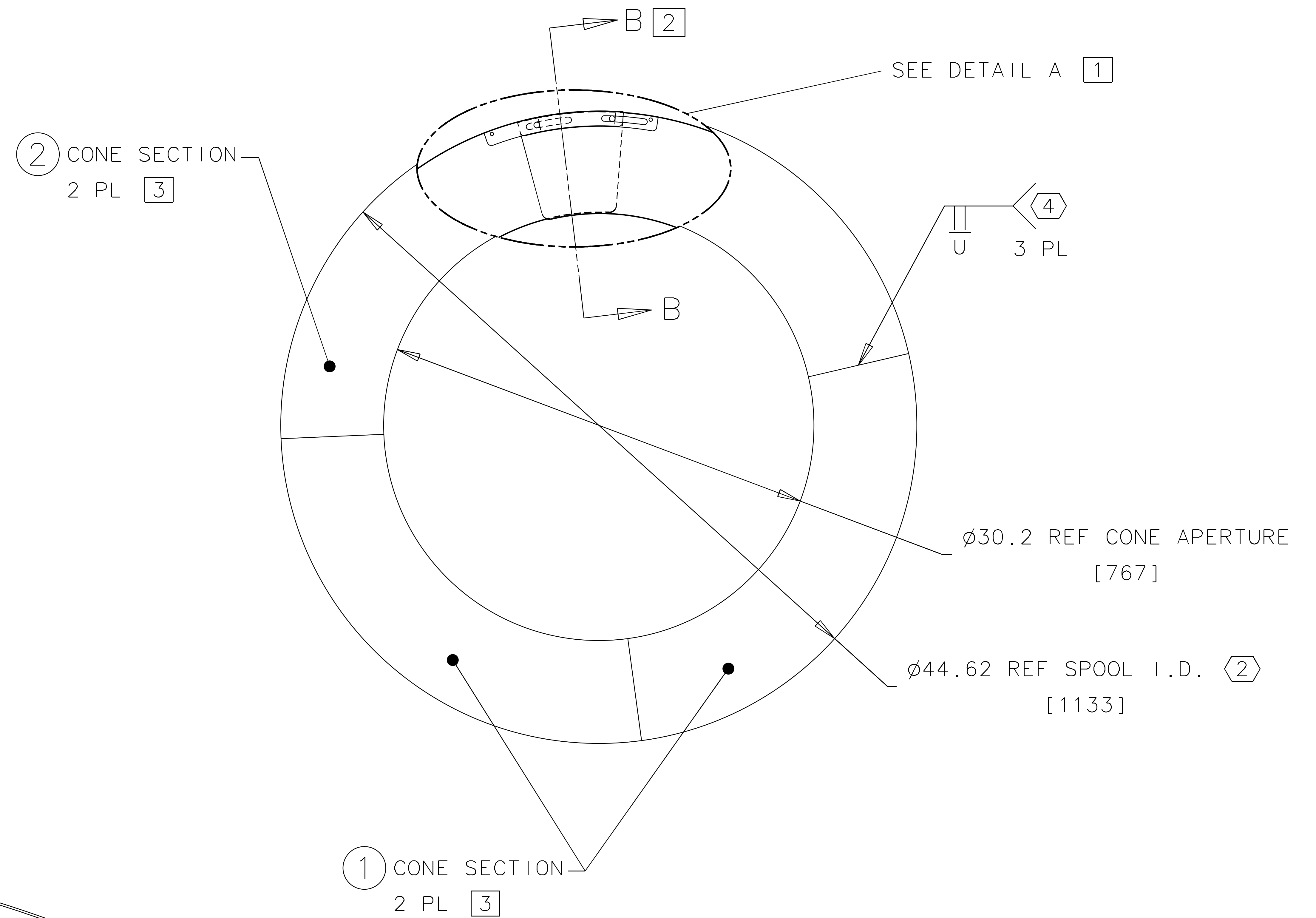


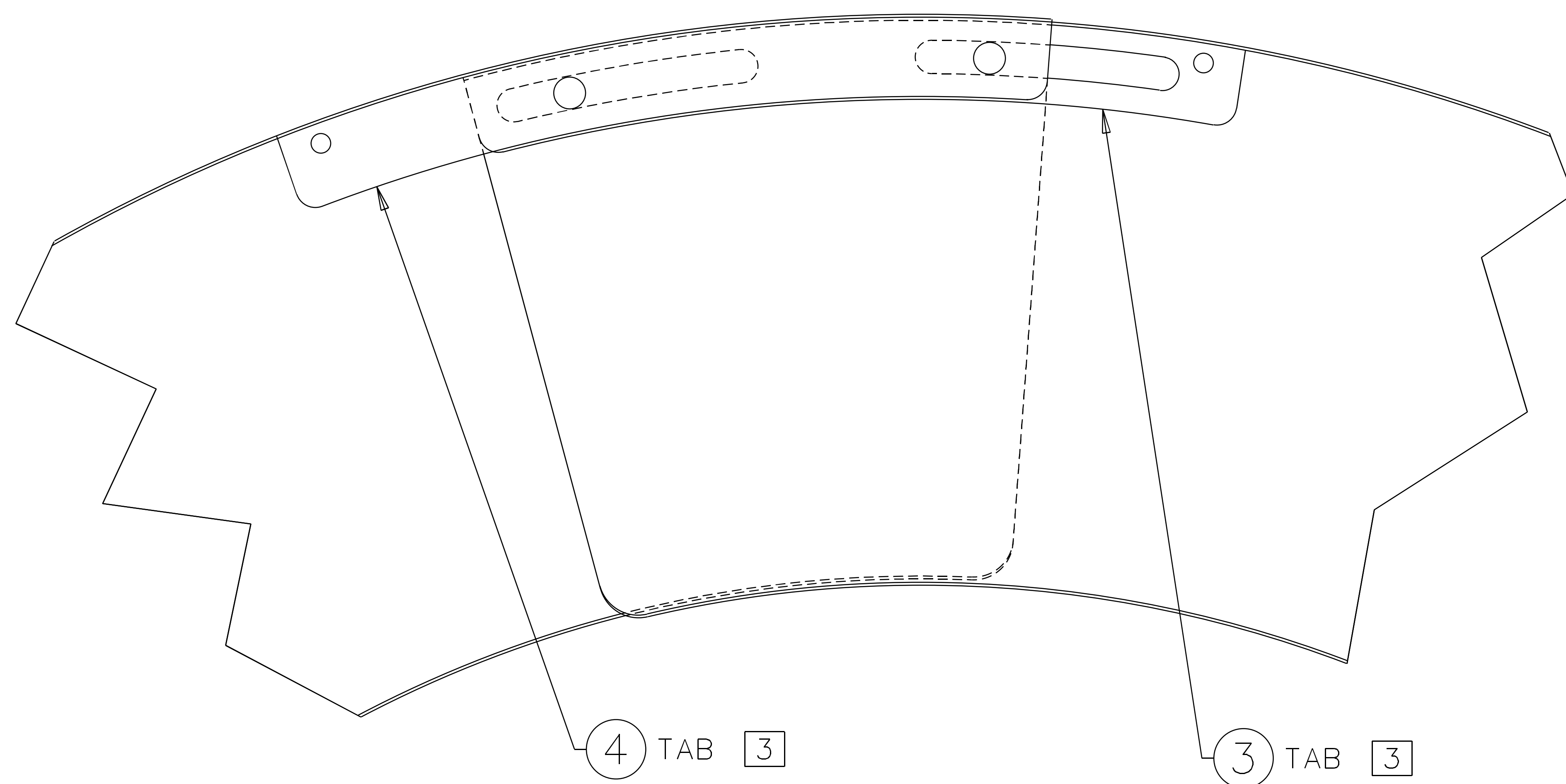
REV	DATE	DRAWN BY	CHECKED	DCC	DCN/DESCRIPTION
A	7-15-99	C. Conley			E980267-00/INITIAL RELEASE
B	8-31-99	C. Conley			E990331-00/INITIAL RELEASE

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. BREAK ALL SHARP EDGES.
- ② USE THIS DIMENSION  $\pm 1/4$  FOR ROLLING AND WELD FIXTURING.
- ③ GTAW (3 WELDS FOR EACH "TAB").
- ④ 100% PENETRATION GTAW-BACKSTEP WELD IN UPWARD DIRECTION, FAR SIDE. USE ARGON GAS FOR SHIELDING & BACKING.
- ⑤ NOTE THAT THESE RADII ARE SLIGHTLY DIFFERENT ON EITHER TAB (ITEM 3 & ITEM 4).
- ⑥ ITEM 2 ONLY.
- ⑦ ALT: STANDARD 304L STAINLESS, POLISHED #8 FINISH, 20ga.
- ⑧ NOTED SIDE TO BE POLISHED SIDE.
- ⑨ STAMP OR ENGRAVE BASIC PART NUMBER AND SERIAL NUMBER IN THIS REGION AS FOLLOWS "D980451 s/n-XXX", WHERE "XXX" IS A CONSECUTIVE INTEGER 001 ETC.. LETTERING TO BE .12 HIGH MIN.
- ⑩ CLEANING AND BAGGING TO BE PERFORMED BY ALLIED ENGINEERING, ALAMEDA, CA, ACCORDING TO EXISTING PROCEDURES USED BY ALLIED FOR LIGO SEISMIC COMPONENTS.
- ⑪ FIRE BAFFLE IN A PASS THROUGH AIR BAKE OVEN IN A HYDROCARBON FREE ENVIRONMENT. TWO 20 MINUTE CYCLES RAMPING FROM ROOM TO ABOVE 800 C TO ROOM. BAG PER LIGO-E960022 SECTION 5 (OMIT PART (a)). FIRING TO BE PERFORMED BY WEST COAST PORCELAIN, CORONA, CA.
- ⑫ FOR ALL SHIPPING, PACKAGE BAFFLE IN A PROTECTIVE WOODEN CRATE WHICH RIGIDLY SUPPORTS ITS FORM, AND WILL NOT PUNCTURE THE SEALED BAGS (SEE ⑩ ⑪ FOR BAGGING).
- ⑬ WIPE DOWN BAFFLE THOROUGHLY (THREE COMPLETE PASSES) WITH ALCOHOL AND POLY CLEANWIPES IN A LIGO SITE CLASS 100 CLEAN ROOM BEFORE INSTALLATION.
- ⑭ ALT: TWO SECTIONS  $109.0^{\circ} \pm .1^{\circ}$  ARC EACH.
15. THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT, MARKS, OR FORMING DISCOLORATION IS PERMISSIBLE ON PART.



BAFFLE ASSEMBLY ⑩ ⑪ ⑫ ⑬



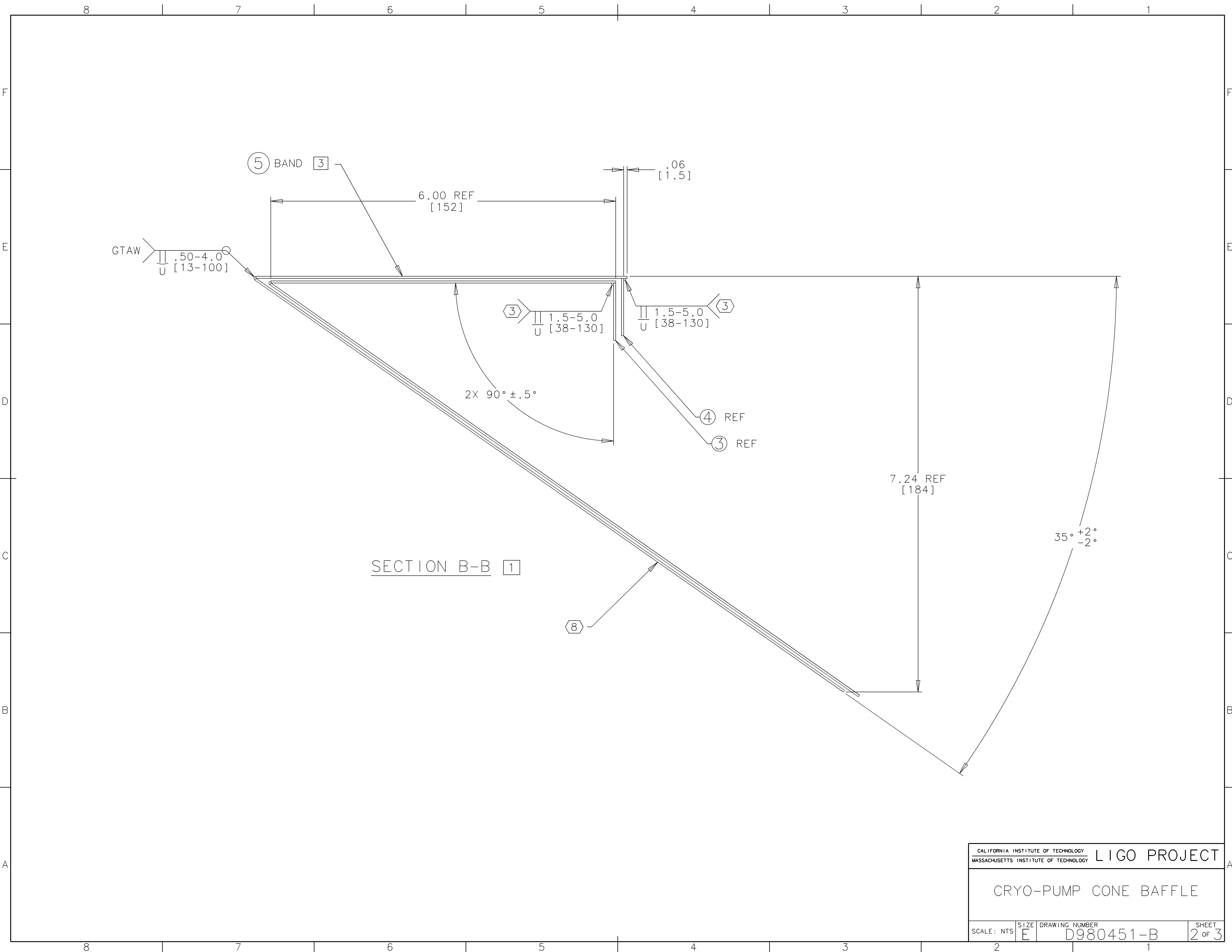
DETAIL A

DRAWN INSTALLED IN SPOOL (44.62 I.D.)  
7.5 OVERLAP AT BAND

QTY	REQD	FSOM NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DISCRIPTION	MATERIAL SPECIFICATION	ITEM NO
1				BAND	304L BRIGHT ANNEALED STAINLESS, 20ga	⑦ 5
1				TAB, SLOTTED	304L BRIGHT ANNEALED STAINLESS, 20ga	⑦ 4
1				TAB	304L BRIGHT ANNEALED STAINLESS, 20ga	⑦ 3
2				CONE SECTION 2	304L BRIGHT ANNEALED STAINLESS, 20ga	⑦ 2
2				CONE SECTION 1	304L BRIGHT ANNEALED STAINLESS, 20ga	⑦ 1

DRWN	C. Conley	DATE	8-31-99	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY <b>LIGO PROJECT</b> 1-Deas CAD file: D980451_B.dwg dcc file: D980451-B.pdf TITLE <b>CRYO-PUMP CONE BAFFLE</b>			
CHKD							
ENGR							
APPD							
UNLESS OTHERWISE SPECIFIED:				SCALE: NTS	SIZE	DRAWING NUMBER	SHEET
DIMENSION UNITS ARE inches [mm]				E		D980451-B	1 of 3
TOLERANCES ARE:							
X.XXX: $\pm 0.005$							
X.XX: $\pm 0.03$							
ANGLES: $\pm 0.5^{\circ}$							
NEXT ASSEMBLY: D980537, D990475							

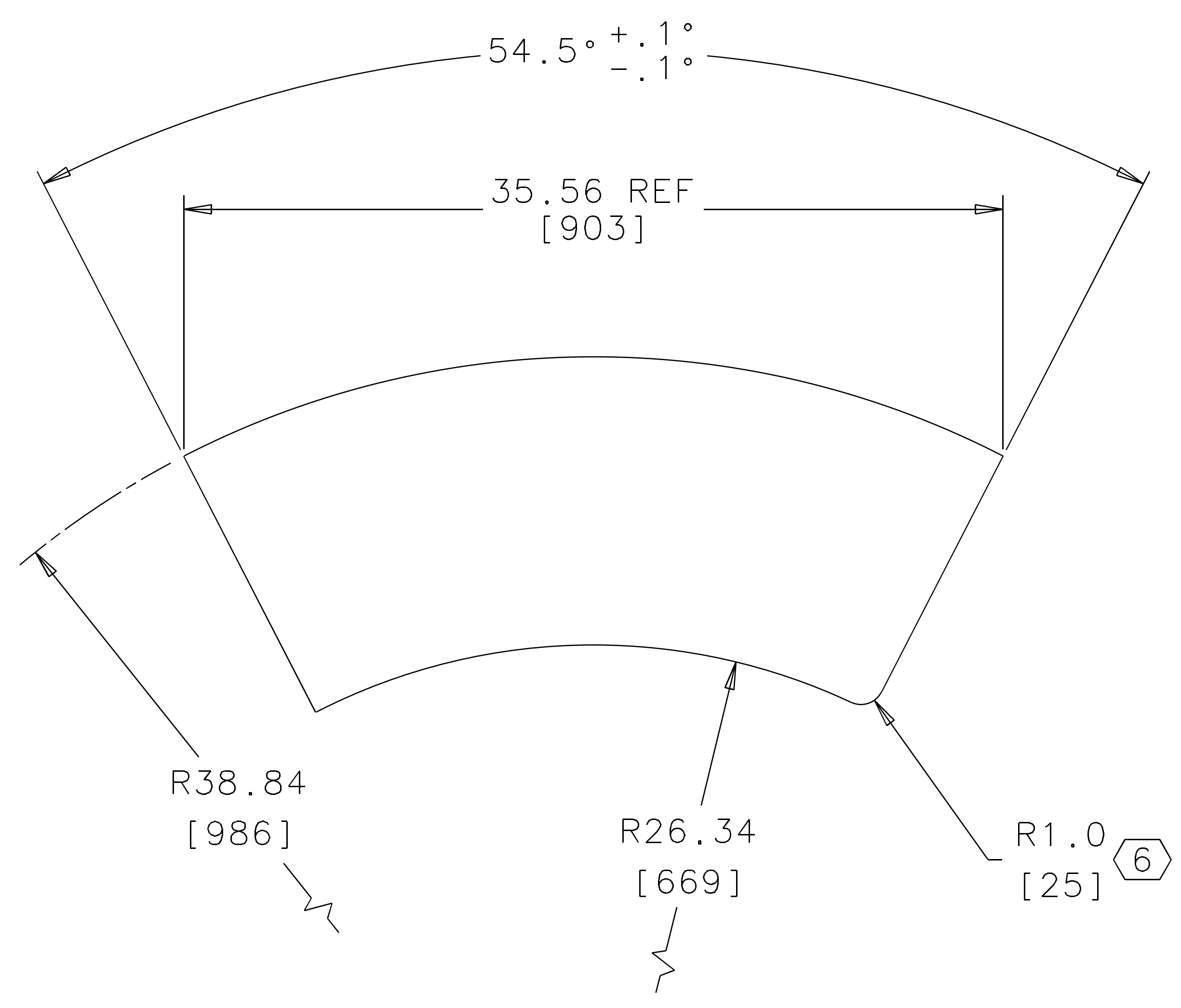


SECTION B-B [1]

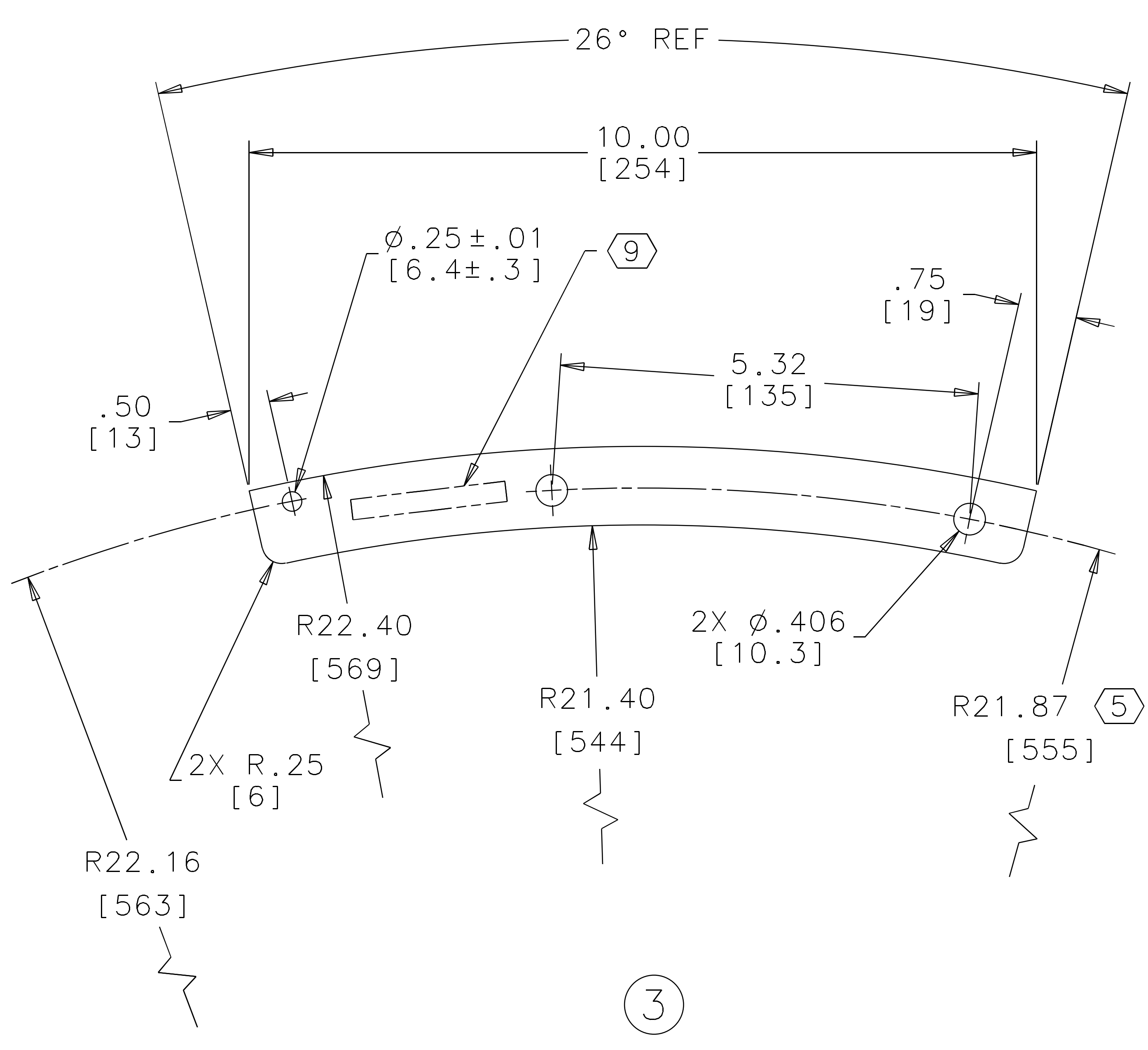
CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
CRYO-PUMP CONE BAFFLE			
SCALE: NTS	SIZE	DRAWING NUMBER	SHEET
E		D980451-B	2 OF 3

8 | 7 | 6 | 5 | 4 | 3 | 2 | 1

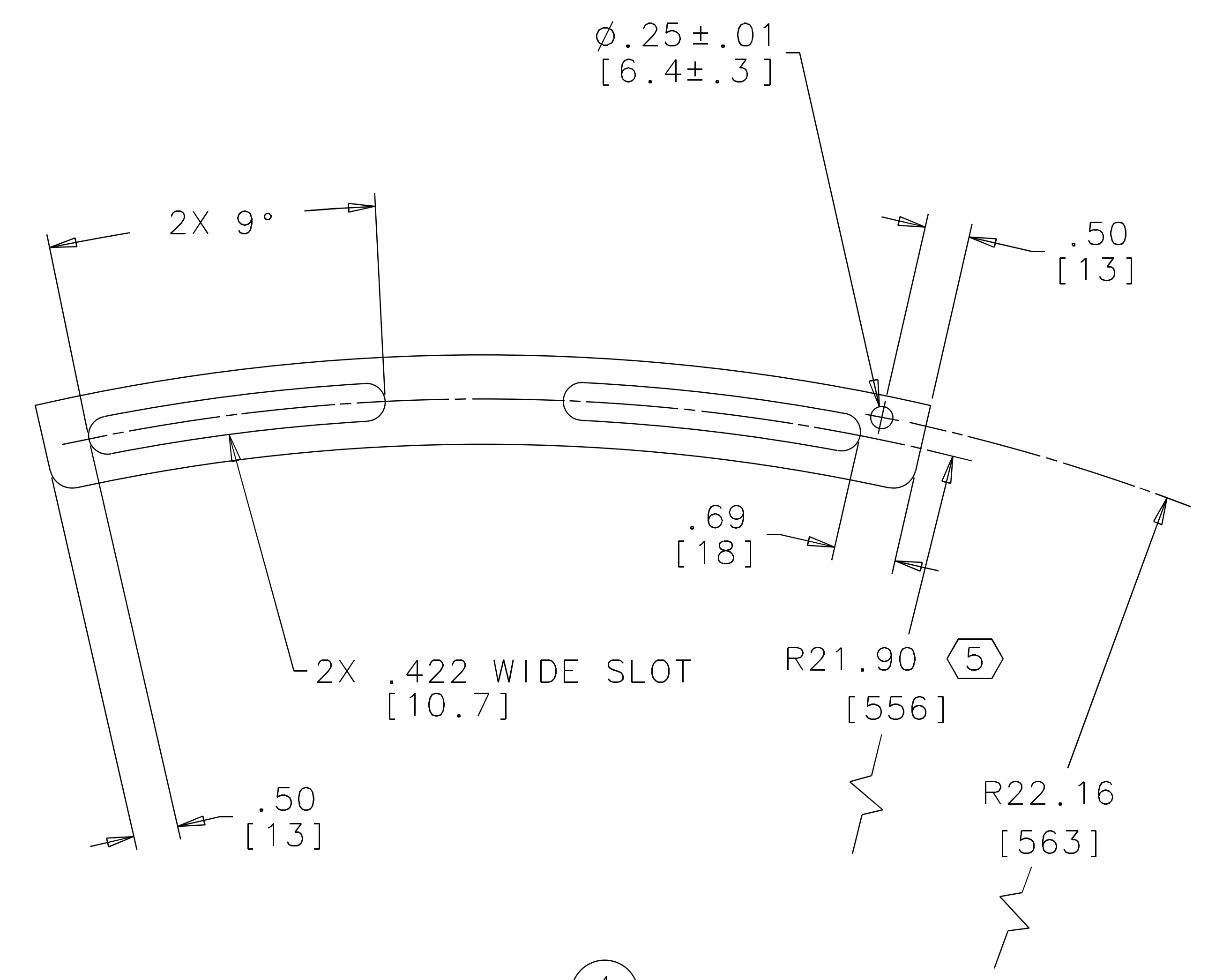
F  
E  
D  
C  
B  
A



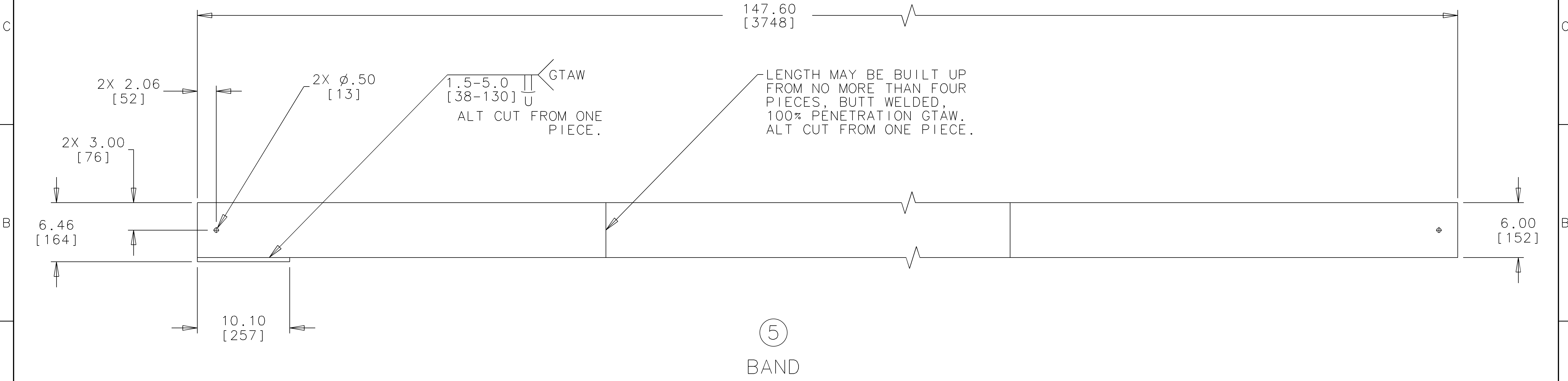
① & ②  
CONE SECTIONS ⑭



③  
TAB



④  
SLOTTED TAB  
(SAME AS ③ EXCEPT AS NOTED)



⑤  
BAND

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
CRYO-PUMP CONE BAFFLE			
SCALE: NTS	SIZE E	DRAWING NUMBER D980451-B	SHEET 3 OF 3

8 | 7 | 6 | 5 | 4 | 3 | 2 | 1