

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Luke Williams	Luke Williams	352-392-4947 OR 352-328-6473	ELIGO IO FI ALUMINUM AND BRONZE BAKE	

Dwg/Part Number	Rev	Part Description / Material	Serial Number	Qty
D070463-00		FI Hard Aperture	Aluminum 6061-T6	4
D070464-00		FI Calcite Mount	Aluminum 6061-T6	4
D070465-00		FI 1" Optic Mount	Aluminum 6061-T6	6
D070466-00		FR Dust Shield	Aluminum 6061-T6	1
D070467-00		FR NG TGG Holder,	Aluminum 6061-T6	2
D070468-00		FR Sleeve Lock	Aluminum 6061-T6	2
93181A009		#8-32 Nuts, McMaster-Carr	Aluminum 6061-T6	100
D070469-00		FR Stand	Aluminum 6061-T6	2
D070470-00		FR Thick Strap	Aluminum 6061-T6	4
XXX		Dog Clamps	Aluminum 6061-T6	20
D070471-00		FI 1" Optic Lock Ring	Phosphor Bronze	6
D070472-00		FR Positioning Screw	Phosphor Bronze	6
D070473-00		FR TGG Cap	Phosphor Bronze	1

N.B.: A copy of this traveller must be submitted to the DCC each time the original is shipped with the associated part(s) and when the traveller has been completed.

advancedligo

DCC Number: E 070251-00-D

Date Prepared: 10-24-07

D070474-00		FR Quartz Holder	Phosphor Bronze		1
D070475-00		FR Quartz Cap	Phosphor Bronze		1

Used In (next higher assembly): ELIGO IO FARADAY ISOLATOR

Vendor Name	PO/Contract Number
UF, McMaster-Carr	

Data Package, Receiving/Inspection Remarks:

Inspection Required Y/N	Visual Damage Y/N	Comments	Name/ Initials	Date Comp.
N				

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
1	Clean			Per E960022-B, Class A		
2	Vacuum Bake			Per E960022-B, Class A, 120C for 48 hours		
3	Control Point			Review/Approve RGA scan		
4	Wrap & Tag vacuum clean parts			Wrap (UHV foil) and place in ameristat bags. Please be especially careful with the TGG holders and dust shield, as they are quite fragile.		

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#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
5	Ship and Deliver/File paperwork			Please send with Fed Ex Overnight to: Kate Dooley LIGO Livingston Laboratory 19100 LIGO Lane Livingston, LA 70754 USA File one copy of traveler with the DCC. Note: Ship original traveler with these parts.		

END: Go to Traveler or procedure associated with next higher assembly processing

Special Instructions (Handling/Packaging Constraints, Remarks, etc.) or Notes:

Hi Bob, these parts were scheduled to be class A clean and baked at LLO, but the schedule was interrupted when the oven went down. We are hoping to start using these parts on Nov. 1st, so anything that can be done to get these parts processed and shipped back to LLO as quickly as possible will be greatly appreciated. If there are any problems, please call me at 352-328-6473. Thanks, Luke

Please do not assemble any parts after cleaning.

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Pressure Contribution from Flag Hydrocarbons

40M Lab RGA Scan Results

Job# C111207_LW_AL

Description: ELIGO FI AL & Bronze Parts
Oven Used: C

Date: 11/12/2007

AMU 41 2.50E-15 amps from RGA scan listing
AMU 43 9.00E-16 amps from RGA scan listing
AMU 53 0.00E+00 amps from RGA scan listing
AMU 55 0.00E+00 amps from RGA scan listing
AMU 57 0.00E+00 amps from RGA scan listing

Sum Flag H/C AMUs 3.40E-15 amps

Calib leak rate 2.36E-10 torr l/s (Argon)

AMU 40 (w/leak open) 1.00E-13 amps

AMU 40 (background) 1.00E-14 amps

Calib leak contributes 9.00E-14 amps = (w/leak open) - (background)

Flag H/C Outgassing 8.916E-12 torr l/s = (Sum Flag H/C AMUs) x (Calib leak rate)/(Calib leak contrib.)

Test item surf area 2.37E+03 cm²

Normalized outgassing 3.762E-15 torr l/s-cm² = Flag H/C Outgassing/Test item surf area

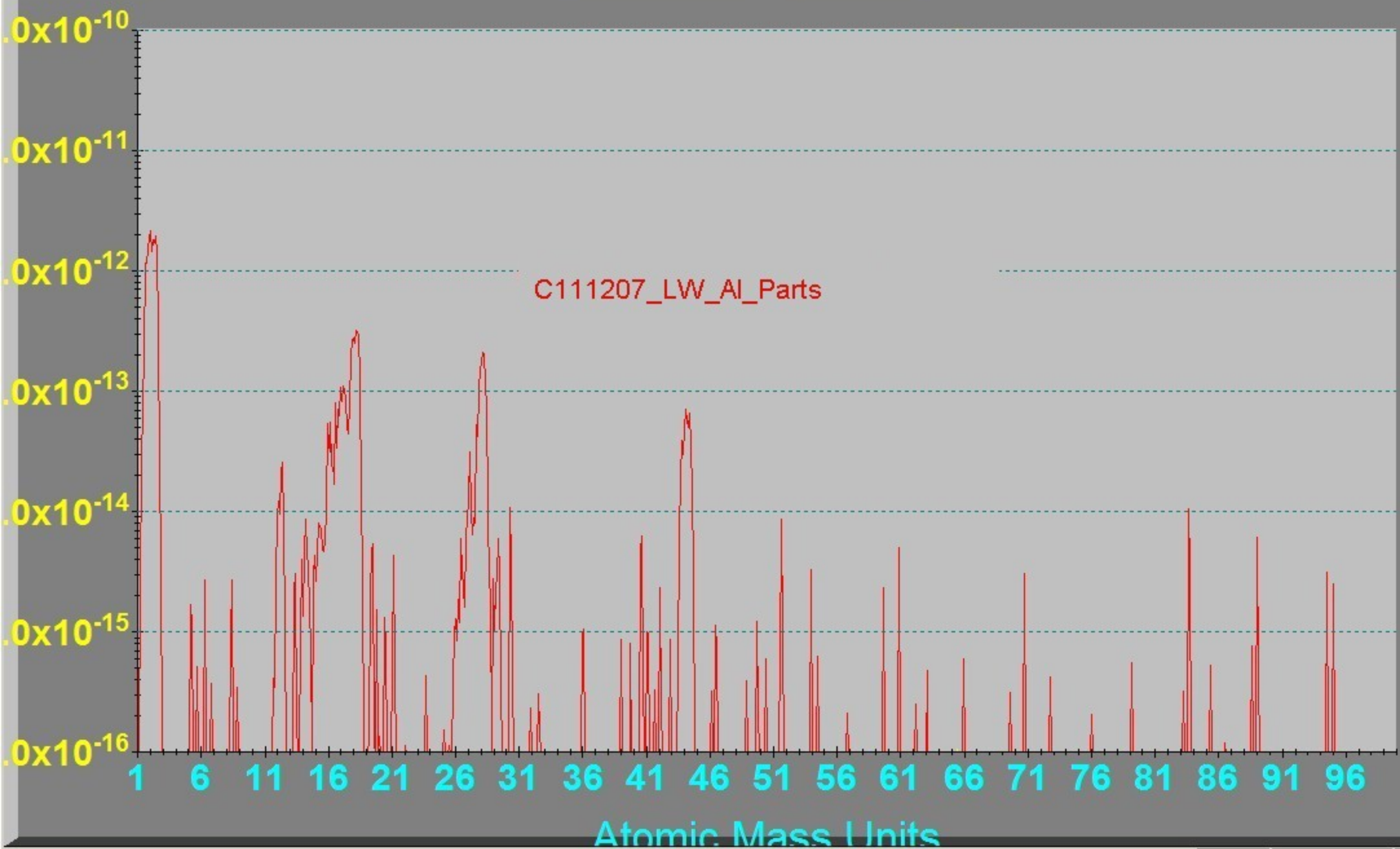
Full description: See Traveler E070251-00

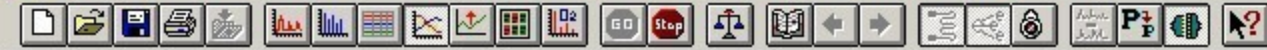
Pre-scan bake: 120C for 48Hrs.



Amps

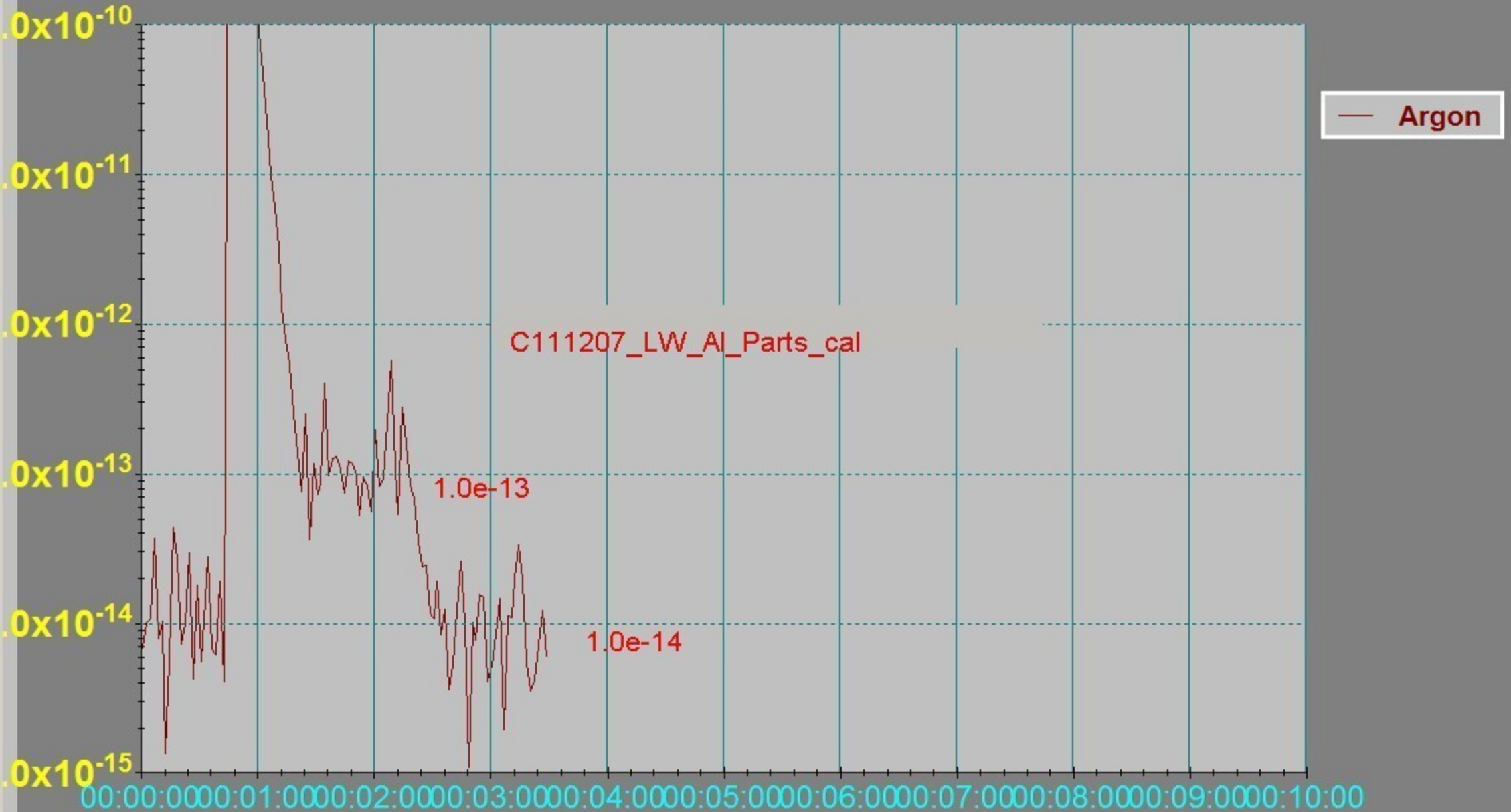
RGA Analog Scan





Amps

RGA P vs T Scan



Time (hh:mm:ss)