

Table 2. HAM Large Triple Suspension (HLTS) Machined Parts Quantities

Item #	Part #	Rev.	Description	LLO Qty	LHO Qty	Total Qty	Inspection Criteria	Priority Level	Engrave/Bag and Tag
1	D020601	v2	Blade Clamp (0.0 Degree), Upper Blade, Outside	8	12	20	Level 3	Priority 1	Engrave
2	D020602	v2	Blade Clamp (0.0 Degree), Lower Blade, Inside	16	24	40	Level 3	Priority 1	Engrave
3	D020605	v3	Main Section, Upper Mass	4	6	10	Level 1	Priority 1	Engrave
4	D020607	v3	T-Piece, Upper Mass	4	6	10	Level 2	Priority 2	Engrave
5	D020610	v3	Lower Clamp, Upper Wire, Inside	12	20	32	Level 3	Priority 2	Bag and Tag
6	D020611	v4	Upper Clamp, Upper Wire, Inside	12	20	32	Level 3	Priority 2	Engrave
7	D020622	v3	Blade Clamp (0.0 Degree), Upper Blade, Inside	8	12	20	Level 3	Priority 1	Engrave
8	D020623	v2	Blade Clamp (0.0 Degree), Lower Blade, Outside	16	24	40	Level 3	Priority 1	Engrave
9	D020624	v3	Lower Clamp, Upper Wire, Outside	12	20	32	Level 3	Priority 2	Bag and Tag
10	D020652	v2	C-Clamp, Upper Mass	12	20	32	Level 4	Priority 2	Engrave
11	D020653	v2	Screwdrive System	16	24	40	Level 4	Priority 2	Engrave
12	D030021	v2	SHCS, 1/4-20 X 2.5 Long, Fully Threaded, Rounded End	130	216	346	Level 4	Priority 2	Bag and Tag
13	D030023	v3	SHCS, 1/4-20 X 1 Long, Fully Threaded, Rounded End	44	72	116	Level 4	Priority 2	Bag and Tag
14	D030139	v2	Roll Offset, T-Piece, Upper Mass	4	6	10	Level 2	Priority 2	Engrave
15	D030148	v2	Lower Wire Breakoff, Intermediate Mass	12	20	32	Level 4	Priority 2	Engrave
16	D030149	v2	Intermediate Wire Breakoff, Intermediate Mass	24	40	64	Level 4	Priority 2	Engrave
17	D030155	v2	Center Offset, Intermediate Mass	4	6	10	Level 2	Priority 2	Engrave
18	D030156	v2	Side Offset, Intermediate Mass	8	12	20	Level 4	Priority 2	Engrave
19	D070309	v2	Top Blade Guard Riser	16	24	40	Level 4	Priority 2	Engrave
20	D070310	v2	Top Blade Guard Bar	8	12	20	Level 4	Priority 2	Engrave
21	D070321	v2	Earthquake Stop Bridge Crossbar	16	24	40	Level 4	Priority 2	Engrave
22	D070322	v2	Earthquake Stop Bracket, Long	30	48	78	Level 4	Priority 2	Engrave
23	D070327	v2	Base Plate, Rotational Adjuster	8	12	20	Level 4	Priority 1	Engrave
24	D070328	v2	Rotating Plate, Rotational Adjuster	8	12	20	Level 4	Priority 1	Engrave
25	D070329	v2	Pull Plate	8	12	20	Level 4	Priority 2	Engrave
26	D070330	v2	Push Plate	8	12	20	Level 4	Priority 2	Engrave
27	D070331	v3	Shim, 1mm, Upper Blade	8	12	20	Level 3	Priority 1	Engrave
28	D070333	v2	Additional Mass Disk, 100g	90	148	238	Level 4	Priority 3	Engrave
29	D070336	v3	Main Section, Intermediate Mass	4	6	10	Level 1	Priority 1	Engrave
30	D070338	v4	Metal Bottom Mass	4	6	10	Level 2	Priority 1	Engrave
31	D070341	v3	Upper Clamp, Upper Wire, Outside	12	20	32	Level 3	Priority 2	Bag and Tag
32	D070394	v3	Upper Clamp, Intermediate Wire, Outside	24	40	64	Level 3	Priority 2	Bag and Tag
33	D070405	v3	Lower Clamp, Intermediate Wire, Inside	24	40	64	Level 3	Priority 2	Bag and Tag
34	D070406	v3	Lower Clamp, Intermediate Wire, Outside	24	40	64	Level 3	Priority 2	Bag and Tag
35	D070438	v4	Clamp, Lower Loop Wire	24	40	64	Level 3	Priority 2	Bag and Tag
36	D070449	v2	Coil Holder (Tablecloth)	4	6	10	Level 1	Priority 2	Engrave
37	D070460	v2	Earthquake Stop Mount, Long	36	60	96	Level 4	Priority 2	Engrave
38	D070585	v4	Upper Clamp, Intermediate Wire, Inside	24	40	64	Level 3	Priority 2	Engrave
39	D080124	v3	Prism Breakoff, Lower Wire	8	12	20	Level 4	Priority 1	Engrave
40	D080182	v2	Collar, Upper, 100g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
41	D080183	v2	Collar, Lower, 100g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
42	D080221	v2	Guard, Lower Blade	8	12	20	Level 4	Priority 1	Engrave
43	D080223	v2	Collar, Upper, 300g, Intermediate Mass	4	6	10	Level 2	Priority 3	Engrave
44	D080225	v2	Collar, Upper, 500g, Intermediate Mass	4	6	10	Level 2	Priority 3	Engrave
45	D080227	v2	Collar, Upper, 700g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
46	D080229	v2	Collar, Upper, 900g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
47	D080232	v2	Collar, Lower, 300g, Intermediate Mass	4	6	10	Level 2	Priority 3	Engrave
48	D080234	v2	Collar, Lower, 500g, Intermediate Mass	4	6	10	Level 2	Priority 3	Engrave
49	D080236	v2	Collar, Lower, 700g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
50	D080238	v2	Collar, Lower, 900g, Intermediate Mass	2	4	6	Level 2	Priority 3	Engrave
51	D080724	v3	Mounting Cap, Earthquake Stop	104	176	280	Level 4	Priority 3	Bag and Tag
52	D0900340	v2	Lower AOSEM Mounting Bracket, Bottom Mass	8	12	20	Level 4	Priority 2	Engrave
53	D0900666	v2	Base Plate, Library of Clamps, Upper Blade	2	4	6	Level 2	Priority 1	Engrave
54	D0900667	v3	Blade Clamp (0.5 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
55	D0900668	v3	Blade Clamp (1.0 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
56	D0900669	v3	Blade Clamp (1.5 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
57	D0900670	v3	Blade Clamp (2.0 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
58	D0900671	v3	Blade Clamp (2.5 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
59	D0900672	v3	Blade Clamp (3.0 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
60	D0900673	v3	Blade Clamp (3.5 Degree), Upper Blade, Inside	4	8	12	Level 3	Priority 1	Engrave
61	D0900674	v2	Blade Clamp (0.5 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
62	D0900675	v2	Blade Clamp (1.0 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
63	D0900676	v2	Blade Clamp (1.5 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
64	D0900677	v2	Blade Clamp (2.0 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
65	D0900678	v2	Blade Clamp (2.5 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
66	D0900679	v2	Blade Clamp (3.0 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
67	D0900680	v2	Blade Clamp (3.5 Degree), Upper Blade, Outside	4	8	12	Level 3	Priority 1	Engrave
68	D0900682	v2	Blade Clamp (0.5 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
69	D0900683	v2	Blade Clamp (1.0 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
70	D0900684	v2	Blade Clamp (1.5 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
71	D0900685	v2	Blade Clamp (2.0 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
72	D0900686	v2	Blade Clamp (2.5 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
73	D0900687	v2	Blade Clamp (3.0 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
74	D0900688	v2	Blade Clamp (3.5 Degree), Lower Blade, Inside	8	16	24	Level 3	Priority 1	Engrave
75	D0900689	v2	Base Plate, Library of Clamps, Lower Blade	2	4	6	Level 2	Priority 1	Engrave
76	D0900690	v2	Blade Clamp (0.5 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
77	D0900691	v2	Blade Clamp (1.0 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave

78	D0900692	v2	Blade Clamp (1.5 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
79	D0900693	v2	Blade Clamp (2.0 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
80	D0900694	v2	Blade Clamp (2.5 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
81	D0900695	v2	Blade Clamp (3.0 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
82	D0900696	v2	Blade Clamp (3.5 Degree), Lower Blade, Outside	8	16	24	Level 3	Priority 1	Engrave
83	D0900990	v2	SHCS, #8-32 X 1.5 Long, Fully Threaded, Rounded End	24	36	60	Level 4	Priority 2	Bag and Tag
84	D0900999	v3	SHCS, 1/4-20 X 2 Long, Fully Threaded, Rounded End	16	24	40	Level 4	Priority 2	Bag and Tag
85	D0901241	v2	Earthquake Stop Mount, Bridge	32	48	80	Level 4	Priority 2	Engrave
86	D0901286	v2	Secondary Metal Prism Breakoff	30	50	80	Level 3	Priority 1	Bag and Tag
87	D0901405	v2	Additional Mass Disk, 50g	22	36	58	Level 4	Priority 3	Engrave
88	D0901492	v2	AOSEM Alignment Bracket, Intermediate Mass	16	24	40	Level 4	Priority 2	Engrave
89	D0901493	v2	Lower AOSEM Mounting Bracket, Intermediate Mass	8	12	20	Level 4	Priority 2	Engrave
90	D0901549	v2	AOSEM Alignment Bracket, Bottom Mass	16	24	40	Level 4	Priority 2	Engrave
91	D0901550	v2	Upper AOSEM Mounting Bracket, Bottom Mass	8	12	20	Level 4	Priority 2	Engrave
92	D0902025	v2	Upper AOSEM Mounting Bracket, Intermediate Mass	8	12	20	Level 4	Priority 2	Engrave
93	D0902431	v1	Magnet Standoff	24	40	64	Level 4	Priority 1	Bag and Tag
94	D1000659	v1	AOSEM Adjuster Shaft	64	96	160	Level 4	Priority 3	Bag and Tag
95	D1001229	v1	Additional Mass Disk, 20g	64	104	168	Level 4	Priority 3	Engrave
96	D1001230	v1	Additional Mass Disk, 10g	22	36	58	Level 4	Priority 3	Engrave
97	D1001534	v1	Magnetic Plug	84	126	210	Level 3	Priority 3	Bag and Tag
98	D1001669	v1	Pitch Offset, T-Piece, Upper Mass	4	6	10	Level 2	Priority 2	Engrave
99	D1001697	v1	Magnet Retainer, BOSEM	42	63	105	Level 3	Priority 3	Engrave
100	D1001698	v1	Magnet Flag, BOSEM	54	90	144	Level 3	Priority 3	Engrave (if possible)
101	D1001699	v1	Magnet Holder, BOSEM, HLTS	36	54	90	Level 4	Priority 2	Engrave
102	D1001914	v2	Shim, 2mm, Upper Blade	8	12	20	Level 3	Priority 1	Engrave
103	D1002134	v1	Mounting Bracket Lateral Section	16	24	40	Level 4	Priority 2	Engrave
104	D1002135	v1	Mounting Bracket Longitudinal Section	16	24	40	Level 4	Priority 2	Engrave
105	D1002823	v1	Earthquake Stop Bracket Back, Bottom Mass, Lower	8	12	20	Level 4	Priority 2	Engrave
106	D1002824	v1	Earthquake Stop Bracket Side, Bottom Mass, Lower	8	12	20	Level 4	Priority 2	Engrave
107	D1002858	v1	AOSEM Adjustment Collar (Reverse Side)	32	48	80	Level 4	Priority 3	Bag and Tag
108	D1002865	v1	Adjustment Nut, Thick, AOSEM Alignment Assembly	77	115	192	Level 4	Priority 3	Bag and Tag
109	D1002973	v2	Shim, 0.5mm, Upper Blade	8	12	20	Level 3	Priority 1	Engrave
110	D1003104	v1	Shim, 1.5mm, Upper Blade	8	12	20	Level 3	Priority 1	Engrave
111	D1003105	v1	Shim, 0.0mm, Upper Blade	8	12	20	Level 3	Priority 1	Engrave
112	D970075	v2	Dumbbell Standoff	24	40	64	Level 4	Priority 1	Bag and Tag

Total Quantity: 4835

Inspection Criteria:

- Level 1** Inspect all parts and provide inspection reports by serial number prior to shipment to LIGO.
- Level 2** Inspect all parts and provide inspection reports on first and last items only prior to shipment to LIGO.
- Level 3** Inspect first and last parts and random 30% and provide inspection reports by serial number prior to shipment to LIGO.
- Level 4** Inspect first and last parts and random 10% and provide inspection reports on first and last items only prior to shipment to LIGO.

Production Priority Level:

- Priority 1** Parts to be produced **first**
- Priority 2** Parts to be produced **second**
- Priority 3** Parts to be produced **third**