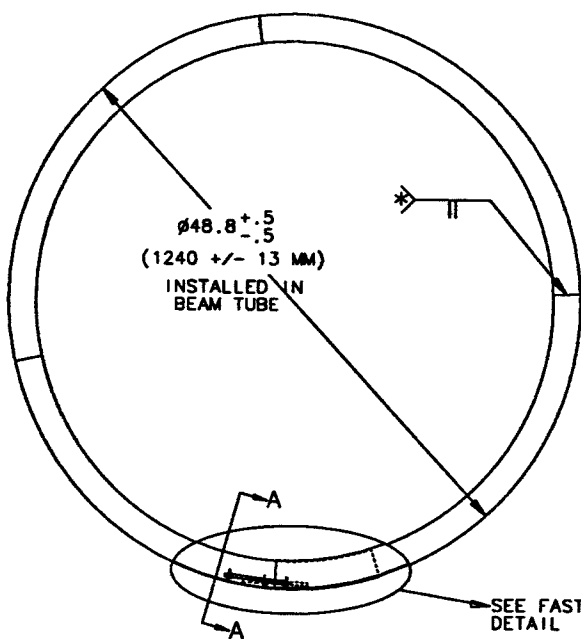
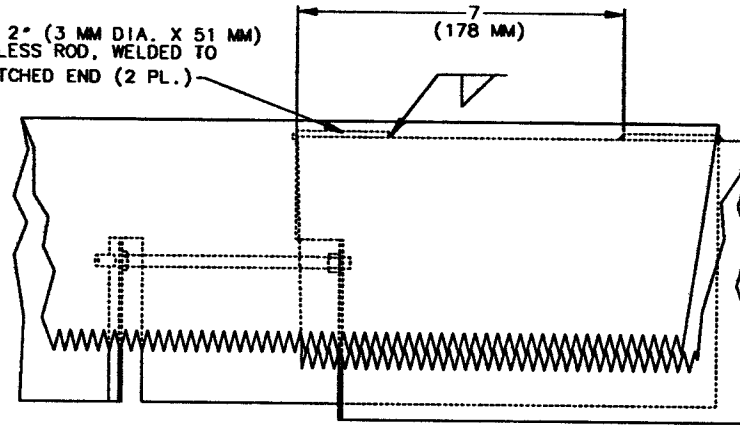


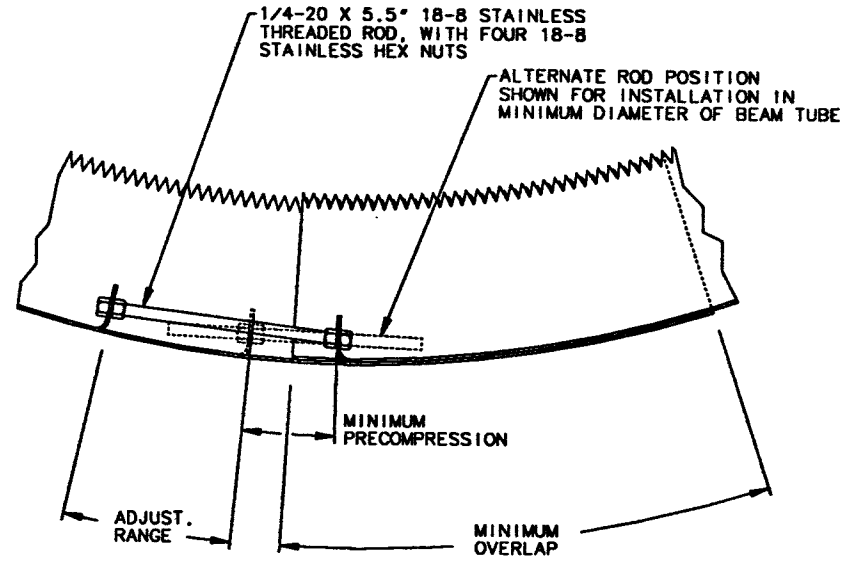
REV	DATE	BY	APPV	DESCRIPTION

1/8 DIA. X 2" (3 MM DIA. X 51 MM)  
304L STAINLESS ROD, WELDED TO  
BAND AT NOTCHED END (2 PL.)



**BAFFLE ASSEMBLY**

\* TOP SURFACE OF CONE SEGMENT BUTT JOINTS TO BE FREE OF WELD MELT-THROUGH OR DISCOLORATION.



**FASTENER DETAIL**

(DRAWN INSTALLED IN MAXIMUM DIAMETER OF BEAM TUBE)

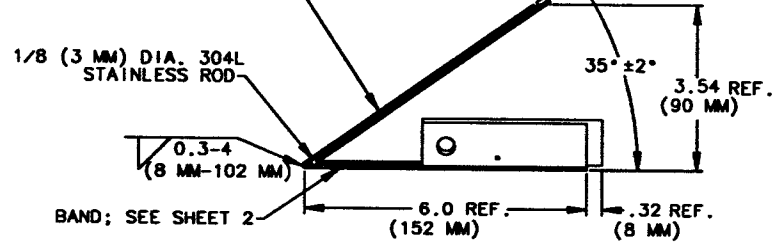
CLEANING OF CONE & BAND, AFTER WELDING (ROD & NUTS CLEANED AND PACKAGED SEPARATELY, WITH IDENTICAL PROCESS):

1. WASH: SPRAY WITH A MIXTURE OF 5% MIRACHEM DETERGENT & 95% STEAM, WITH DURATION SUFFICIENT TO HEAT ALL BAFFLE SURFACES TO 130F; DO NOT ALLOW TO DRY UNTIL RINSE IS COMPLETE.
2. RINSE: SPRAY WITH 100% STEAM, SAME DURATION AS WASH STEP ABOVE TO RINSE ALL TRACES OF DETERGENT. ALLOW TO DRY IN CLEAN ENVIRONMENT.
3. PACKAGING: "WIND" WELDMENT TO 30" O.D. AND TIE WITH CABLE TIE. WRAP WITH CALTEX PLASTICS CP STAT 100 OR EQUAL, SEALING ALL SEAMS WITH TAPE. TAKE CARE TO PREVENT TAPE FROM CONTACTING METAL PARTS.

LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:  
X.XX: +/- 0.03  
X.X: +/- 0.10

ALL DIMENSIONS ARE IN INCHES OR DEGREES UNLESS OTHERWISE NOTED.

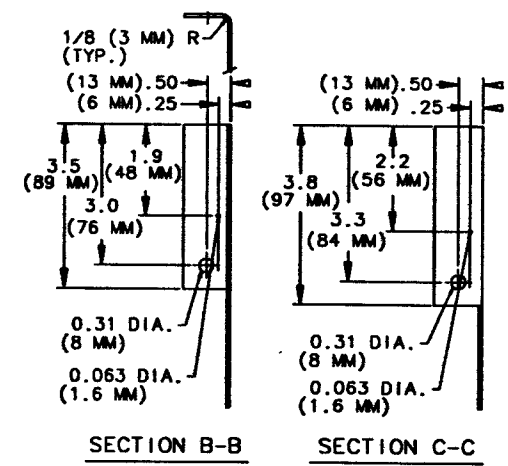
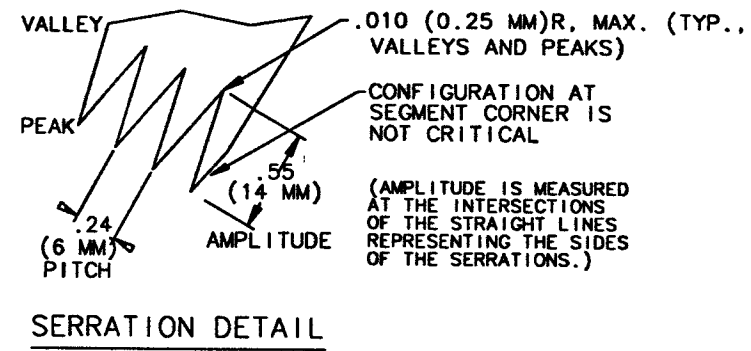
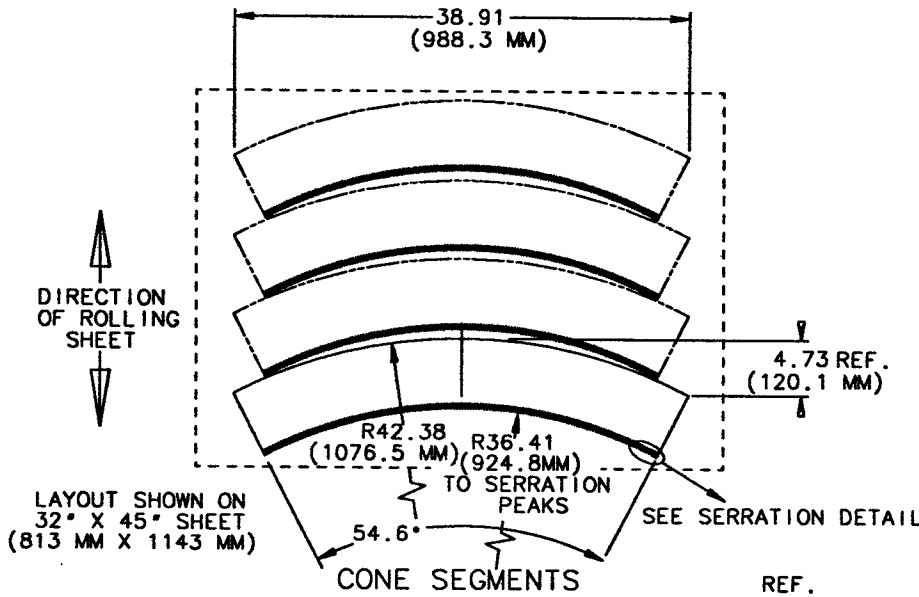
CONE, ROLLED FROM 4 WELDED SEGMENTS; SEE SHEET 2. (TOP SURFACE IS THIS SIDE)



**SECTION A-A**

(CURVATURE, ROD & NUT ARE IGNORED FOR SIMPLICITY)

LIGO PROJECT	
	BEAM TUBE
	BAFFLE
	0950094



**CONE SEGMENTS** REF.

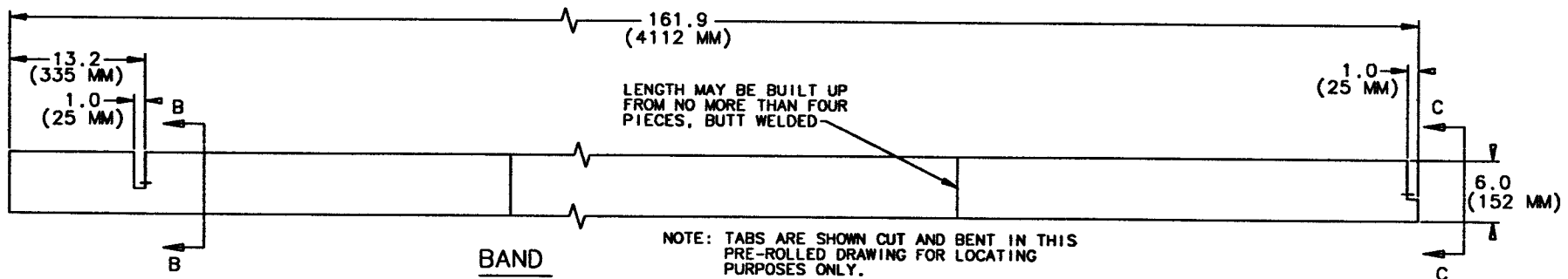
FOUR SEGMENTS REQ'D. PER BAFFLE

MATERIAL: 304L STAINLESS STEEL

FINISH, TOP SURFACE:	#2 BA	#8 POLISH
FINISH, BOTTOM SURFACE:	NOT CRITICAL	NOT CRITICAL
THICKNESS:	0.020 (0.51 MM)	0.065 (1.65 MM)

NOTE: SUPPLY ADHERED PAPER PROTECTOR (OR EQUAL) ON TOP SURFACE OF CONE SEGMENTS; LEAVE ON SURFACE (WHERE POSSIBLE) THROUGH SHIPPING.

CONE SEGMENTS TO BE CUT BY WATERJET, PLASMA, OR LASER PROCESS.



**BAND**

ONE REQ'D. PER BAFFLE

MATERIAL: 304L STAINLESS STEEL

FINISH IS NOT CRITICAL

THICKNESS:

0.020 (0.51 MM),	BAFFLE "A"
0.065 (1.65 MM),	BAFFLE "B"

LINEAR TOLERANCES, UNLESS OTHERWISE NOTED:

X.XXX:	+/- 0.003
X.XX:	+/- 0.03
X.X:	+/- 0.1

ALL DIMENSIONS ARE IN INCHES OR DEGREES, UNLESS OTHERWISE NOTED

LIGO PROJECT	
DATE: 10/16/95	DESCRIPTION: BEAM TUBE BAFFLE
BY: MTS	APP: MTS
NO: 0950094	REV: 2/2