

LIGO PROCESS TRAVELER

DCC Number: **E990266-00-X**

Date Prepared: **6/28/99**

Originator		Cognizant Engineer		Ext./Phone#	Project	Account Number
Michael Smith		Michael Smith		2062	COS	5F515
Dwg/Part Number	Rev	Part Description		Serial Number	Qty	
		PO Mirror Assemblies, BSC4, BSC7				
D980523	B	PO Mirror			3	
D990039	B	BACK PLATE			3	
D990040	B	ELEVATION FLEXURE			3	
D990041	B	AZIMUTYH FLEXURE			3	
D990042	B	AZIMUTH AXIS STIFFNER			3	
D990043	B	FLEXURE BACK STIFFNER			6	
D990044	B	MOUNT FOOT (PO MIRROR)			3	
D990045	B	MOUNT GUSSET PLATE BS/BSC-7			3	
D990046	B	MOUNT GUSSET PLATE ITMX/BSC-4			3	
D990047	B	MOUNT GUSSET PLATE ITMY/BSC-4			3	
D990048	B	AXIS BRACE			9	
D990049	A	MOUNT SIDE PLATE BS/BSC-7			6	
D990050	A	MOUNT SIDE PLATE ITMX/BSC-4			6	
D990051	A	MOUNT SIDE PLATE ITMY/BSC-4			6	
D990055	A	FLEXURE ADJUSTMENT SCREW			6	
D990113	B	TENSION SCREW			6	
D990114	B	TENSION SCREW SLEEVE			6	
D990115	B	SPRING			6	
D990117	B	MIRROR CLAMP			9	
D990118	B	CAP MIRROR CLAMP			9	
		1/4 - 20 x 1.0 lg. SHCS			39	
		1/4 - 28 x 1/4 lg. SHCS			6	
		6 - 32 x .37 lg. FHCS			18	
		6 - 32 x 1/4 lg. Button Hd.			12	

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.

Dwg/Part Number	Rev	Part Description	Serial Number	Qty
		6 - 32 x 1/4 lg. Hex Hd Scr.		6
		1/4 x 1 1/2 lg. Sh. Scr.		9
		10 - 24 x 3/4 lg. FHCS		69
		1/4 x 28 Hex Nut		6
		1/4 ID Washer		12
		Ball S. Stl. .156 Dia.		9
		Bellville Washer		72
		1/4 ID Large Washer		6
		10 - 32 x 3/4lg. FHCS		18

Used In (next higher assembly):	D990052, BS/BSC7 PO Mirror Front and Side View

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
y		Inspect for breakage during shipment		

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Control Point	NA	NA		NA	NA
2	Clean		LHO	per LIGO-E960022, as applicable	B. Weaver	
3	wrap and bag		LHO	per LIGO-E960022	B. Weaver	
4	Vacuum Bake		LHO	per LIGO-E960022	K. Ryan	

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.													
5	Control Point		LHO	Review/approve RGA:scan # _____ scan # _____ scan # _____ scan # _____ scan # _____ scan # _____ scan # _____ Note: attach RGA scan(s) to this traveler.	K. Ryan														
	Package		CIT	<table border="1" style="width: 100%; border-collapse: collapse; margin-bottom: 10px;"> <thead> <tr> <th style="width: 10%;">No.</th> <th style="width: 15%;">Qty per package</th> <th style="width: 75%;">Part</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> </tbody> </table> (see also qty. for each shipping destination below)	No.	Qty per package	Part							Ken Mailand					
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7	Ship		CIT	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th rowspan="2" style="width: 5%;">No.</th> <th colspan="3" style="width: 30%;">Ship Qty.</th> <th rowspan="2" style="width: 60%;">Part Description</th> </tr> <tr> <th style="width: 10%;">LHO</th> <th style="width: 10%;">LLO</th> <th style="width: 10%;">Other</th> </tr> </thead> <tbody> <tr> <td> </td> <td style="text-align: center;">all</td> <td> </td> <td> </td> <td>PO mirror Assy, BSC4 & BSC7</td> </tr> </tbody> </table>	No.	Ship Qty.			Part Description	LHO	LLO	Other		all			PO mirror Assy, BSC4 & BSC7	Ken Mailand	
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