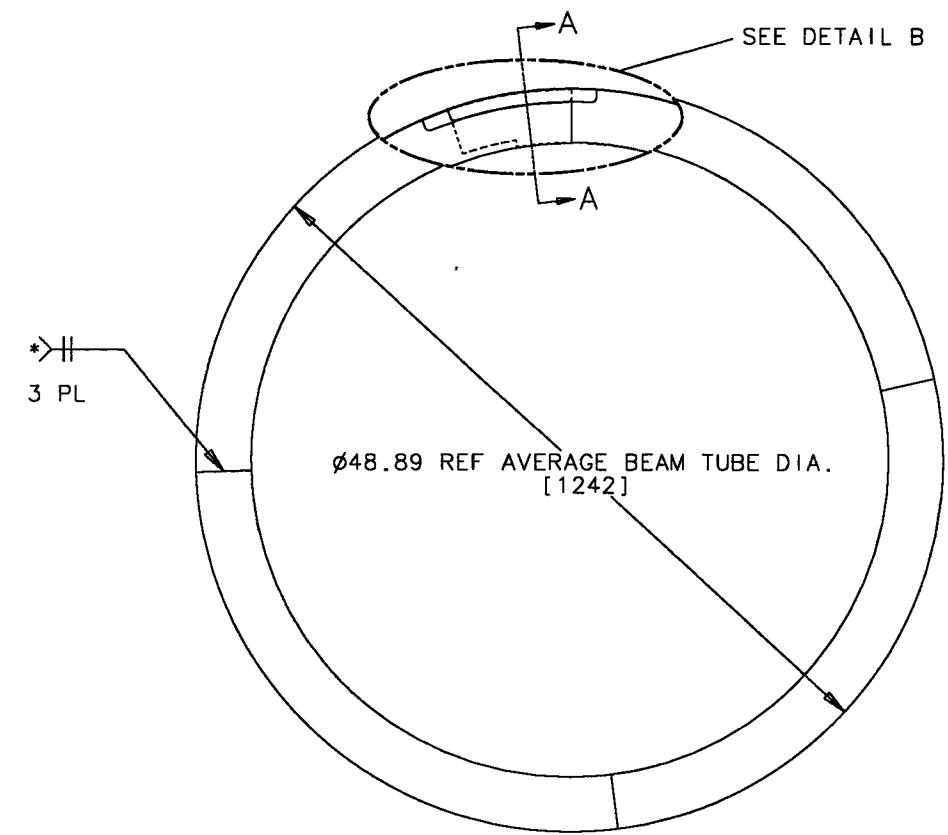
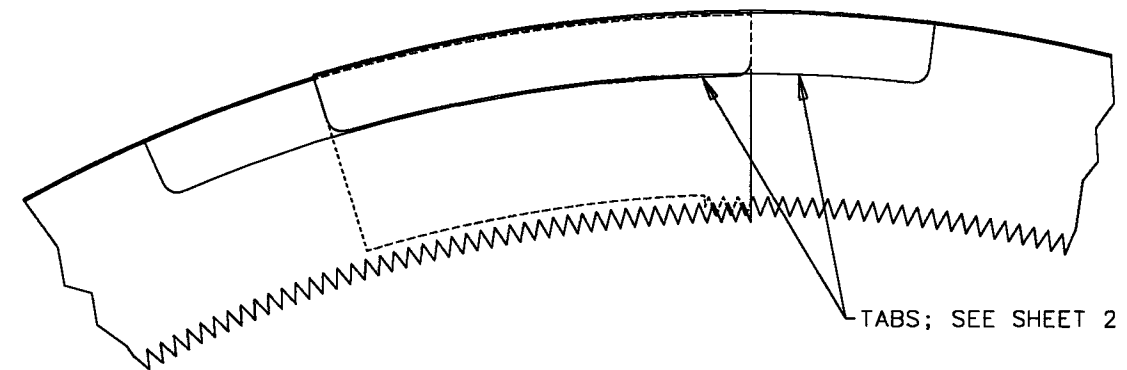


REV	DATE	DRWN	APPD	DCN/DESCRIPTION



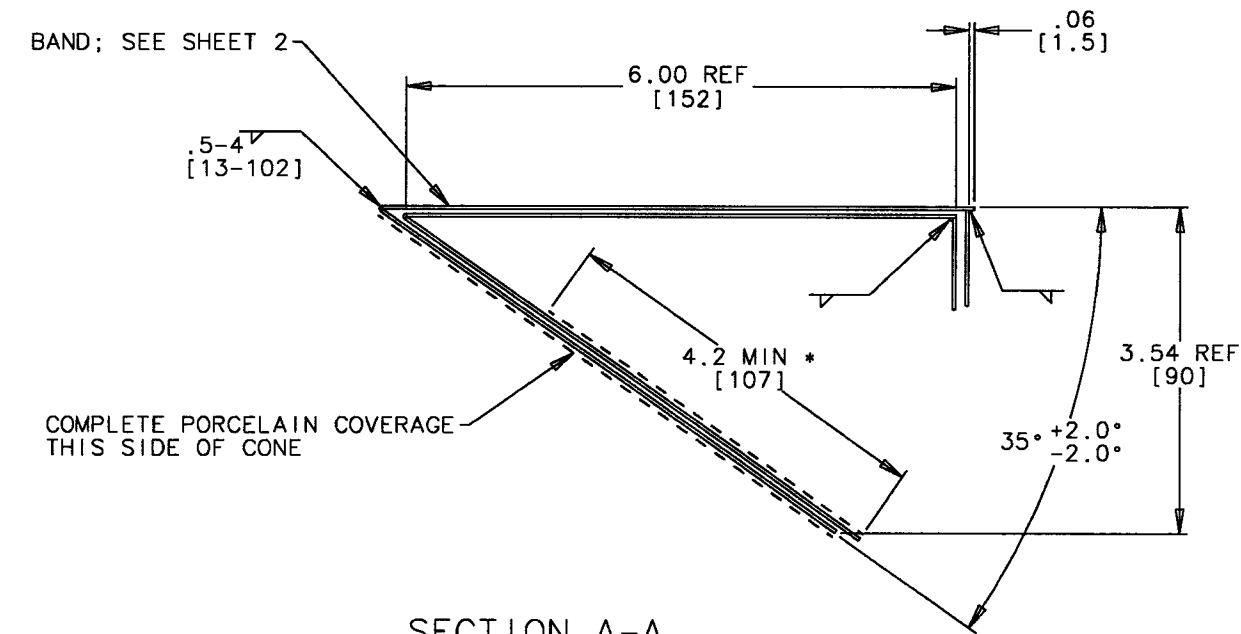
BAFFLE ASSEMBLY

* TOP SURFACE OF CONE SEGMENT BUTT JOINTS TO BE FREE OF WELD MELT-THROUGH. EDGE MISMATCH NOT TO EXCEED .010 [.25] AT SERRATIONS. ALT 2 RATHER THAN 4 SEGMENTS.



DETAIL B

DRAWN INSTALLED IN MAXIMUM DIAMETER OF BEAM TUBE (∅49.17)
7.5 OVERLAP AT BAND



SECTION A-A

(CURVATURE IGNORED FOR SIMPLICITY)

* PORCELAIN COVERAGE THIS SIDE OF CONE

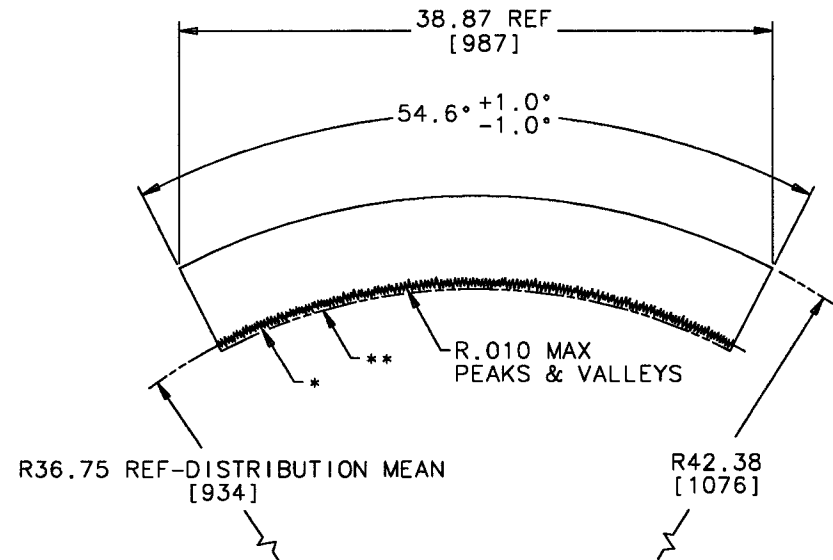
LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:

- X.XXX: ± 0.003
- X.XX: ± 0.03
- X.X: ± 0.10

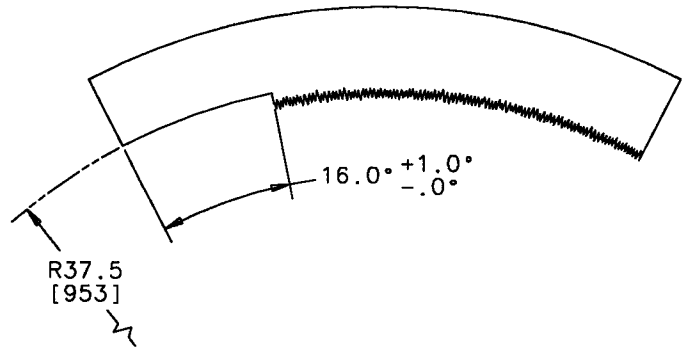
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.

CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
DRWN	C. CONLEY	BEAM TUBE BAFFLE, FULL	
CHGD		SERRATION, FABRICATION	
ENGR		BAND PORCELAIN COVERAGE	
APPD		DETAIL	
SCALE:	NTS	DRAWING NUMBER	D960045
		SHEET	1
		REV	21A

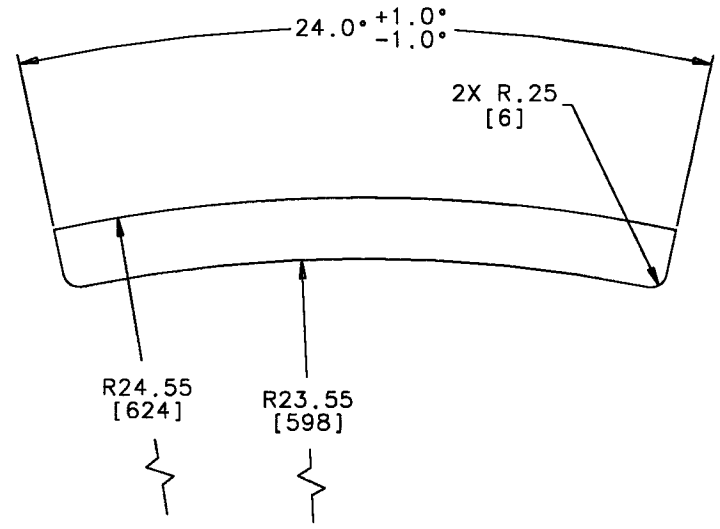
3/20/96
3/20/96
3/20/96



①
3 REQ'D.



② SAME AS -1 EXCEPT AS NOTED
1 REQ'D.



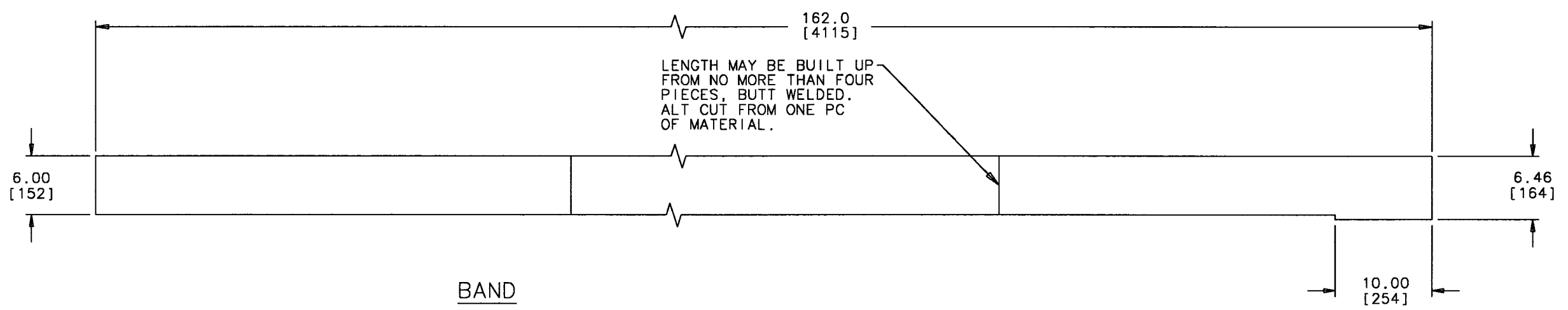
TAB
2 REQ'D

* ACTUAL DIMS WILL BE PROVIDED TO VENDOR IN ELECTRONIC FORM, AutoCad R12 IGES FILE: BAFFLES.igs
** MATERIAL ENVELOPE (R36.32 [922.5]).

CONE SEGMENTS

MATERIAL: 304L STAINLESS STEEL
THICKNESS: 20ga (.036 NOM)
CONE SEGMENTS TO BE CUT BY WATERJET OR LASER PROCESS.
ALT METHOD TWO SECTIONS 109.2° EACH.

MATERIAL: 304L STAINLESS STEEL
THICKNESS: 20ga (.036 NOM)
NO OVER SPRAY ON THIS PART



BAND
1 REQ'D.

MATERIAL: 304L STAINLESS STEEL
THICKNESS: 20ga (.036 NOM)

LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:
X.XXX: ± 0.003
X.XX: ± 0.03
X.X: ± 0.1
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.

CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
DRWN	C. CONLEY	TYPE	BEAM TUBE BAFFLE, FULL SERRATION, FABRICATION AND PORCELAIN COVERAGE DETAIL
CHKD		SHEET	2
ENGR		REV	1A
APPR		DRAWING NUMBER	D960045
SCALE: NTS			