

# LIGO PROCESS TRAVELER

DCC Number: E010121-00-X

Date Prepared: 6/22/01

Originator		Cognizant Engineer		Ext./Phone#	Project	Account Number
Dennis Coyne		Doug Cook		509-372-8107	LIGO	N/A
Dwg/Part Number	Rev	Part Description	Serial Number	Qty		
D990479	F	PAM Bracket, Aluminum	N/A	approx. 400		
<b>Used In (next higher assembly):</b>		Used in Large Optic Suspension (LOS), Sensor/Actuator Heads (i.e. OSEM): D000069-A, Sensor/Actuator Assembly, Long, SMD				
Vendor Name				PO/Contract Number		
?				?		

**Data Package, Receiving/Inspection Remarks:**

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/Initials	Date Comp.
Y	N	Doug Cook has performed lot inspection at the vendor Note: Post bake fit check & inspection will also be performed by Doug Cook at LHO		

**Process Flow:**

#	Operation	Start Date	Work Area	Instructions	Name/Initials	Date Comp.
1	Clean		LHO	per E960022	K. Ryan	
2	Vacuum Bake		LLO small oven	per E960022 120C for 48 hr.	J. Langdale	
3	Control Point		NA	Review/approve RGA scan # _____ Note: Attach RGA scans to this traveller	D. Coyne	
4	Wrap & Tag vacuum clean parts per E960022-A		LLO	Wrap (UHV foil) and double bag (CP Stat or equiv.) per E960022 with 100 parts per bag	J. Langdale	
5	Ship		LLO	Send via express delivery: Attn: Doug Cook, LIGO Hanford Observatory <b><u>Note: Ship copy of traveler with these parts.</u></b>	J. Langdale	

*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.
6	PAM Bracket/Screw Assembly & Fit Check		LHO	Assemble the PAM brackets with PAM screw/magnet assemblies. Check for clean running fit and low run. Rework threads with tap &/or die as needed.  Note: Assembly & handling in clean room per M990034-B	D. Cook	
7	Wrap & Tag vacuum clean parts per E960022-A		LHO	Wrap (UHV foil) and double bag (CP Stat or equiv.) per E960022 with 100 parts per bag	D. Cook	
8	Ship		LHO	Ship completed PAM bracket/PAM screw/magnet assemblies to Attn: Todd Etzel, LIGO Caltech (for assembly into heads)  <b><u>Note: Ship copy of traveler with these parts.</u></b>	D. Cook	
9	Sensor/Actuator Head Assembly		CIT	Assemble PAM bracket/screw/magnet subassembly into Sensor/Actuator Heads  Note: Assembly & handling in clean room per M990034-B	T. Etzel	
10	File Traveller, store spare parts		CIT	Store spare PAM brackets subassemblies in clean packaging per E960022 in the LIGO CIT, 40m South Annex clean room  File this completed traveller with the DCC.	T. Etzel	
END: Go to Traveler associated with next higher assembly processing						

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