

LIGO PROCESS TRAVELER

DCC Number: E990208-00-X

Date Prepared: 5/12/99

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
D. Coyne	M. Fine	x3307	LIGO	5F511

Dwg/Part Number	Rev	Part Description	Serial Number	Qty
D972715-1	C	HAM Isolation Stack Leg Assembly Pins & Screws	N/A	23
D972715-3	C	HAM Leg Screw 1	Allied Job No. 4067	22
D972715-5	C	HAM Leg Screw 2		24
		HAM Safety Pin		

Used In (next higher assembly): D972501, LIGO HAM Top Assembly

Vendor Name	PO/Contract Number
Allied Engineering 2421 Blanding Ave Alameda, CA 94501	PO# (LIGO-C)PC246826

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
Y	Y	Check for visual damage to packaging & parts (as they are cleaned). In particular confirm that: 1) the leg screws (D972715-1 and -3) are silver plated 2) the safety pins (D972715-5) are not silver plated 3) all threads appear to be smooth and free of nicks or burrs 4) Confirm Qty.	T. Evans	

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Clean & Vacuum Bake		LLO Vac Prep	Clean and vacuum bake as a stainless steel part per LIGO-E960022-latest	T. Evans	
2	Control Point		NA	Review/approve RGA scan # _____ Attach the RGA package (cal., scan, hydrocarbon mass sum, etc.)	D. Coyne	

N.B.: A copy of this traveler must be submitted to the DCC each time the original is shipped with the associated part(s) and when the traveler has been completed.

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#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
3	Wrap & Tag clean parts		LLO Vac Prep	per E960022-latest a) Wrap each part individually in UHV foil b) Group all parts into quantities of 12 per CPStat (or BayStat) bag c) place a set consisting of 1 bag of each of the 3 types of parts into a single bag. d) Mark the bag "HAM Leg Screw/Pin Set" and with the part no.s, part names, qty.s and traveler no & "UHV clean warning" sticker Note: If there are insufficient parts for a complete set, mark the outer bag label "incomplete set"	T. Evans	
4	Copy & File Traveler		NA	Copy this traveler and file with the DCC along with all attachments including the RGA Scans	T. Evans	

END: Go to SEI Assembly Traveler (associated with D972501 or D972001) for next assembly processing.
N.B.: Cite this traveler number on the SEI Assembly Traveler when pulling parts for the assembly.

Special Instructions (Handling/Packaging Constraints, Remarks, etc.) or Notes:

Handle according to LIGO vacuum preparation procedures in LIGO-E960022-A (or latest revision)