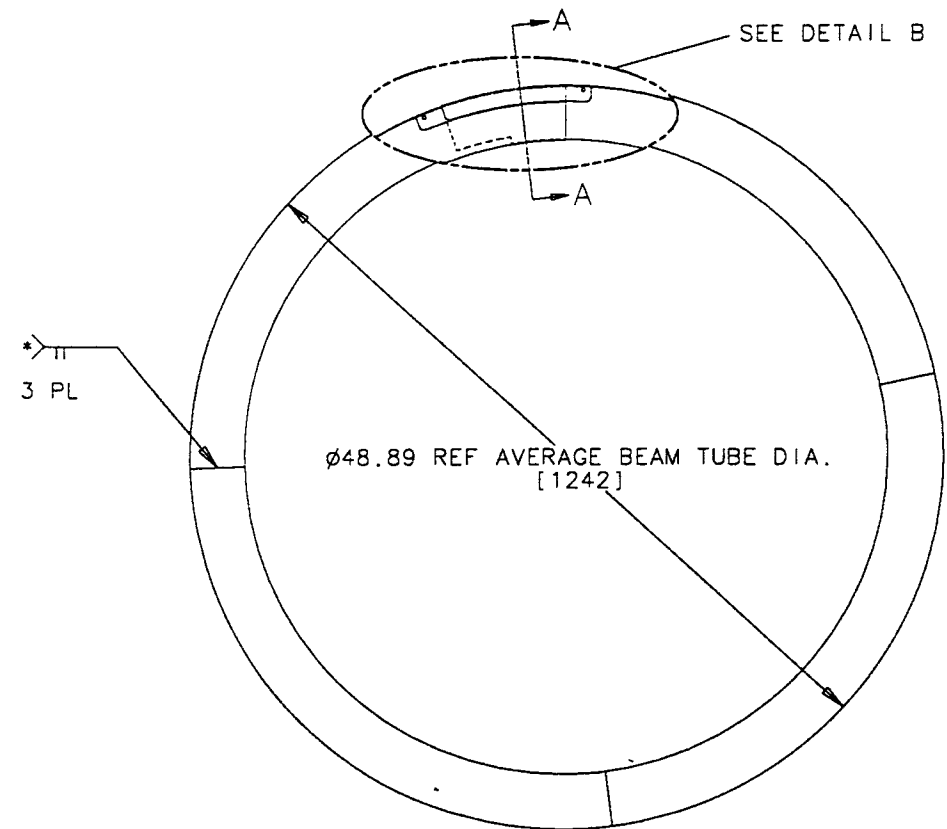


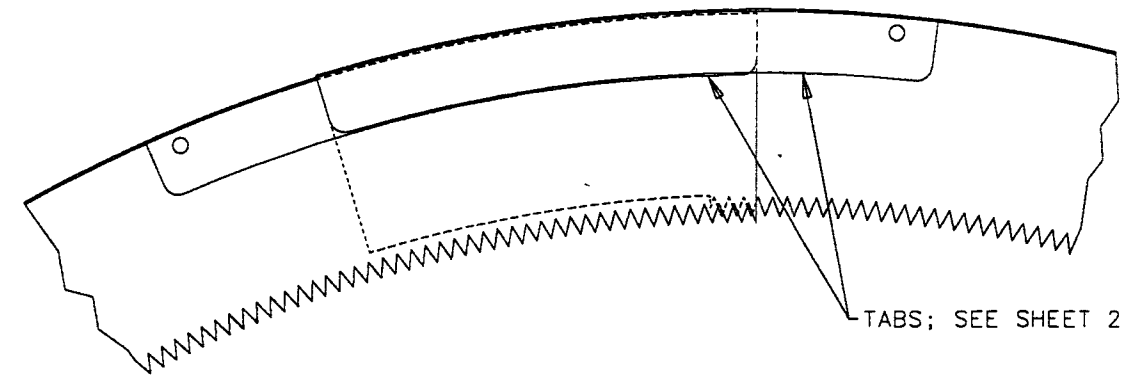
REV	DATE	BY	APPD	DESCRIPTION
B	12/25/95	C	CONLEY	HOLES IN TAB & BAND, BAND LENGTH

TOL. DETAIL ①-②  
 TAB  
 ANGLE DETAIL ②



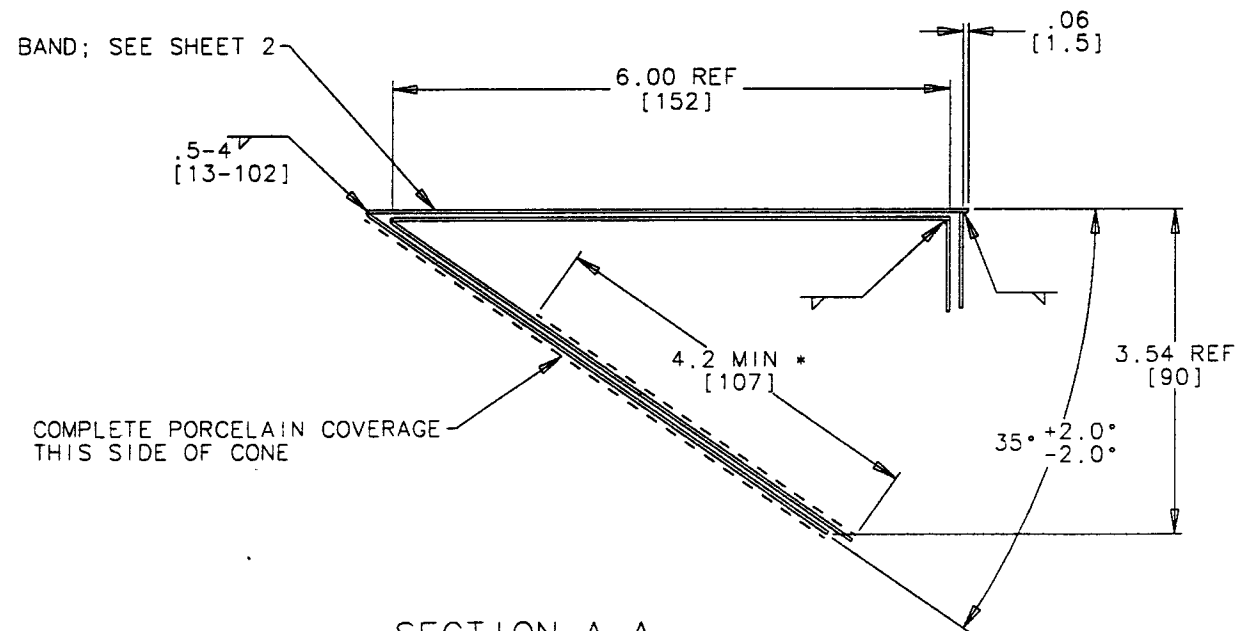
**BAFFLE ASSEMBLY**

\* 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 (49.18)  
 7.5 OVERLAP AT BAND



**SECTION A-A**

(CURVATURE IGNORED FOR SIMPLICITY)

\* PORCELAIN COVERAGE THIS SIDE OF CONE

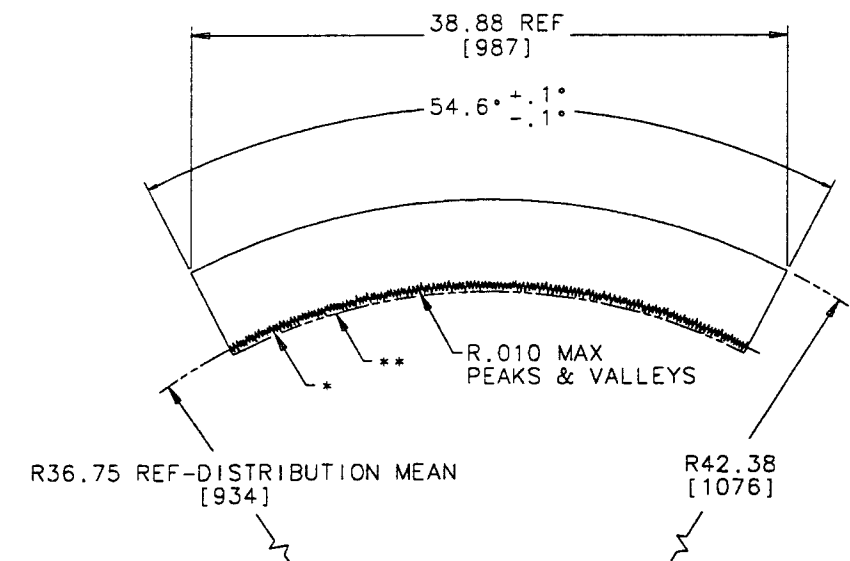
LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:

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

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.

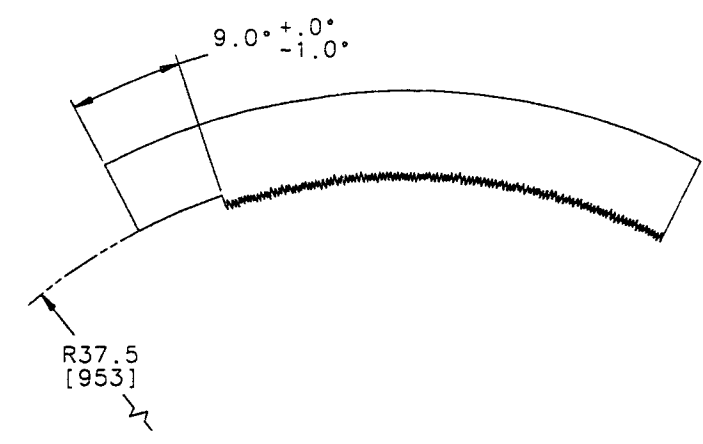
CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
DRAWN	CHKD	ENGR	APPD
C. CONLEY	A. SIRLEY	A. LAZZARINI	D. COYNE
BEAM TUBE BAFFLE, FULL SERRATION, FABRICATION AND PORCELAIN COVERAGE DETAIL		DRAWING NUMBER	SHEET REV
SCALE: NTS		D960045	1*2 B

REV	DATE	DRWN	APPD	DESC/DESCRIPTION



(-1)

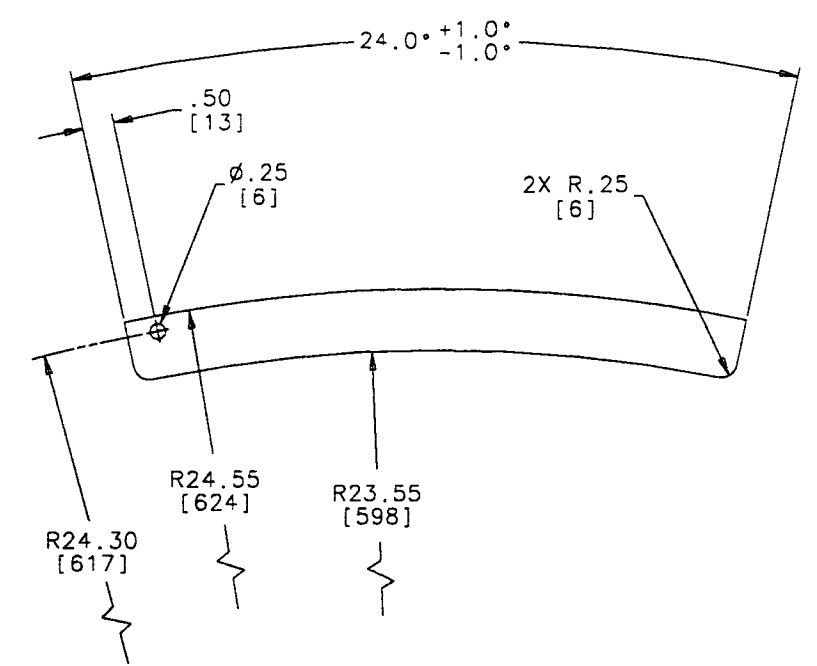
3 REQ'D.



(-2)

SAME AS -1 EXCEPT AS NOTED

1 REQ'D.



TAB

2 REQ'D

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

\* ACTUAL DIMS WILL BE PROVIDED TO VENDOR IN ELECTRONIC FORM, I-DEAS MS2 DRAFTING FILE: D960508-00-E.asc, OR TRANSLATION THEREOF

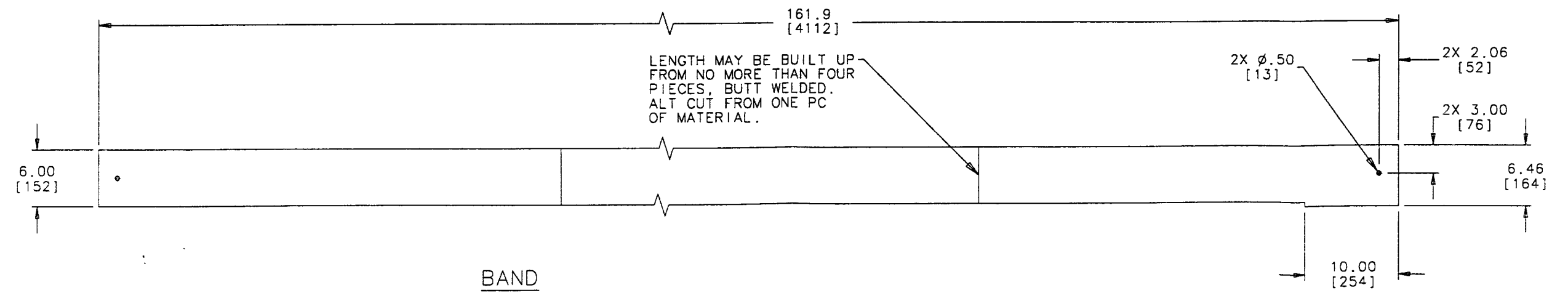
\*\* MATERIAL ENVELOPE (R36.32 [922.5]).

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.



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	
MARCHMONT'S INSTITUTE OF TECHNOLOGY			
DRWN	C CONLEY	DESCRIPTION	BEAM TUBE BAFFLE, FULL SERRATION, FABRICATION AND PORCELAIN COVERAGE DETAIL
CHKD			
ENGR			
APPR			
SCALE	NTS	TYPE	D960045 2#2