



CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

DCN No. E010210-00-D

SHEET 1 OF 1

10/29/01

# DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
LIGO-E000460-A-W	SOS Optic Process Traveler Form	B

**CHANGE DESCRIPTION (FROM/TO):**

Added Wire Specification Section.

**REASON FOR CHANGE:** Updated for Detector Installation/Documentation.

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

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION (X=incl. docs)																					
<input checked="" type="checkbox"/> No hardware affected (record change only) <input type="checkbox"/> List S/Ns which comply already: <input type="checkbox"/> List S/Ns to be reworked or scrapped: <input type="checkbox"/> List S/Ns to be built with this change: <input type="checkbox"/> List S/Ns to be retested per this change: <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<table> <tr> <td></td> <td>Barish</td> <td>Coles</td> </tr> <tr> <td>X Coyne</td> <td>Lazzarini</td> <td>Lindquist</td> </tr> <tr> <td>Raab</td> <td>Sanders</td> <td>Shoemaker</td> </tr> <tr> <td>Stapfer</td> <td>X Tyler</td> <td>Weiss</td> </tr> <tr> <td>Whitcomb</td> <td>CCis</td> <td>owicz</td> </tr> <tr> <td></td> <td>X J. Hazel Romie</td> <td></td> </tr> <tr> <td></td> <td>X D. Ottaway</td> <td></td> </tr> </table>		Barish	Coles	X Coyne	Lazzarini	Lindquist	Raab	Sanders	Shoemaker	Stapfer	X Tyler	Weiss	Whitcomb	CCis	owicz		X J. Hazel Romie			X D. Ottaway	
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**SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT?**  No  Yes (If yes, enter Change Request number )

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: B. Weaver	<i>B. Weaver</i>		10/29/01
TASK LEADER: B. Weaver			
GROUP LEADER: D. Coyne	<i>D. Coyne</i>		10/29/01
DCC RELEASE:	<i>[Signature]</i>		11-11-01



**LIGO SMALL OPTIC PROCESS TRAVELER Form E000460-B-W**

DCC Number:

E -00-X

Date Prepared:

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Originator	Cognizant Engineer	Ext./Phone#	
Optic Dwg/Part Number	Rev	SOS Description	Serial Number

**Process Flow:**

Any deviation from procedures must be approved and noted below

#	Operation/Instructions (Comments)	1st time			2nd time		
		Name/ Initials	Start Date	End Date	Name/ Initials	Start Date	End Date
1	Clean and inspect optic per E990034						
2	Determine guide rod groove position and cement wire standoff and wire rod in place per E970037						
3	Cure Epoxy for 6-12 hrs. with a heat lamp.						
4	Remove part from fixture and visually inspect.						
5	Align part on appropriate gripper magnet standoff fixture (right or left) and cement face magnets and side magnets.						
6	Air bake epoxy for 2 hrs. at 100 degrees C						
7	Remove fixture and visually inspect part.						
8	Wire Specification Spool PO#: Spool Lot#: Order Date: Wire Diameter:						

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.



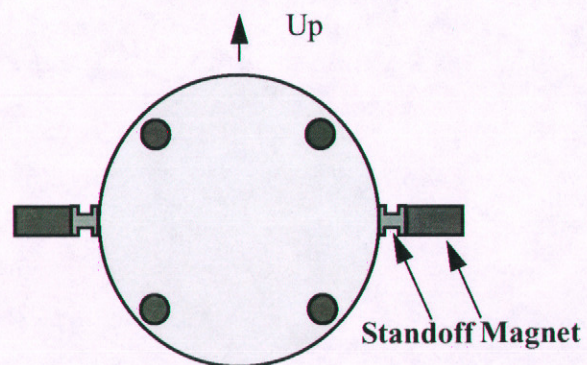
#	Operation/Instructions (Comments)	1st time			2nd time		
		Name/ Initials	Start Date	End Date	Name/ Initials	Start Date	End Date
9	Hang, balance optic, locate and epoxy wire standoff per (SOS) E970037; <b>complete QC worksheet LIGO-E970080-00-D</b>						
10	Cure epoxy with a heat lamp for 6-12 hrs.						
11	Remove from structure tower - CO2 blow optic						
12	Vacuum bake per E960022 VBO Load#___ scan#_____ VBO Load#___ scan#_____ VBO Load#___ scan#_____ VBO Load#___ scan#_____						
13	Perform "razor blade" test to bonds. If any failures, record which bond failed						
14	Resuspend optic in tower. Balance Angle after bake:						
15	Match 5 Sensor/Actuator heads and install. 1. 2. 3. 4. 5.						
16	Install tower in MC. Location:						



**NOTES:**

Indicate location of failed bonds, if any. As reference, indicate the position of the wire rod and wire standoff on Figure 1

Figure 1





**LIGO** SMALL OPTIC PROCESS TRAVELER Form E000460-B-W

DCC Number: E\_\_\_\_-00-X  
Date Prepared: \_\_\_\_\_

**Table 1: Notes and Process Items**

Date	Name	Description

*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.*