



# COMPONENT SPECIFICATION

TITLE MECHANICAL FABRICATION OF BEAM TUBE BAFFLES

APPROVALS:	DATE	REV	DCN NO	BY	CHK	DCC	DATE
DRAWN:		A	E960038	n/a	n/a	n/a	n/a
CHECKED:							
APPROVED:							
DCC RELEASE:							

## MECHANICAL DESCRIPTION OF BEAM TUBE BAFFLE

The baffles consist of 20 ga (nom. 0.036") thick 304L SS sheet metal conformed to a truncated conical surface, supported by a cylindrical band. The larger base of this cone has a nominal diameter of 48.89". The smaller base of the cone has a pseudo random serrated edge in one type and no serrations on the second type. These are represented on LIGO Drawings #D950094 Rev. G and #D960024, respectively.

## SPECIFICATIONS FOR BEAM TUBE BAFFLES

- All material will be new, ASME Specification SA-240, Type 304L with mill finish. Vendor to provide Material Certification and Certificate of Conformance to all specification and drawing requirements.
- All surfaces of the cone segments section to be bead blasted with AlO<sub>2</sub>, SBA 20-40 prior to weld assembly.
- The serrations, on baffles which require them, will be cut by laser. LIGO will provide, to the successful vendor, an electronic file in Autocad by AutoDesk (R-12 or R-13) for purposes of programming CNC cutting equipment.
- The stainless steel will be kept clean and free of dirt, grease, oil and any other contaminates throughout fabrication. No burrs or sharp edges, except for the sharp edges on the serration are allowed.
- Baffles will be packaged in rigid shipping containers constructed with new material, that can be opened and resealed at least two times without damage to container. Baffles will be separated by rigid means within the container, and must be easily removable from it. There will be five baffles per container. The container maximum dimensions will be 3'6" W x 3'6" D x 4'0" H with provisions for transport by pallet jacks.
- Delivery to begin within four (4) weeks of award of execution of Purchase Order, at a rate of 35 assemblies a week.
- Shipping instructions: FOB vendor.



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## BID SHEET

	Welded Band 4 Serrated Sections	Welded Band 2 Serrated Sections	Continuous Band 4 Serrated Sections	Continuous Band 2 Serrated Sections
Unit Cost Serrated Baffles				
1 2				
0 5				
0 0				
- 5				
0 0				
2 0				
Unit Cost Non-Serrated Baffles				
5 1				
0 0				
0 0				

The Institute reserves the right to award this contract to more than one bidder in whatever combination is most advantageous in price and schedule.