

Title: FABRICATION PLAN FOR CRYOPUMPS

FABRICATION PLAN
FOR
80K CRYOPUMPS
LIGO VACUUM EQUIPMENT

Hanford, Washington
and
Livingston, Louisiana

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Information contained in this specification and its attachments is proprietary in nature and shall be kept confidential. It shall be used only as required to respond to the specification requirements, and shall not be disclosed to any other party.

6	PF 5/1/96	REV 5/2/96	ISSUED PER DED 0/6/1 FOR RDR
REV LTR.	BY-DATE	APPD. DATE	DESCRIPTION OF CHANGE

PROCESS SYSTEMS INTERNATIONAL, INC.				SPECIFICATION		
INITIAL APPROVALS	PREPARED	DATE	APPROVED	DATE	NumberA V049-2-082	Rev.
	PF	5/1/96	RES	5/2/96	LIGO-896016A-00-V	φ

TABLE OF CONTENTS

- 1.0 Purpose
- 2.0 General
- 3.0 Responsibility
- 4.0 Fabrication Plan

ATTACHMENTS:

- 1. Cryopump Fabrication Documents
- 2. Fabrication Flow Chart
- 3. Fabrication Priority List

Number
Rev.

SPECIFICATION		
Number	V049-2-082	Rev.
A		<i>Ø</i>

1.0 PURPOSE

The purpose of this procedure is to define design guidelines, specifications, and procedures to enable PSI to specify, purchase, inspect, fabricate, test and ship the 80K Cryopumps per LIGO requirements.

2.0 GENERAL

All Cryopumps shall be fabricated per this fabrication plan. Each fabrication process shall be controlled via a written procedure. A "first article" approach will be used to validate all fabrication processes prior to release of the full vessel lot.

All vessels will be fabricated in accordance with the Quality Plan. Key points in the fabrication process shall be verified to ensure consistent results.

All vacuum equipment shall be fabricated in accordance with LIGO Project Contract PC175730 dated September 12, 1995, and subsequent change orders.

3.0 RESPONSIBILITY

The Manufacturing Department is responsible for the execution of this procedure, with input and monitoring by the Project Engineer, the Quality Assurance Department, and the Project Manager.

4.0 FABRICATION PLAN

4.1 A first article approach will be used to start the Cryopump manufacturing cycle to validate the manufacturing procedures and technique prior to the full production release.

4.2 The Cryopumps will be fabricated at PSI. PSI will perform vessel cleaning, leak checking, bakeout and preparation for shipment.

4.3 The Cryopumps will be fabricated and tested per documents listed in Attachment I "Fabrication Documents".

4.4 The Cryopumps will be fabricated and tested per Attachment 2 Cryopump Fabrication Flow Chart.

4.5 The Cryopumps will be fabricated according to the Fabrication Priority List Attachment 3.

SPECIFICATION

Number

A

V049-2-082

Rev

Ø

4.6 Procurement

PSI will procure all S.S. plate and flange material.

PSI will purchase vessel heads.

4.7 Quality Assurance

The Cryopump Fabrication Process shall be monitored and control via the Quality Plan V049-2-098.

PSI will inspect all incoming materials to the purchase documents.

4.8 Shop Conditioning/Testing

The Cryopumps will be shop conditioned (cleaned, bakeout, etc.) per PSI Procedure V049-2-047.

4.9 Preparation For Shipment

The Cryopumps will be prepared and shipped per PSI Procedure V049-2-123.

Number

Rev.

SPECIFICATION

Number

A

V049-2-082

Rev.

φ

Title

FABRICATION PLAN FOR CRYOPUMPS

ATTACHMENT 1

CRYOPUMP DOCUMENTS

- | | | |
|-----|--|---|
| 1. | Spec. For Cryopump Fabrication | V049-2-096 |
| 2. | Cryopump Quality Plan | V049-2-098 |
| 3. | Bill of Material | V049-4-004, V049-4-005 |
| 4. | Flanges | V049-2-040 & V049-2-042 |
| 5. | Heads | V049-2-039 |
| 6. | Raw Material Handling Procedure | V049-2-120 |
| 7. | Weld Data Sheet Spec. | V049-2-084 |
| 8. | Weld Procedures | V049-2-070, V049-2-071,
V049-2-072, V049-2-073 |
| 9. | Weld Repair Procedure | V049-2-074 |
| 10. | Cleaning Procedures | V049-2-015 |
| 11. | Painting Procedures | V049-2-077 |
| 12. | Components Shop Conditioning/Test Plan | V049-2-047 |
| 13. | Bakeout Procedure | V049-2-019 |
| 14. | Leak Test Procedure | V049-2-014 |
| 15. | Dimensional Verification Procedure | V049-2-121 |
| 16. | Component Packaging, Handling, and Shipping
Procedure | V049-2-123 |
| 17. | PSI Drawing | |
| | 80K Cryopump - Long | V049-4-004 |
| | 80K Cryopump - Short | V049-4-005 |
| | 44 5/8" ID Flange Detail (Grooved) | V049-4-017 |

Number
Rev.

SPECIFICATION

Number

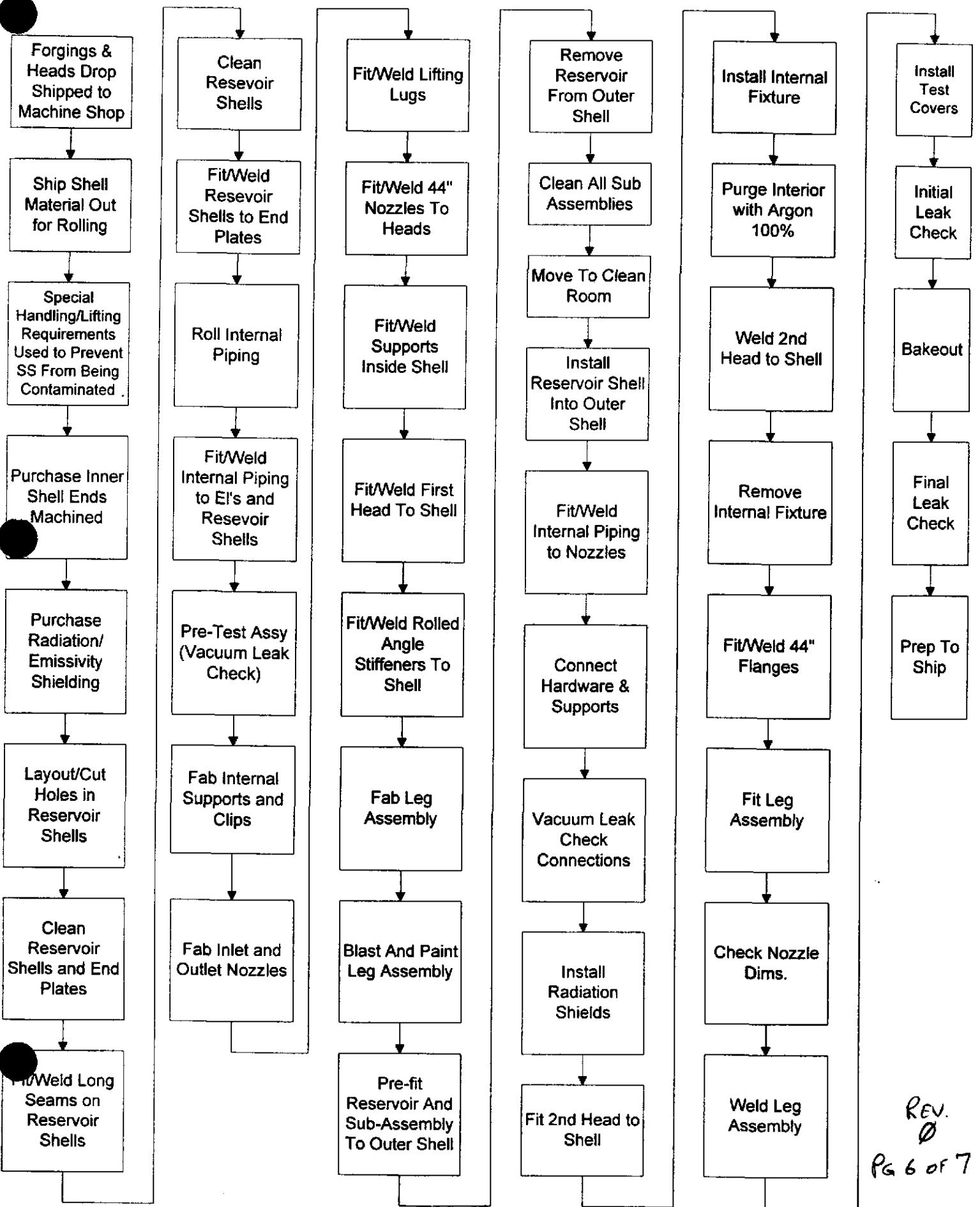
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V049-2-082

Rev.

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**ATTACHMENT 2
80K CRYOPUMP FABRICATION PROCESS DIAGRAM**



REV. 0
Pg 6 of 7

Title

FABRICATION PLAN FOR CRYOPUMPS

ATTACHMENT 3

80K CRYOPUMP FABRICATION PRIORITY LIST

WCP1	(CS)
WCP2	(CS)
WCP3	(LMS)
WCP4	(LMS)
WCP7	(LES)
WCP5	(RMS)
WCP6	(RMS)
WCP8	(RES)
LCP1	(CS)
LCP2	(CS)
LCP3	(LES)
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Number

Rev.

SPECIFICATION

Number	A	V049-2-082	Rev.	ϕ
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