*LIGO Laboratory / LIGO Scientific Collaboration*

E1000618-v1 *LIGO* 07 Sept. 2010

L4-C Seismometer Assembly Procedure

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Distribution of this document:

Advanced LIGO Project

This is an internal working note

of the LIGO Laboratory.

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**Clean room standards**

For a clean assembly all LIGO standards should be followed, as presented in the latest version of the **LIGO Contamination Control Plan (E0900047).** Clean room garb including UHV gloves should be worn when working with parts.

All tools that come in contact with assembly should be cleaned to class B standards.

Assembly will be done under a portable clean room. Any time a part of the assembly is not covered by the portable clean room or not being actively worked on it should be covered with appropriate clean covers. (C3 polyester or equivalent).

**Torque Values for Bolts:**

Standard torque values according to manufacturer standards for screw material should be used.

**Parts prep work: alignment pins and helicoils**

To facilitate assembly, parts requiring helicoils and/or pins to be inserted before assembly will be listed to allow preliminary preparation of the parts, after cleaning and before starting general assembly. See Appendix C for list.

**Weight**

Approximated weights are provided in this assembly procedure as an indication for safety purpose.

**Note:**

This Assembly is used i two configurations 1 is as shown, The other will involve mounting a plate turnig it into D1000525.

D047820 L4C Seismometer Pod pic.TIF

Figure

Reference D047820 and T080261 (Building L4-C Pods)

D1000525 L4C-ADL INTERPOSER ASSY pics.TIF1. Attach Item (1) D0902283 Interposer to Item (2) D047820 L4-C Assembly as shown in Figure 2, note orientation mark on Item (2), using the hardware supplied with the unit Items (17) and (18) screws and Item (14) vented washers from mentioned in Figure 1

Figure