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# LIGO LABORATORY

California Institute of Technology

1200 E. California Blvd.

Pasadena, CA 91125

**Statement of Work**

**TMS Suspension Springs**

**C1200457-v2**

Note to LIGO users: all red text in this template is font type ‘hidden’ and comprises instructions to complete the SOW. Easier than deleting them, you can hide all red text before saving. In Word 2010, click File, Options (on the left side), Display (on the left side), and then unclick “Hidden Text”.

The “TEMPLATE” watermark can be removed by clicking Page Layout, Watermark, and then Remove Watermark.

1. **Scope (LIGO sub-system)**

This Statement of Work covers the manufacturing of two types of maraging steel 'thin' curved blade springs according to LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf), sections 1 through 2.4. Parts will be manufactured from LIGO supplied material.

Briefly describe the work. For example: Fabrication of Vacuum Pod components for Advanced LIGO BSC-ISI Seismometers.

1. **Document Access**

Many supplemental documents and specifications are incorporated into and made a part this Statement of Work. Click on the document links to access these documents from the LIGO Document Control Center (DCC) or go on line to the LIGO Public DCC at <https://dcc.ligo.org/> to access the DCC#.

1. **Commercial Terms and Applicable LIGO Specifications:**

**Note: The documents listed below are invoked for this Statement of Work and comprise additional requirements which are integral to this Statement of Work.**

Important: C080185 and Q0900001 apply to all SOWs. Add/delete others as appropriate.

Check to be sure the latest revisions are specified below (please notify QAME or Systems if this template needs to be updated).

* [LIGO-C080185-v1](https://dcc.ligo.org/public/0002/C080185/001/C080185-00_Commerical_Terms.pdf) LIGO Commercial Items or Services Contract General Provisions
* [LIGO-Q0900001-v5](https://dcc.ligo.org/public/0001/Q0900001/005/Q0900001-V5.pdf) Advanced LIGO Supplier Quality Requirements
* [LIGO-E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf) Process for Manufacturing Cantilever Spring Blades for AdvLIGO

1. **Quality System:**

Referring to the above referenced LIGO Specification Q0900001, Suppliers should include a copy of their current ISO 9001, AS9100, or TS16949 certification in their bid package. Suppliers lacking current certification should send a copy of their Quality Manual with their bid package.

1. **Parts to be manufactured, Quantity Required, and Inspection requirements:**List all parts to be made, including the **public** hyperlink to the latest revision, and the total quantity required. If you have more than ten parts, create a separate drawing document posted to the DCC as a public document, and link here.

|  |  |  |  |
| --- | --- | --- | --- |
| **Drawing #** | **Part Description** | **Total Qty:** | **Parts to be Inspected** |
| [LIGO-D1200116-v1](https://dcc.ligo.org/DocDB/0085/D1200116/001/D1200116-v1%20aLIGO%20TMS%20Upper%20Stage%20Blade%20Spring.pdf) | aLIGO TMS Upper Stage Blade Spring | 21 | Serial #'s 001 thru 021  (All Parts) |
| [LIGO-D1200117-v1](https://dcc.ligo.org/DocDB/0085/D1200117/001/D1200117-v1%20aLIGO%20TMS%20Lower%20Stage%20Blade%20Spring.pdf) | aLIGO TMS Lower Stage Blade Spring | 21 | Serial #'s 001 thru 021  (All Parts) |

**Notes:**

**(1) Refer to section 7.6.1 of this SOW for scope of inspection required.**

**(2) See section 7.7 for Part Number and Serial Number marking requirement.**

**(3) The above drawings are to be revised prior to purchase order for this work. The change to each drawing will consist primarily of a decrease in curve radius, with negligible change to flat pattern dimensions. The decrease in curve radius in each case will be on the order of 5%.**

1. **Manufacturing Facilities, Equipment, and Capability:**

LIGO personnel will inspect the supplier's facilities and equipment to ascertain that the supplier possesses adequate and appropriate facilities, equipment, and capability for the stated work. Supplier must insure that all sub-contractors have the necessary facilities, equipment, and capabilities for the sub-contracted work. LIGO reserves the right to inspect all sub-contractors' facilities.

Note 1: Care should be given to the selection of the AQL number. Consider the amount of time (which equals cost) required to 100% inspect a given number of parts. Contact QAME for advice.

Note 2: Additional inspection instructions beyond the AQL number can be given – such as 100% inspection of all threaded holes.

1. **Manufacturing Requirements:**
   1. **Fabrication:**
      1. All parts are to be manufactured in strict accordance with LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf), and all additional requirements of this SOW, except for section 2.5, section 2.6 and section 3.0 of [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf). (Supplier is not responsible for nickel plating or hydrogen embrittlement bake as per section 2.5 and section 2.6 of [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf).)

All parts are 'thin' curved springs as described in section 2.2 of LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf).

Supplier is responsible for all sub-contractors' conformance to LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf) wherever applicable, including handling and protection of parts, and to all additional and applicable requirements of this SOW.

* + 1. Included with price and delivery quote, supplier will supply a complete outline of the intended manufacturing process.
    2. For each completed part, the two major surfaces must be finished per LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf) and the drawings, to a 32 µinch Ra [.8 µm Ra] roughness maximum. For each completed part, all non-major surfaces including hole surfaces must be finished to a 63 µinch Ra [1.6 µm Ra] roughness maximum (not per Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf) or the drawings).
    3. All completed parts must consist of 100% virgin material, free of repairs such as plugs or welds.
  1. **Material:**

LIGO will supply the raw material for all parts from stock on hand. This material is Maraging Steel C-250, circa 2002 per AMS 6512D, .27 inch thick sheet.

NOTE: LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf) , section 2.1, requires Maraging Steel C-250 per AMS 6520. This discrepancy is noted and approved by LIGO.

* 1. **Tooling:**
     1. LIGO possesses some tooling specifically for production and inspection of the parts of this SOW. This tooling may be useful to the supplier and is available for their use. This tooling will remain the property of LIGO.
     2. Supplier will supply all further necessary tooling for production and inspection of the parts. This tooling, for an agreed NRE, will be the property of LIGO.
  2. **Sub-Contracted Work:**

LIGO expects that at least 2/3 (by dollar value) of the contracted work be performed by the Supplier named on the Purchase Order. All sub-contracted work shall be done in accordance with the manufacturing process agreed to prior to award of prime contract. The Supplier shall be responsible for all sub-contracted work.

* 1. **Precedence:**

If any conflict is perceived among the drawings and other invoked documents of this SOW (see section 3.0 for other invoked documents), the supplier is requested to contact a LIGO representative for resolution.

* 1. **Inspection of Parts:** Add/delete as appropriate

LIGO reserves the right to source inspect at supplier's facility after:

* + flatflat fabrication
  + rolling (curve forming)
  + heat treat
    1. All completed parts (Serial Numbers 001 through 021 for both Part Numbers) shall be inspected by the supplier for full conformance to the specifications of the drawings, except as stated in section 7.1.3 of this SOW.
    2. Prior to delivery, supplier will provide complete drawing conformance inspection reports for all parts according to Part Number and Serial Number. See section 8.0, this SOW.
  1. **Marking of Parts:**

Each part is to be numbered in an approximate location as noted on the drawing. Marking is to be scribed, engraved (a vibratory tool may be used), or laser applied. No inks or dyes are permitted. Marking shall consist of part number with revision, followed by a three digit serial number. Serial numbers shall start at 001 and proceed consecutively. Character height shall be .10" minimum.

Example: D1200116-V2 S/N 004

* 1. **Manufacturing Environment and Protection of Parts:** Add/delete as appropriate
     1. LIGO personnel will initially inspect the supplier's facility to ascertain acceptable moisture control, general air quality control, and general facility cleanliness control. All sub-contractors must agree that LIGO may similarly inspect their facilities.
     2. Parts must be protected from moisture at all times up to and including time of delivery. fla These requirements apply to all sub-contractors, and supplier is responsible for all sub-contractors' conformance to them. These requirements are in addition to the various protection and special handling requirements throughout LIGO Specification [E0900023-v11](https://dcc.ligo.org/public/0000/E0900023/011/E0900023-v11_Manufacturing%20Process%20Spec%20for%20Cantilever%20Spring%20Blades.pdf).

1. **End Item Data Package:** Add/delete lines as necessary

Before delivery of the parts, the Supplier shall provide the following data, as a minimum:

* Any as-built modifications (with approval of the LIGO Contracting Officer) as mark-ups to the drawings
* Heat Treat and/or Stress Relief certifications, if applicable
* Inspection reports according to Sections 5.0 and 7.6.1&2 of this SOW
* Certificate of compliance for each part number stating conformance to contract and drawing requirements

1. **Delivery Requirements:**
   1. **Shipping Containers and Packaging:**

The contractor is responsible for providing shipping containers and transportation which protects these parts from damage from the transportation environment (weather, handling, accidents, etc.). Mating edges of parts should be especially protected from damage during shipping.

Note any special packaging requirements here (i.e., wrap in UHV foil and Ameristat).

* 1. **Shipping Destination:**

The deliveries are FOB at these destinations, i.e. the Supplier has the responsibility for shipping title and control of goods until they are delivered and the transportation has been completed. The contractor selects the carrier and is responsible for the risk of transportation and for filing claims for loss or damage.

Delete shipping destinations that don’t apply to this SOW. Be sure to reference the shipping abbreviations (i.e., LLO) in the Delivery Schedule if there is more than one shipping destination.

These items will be shipped to:

**California Institute of Technology (CIT)**   
attn: Ken Mailand

LIGO Project MS 100-36

391 S. Holliston Ave.

Pasadena, CA 91125

* 1. **Delivery Schedule:**

LIGO desires to receive (at the address cited in 9.2 above) *at least* 4 pieces of each part number within 8 weeks ARO and the balance within 12 weeks ARO.  Please quote the best delivery that you are confident of achieving, even if it exceeds the desired delivery time.  Among other factors, the quoted delivery time will be a consideration in the award selection process.Insert a list or table detailing the delivery requirements (by P/N, as necessary). Delivery should be specified in weeks ARO (after receipt of order). Please also specify the shipping destination (i.e. LLO).

Note any first article requirements. If applicable, the SOW must state upfront that LIGO wants to assemble the first articles for fit check before the rest of the order is completed.