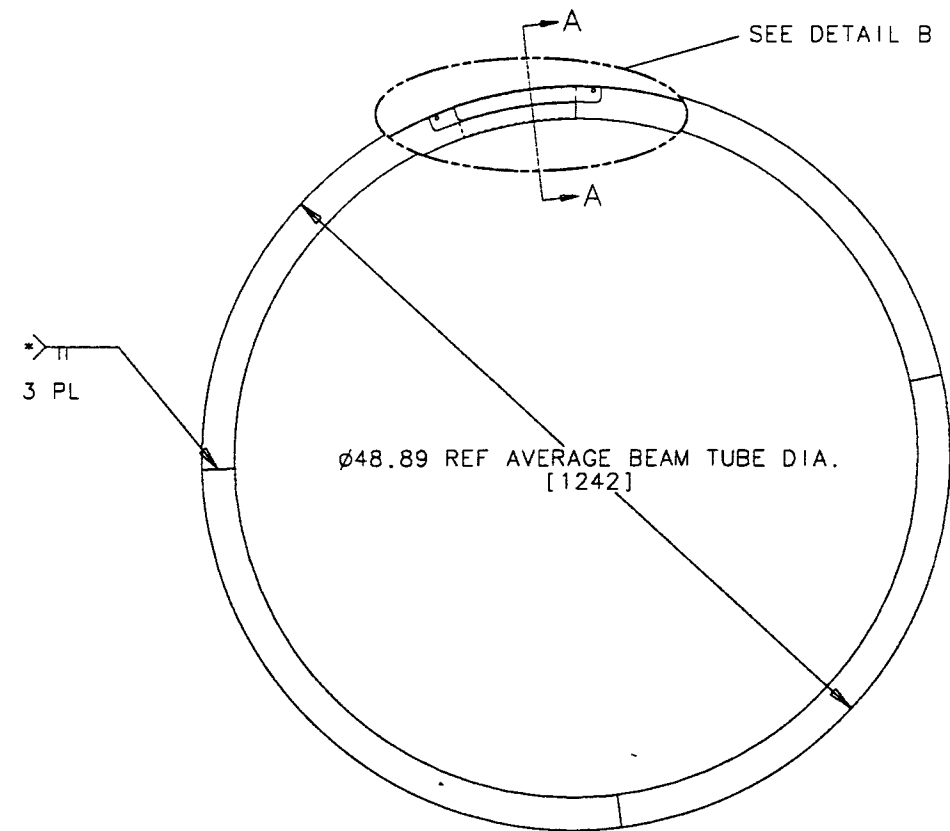


REV	DATE	DRWN	APPD	DESCRIPTION
1	4/25/96	C		HOLES IN TAB & BAND, BAND LENGTH

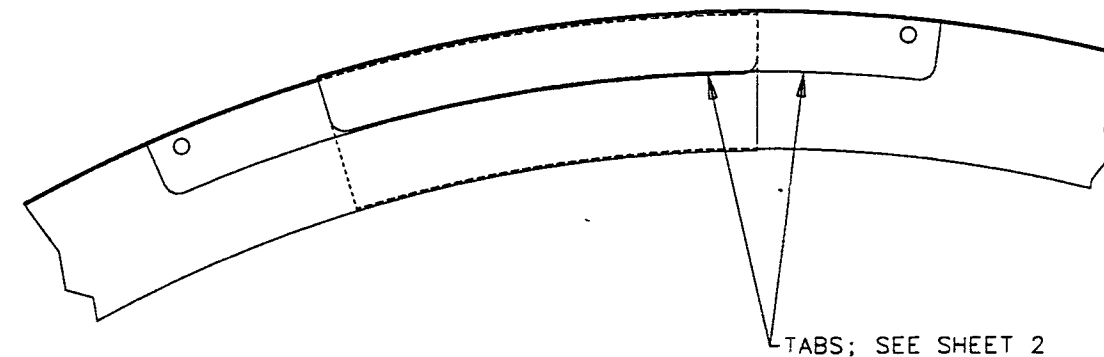
TOL. DETAIL ①
 & TAB
 ANGLE DETAIL ②



∅48.89 REF AVERAGE BEAM TUBE DIA.
 [1242]

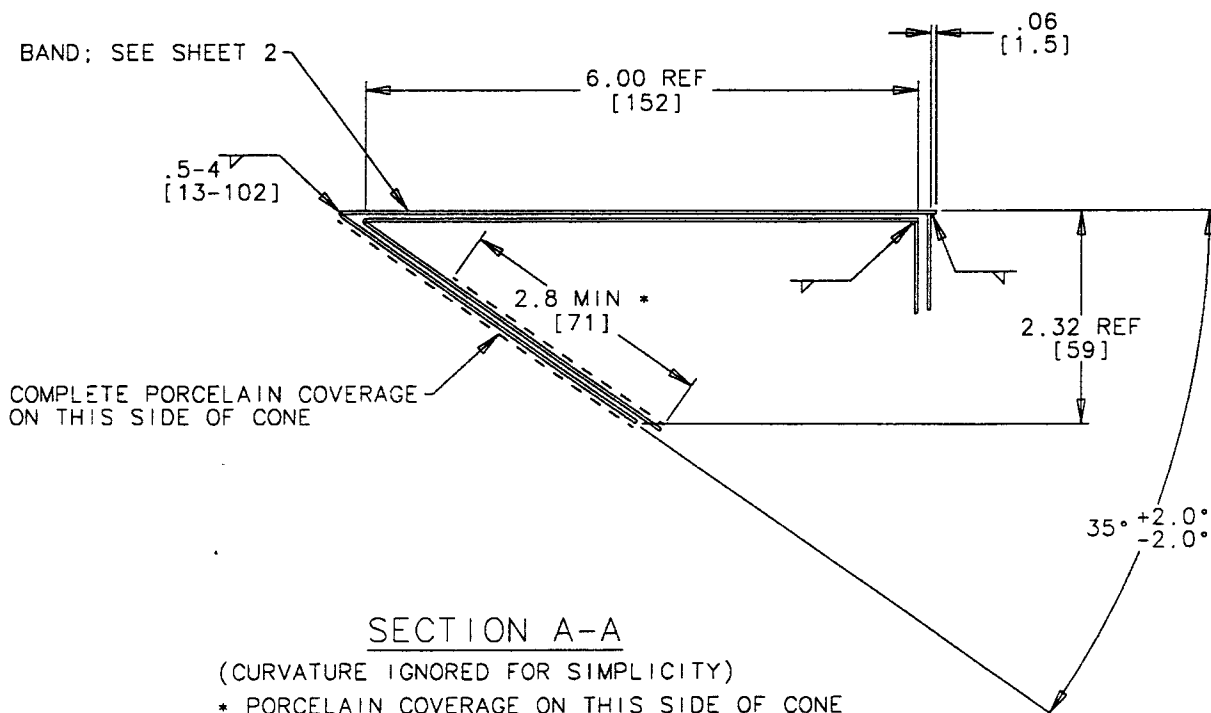
BAFFLE ASSEMBLY

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



DETAIL B

DRAWN INSTALLED IN MAXIMUM DIAMETER OF BEAM TUBE (∅49.18)
 7.5 OVERLAP AT BAND



SECTION A-A

(CURVATURE IGNORED FOR SIMPLICITY)

* PORCELAIN COVERAGE ON THIS SIDE OF CONE

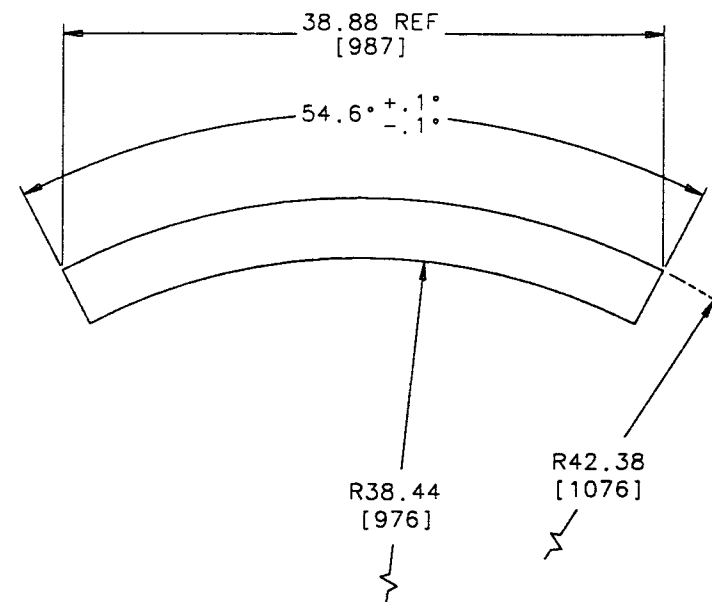
LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:

- 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	TYPE	BEAM TUBE BAFFLE, NON-SERRATED, FABRICATION AND PORCELAIN COVERAGE DETAIL
ENGR	A. SIBLEY	DRAWING NUMBER	D960046
APPD	A. LAZZARINI	SHEET	1
APPD	D. COYNE	REV	2
SCALE	NTS		

REV	DATE	DRWN	APPD	DCW/DESCRIPTION



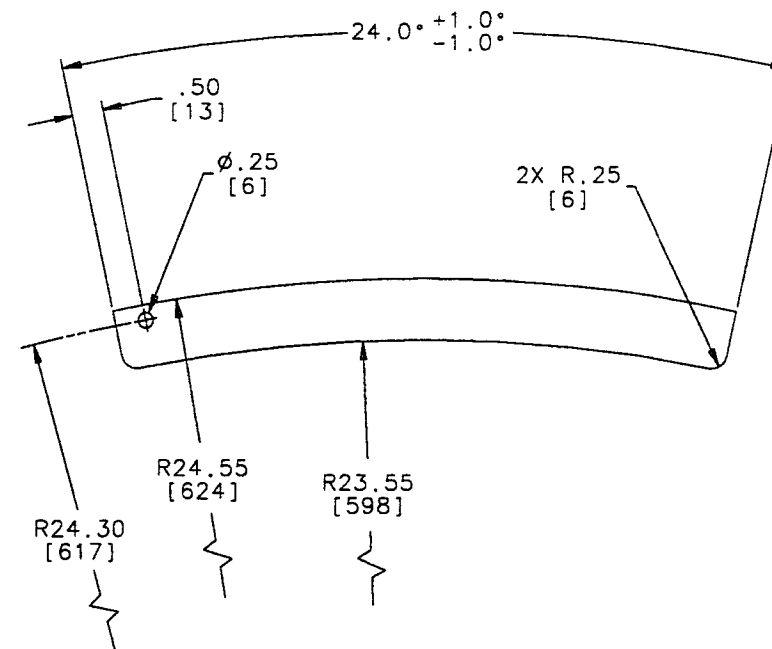
CONE SEGMENT

4 REQ'D.

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

CONE SEGMENTS TO BE CUT BY WATERJET
OR LASER PROCESS.

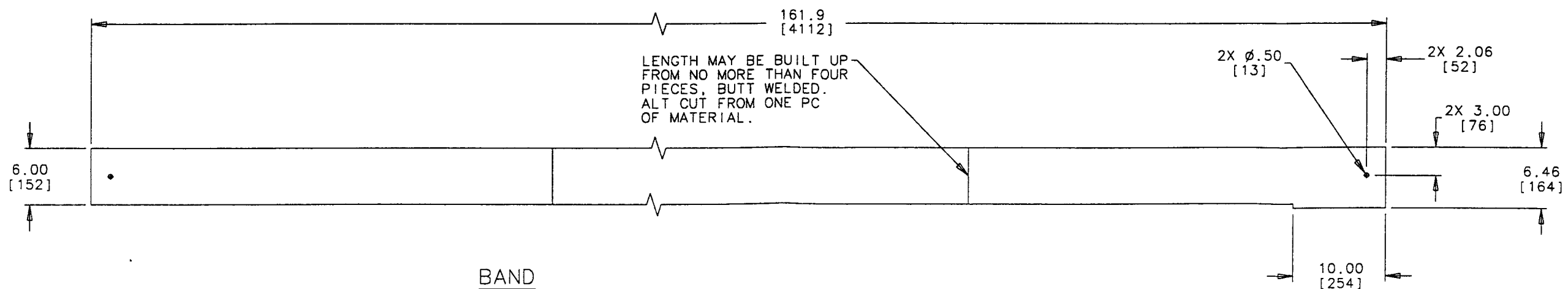
ALT METHOD TWO SECTIONS 109.2° EACH.



TAB

2 REQ'D

MATERIAL: 304L STAINLESS STEEL
THICKNESS: 20ga (.036 NOM)
NO OVER SPRAY ON THIS PART
NOTE ASSEMBLY DETAIL B FOR ORIENTATION



BAND

1 REQ'D.

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

LENGTH MAY BE BUILT UP
FROM NO MORE THAN FOUR
PIECES, BUTT WELDED.
ALT CUT FROM ONE PC
OF MATERIAL.

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 MICHIGAN STATE UNIVERSITY		LIGO PROJECT	
DRWN: C. CONLEY	ENGR:	BEAM TUBE BAFFLE, NON-SERRATED, FABRICATION AND PORCELAIN COVERAGE DETAIL	
APPD:	TYPE:	DRAFTING NUMBER: D960046	SHEET REV: 2/2 B
SCALE: NTS			