

advancedligo

Process traveler

DCC Number: E070316-00-X

Date Prepared: 11/27/07

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Stephany Foley	Ken Mason	617-324-5250	SEI, HAM Enhanced LIGO	

Dwg/Part Number	Rev	Part Description / Material	Serial Number	Qty
		ALL PART ON THIS TRAVELER ARE Aluminum 6061		
D071004		Support Post Gusset, Aux		3
D071005		Support Post Gusset, Main		3
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 Out 1		3
D071056		Rib, Rad, GS-13 Out 2		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 type01		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 Out 1		3
D071069		Rib, Rad, Flexure Out 2		3
D071070		Rib, Tan, Flexure Cen		3
D071071		Rib, Tan, Flexure Mid		3
D071072		Rib, Tan, Flexure Mid Cover		3
D071073		Rib Bracket, 60 Deg		6

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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	7
D071132	Actuator L-Bracket. Horiz	6
D071140	Locker Base	4
200047932	Sleeve, Housing	4
200047936	Base (D-1)	4
200047936	Cap (D-2)	8
D071180	GS13 Adapter Plate	6
D071250	Barrel Nut (Type 00)	189
D071250	Barrel Nut (Type 01)	626
D071250	Barrel Nut (Type 02)	130
D071255	Wiring breadboard	10
D071009	Particle fence, AL 6061	3
D071160	Sensor Target Mount, AL 6061	6
D071161	Sensor Head Base, AL 6061	6
D071162	Sensor Head Washer, AL 6061	6
D071163	Sensor Head Mount, AL 6061	6
D071164	Sensor Head Base Plate, AL 6061	6
D071165	Sensor Target-- AL 1100 DIAMOND TURNED FINISH- TAKE CARE IN CLEANING	8
D071166	Sensor Target Body, AL 6061	6
D071170	Sensor Head Standoff, Horiz., AL 6061	3
D071175	Sensor Head Bracket, Vert., AL 6061	3
D071183	GS-13 Cable Restraint, AL 6061	8
D070534	Actuator Stops	12

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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.
Y		Check Parts and remove any leftover Helicoil inserts in all parts.		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
1	Clean		CIT	per E960022, with the following special instructions or cautions:	R. Taylor	
2	Bake		CIT	per E960022 to a temperature of 120C for 48 Hrs.	R. Taylor	
3	Control Point		NA	Review/approve RGA scan # First Half of crate 1	D. Coyne	
4	Control Point		NA	Review/approve RGA scan # Second Half of crate 1	D. Coyne	
5	Control Point		NA	Review/approve RGA scan # First half of crate 2	D. Coyne	
6	Control Point		NA	Review/approve RGA scan # Second Half of crate 2	D. Coyne	
7	Control Point		NA	Review/approve FTIR Report#	D Coyne	

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#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
7	Wrap/ Tag UHV Clean Parts per E960022-A		CIT		R Taylor	
8	Deliver/File paperwork		CIT	Make 2 copies of the Traveler. File one copy with the DCC.	R Taylor	
9	SHIP TO			Please send to: Hanford c/o SEI Note: Ship original traveler with these parts.	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 parts are for the Enhanced LIGO build at the Hanford site.
2.
3.
4.

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