



# Process Traveler

DCC Number: E070236-00-D

Date Prepared: 10-11-07

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Stephany Foley	Ken Mason	617-258-8295	SEI ELIGO	

Dwg/Part Number	Rev	Part Description	Serial Number	Qty
D071004		Support Post Gusset, Aux		3
D071005		Support Post Gusset, Main		3
D071006		Stiffener Rib, Type 00		3
D071006		Stiffener Rib, Type 02		1
D071007		Stiffener Plate, Type 00		1
D071007		Stiffener Plate, Type 01		4
D071008		Stiffener End Cap		2
D071052		Rib, Tan, GS-13 Mid		3
D071053		Rib, Tan, GS-13 Cen		3
D071054		Rib, Rad, GS-13 Mid		3
D071055		Rib, Rad, GS-13 Out1		3
D071056		Rib, Rad, GS-13 Out2		3
D071057		Outer Wall, Horiz GS-13		3
D071058		Outer Wall, Flexure Access		3
D071059		Outer Wall, Small Panel		9
D071060		Outer Wall, Bracket 120 Type00		6
D071060		Outer Wall, Bracket 120 Type 01		6
D071061		Outer Wall, Bracket 90		9
D071063		Keel Wall		6
D071065		Keel Base		1
D071067		Spring Hatch, Optics Table		3
D071068		Rib, Rad, Flexure Out1		3
D071069		Rib, Rad, Flexure Out2		3
D071070		Rib, Rad, Flexure Cen		3
D071071		Rib, Rad, Flexure Mid		3

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

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D071072	Rib, Rad, Flexure Mid Cover	3
D071073	Rib Bracket, 60 Deg	6
D071074	Flexure Post	3
D071075	Flexure Post Bracket, Tan	3
D071076	Flexure Post Bracket Rad	3
D071105	Flexure Lower Plate	3
D071120	Actuator Magnet Mount	6
D071121	Actuator Coil Support	6
D071122	Actuator U-Bracket, Vert	6
D071129	Actuator Setup Bar	6
D071132	Actuator L-Bracket, Horiz	6
D071140	Locker Base	4
D071180	GS-13 Adaptor Plate	6
D071250	Barrel Nut Type 00	189
D071250	Barrel Nut Type 01	626
D071250	Barrel Nut Type 02	130
D071255	Wiring Breadboard	8
D047932	Sleeve Housing	4
D047936	Base (D-1)	4
D047936	Cap (D-2)	8

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Used In (next higher assembly):

Vendor Name

PO/Contract Number

### 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	Re-Clean		CIT	per E960022, with the following special instructions or cautions:	R. Taylor	
2	Re-Vacuum Bake		CIT	per E960022 to a temperature of 120C	R. Taylor	
3	Control Point		NA	Review/approve RGA scan # F11807	D. Coyne	
4	Control Point		NA	Review/approve RGA scan # F112607	D. Coyne	
5	Control Point		NA	Review/approve RGA scan # F120407	D. Coyne	
4	Wrap & Tag vacuum clean parts per E960022-A		CIT	Wrap (UHV foil) and bag (CP Stat or equiv.) per E960022.	R. Taylor	

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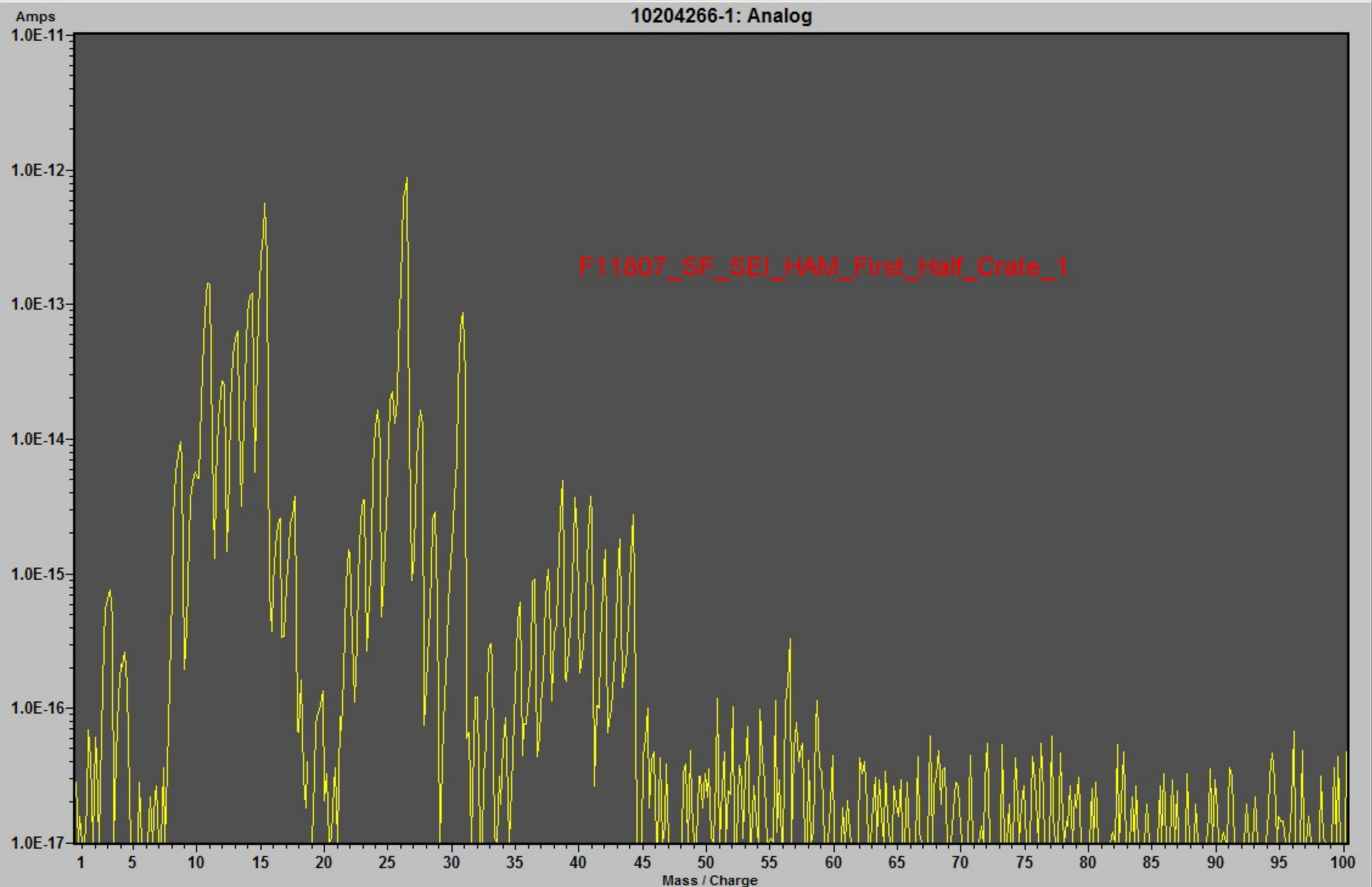
#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
5	Deliver/File paperwork		CIT	Make 2 copies of the Traveler. File one copy with the DCC.	R Taylor	
6.	SHIP TO			Please send to: When cleaned these parts need to go to LLO  <b>Note: Ship original traveler with these parts.</b>	R Taylor	

END: Go to Traveler or procedure associated with next higher assembly processing

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

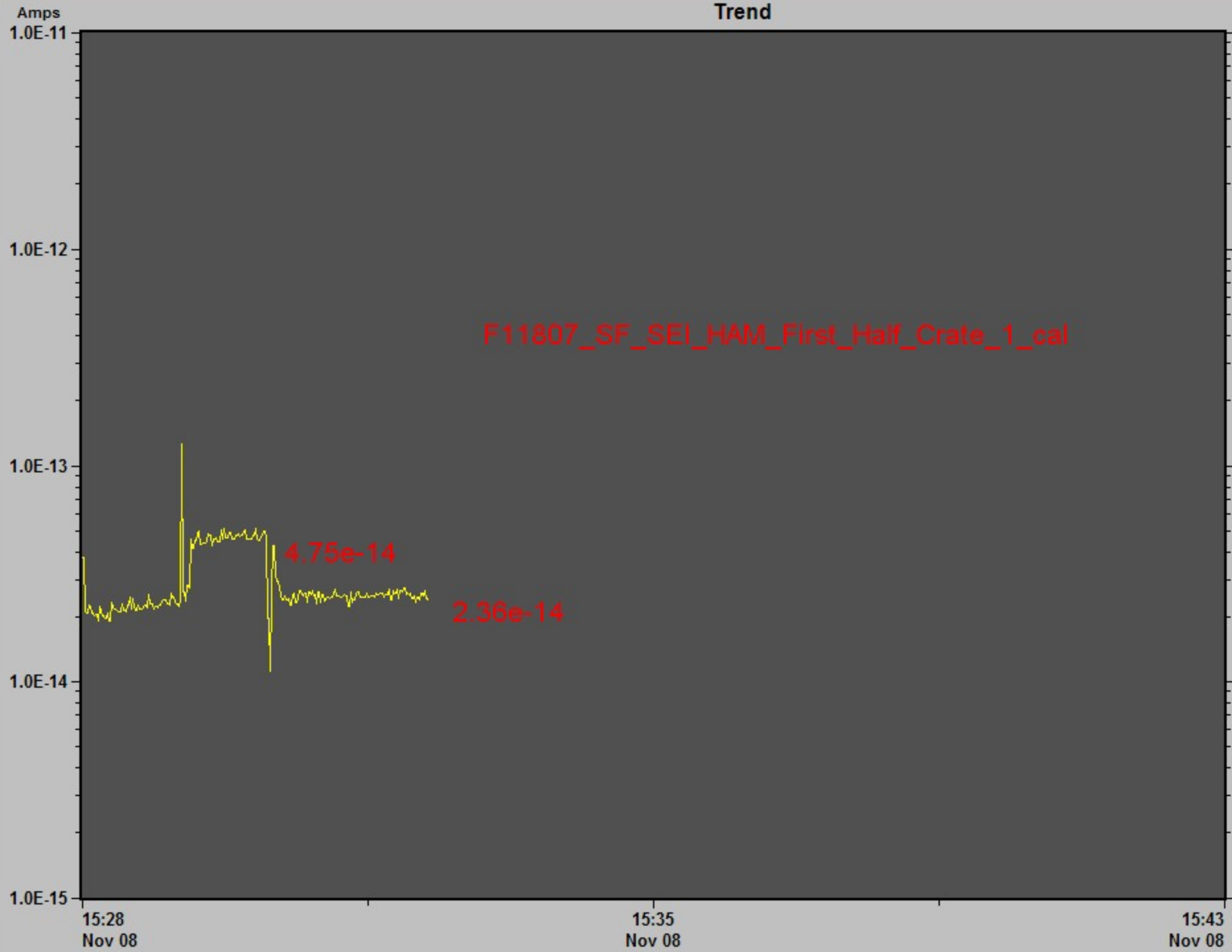
1. These are parts for the L1 HAM
2. Parts will go to Livingston when cleaned.
3. Parts are needed at Livingston by 11-13-07
4.

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Trend



10204266-1: 28 2.36E-14

F11807\_SF\_SEI\_HAM\_First\_Half\_Crate\_1\_cal

# Pressure Contribution from Flag Hydrocarbons

## 40M Lab RGA Scan Results

Job# F11807

Description: SEI HAM Aluminum Parts  
Oven Used: C

Date: 11/8/2007

AMU 41	3.83E-15 amps	from RGA scan listing
AMU 43	2.31E-15 amps	from RGA scan listing
AMU 53	6.12E-17 amps	from RGA scan listing
AMU 55	1.00E-17 amps	from RGA scan listing
AMU 57	6.07E-17 amps	from RGA scan listing

Sum Flag H/C AMUs 6.27E-15 amps

Calib leak rate 2.36E-10 torr l/s (Argon)

AMU 40 (w/leak open) 4.75E-14 amps

AMU 40 (background) 2.36E-14 amps

Calib leak contributes 2.39E-14 amps = (w/leak open) - (background)

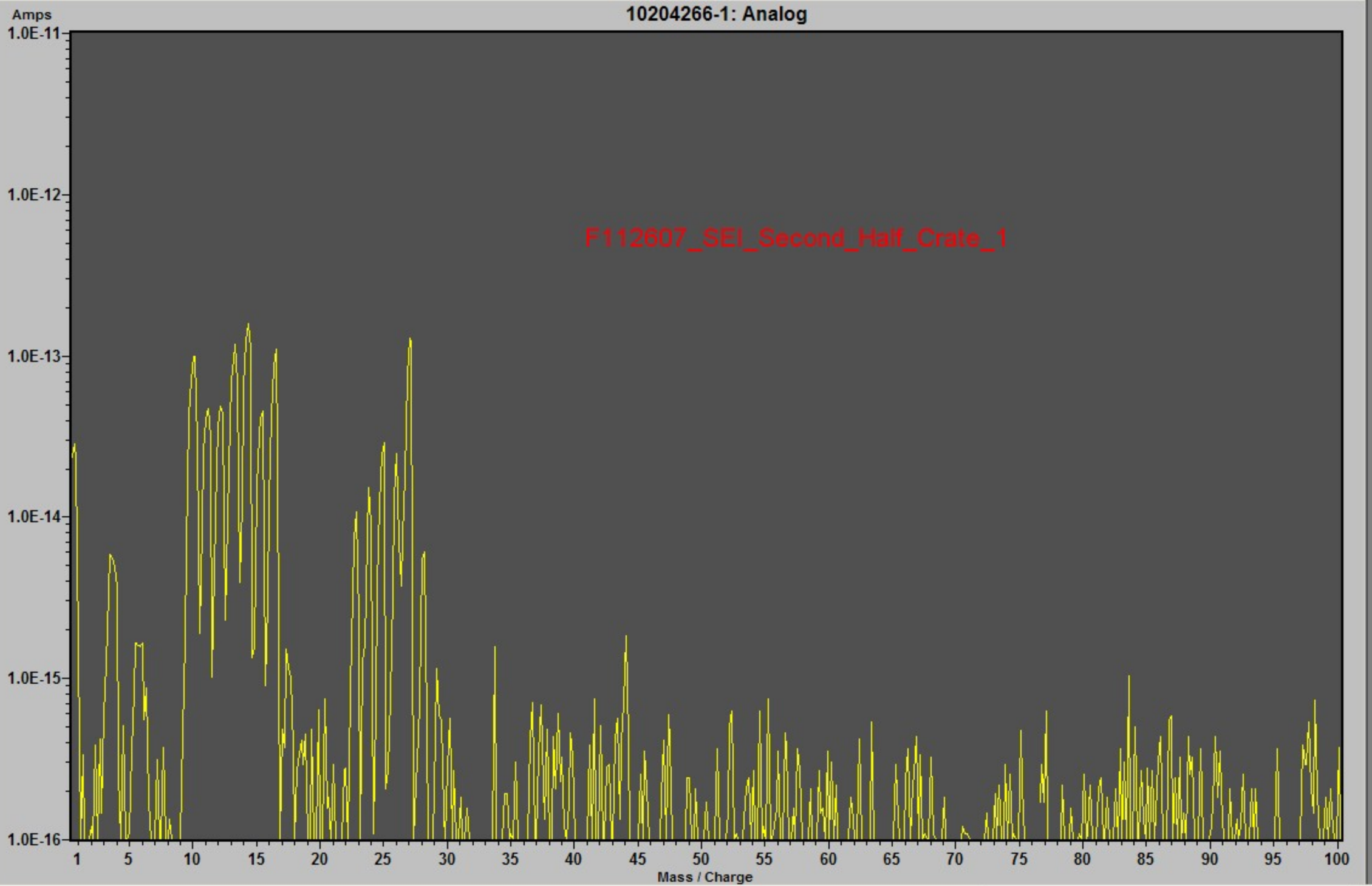
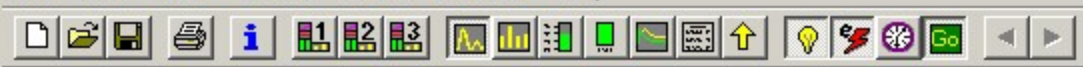
Flag H/C Outgassing 6.193E-11 torr l/s = (Sum Flag H/C AMUs) x (Calib leak rate)/(Calib leak contrib.)

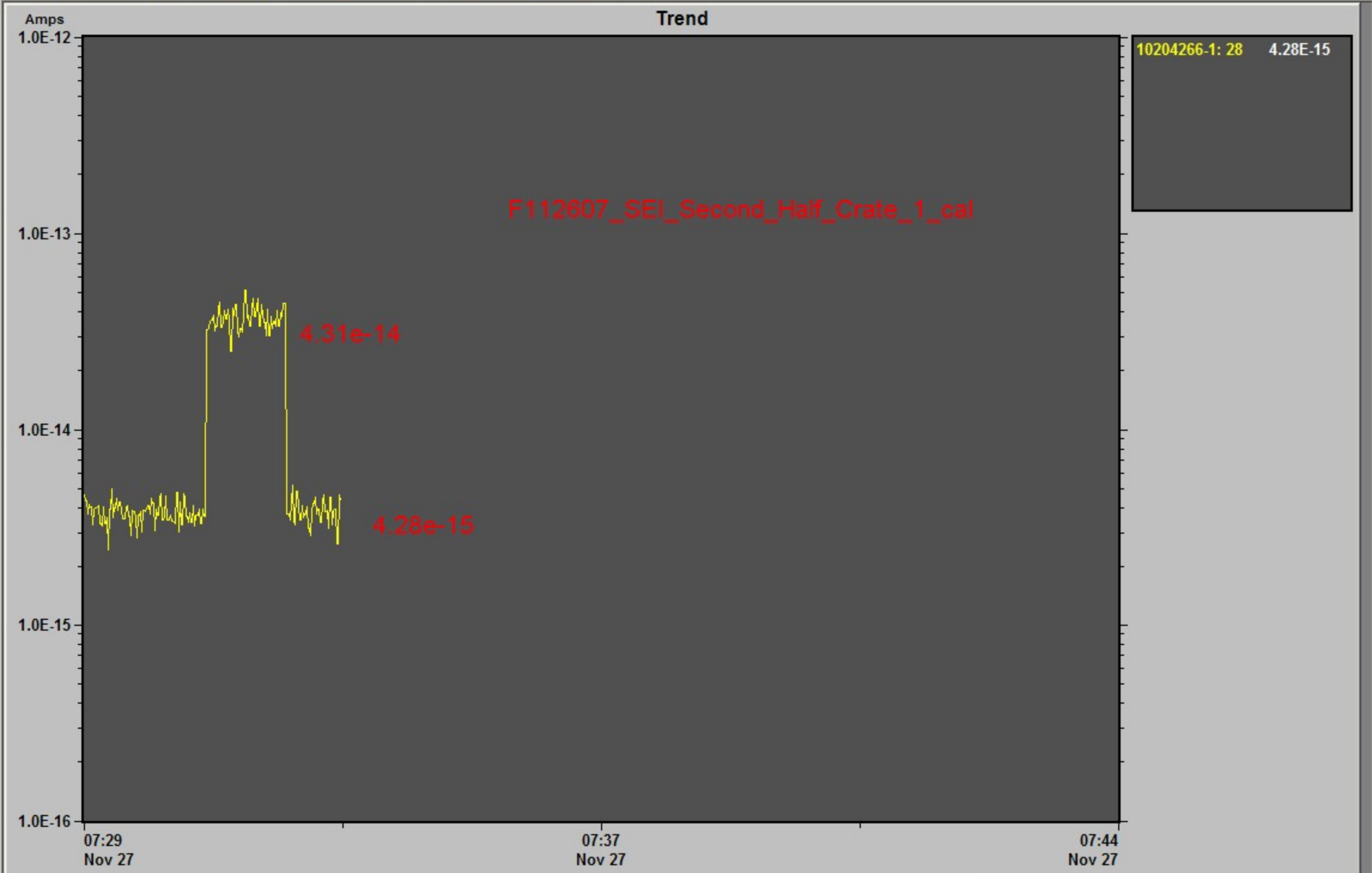
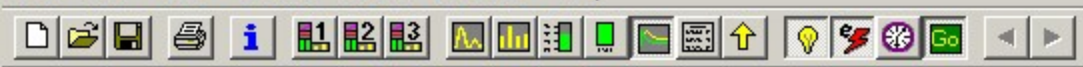
Test item surf area 4.65E+04 cm<sup>2</sup>

Normalized outgassing 1.333E-15 torr l/s-cm<sup>2</sup> = Flag H/C Outgassing/Test item surf area

Full description: First Half of crate 1 of SEI HAM Aluminum parts ( all Very Large Parts)

Pre-scan bake: 120C for 48 Hrs.





# Pressure Contribution from Flag Hydrocarbons

## 40M Lab RGA Scan Results

Job# F112607

Description: SEI Second Half Crate 1  
Oven Used: F

Date: 11/26/2007

AMU 41	3.80E-16 amps	from RGA scan listing
AMU 43	4.20E-16 amps	from RGA scan listing
AMU 53	1.10E-16 amps	from RGA scan listing
AMU 55	6.10E-16 amps	from RGA scan listing
AMU 57	5.40E-16 amps	from RGA scan listing

Sum Flag H/C AMUs 2.06E-15 amps

Calib leak rate 2.36E-10 torr l/s (Argon)

AMU 40 (w/leak open) 4.31E-14 amps

AMU 40 (background) 4.28E-15 amps

Calib leak contributes 3.88E-14 amps = (w/leak open) - (background)

Flag H/C Outgassing 1.252E-11 torr l/s = (Sum Flag H/C AMUs) x (Calib leak rate)/(Calib leak contrib.)

Test item surf area 4.50E+04 cm<sup>2</sup>

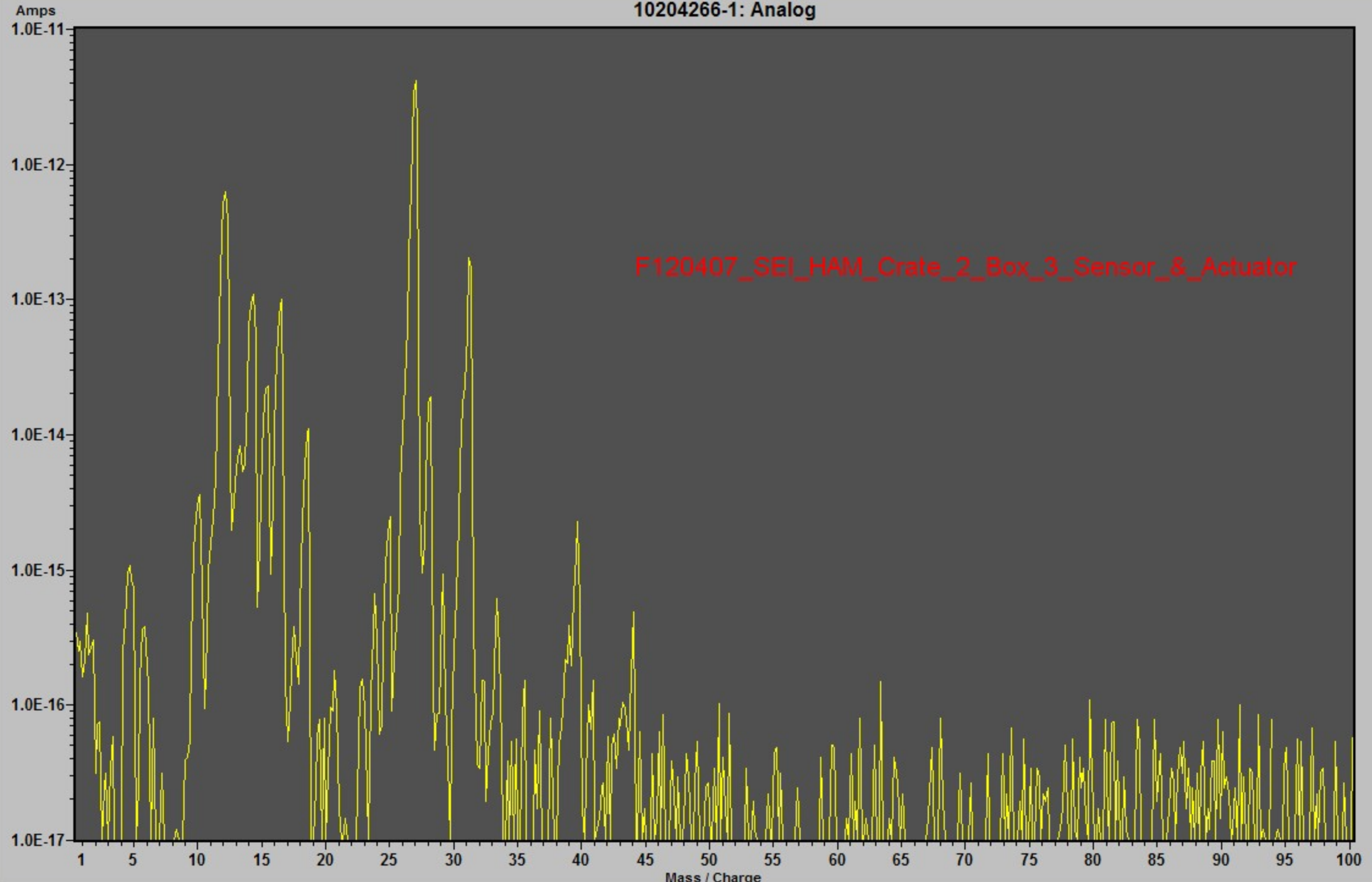
Normalized outgassing 2.783E-16 torr l/s-cm<sup>2</sup> = Flag H/C Outgassing/Test item surf area

Full description: Very Large load of aluminum plates for SEI

Pre-scan bake: 120C for 48 Hrs.

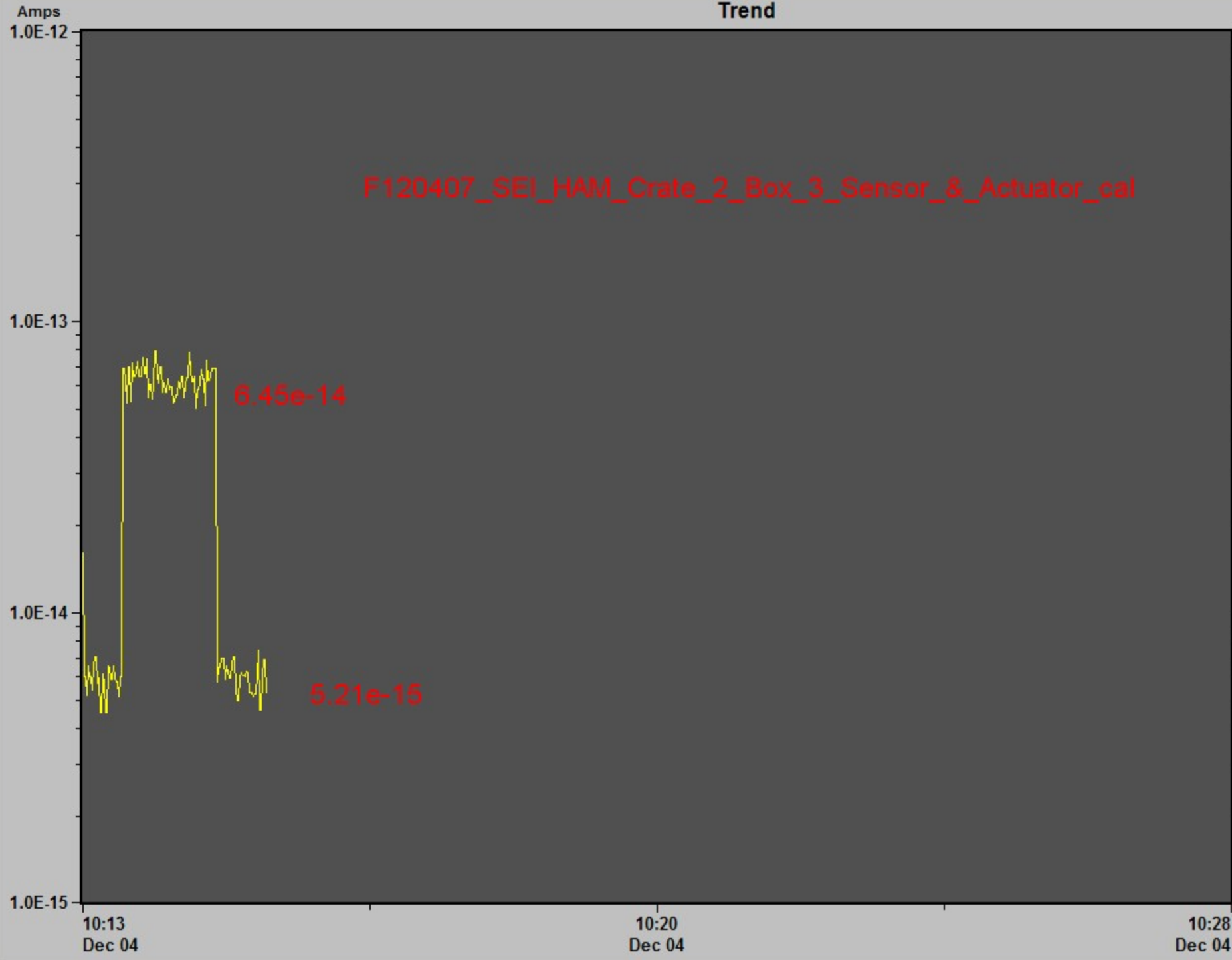


10204266-1: Analog





Trend



10204266-1: 28 5.21E-15

# Pressure Contribution from Flag Hydrocarbons

## 40M Lab RGA Scan Results

Job# F120407

Description: SEI Ham Crate 1,Box2, Sensor,& Act  
Oven Used: C

Date: 12/4/2007

AMU 41	1.50E-16 amps	from RGA scan listing
AMU 43	1.00E-16 amps	from RGA scan listing
AMU 53	3.50E-17 amps	from RGA scan listing
AMU 55	2.00E-17 amps	from RGA scan listing
AMU 57	2.00E-17 amps	from RGA scan listing

Sum Flag H/C AMUs 3.25E-16 amps

Calib leak rate 2.36E-10 torr l/s (Argon)

AMU 40 (w/leak open) 6.45E-14 amps

AMU 40 (background) 5.21E-15 amps

Calib leak contributes 5.93E-14 amps = (w/leak open) - (background)

Flag H/C Outgassing 1.294E-12 torr l/s = (Sum Flag H/C AMUs) x (Calib leak rate)/(Calib leak contrib.)

Test item surf area 1.00E+04 cm<sup>2</sup>

Normalized outgassing 1.294E-16 torr l/s-cm<sup>2</sup> = Flag H/C Outgassing/Test item surf area

see travelers; E070295-00 , E070285-00 , And some parts ar on Traveler E070236-00

Full description: marked with \*. ( all aluminum parts)

Pre-scan bake: 120C for 48Hrs