

INITIATOR TZ

DATE 8/19/98

L190-E980586-00-D

ENGINEERING CHANGE REQUEST (ECR)

NEXT ASSEMBLY NO. 972001

CUSTOMER DRAWING NO. 97221A

DRAWING TITLE LIGO CLD Spring

REVISION: FROM 01 TO A



HYTEC
INCORPORATED

DESCRIPTION OF CHANGE (Simple Phrase, Identify Class If Possible):

1. Incorporate new gapping on aluminum slugs
WAS 7.72 now 10.00mm
2. Update the drawing to current mfg plans
(see attached).

REASONS FOR CHANGE:

1. Improved rejection of springs
2. Incorporate the current mfg concepts

IDENTIFY OTHER PARTS/GROUPS THAT INTERFACE WITH THE ABOVE (Required):

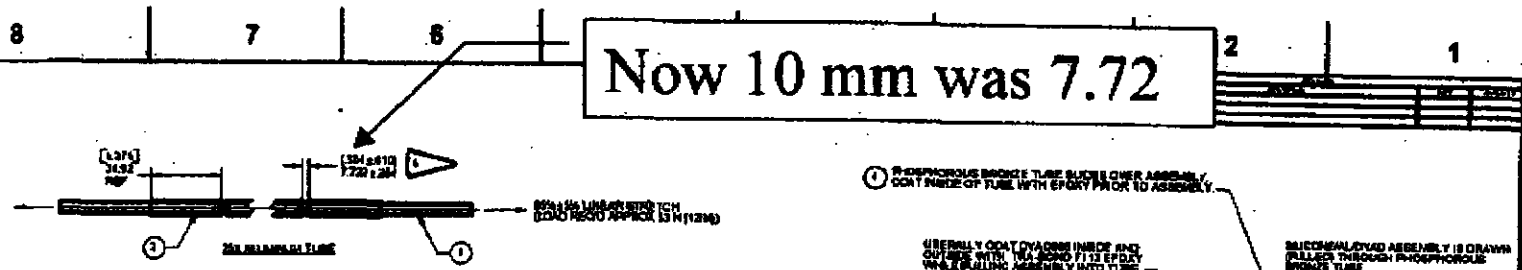
INTERFACE	RESPONSIBLE PARTY	INITIAL
N/A		

NOTIFY COGNIZANT DESIGNER: Roger

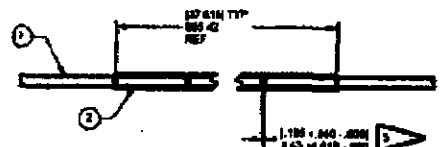
NOTIFY COGNIZANT ENGINEER: Tim / Eric

APPROVED: [Signature]

Now 10 mm was 7.72



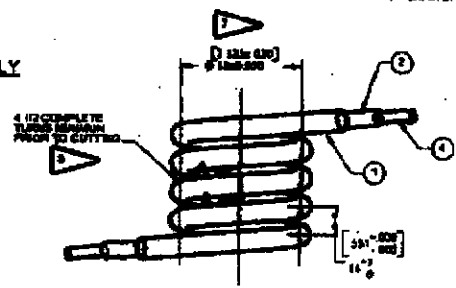
STEP 1: SPACE ALUMINUM SECTIONS ON STRETCHED SILICONE TUBE



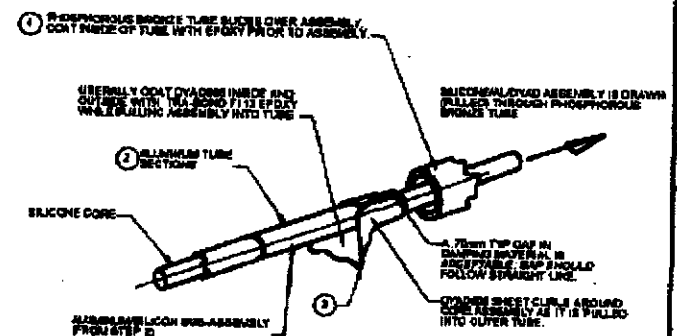
STEP 2: COMPLETED ALUMINUM/SILICONE SUB-ASSEMBLY



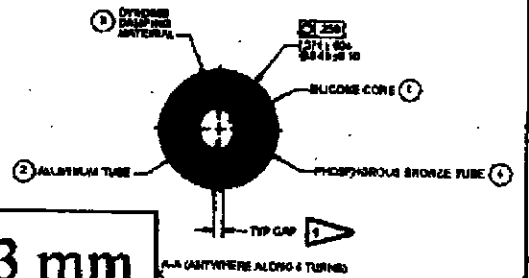
STEP 4: SWAGED ASSEMBLY



STEP 5: UNTRIMMED COIL



STEP 3: FABRICATION BEFORE SWAGE PROCESS



Now 4.44 mm was 3.43 mm

- NOTES:
1. ALL DIMS IN MM UNLESS
 2. ALL MACHINING AND FINISHING PROCESSES MAINTAINED TO STANDARD ULTRA-PRECISION TECHNOLOGICAL SPECIFICATIONS LISTED HERE OR SOG HYTES. ALL ISO 9000 PROCESS IS MORE STRINGENT
 3. SPECIAL FINISH SHALL BE PROVIDED FOR ALL MATERIALS, CHEMICAL CUTTING FLUIDS, ETC. USE DIRM THE 1.00000000
 4. ASSEMBLY PERFORMED WITH SILICONE CORE AT ROOM TEMPERATURE REQUIRES ABOUT 1 LB FORCE. OPERATOR TO BE CAUTIONED TO AVOID OVERHEATING AND TO WEAR PROTECTIVE GLOVES ON SILICONE CORE.
 5. ASSEMBLY MUST BE HELD FOR 1 HOUR OF HEATING PER HOUR OF HEATING ON SILICONE CORE.
 6. COILS MUST BE HELD FOR 1 HOUR OF HEATING PER HOUR OF HEATING ON SILICONE CORE.
 7. SWAGED ASSEMBLY MUST BE HELD FOR 1 HOUR OF HEATING PER HOUR OF HEATING ON SILICONE CORE.
 8. SWAGED ASSEMBLY MUST BE HELD FOR 1 HOUR OF HEATING PER HOUR OF HEATING ON SILICONE CORE.

HYTEC, INC		HYTEC, INC	
LIGO ISOLATION SYSTEM COIL SPRING		LIGO ISOLATION SYSTEM COIL SPRING	
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