E1200254-v3

Derek Bridges

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Tolerances for Height Measurements of the HAM Suspensions During Assembly

In the tables below, the measurements of all listed degrees of freedom are calculated from measurements of the height of certain points on the suspension. The degrees of freedom are color coded:

* Black – Vertical (Height) as measured from the surface of the optical table
* Blue – Roll
* Green – Pitch

HAM Large Triple Suspension (HLTS)

| Description of Measurement | Design Value | Accuracy of Measurement[[1]](#endnote-1) | Tolerance Before Creep Bake | Tolerance for Final Metal Build | Tolerance for Glass Optic Build |
| --- | --- | --- | --- | --- | --- |
| Upper Blade Wire Breakoff Height (relative to optical table) | 806.12 mm | LLO – 0.25 mm[[2]](#endnote-2)LHO – 0.01 mm[[3]](#endnote-3) | ±1 mm |
| Upper Blade Wire Breakoff Height (relative to other blade) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Tablecloth Height – Upper Surface (relative to optical table) | 658.59 mm | LLO – 0.25 mmLHO – 0.01 mm | Determined by Upper Mass Height |
| Upper Mass Height – Bottom of Screwdrive Block (relative to optical table) | 613.18 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of Screwdrive Block | 0 mrad | LLO – ≈ 0.853 mradLHO – ≈34.1 μrad | 5 mrad |
| Upper Mass Pitch – Bottom of Screwdrive Block | 0 mrad | LLO – ≈2.59 mradLHO – ≈104. Μrad | 5 mrad |
| Upper Mass Height – Bottom of T-Piece (relative to optical table) | 552.23 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of T-Piece | 0 mrad | LLO – ≈2.17 mradLHO – ≈86.9 μrad | 5 mrad |
| Upper Mass Pitch – Bottom of T-Piece | 0 mrad | LLO – ≈2.60 mradLHO – ≈104. Μrad | 5 mrad |
| Lower Blade Wire Breakoff Height (relative to optical table) | 608.84 mm | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| Lower Blade Wire Breakoff Height (relative to other blades) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| d1 Value | 1.00 mm | LLO – 0.25 mmLHO – 0.01 mm | -0.5 mm / +1 mm |
| Intermediate Mass Height – Upper Surface (relative to optical table) | 461.63 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required)±0.5 mm (desired) |
| Intermediate Mass Roll – Upper Surface | 0 mrad | LLO – ≈1.17 mradLHO – ≈46.8 μrad | 5 mrad |
| Intermediate Mass Pitch – Upper Surface | 0 mrad | LLO – ≈2.50 mradLHO – ≈100. Μrad | 5 mrad |
| Bottom Mass Height – Top of Bottom Mass (relative to optical table) | 291. mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Pitch | 0 mrad | LLO – ≈2.50 mradLHO – ≈100. Μrad | 5 mrad | ±0.28 mrad (see T080307) |
| Bottom Mass Height – Edge of Prism | 159.5 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Height – Bottom of Side Bores in Metal Mass (relative to optical table) | 130.24mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) | N/A |
| Bottom Mass Roll – Bottom of Side Bores in Metal Mass | 0 mrad | LLO – ≈2.07 mradLHO – ≈82.9 μrad | 5 mrad | N/A |
| Bottom Mass Height – Center of Metal Mass/Optic (relative to optical table) | 158.5 mm | N/A – cannot be measured directly | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Height – Bottom of Metal Mass/Optic (relative to optical table) | 25.98 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (see required – M1100192)±0.5 mm (desired) |

HAM Small Triple Suspension (HSTS)

| Description of Measurement | Design Value | Accuracy of Measurement | Tolerance Before Creep Bake | Tolerance for Final Metal Build | Tolerance for Glass Optic Build |
| --- | --- | --- | --- | --- | --- |
| Upper Blade Wire Breakoff Height (relative to optical table) | 826.6 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Blade Wire Breakoff Height (relative to other blade) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Tablecloth Height – Upper Surface (relative to optical table) | 559.95 mm | LLO – 0.25 mmLHO – 0.01 mm | Determined by Upper Mass Height |
| Upper Mass Height – Bottom of Main Section (relative to optical table) | 536.61 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of Main Section | 0 mrad | LLO – ≈1.45 mradLHO – ≈58.2 μrad | 5 mrad |
| Upper Mass Height – Bottom of T-Piece (relative to optical table) | 479.41 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of T-Piece | 0 mrad | LLO – ≈5.00 mradLHO – ≈200. Μrad | 10 mrad | 5 mrad |
| Upper Mass Pitch – Bottom of T-Piece | 0 mrad | LLO – ≈5.00 mradLHO – ≈200. Μrad | 10 mrad | 5 mrad |
| Lower Blade Wire Breakoff Height (relative to optical table) | 525.46 mm | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| Lower Blade Wire Breakoff Height (relative to other blades) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| d1 Value | 2.00 mm | LLO – 0.25 mmLHO – 0.01 mm | -0.5 mm / +1.5 mm (required)0 mm / +1 mm (desired) |
| Intermediate Mass Height – Upper Corner of Lower Wire Clamp (relative to optical table) | 371.17 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Intermediate Mass Pitch | 0 mrad | LLO – ≈3.33 mradLHO – ≈133. Μrad | 5 mrad |
| Intermediate Mass Roll – Upper Corners of Lower Wire Clamp | 0 mrad | LLO – ≈1.67 mradLHO – ≈66.7 μrad | 5 mrad |
| Bottom Mass Height – Top of Bottom Mass (relative to optical table) | 215. mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Pitch | 0 mrad | LLO – ≈1.67 mradLHO – ≈66.7 μrad | 5 mrad | ±0.26 mrad (see T080307) |
| Bottom Mass Height – Edge of Prism | 141. mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Height – Bottom of Side Bores in Metal Mass (relative to optical table) | 124.13 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) | N/A |
| Bottom Mass Roll – Bottom of Side Bores in Metal Mass | 0 mrad | LLO – ≈2.41 mradLHO – ≈96.3 μrad | 5 mrad | N/A |
| Bottom Mass Height – Center of Metal Mass/Optic (relative to optical table) | 140. mm | N/A – cannot be measured directly | ±1 mm (required – see M1100192)±0.5 mm (desired) |
| Bottom Mass Height – Bottom of Metal Mass/Optic (relative to optical table) | 65. mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm (required – see M1100192)±0.5 mm (desired) |

Output Mode Cleaner Suspension (OMCS)

| Description of Measurement | Design Value | Accuracy of Measurement | Tolerance Before Creep Bake | Tolerance for Final Metal Build | Tolerance for Glass Optic Build |
| --- | --- | --- | --- | --- | --- |
| Upper Blade Wire Breakoff Height (relative to optical table) | 646.99 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Blade Wire Breakoff Height (relative to other blade) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Tablecloth Height – Upper Surface (relative to optical table) | 431.29 mm | LLO – 0.25 mmLHO – 0.01 mm | Determined by Upper Mass Height |
| Upper Mass Height – Bottom of Main Section (relative to optical table) | 408.41 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of Main Section | 0 mrad | LLO – ≈1.12 mradLHO – ≈44.6 μrad | 5 mrad |
| Upper Mass Pitch – Bottom of Main Section | 0 mrad | LLO – ≈3.22 mradLHO – ≈129. μrad | 5 mrad |
| Upper Mass Height – Bottom of T-Piece (not including boss for threaded hole) (relative to optical table) | 341.86 mm | LLO – 0.25 mmLHO – 0.01 mm | ±1 mm |
| Upper Mass Roll – Bottom of T-Piece | 0 mrad | LLO – ≈5.00 mradLHO – ≈200. μrad | 10 mrad |
| Upper Mass Pitch – Bottom of T-Piece | 0 mrad | LLO – ≈5.00 mradLHO – ≈200. μrad | 10 mrad |
| Lower Blade Wire Breakoff Height (relative to optical table) | 397.25 mm | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| Lower Blade Wire Breakoff Height (relative to other blades) | N/A | LLO – 0.25 mmLHO – 0.01 mm | ±0.5 mm |
| d1 Value | 0.33 mm | LLO – 0.25 mmLHO – 0.01 mm | -0.5 mm / +1 mm |
| Bench Height – Top of Lower Wire Bracket (relative to optical table) | 167.94 mm | LLO – 0.25 mmLHO – 0.01 mm | ±2 mm (required – see T070189)±0.5 mm (desired) |
| Bench Height – Top Surface of Bench (relative to optical table) | 157.89 mm | LLO – 0.25 mmLHO – 0.01 mm | ±2 mm (required – see T070189)±0.5 mm (desired) |
| Bench Height – Top Surface of Metal Bench (no shims) (relative to optical table) | 154.59 mm | LLO – 0.25 mmLHO – 0.01 mm | ±2 mm (required – see T070189)±0.5 mm (desired) | N/A |
| Bench Height – Bottom Surface of Bench (relative to optical table) | 116.49 mm | LLO – 0.25 mmLHO – 0.01 mm | ±2 mm (required – see T070189)±0.5 mm (desired) |
| Bottom Mass Roll  | 0 mrad | TBD | TBD | TBD | TBD |
| Bottom Mass Pitch | 0 mrad | TBD | TBD | TBD | TBD |

1. Accuracy of Measurement for angular measurements is determined by taking the inverse tangent of (vertical measurement/nominal horizontal distance between vertical measurement points). [↑](#endnote-ref-1)
2. For LLO, the vertical Accuracy of Measurement is for a vertically mounted metric ruler with divisions of 0.5 mm. [↑](#endnote-ref-2)
3. For LHO, the vertical Accuracy of Measurement is for a Mitutoyo height gauge with an accuracy of 0.01 mm. [↑](#endnote-ref-3)