

JPL D- 29326

SIM XMET Beam Launcher  
Collimator Optics

Specification for the SIM XMET BEAM LAUNCHER COLLIMATOR OPTICAL  
ASSEMBLY

L. Scherr, Document Custodian

Approvals:

 7/2/04

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Lawrence Scherr, Optical Engineering Lead

 7/2/04

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Andrew Lamborn, Mechanical Engineering Lead

 7/2/04

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Muthu Jeganathan, Project Element Manager  
SIM XMET Beam Launcher

Jet Propulsion Laboratory  
California Institute of Technology

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## I. Introduction

### 1.1 Purpose

This document defines the procurement specification for the SIM Beam Launcher Collimator optical assembly.

### 1.2 Scope

This specification establishes the minimum specification requirements for the SIM Beam Launcher Collimator optical assembly.

## 2 APPLICABLE DOCUMENTS

### 2.1 Government Documents

The following documents apply as referenced within this document;

#### SPECIFICATIONS

##### Military

MIL-G-174	Glass, Optical
MIL-O-13830	Optical components for fire control instruments: general specifications governing the manufacture, assembly and inspection of
MIL-M-13508	Mirrors, Front Surfaced, Aluminum for Optical Elements

##### Standards

ANSI/ASQC 9001	Quality Management and Quality Assurance Standards
MIL-STD-1241	Optical terms and definitions
MIL-STD-45662	Calibration system requirements

### 2.2 Jet Propulsion Laboratory Documents

#### Exhibit 1

10240325 Rev A	Mirror, parabolic beam launcher drawing
10240321 Rev A	Two fold flat secondary drawing
10240322 Rev A	Mirror support post drawing
10240323 Rev A	Collimator assembly drawing

### **3 Requirements**

#### **3.1 General**

The collimator assembly shall comply with the requirements of this document except as further defined by the applicable detail specifications or drawing.

#### **3.2 Materials and Processes**

When a specific material is not referenced, the manufacturer shall be responsible for the selection of materials consistent with the requirements specified.

3.2.1 Glass Blank Materials – The material to be used for the fabrication of all lenses and witness samples shall be the specified optical material.

3.2.2 Adhesive – Adhesives shall meet environmental conditions and be vacuum compatible. Adhesive and bonding procedure shall be approved by JPL.

3.2.3 Adapter – An adapter shall be designed by the vendor to bond the angled fiber ferrule in the parabola 5mm hole. Adapter design and bonding procedure shall minimize WFE on optics and shall be approved by JPL.

#### **3.3 Physical Requirements**

3.3.1 Dimensions – Configurations and dimensions shall be as specified in the individual specifications or drawing.

3.3.2 Surface Quality – Surface quality within the clear aperture of optical surfaces shall conform to MIL-O-13830 and shall be as specified in the individual specifications or drawing.

3.3.3 Adherence – Coating layers shall conform to adherence requirement of MIL-M-13508.

#### **3.4 Optical Characteristics**

3.4.1 Surface Figure/Surface Irregularity – The surface figure-surface irregularity of each mirror shall be as specified in the individual specification or drawing.

3.4.2 Radius of curvature – The radius of curvature of each mirror shall be recorded by interferogram.

3.4.3 Reflectivity – Reflectivity versus wavelength shall be recorded by spectral curve.

#### **3.5 Environmental**

##### **3.5.1 Temperature Ranges:**

- Operating: +17°C to +28°C

- Survival: -35°C to +75°C

#### **3.6 Assembly Requirements**

- 3.6.1 The collimator is designed for a fiber source located through the center of the 5mm parabola hole at the parabola surface.
- 3.6.2 During assembly all elements shall be centered and aligned to meet Wave Front Error (WFE) and boresight requirements, then bonded in place.
- 3.6.3 Dimension tolerances shall be controlled with detail design drawings.
- 3.6.4 Polarization maintaining (PM) optical fiber for 1.319 micron wavelength, with 8 degree angled ferrule, shall be bonded in the parabola 5mm hole, at best focus, to launch light to the collimator. The fiber shall be 0.5 meter long with FC/APC pigtail connector on the non-bonded end. Slow axis of the PM fiber shall be aligned with key on the pigtail connector and with angled ferrule on the bonded end, to within 1 degree. Light with polarization parallel to the slow axis shall be launched into the fiber. Slow axis shall be aligned along the A-A line in drawing 10240325, to within 1 degree.
- 3.6.5 The apex of the angled ferrule shall be along the A-A line in drawing 10240325, with tallest part closest to the parabola center.
- 3.6.6 Fiber focus tolerance must be held to +/-0.010 mm, to meet a WFE budget.

### 3.7 Workmanship

Workmanship and finish shall be of sufficiently high quality throughout to assure optical properties consistent with the requirements of this specification. The end product shall be free from defects that could affect performance. On all coated surfaces there will be no visible defects on the coated surfaces indicative of poor adhesion such as loose, peeled or blistered coatings.

### 3.8 Identification and Marking

Each collimator shall be permanently marked or inscribed with a unique number such as that performance is not affected and shall allow for correlation of performance data. Labels and tapes shall not be used for marking purposes. All optics shall be bagged and tagged.

Accepted marking forms are:

1. Inscription
2. Worn-O-Ink
3. UVEXES 105 black ink

### 3.9 Handling of optical and mechanical components

Handling of optical and mechanical components shall be such that optical performance is not detrimentally affected. Proper precautions shall be taken to assure that no surfaces are soiled, smudged or corroded. Minimum precautions shall include the use of lint-free cotton or plastic gloves.

## 4. Optical Fabrication, Testing, and Acceptance Criteria

### 4.1 Optical fabrication issues:

4.1.1 The vendor shall supply as-built recorded data to JPL for the optical assemblies including effective focal length and back focal length measurements.

4.1.2 Optical Element Tolerances: The vendor shall assume the following optical tolerances for the assembled collimator and prototype:  
The prototype RPM assembly is a dimensionally correct assembly but with relaxed tolerances.

<i>Parameter</i>	<i>Final assy</i>	<i>Prototype assy</i>
Collimated beam WFE	/14 PV at 633 nm	/5 PV at 633 nm
Beam angle wrt boresight	1 arcmin	3 arcmin
RMS surface roughness	5 Angstroms	10 Angstroms

## 4.2 Optical Testing Issues

4.2.1 All collimators shall be tested for wavefront error on-axis at 0.6328 micron, before the fiber source is mounted in the 5mm parabola hole. An interferometer, reference flat, and retroball snug fit in the 5mm parabola hole, may be used. This testing shall be done at standard temperature and pressure (STP).

## 4.3 Optical Acceptance

4.3.1 Collimator acceptance value for collimated wavefront error, when launched from the fiber bonded at best focus, shall be:

Transmitted wavefront: collimated gaussian beam,  
lambda/14 transmitted PV WFE (at 0.633 micron).

Testing procedure shall be approved by JPL.

4.3.2 The collimator output beams from the two fiber sources shall be boresighted, to the parabola optical axis and to each other, within 1 arcminute.

# 5 Quality Assurance Provisions

## 5.1 Responsibility for Inspection

The manufacturer is responsible for the performance of all inspection requirements as specified. The manufacturer shall utilize his own or other inspection facilities or services. Inspection records of the examinations and tests shall be kept complete and shall be delivered with the optical system to JPL. The manufacturer reserves the right to perform any inspections deemed necessary to assure that sub contractors and services conform to the specified requirements.

5.1.1 Inspection conditions and Methods – Unless otherwise specified, tests and inspection shall be performed under the following ambient conditions:  
Room temperature 15° C to 25°C, ambient barometric pressure and relative humidity less than 80%.

5.1.1 Test Equipment and Inspection Facilities – Test equipment and inspection facilities shall be of sufficient accuracy, quality and quantity to permit performance of the required inspection. The manufacturer shall maintain calibration of inspection equipment in accordance with MIL-STD-45662.

## 5.2 Failure Reporting and corrective Action System

The manufacturer shall implement a formal closed loop system for reporting analysis and correction failures that occur during acceptance tests. Failure Reportable to the buyer -- The manufacturer shall notify JPL of the following failures in accordance with the following:

5.2.1 24-Hour Failure Notification – The manufacturer shall notify JPL of all reportable failures by telephone or other appropriate means, as soon as possible, and not later than 24 hours after the failure occurred, and after formation of corrective action.

5.2.2 Failure Analysis and Corrective Action – The manufacturer shall perform failure analysis on reportable failures when directed by JPL. When failure analysis is directed, the manufacturer shall submit to JPL for approval recommendations for corrective action to prevent failure recurrence. Failure reports shall be considered closed when corrective action has been implemented and the report approved in writing by JPL.

## 6. Storage Requirements

The lenses shall be stored at a controlled temperature of +15°C to +50°C and a relative humidity of less than 80%.

## 7. Product Certification

A certificate of compliance shall accompany each delivery supplied to this specification certifying that all requirements specified herein have been compiled with, and stating the manufacturer's part name, part number, lot number, JPL's purchase order number, part name and part number.

## 8. Transportation Requirements

### 8.1 Packaging and Packing

Each collimator assembly shall be wrapped carefully and be properly packed. Proper precautions shall be taken to assure that no surfaces are soiled, smudged or corroded. Use lint-free and non-outgassing packaging.

### 8.2 Marking for Shipment and Storage

All bagged collimator assemblies shall be marked legibly with the item name, serial number, JPL's address, and purchase order number.

- 8.2.1 Warning Label – The interior package shall be plainly marked with the warning label shown below:

NOTICE: JET PROPULSION LABORATORY  
Do not open in an uncontrolled atmosphere  
Contact: Larry Scherr 4-9377