



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID) D970038-B-D	TITLE Large Optic Suspension (LOS) Structural Fabrication Specification	NEW REV. C
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CHANGE DESCRIPTION (FROM/TO):

The pickle and passivation should be the last process step for the fabrication of the LOS structures and height adapters. The part should be wrapped cleanly and securely after this process and then shipped to us.

So, move paragraph 2.2.7 Pickle and Passivate down past paragraph 2.2.8 Post- Weld Stress Relief. Therefore, the new order is...2.2.6 Carbon Steel Contamination, 2.2.7 Post-Weld Stress Relief and 2.2.8 Pickle and Passivate.

Add Paragraph 2.2.9 Handling and Shipping Procedures
 See Page 2

REASON FOR CHANGE: Optimize fabrication process steps, and add a step, to insure clean weldments.

ACTION: Incorporate change Attach DCN to drawing(s) Other action (specify):

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION		
<input checked="" type="checkbox"/> No hardware affected (record change only)	Althouse	Barish	Coles
<input type="checkbox"/> List S/Ns which comply already:	Coyne	Lazzarini	Lindquist
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	Stapfer	Tyler	Shoemaker
<input type="checkbox"/> List S/Ns to be built with this change:	Weiss	Whitcomb	
<input type="checkbox"/> List S/Ns to be retested per this change:			
<input type="checkbox"/>			
<input type="checkbox"/>			
<input type="checkbox"/>			
<input type="checkbox"/>			

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (if yes, enter CR (CCB) or TCP (TRB) no.)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: J. Hazel	3-27-98		
TASK LEADER:			
GROUP LEADER: <i>J.P. Coyne</i>	3/27/98		
DCC RELEASE: <i>J. P. Coyne</i>	4/1/98		



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CHANGE DESCRIPTION (FROM/TO):

Continued from page 1:

Weldments should be inspected before the pickling process. After pickling and passivation, Nitrilite gloves should be worn when wrapping the parts for shipment. Nitrilite 100% nitril gloves are from Ansell Edmont Industrial. Once the parts are pickled, the parts should be handled as little as possible.

Processed parts awaiting shipping will be wrapped as follows:

(a) wrap the part(s) with UHV quality aluminum foil

(b) Place each part(s) in an anti-static bag fabricated from "CP Stat 100(TM) ESD poly sheet cleaned to Class 100"

(d) Compress the bag tightly around the part. Tie wrap the bag for closure, or use a bag with a zipper.

(e) Place "UHV CLEAN PART..." and identification labels outside bag.

(f) Place the bagged part(s) in an appropriate shipping container, using care to not puncture or cut the bag. Seal the shipping container closed. Attach a label with the LIGO part number (drawing number(s), including revision letter) and serial number(s) to the outside of the container.

The shipping containers must be such that they insure that the double bags do not get punctured and that the parts are properly supported during transit.

The CP Stat material is ordered as follows:

CP Stat 100 ESD sheeting cleaned to Class 100 with CFC certification that it passes JPL specifications. At the time of this writing, it is available in various sheet and bag sizes from:

Caltex Plastics, Inc.
P.O. Box 58546
2380 E. 51st Street
Vernon, CA 90058
(213) 583-4140

At the time of this writing, one source for UHV Quality Aluminum Foil is:

ASTM B-479 Dry Annealed A Allfoil
4597 Vanepps Rd.
Brooklyn, OH 44131
(216) 661-0211