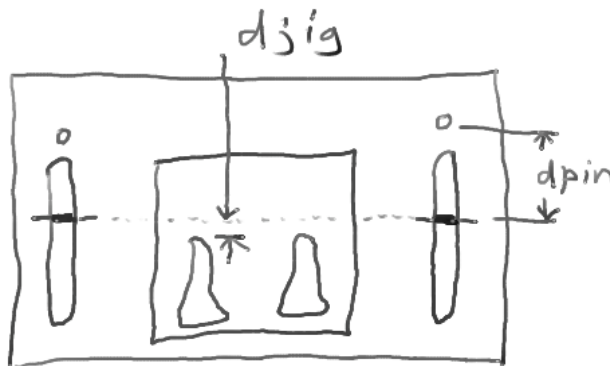


Figure 9: Bonding jig in neutral position – sliders not shown

Each slot has a slider which serves two purposes: (i) it can be set with calipers at a precise location relative to a locating pin to define a non-neutral position of the jig and (ii) by sighting down the edge of the slider, the position set at the top of the slot can be compared to positions on the flat below without parallax error.

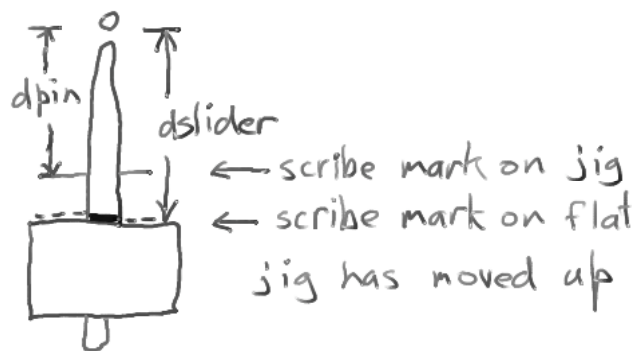


Figure 10: Use of slider on bonding jig

The distance from the pin to the scribe mark on the jig is d_{pin} . If the distance to the slider is set to some other value $d_{slider1}$ or $d_{slider2}$ and the edge of the slider is aligned with the scribe mark on the flat, then

$$d_{slider1} - d_{pin} = d_{jig} - d_{ear1}$$

or

$$d_{slider2} - d_{pin} = d_{jig} - d_{ear2}$$

That is, increasing the slider distance decreases the distance from the tip of the ear to the centre of the flat or the COM.

4 Implications for ear bonding

Combining the relationships in the previous sections gives the following values for `dslider1` and `dslider2` for use in ear bonding (see associated Mathematica notebook T070138-00.nb.):

$$dslider1 = d3 + dCOM1 - dflex1 + djig + dpin$$

and

$$dslider2 = d4 + dCOM2 - dflex2 + djig + dpin$$

Using the values in the table gives

$$dslider1 = 19.23$$

and

$$dslider2 = 19.34$$

(Note that in the draft of this document of 8/28/07 used at LASTI for the initial ear bonding, the values given here were 19.29 and 19.40 mm.)

Quantity	Value (mm)	Note
<code>dweld1</code>	2.6	From profile of “fibre 2” taken 08/23/07
<code>dweld2</code>	2.6	From profile of “fibre 2” taken 08/23/07
<code>dflex1</code>	3.02	From profile of “fibre 2” taken 08/23/07
<code>dflex2</code>	3.02	From profile of “fibre 2” taken 08/23/07
<code>dCOM1</code>	0	no wedge on PM
<code>dCOM2</code>	0.11	10’ wedge, top-heavy
<code>dpin</code>	19	from drawing by RAJ; TBC by IW
<code>djig</code>	2.25	from drawing by RAJ; TBC by IW

Table 1: Values for LASTI installation

5 Appendix: CAD analysis of ribbon neck

5.1 Ribbon profile

The top neck of “fibre 2” was chosen as representative of what could be expected, and profiled by Alan Cumming on 08/23/07. For simplicity we take the half-width point to be defined as the point of half the nominal width, i.e., exactly 2500 μm . From inspection of the somewhat noisy profiler data, this is somewhere in the range 3.204-3.317 \approx 3.3 mm in the profiler distance coordinate.

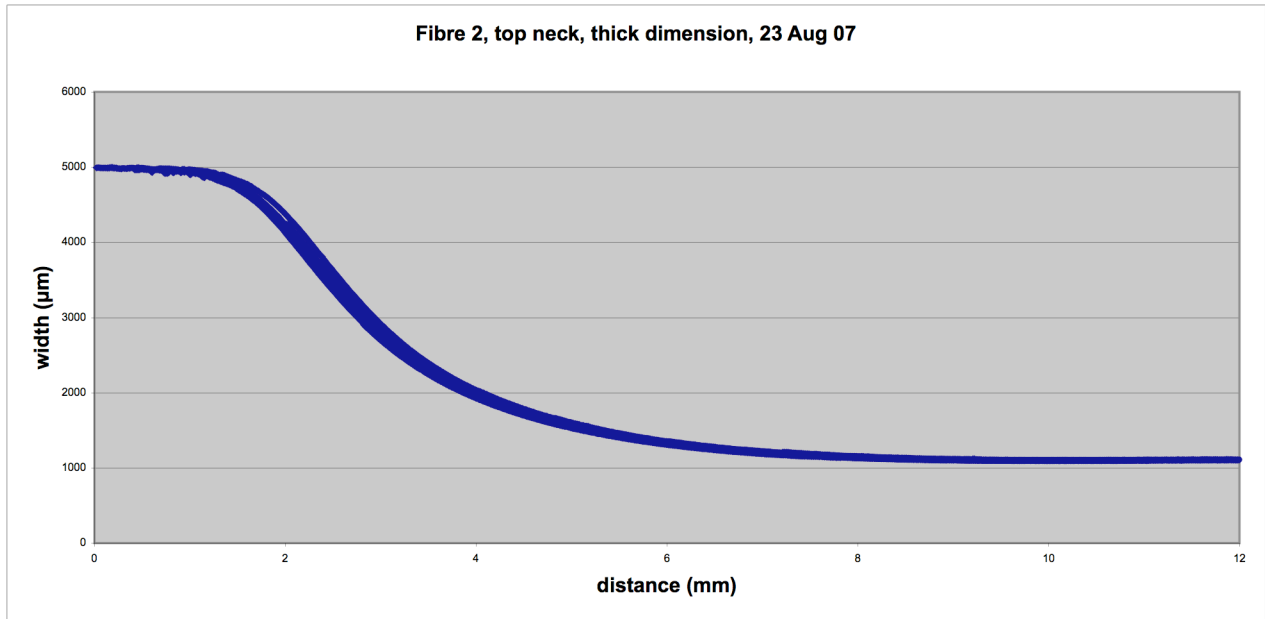


Figure 11: Fibre profile – width.

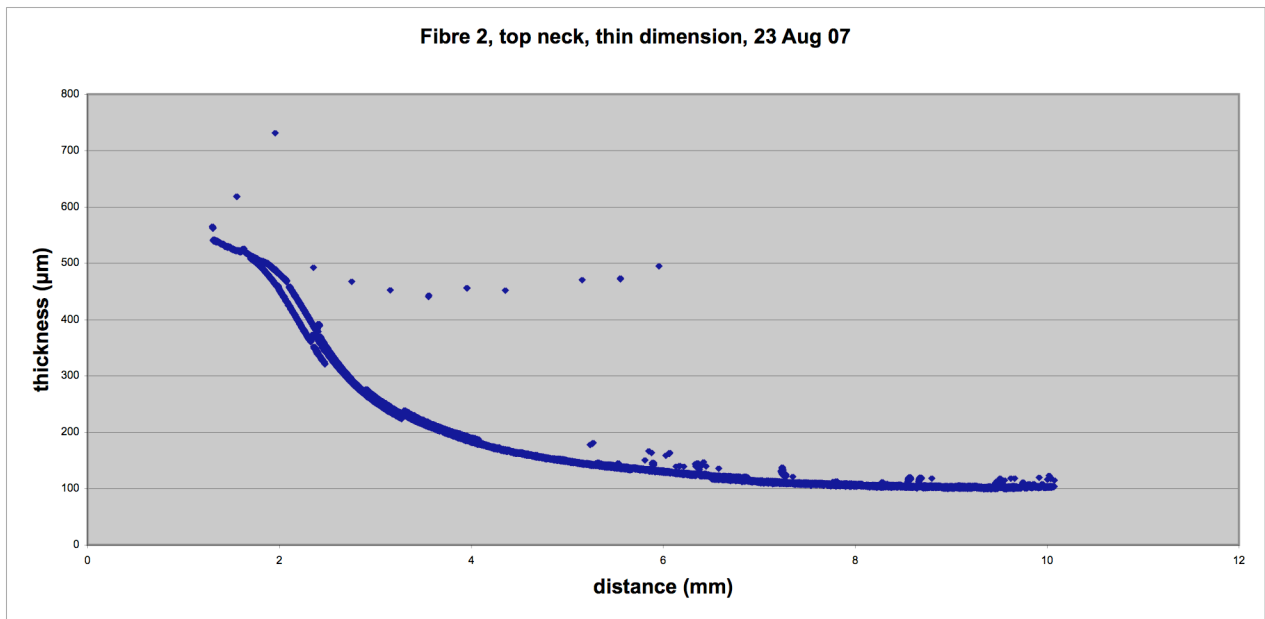


Figure 12: Fibre profile – thickness. An offset of 1.297 mm between the profiler width and thickness distance coordinates has been corrected

5.2 CAD model

The shape of the ribbon through the neck section was fitted as a piece-wise linear taper from the slide to the ribbon (assumed rectangular) via four intermediate rectangular cross-sections as shown in Table 2.

The half-width point is keypoint #7. The default welding point is keypoint #4, which is at the beginning of the taper. Keypoints #1, #2 and #3 were introduced to explore the effects of varying $d_{weld1}/2$. Keypoints #10 and #11 were introduced to allow the line of the straight section of the ribbon to be identified conveniently.

Width (μm)	Thickness (μm)	Profiler width coord (mm)	Distance to half-width point (mm)	-ANSYS Y coord (mm)	ANSYS keypoint number	ANSYS section name
4990	555	-5.3	-8.6	0	#1	slide
4990	555	-2.3	-5.6	3	#2	slide
4990	555	-0.3	-3.6	5	#3	slide
4990	555	0	-3.3	---	---	---
4990	555	0.7	-2.6	6	#4	slide
4851	429	1.3	-2.0	6.6	#5	sect1
4337	494	1.8	-1.5	7.1	#6	sect2
2440	210	3.3	0.0	8.6	#7	sect3
1410	138	5.7	2.4	11.0	#8	sect4
1122	108	9.3	6.0	14.6	#9	ribbon
1122	108	47.7	44.4	50	#10	ribbon
1122	108	97.7	94.4	100	#11	ribbon

Table 2: Simplified ribbon profile used for CAD. Bold entries were read from the measured profile – others are extrapolated assuming uniformity of slide and ribbon. The version of this table in Rev. -00 (used at LASTI for ear bonding) had an offset of 3 mm in the profiler width coordinate due to a error identifying the half-width point, but this did not affect the final ear position.

An ANSYS model incorporating this shape was constructed as follows:

Coordinate system: X longitudinal, Y vertical (+ve up), Z transverse

Element Types: Beam189.

Material Models: fused silica, density 2202, Young's modulus $7.2\text{E}7$, Poisson's ratio 0.17.

Real Constants: none.

Sections: rectangular sections as per Table 2, with B=thickness, H=width, $N_b=0$, $N_h=0$, plus taper sections, taper1=slide to sect1, taper2 = sect1 to sect2, taper3 = sect2 to sect3, taper4 = sect3 to sect4, taper5 = sect4 to ribbon.

Keypoints: as per Table 2.

Lines: between all consecutive pairs of keypoints (#1-#2, #2-#3, etc).

Loads: Displacement constrained in all DOFs at keypoint #1 and all other keypoints down to the welding point (initially keypoint #4); displacement UX=0.01 and load force FY=-97 at #11.

Meshing: All lines meshed with Beam189 with maximum element length of 0.0002 m and cross-sections as per Table 2.

Analysis Type: Static

Solution Controls: Large Displacement Static.

With these constraints, the model gave a plausible neck deformation as shown in Figure 13.

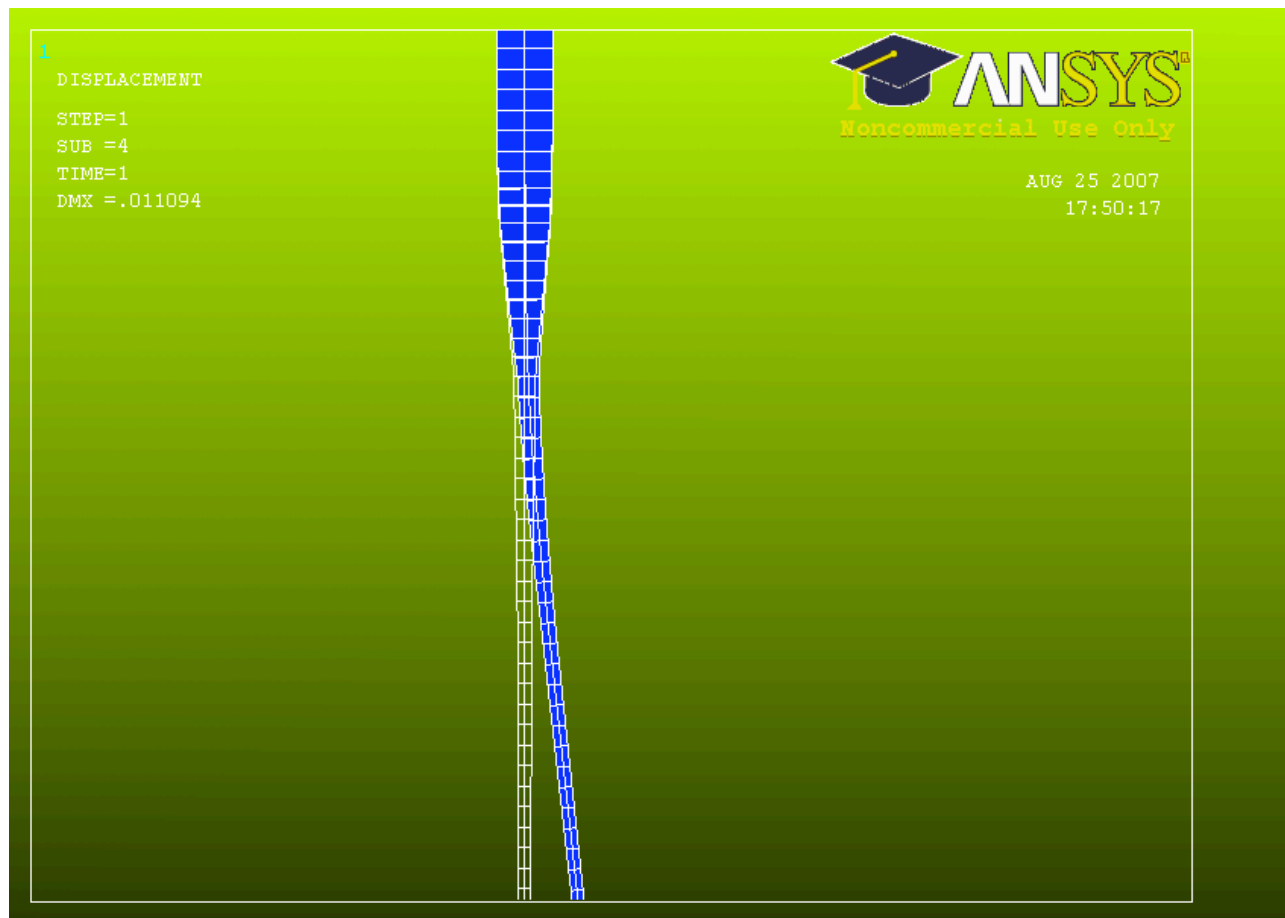


Figure 13: Deformed shape of neck for ribbon welded at keypoint #4 (the beginning of the taper).

5.3 Analysis at default welding point

The flexure point is defined as the point where the line of a section of the ribbon remote from the neck intersects the unbent line. This can be found by parameterizing the end of the ribbon as

$$x = m*(y-c)$$

and using values from two different points to eliminate m and determine c .

With the mesh parameters described above, 1103 nodes were generated. Using the Utility Menu List->Nodes... command, nodes #150 and #504 were identified as keypoints #10 and #11. Using the Nodal Solution command in the Main Menu twice (once for UX and once for UY), the deformed positions of the nodes were identified.

For the initial case with all-DOF constraints at keypoints #1, #2, #3 and #4 (simulating a weld with the tip of the ear at keypoint #4) this resulted in the following equations:

$$0.0044977 = m(-0.05 - 0.00020578 - c) \quad (\text{at KP\#10})$$

$$0.01 = m(-0.1 - 0.00047452 - c) \quad (\text{at KP\#11}).$$

As might be hoped, the x value of keypoint #11 was exactly 0.01 m due to the displacement constraint to that effect. Note that it is important to include the slight vertical sag as well as the horizontal displacement. Solving gives a flexure point of $c = -0.00911502$ m (in the ANSYS Y coordinate) or +9.1 mm down from keypoint #1.

To test the accuracy of the modeling, the model was regenerated with a maximum element length of 0.0001 (i.e., half the initial value) and parameters Nb=5, Nh=5 on all the sections (which selects for more elements laterally). The change in the computed flexure point was negligible.

The corresponding $d_{weld1/2}$ is the distance from keypoint #7 (the half-width point) back to the the weld point (keypoint #4), i.e., $8.6-6.0 = 2.6$ mm. In the same way, $d_{flex1/2}$ is the distance from the weld point forward to the flexure point, i.e., $9.1-6.0 = 3.1$ mm.

5.4 Flexure length as a function of welding point

To explore the effect of different welding points, we added and removed constraints to make each of the keypoints from #1 to #9 a simulated welding point in turn. In the draft of this document of 8/28/07 used at LASTI for earbonding, an all-DOF constraint was applied at keypoint #1, with UX constraints at each subsequent point down to the simulated weld. However especially for keypoints #8 and #9, this was inadequate and allowed some degree of pivoting at the simulated weld. As a result, the $d_{flex1/2}$ for keypoint #9 was only 0.2 mm, rather than the theoretically expected 0.3 mm. Thus in this final -00 version we used all-DOF constraints throughout.

The results are summarized in Table 3 and Figure 14. As might be hoped, the curve asymptotes to constant at 0.3 mm for negative $d_{weld1/2}$ (welding points in the uniform section of the ribbon). For small positive $d_{weld1/2}$, the curve is approximately linear with slope 1, and for larger values the beginnings of a roll-off to an asymptote at 30 mm can be seen. (30 mm = 100*0.3 mm is the flexure distance for the slide.)

Phil Willems did an independent calculation of the flexure correction. His values are incorporated in the table and plot. The agreement is very good.

Lowest constrained keypoint	Lowest constrained position (m)	Flexure position relative to top (m)	dweld1/2	dflex1/2
#1	0	6.19	8.6	6.19
#2	3	7.68	5.6	4.67
#3	5	8.79	3.6	3.79
			3.3	3.61
#4	6	9.02	2.6	3.02
			2.3	2.81
#5	6.6	9.12	2.0	2.52
			1.3	1.87
#6	7.1	9.18	0.9	2.08
#7	8.6	9.61	0	1.01
#8	11.0	11.47	-2.4	0.47
#9	14.6	14.90	-6.0	0.30

Table 3: Data for dflex and dweld. Bold entries are Phil Willems' calculation.

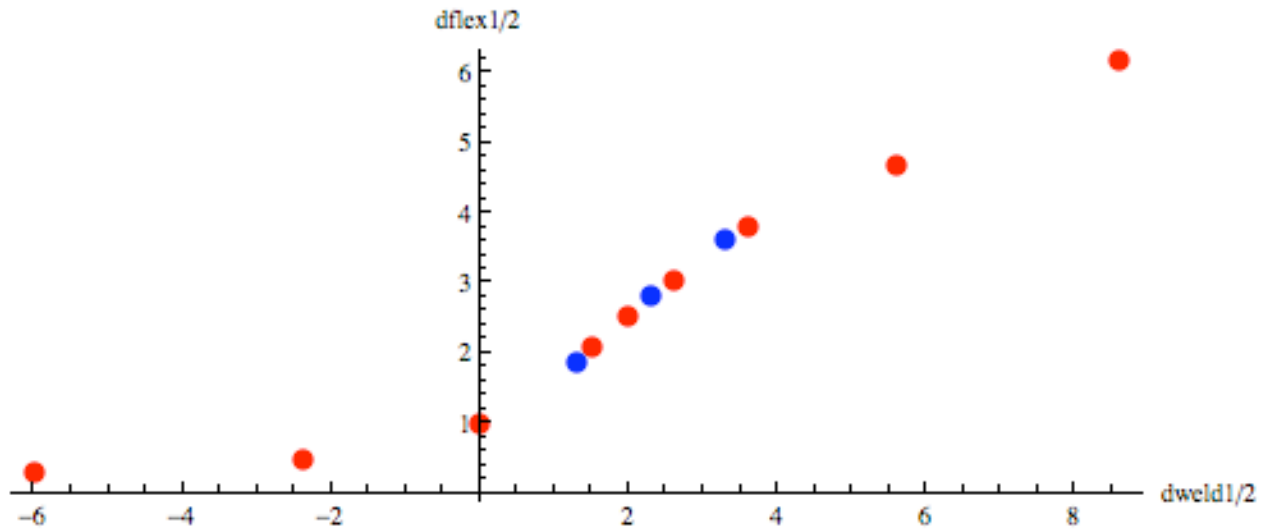


Figure 14: dflex1/2 as a function of dweld1/2. Points in blue are from Phil Willems' calculation.