

**Traveler Number**  
**LIGO-E040110-00-X**

<b>Originator</b>	<b>Cognizant Engineer</b>	<b>Ext./Phone#</b>	<b>PTA</b>
Helena Armandula	Janeen Romie	x2070	LIGO.PRLAS – 5.16 – NSFLIGO.FY02CA

<b>Dwg/Part Number</b>	<b>Rev</b>	<b>Part Description</b>	<b>Serial Number</b>	<b>Qty</b>
See list attached		Stainless steel parts - See list attached Aluminum parts - See list attached		

**Used In (next higher assembly):**

<b>Vendor Name</b>	<b>PO/Contract Number</b>

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

<b>Inspection Required Y/N</b>	<b>Visual Damage Y/N</b>	<b>Comments</b>	<b>Name/ Initials</b>	<b>Date Comp.</b>
Y	Y		H.A/J.R	3/15/04

**Process Flow:**

<b>#</b>	<b>Operation</b>	<b>Start Date</b>	<b>Work Area</b>	<b>Instructions</b>	<b>Name/ Initials</b>	<b>Date Comp.</b>
1	Clean & Vacuum Bake per LIGO Vacuum Prep. Form			per E960022.		
2	Control Point			Review/approve RGA scan # _____ Load # _____ Review/approve RGA scan # _____ Load # _____ Review/approve RGA scan # _____ Load # _____ Review/approve RGA scan # _____ Load # _____ Review/approve RGA scan # _____ Load # _____	D. Coyne/ S. Whitcomb	
3	Wrap & Tag vacuum clean parts per E960022-A					
4	Ship			Ship to Helena Armandula – 391 So. Holliston Ave – Pasadena – CA 91125 M/S 18-34 LIGO - Tel.: 626-395-2070		

## Aluminum Bake

Part #	Item	Quantity
	Assembly deflection jig	2
D020236-001	Guard top plate	1
D020447	Lower bar	3
D020446	Upper bar	2
D020346	Table cloth bracket	4
D020463	Winch fixture adapter plate	2
D020481	Upper mass clamp	7
D020197	Flag for magnet	15
D020482	Upper mass screw drive system	4
D020210	Bridge spacer for magnet	5
D020196	Magnet spacer	11
D020443	Upper blade guard	2
D020562	Upper blade guard assy. Plate	2
D020211	Fit for magnet	6
D020210	Bridge spacer	5
	Bar lower blade holder	2
D030016	Face bracket	3
D030015	Face bracket2	2
D020522	Cross bar bracket	6
D030014	Cross bar bracket2	9
D020523		6
	Aluminum cylinders (target legs)	7
D020445	V block	6
D020448	Catcher bar intermediate mass	2
D020449	Catcher bar for mass	2
D020541	Lower and intermediate mass	2
D020418	Small stiffner brace	2
D020417	OSEM holders	2

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**Aluminum Bake (Cont.)**

D030018	OSEM holders	4
D030017	OSEM holders	2
D020526	Aluminum bars	4
D020420	Aluminum bars	2
D020148	Wire standoffs	4
	Aluminum target	1
D020425	MCStructure front stiffner	2
D020422	MCStructure side stiffner	2

### Stainless Steel Bake

Part #	Item	Quantity
D030041	Table clamp	10
Bags	Assorted screws	2
Bag	Assorted washers	1
Bag	Library of clamps	1
D970180	Winch fixture	2
D960134	Suspension block	2
D030447	Rotating plate	2
D030448	Base plate	2
D030450		1
	Clamps	2
Bag	Library of clamps (lower)	24 upper-24 lower-5 shims
D020198	Upper blade wire clamp	5
D030042	Upper blade plate	5
D020309	Upper mass wire clamp w/groove	10
D020204	Lower wire shim	7
D020203	Clamp outside	7
D020202	Clamp inside	7
D020318	Wire clamp assemblies	7 pairs
D020350	Upper mass weight	2
D030468	Upper mass weight	2
D030078	Upper mass weight	2
D030454	Upper mass weight	1
D030455	Upper mass weight	1
D030079	Upper mass weight	2
D020136	T section-upper mass	1
D020676	Roll insert T section	1
D020199	Magnet holder	3

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**Stainless Steel Bake (Cont.)**

D030076	Magnet spacer	5
D020201	Lower blade flat	8
D020205	Upper blade	4
D020134	Upper mass main section	1
D010268	Blade clamp plate	2
D010261	Mass clamp	2
D010264	Upper blade wire clamp	2
D010265	Wire clamp plate	2
D020148	Wire standoff	8
D020239	Tablecloth	1
	Stainless steel screws	2 bags
	Silver plated srews	1 bag
	Washers	1 bag
D020023	MC Main Structure	1