



LASER INTERFEROMETER GRAVITATIONAL WAVE OBSERVATORY

LIGO Laboratory / LIGO Scientific Collaboration

LIGO

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Addendum to aLIGO HAM ISI Assembly Procedure

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Distribution of this document:
LIGO Scientific Collaboration

This is an internal working note
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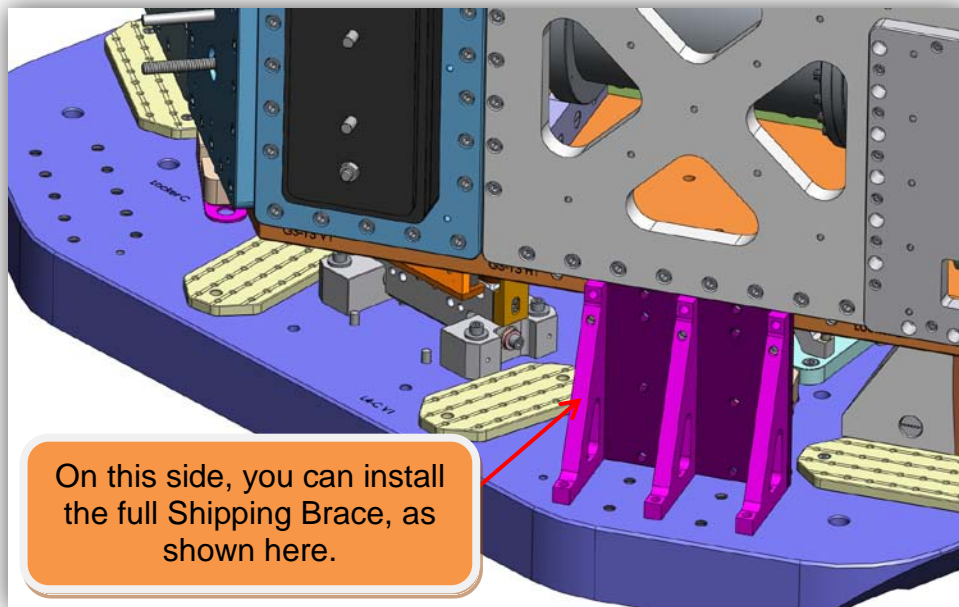
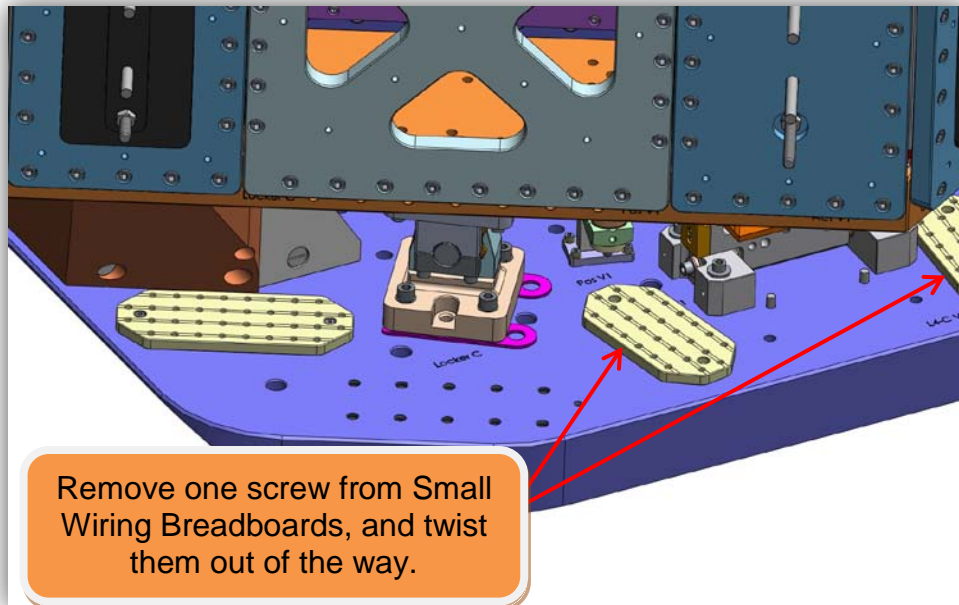
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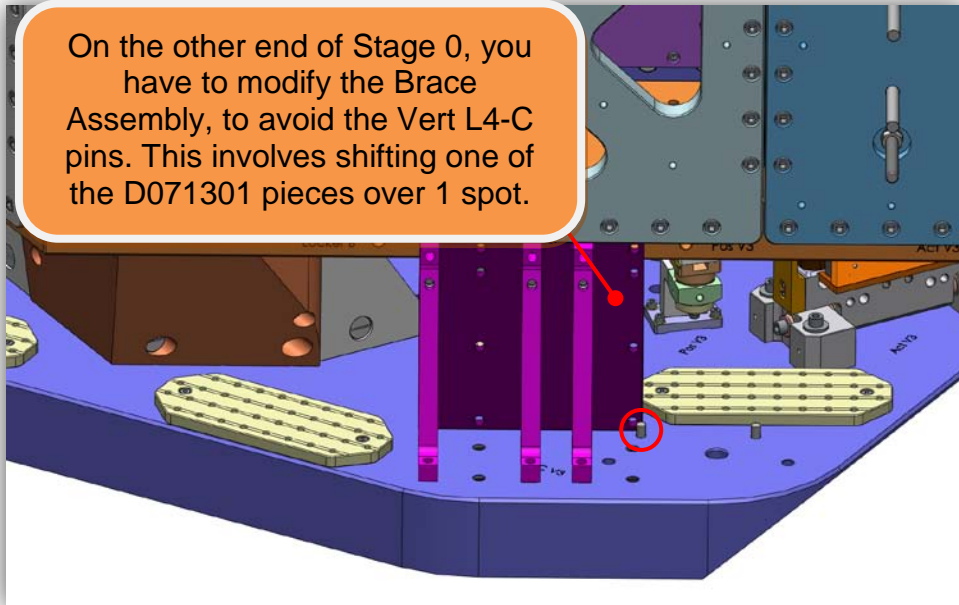
1 Adding Shipping Braces

Four Shipping Braces (D071490) should be installed in the HAM ISI, before the unit is removed from its assembly/test fixture. This document provides visual instructions on how to do this.

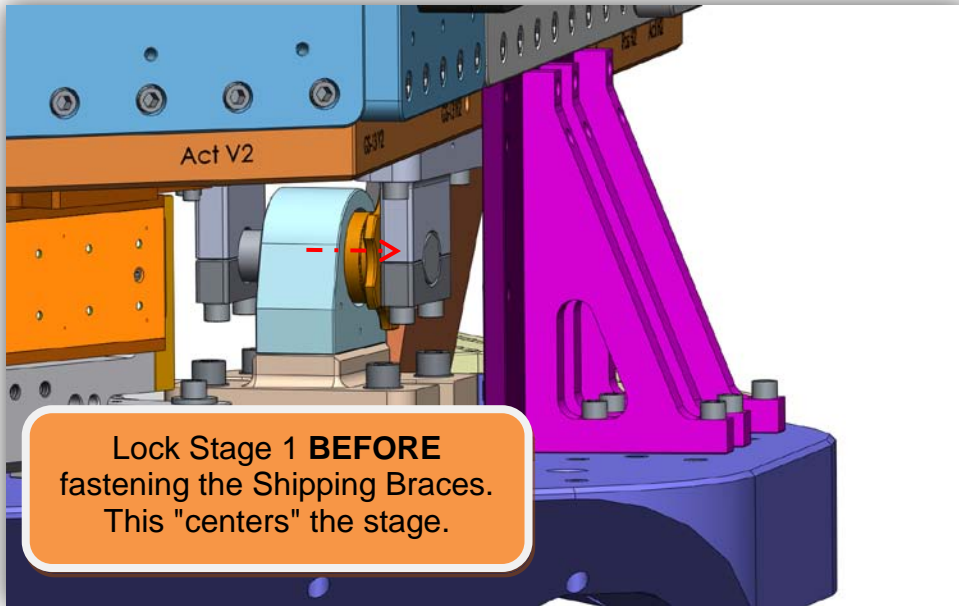
2 CAD Snapshots



On the other end of Stage 0, you have to modify the Brace Assembly, to avoid the Vert L4-C pins. This involves shifting one of the D071301 pieces over 1 spot.



Lock Stage 1 **BEFORE** fastening the Shipping Braces. This "centers" the stage.





Use dial indicators to check motion of Stage 1, while tightening all 4 Shipping Braces.

Release the Lockers **BEFORE** the Shipping Braces' mounting screws are torqued. Check that the Sleeve can move in/out freely. **IT'S CRITICAL THAT THE LOCKERS ARE NOT FORCED TO THEIR LIMITS BY THE SHIPPING BRACES.**
