



Process Traveler

Tip/Tilt Small Parts

DCC Number: E070354-00-X

Date Prepared: 12-18-07

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
David Yeaton-Massey	Bram Slagmolen	510-220-6610	E Ligo	

Dwg/Part Number	Rev	Part Description	Serial Number	Qty

Qty	Part Number	Title	Material
		<u>Al/Teflon/Cu/Bronze</u>	
2	D070173-00	TipTilt Structure Base	ALU
2	D070174-00	TipTilt Structure Side Right	ALU
2	D070175-00	TipTilt Structure Side Left	ALU
2	D070176-00	TipTilt Structure ISCPension Block	ALU
2	D070178-00	TipTilt Structure ECD Holder	ALU
6	D070179-00	TipTilt Structure ECD Separation 1mm	CU
2	D070180-01	TipTilt Structure OSEM Backplane	ALU
4	D070181-00	TipTilt Structure OSEM Backplate-L	ALU
5	D070183-00	TipTilt 2inch Mirror Holder	ALU
10	D070184-00	TipTilt Mirror Inner Wire Clamp 7mm	ALU
10	D070185-00	TipTilt Mirror Outer Wire Clamp	ALU
17	D070187-00	TipTilt Mirror Flag Tappered Step 5mm	ALU
4	D070197-00	TipTilt Structure OSEM Backplate-R	ALU
64	D070198-00	Tip-Tilt OSEM Nut	Bronze
11	D070199-00	Tip-Tilt Mirror Nudge	PFA-440HP
x		0.38mm spring steel wire, 1m	Suspension wire

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MAGNETS

9	D070190-00	TipTilt Mirror Magnet OD10mm L10mm	Neodymium-Iron-Boron
6	D070191-00	TipTilt Mirror Magnet OD5mm L3mm	Neodymium-Iron-Boron

STEEL

17	D070186-00	TipTilt Mirror Flag Base Magnetic	Steel
x		M6 Button-Head SC	S/S
x		M6 Socket-Head SC	S/S
x		M6 Plain+Spring Washers	S/S
x		M5 Button-Head	S/S
x		M5 Plain+Spring Washers	S/S
x		M3 Button-Head	S/S
x		M3 Button-Head	S/S + plated
x		M3 Plain+Spring Washers	S/S
x		M2.5 Button-Head	S/S
x		M2.5 Plain+Spring Washers	S/S
x		M4 Hex Set Screw	S/S
2	D070177-00	TipTilt Structure IS Cpension Bar 60mm	S/S
8	D070182-00	TipTilt Structure Wire Clamp	S/S

Tools

Qty	Title	Description	Material
2	#7 Spanner	9/32" A/F Nut, Adjuster Shaft	?
2	5mm Allan Key	M6 Hex Cap-screw	Steel

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2		4mm Allankey	M6 BH Cap-screws	Steel
2		3mm Allankey	M5 BH Cap-screws	Steel
2		2mm Allankey	M3 BH Cap-screws	Steel
2		1.5mm Allen Key	M2.5 BH Cap-screw, 2-56UNC Cap-Screw	Steel
1	D070193-00	TipTilt Wire Jig Baseplate		ALU
1	D070194-00	TipTilt Wire Jig Centre		S/S + Brass
1	D070195-00	TipTilt Wire Jig Span		S/S
1	D070196-00	TipTilt Wire Jig Clamp		S/S
19		Misc. Tooling Hardware		

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	Clean		CIT	per E960022, with the following special instructions or cautions:	R. Taylor	

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#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
2	Air Bake		CIT	per E960022 to a temperature of (see scan approval)	R. Taylor	
3	Air Bake		CIT	Class B tooling @ 120 C al // 200 C SS	R. Taylor	
4	Control Point		NA	Review/approve RGA scan# Al/Cu/Bronze 120 C	D. Coyne	
5	Control Point		NA	Review/approve RGA scan #C122607 SS 200 C	D. Coyne	
6	Control Point		NA	Review/approve RGA scan # Magnets 80 C	D. Coyne	
7	Wrap & Tag vacuum clean parts per E960022-A		CIT	Wrap (UHV foil) and bag (CP Stat or equiv.) per E960022.	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: 40m c/o David Yeaton-Massey 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:

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1.. Part D070186 – Pack in dry nitrogen

2.

3.

4.

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