

Originator	Cognizant Engineer	Ext./Phone#	Project	Account Number
Stephany Foley	Ken Mason	617-324-5250	E-LIGO SEI HAM	

Dwg/Part Number	Part Description / Material	Qty
20007935	locator, spherical pin kinematic lock ligo D047935B, 440C stainless	4
D071251 -00	gang barrel nut, 17-4 PH stainless steel (3_8-16 w_2 x 3.0)	6
D071251 -01	gang barrel nut, 17-4 PH stainless steel (3_8-16 w_4 x 2.5)	6
D071251 -02	gang barrel nut, 17-4 PH stainless steel (1_2-13 w_2 x 3.0)	3
D071251 -03	gang barrel nut, 17-4 PH stainless steel (1_2-16 w_3 x 2.5)	9
D071251 -04	gang barrel nut, 17-4 PH stainless steel (1_2-16 w_4 x 2.5)	6
D071201	mass spacer, 304 SS	18
D071200 -00	adjustment masses, 304 SS	8
D071200 -01	adjustment masses, 304 SS	10
D071200 -02	adjustment masses, 304 SS	12
D071200 -03	adjustment masses, 304 SS	18
D071200 -04	adjustment masses, 304 SS	9
D071200 -06	adjustment masses, 304 SS	18
D071141 -00 through -10	shim, 304 SS	90
D071136 -00	SHCS, custom captive, 18-8 SS	25
D071136 -01	SHCS, custom captive, 18-8 SS	54
D071003	Support post cap, 304 SS	3
20007934 (aka D070470)	Locker sleeve- stainless with Balinit coating— NOTE: treat as stainless	4
D071103	Flexure Mount / stainless	6
D071471	Flexure Cups / stainless --where's 6 th one??	5

Used In (next higher assembly):

Vendor Name	PO/Contract Number

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.

Data Package, Receiving/Inspection Remarks:

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

Process Flow:

#	Operation	Start Date	Work Area	Instructions	Name/ Initials	Date Comp.
1	Clean		LLO	per E960022: <ul style="list-style-type: none"> ○ clean per E960022: Ultrasonic clean in Liquinox for 10 minutes. ○ Rinse in distilled water at least 3 times, changing the rinse water every time. ○ Ultrasonic clean in methanol for 10 minutes. 	T.E.	1/16/08
2	Vacuum Bake			per E960022: 200°C for 48 hrs	T.E.	1/21/08
3	Control Point			Review/Approve RGA scan	BO'R	1/22/08
4	Wrap & Tag vacuum clean parts				T.E.	1/22/08
5	Ship and Deliver/File paperwork			Please send to: LHO c/o SEI File one copy of traveler with the DCC. Note: Ship original traveler with these parts.	BO'R	1/22/08

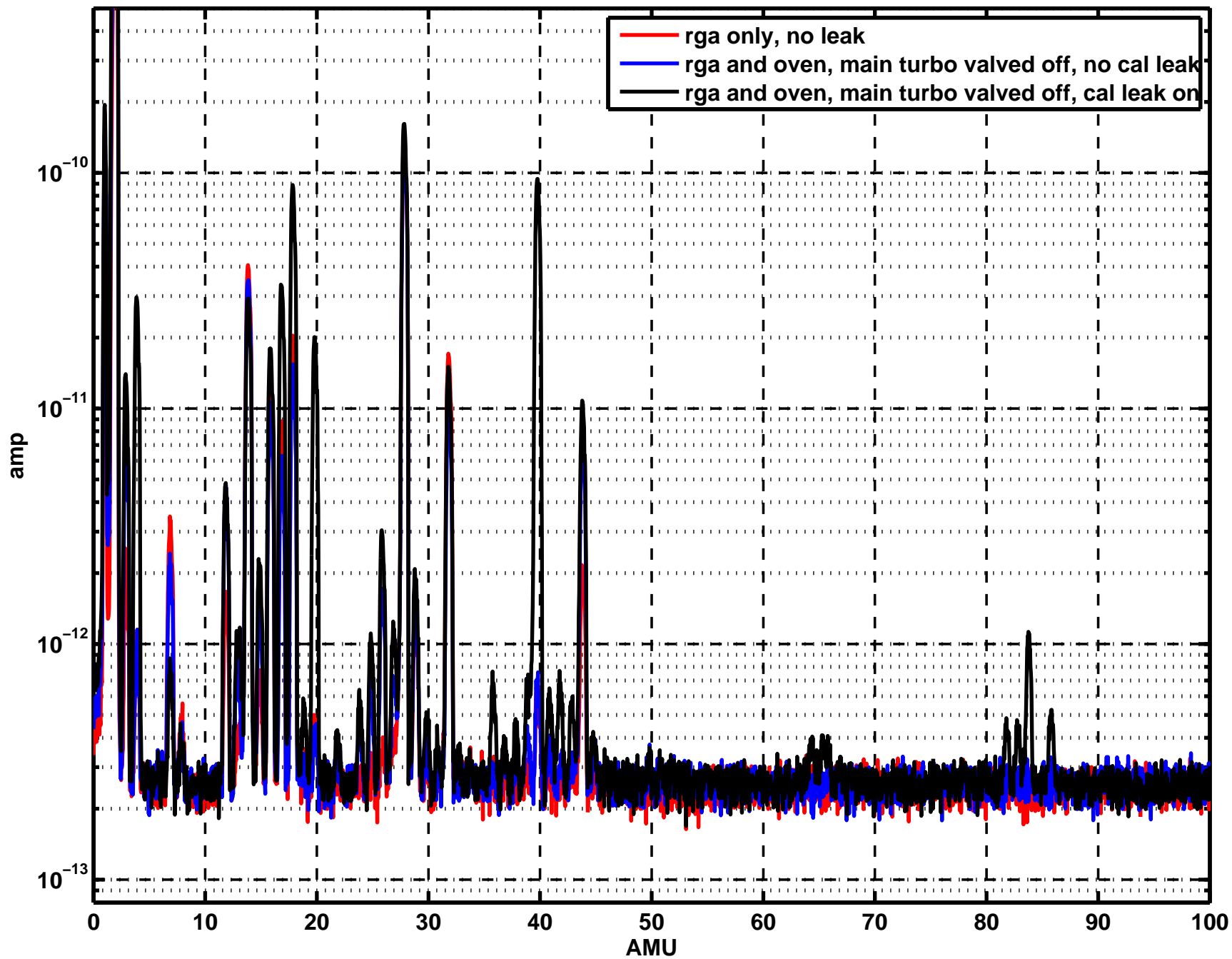
END: Go to Traveler or procedure associated with next higher assembly processing

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

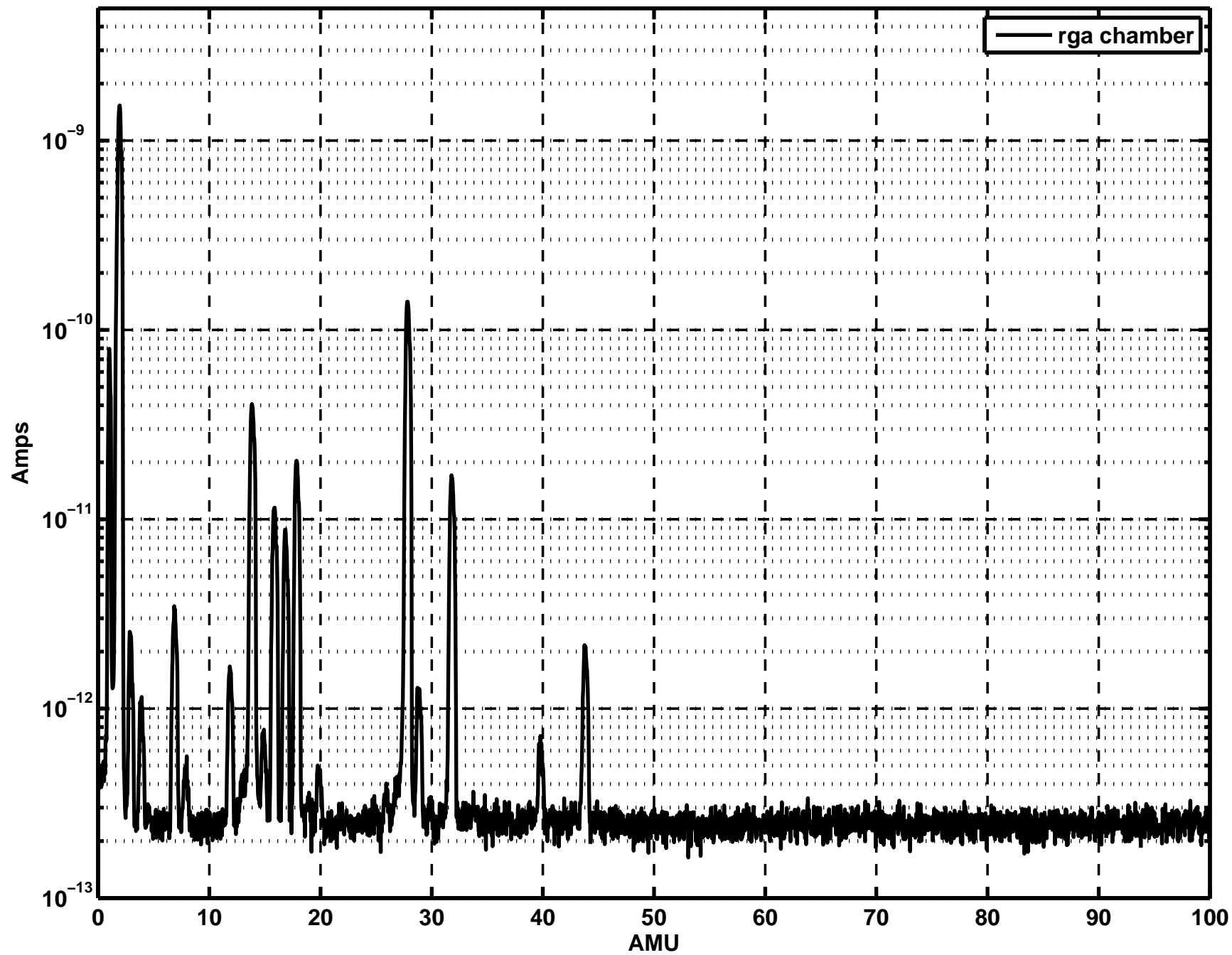
These are parts for the enhanced LIGO SEI build at the Hanford site. The gang-barrel nuts were removed for use on the LLO build. They will be replaced by LLO ones

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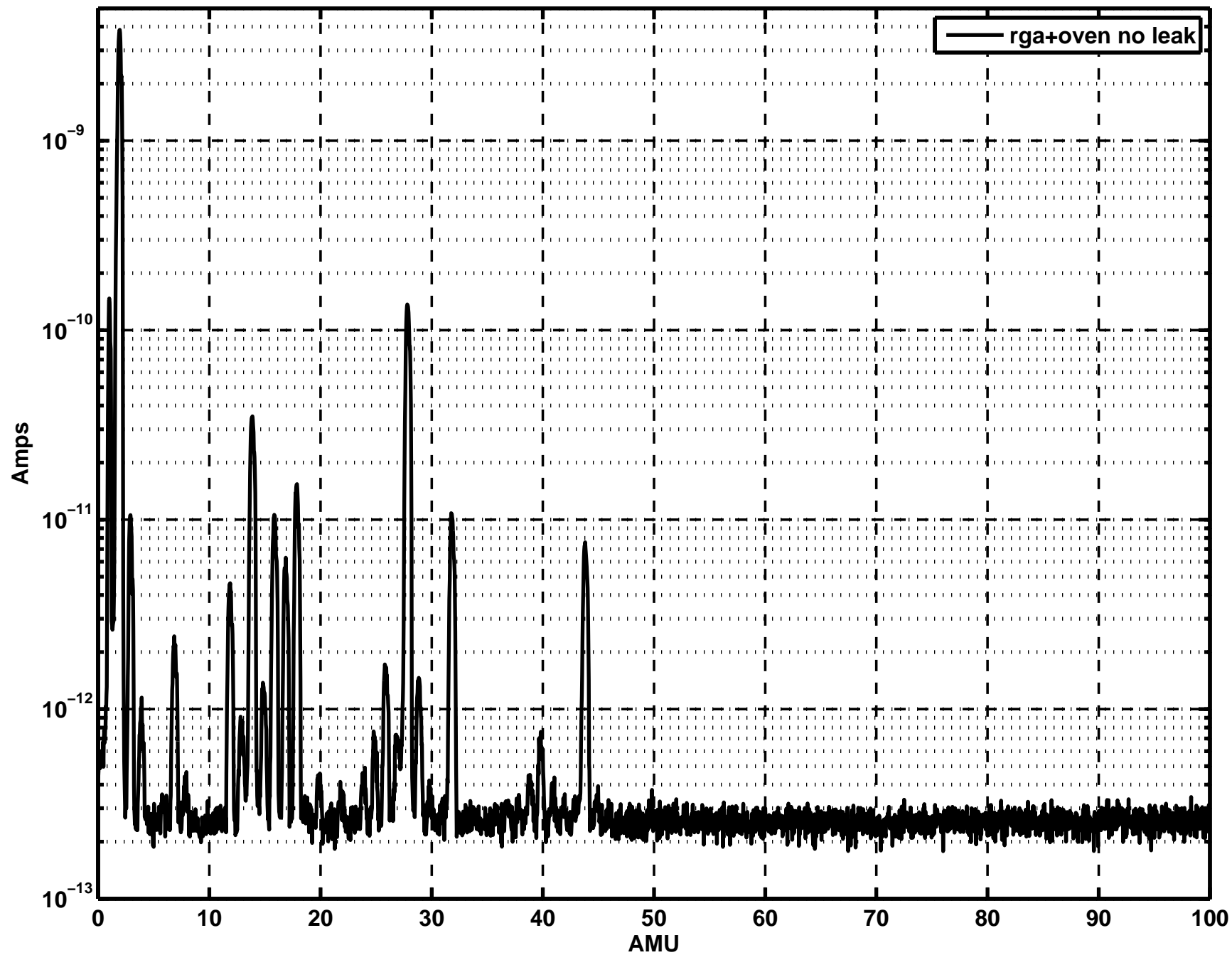
Load 22jan08



RGA Only



RGA+Oven Only



RGA of Oven Load with calibrated leak (main turbo valved off)

