



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D 960045 A	BEAM TUBE Baffle, Full Section, FAB & Porcelain Coverage Detail	B
D 960046 A	" " " NON SERATED " " " "	B

CHANGE DESCRIPTION (FROM/TO): Add HOLES for Tooling for INSTALATION of Porcelain Application
 Changed tol. on detail ①, ② & TAB. Angle Detail ②

REASON FOR CHANGE: Tooling Requirements & Revising of tolerancing

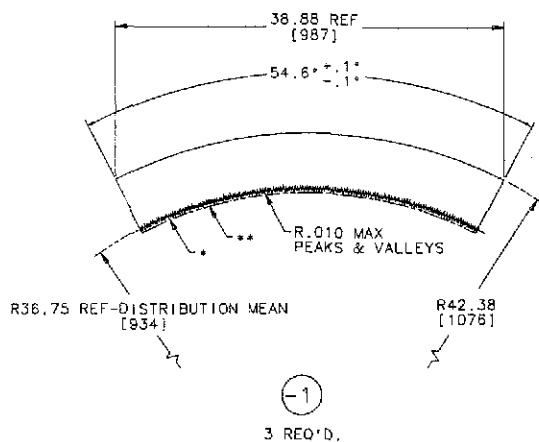
ACTION: Incorporate change Attach DCN to drawing(s) Other action (specify):

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION
<input type="checkbox"/> No hardware affected (record change only)	Althouse Barish Coles Coyne Lazzarini Lindquist Lucas Sanders Shoemaker Stapfer Tyler Vogt Weiss Whitcomb Young L JONES C FRANKLIN A SIBLEY
<input type="checkbox"/> List S/Ns which comply already:	
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	
<input checked="" type="checkbox"/> List S/Ns to be built with this change: <i>all items</i>	
<input type="checkbox"/> List S/Ns to be retested per this change:	
<input type="checkbox"/>	

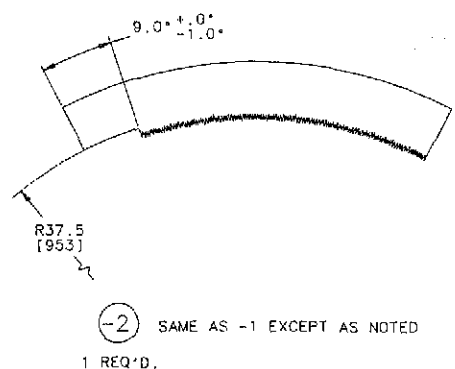
SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (if yes, enter CR (CCB) or TCP (TRB) no.)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: <i>A Sibley</i>	4/25/96		
TASK LEADER: <i>A Sibley</i>	4/25/96		
GROUP LEADER: <i>Mahoney</i>	5/3/96		
DCC RELEASE: <i>Sumner</i>	6/22/96		

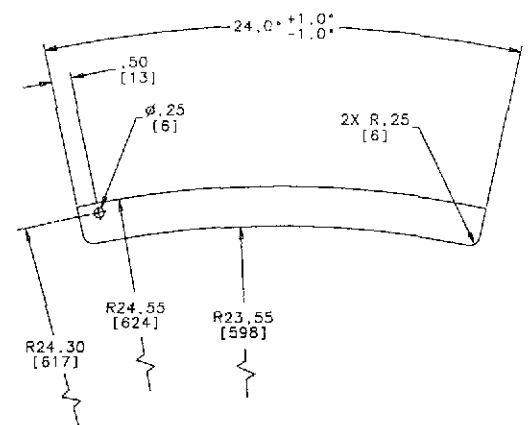
REV	DATE	BY	APP	DESCRIPTION



(-1)
3 REQ'D.



(-2) SAME AS -1 EXCEPT AS NOTED
1 REQ'D.



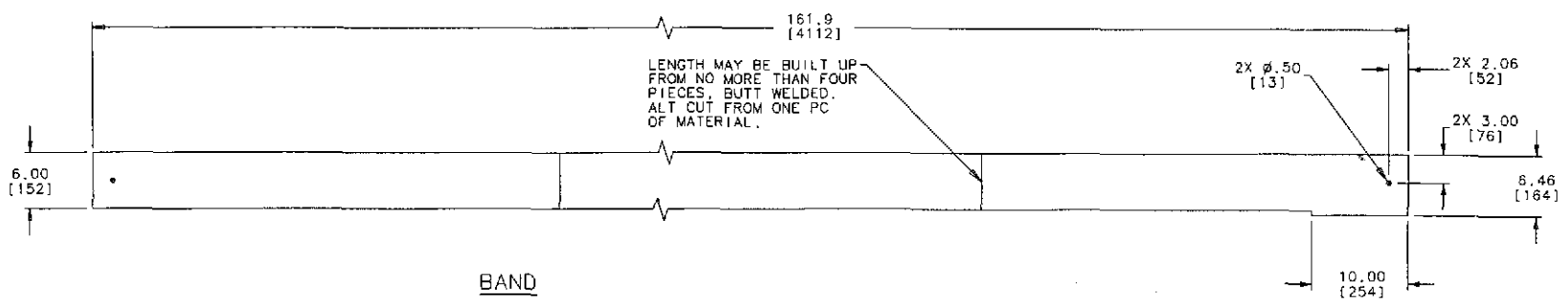
TAB
2 REQ'D

* ACTUAL DIMS WILL BE PROVIDED TO VENDOR IN ELECTRONIC FORM, 1-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.

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



BAND
1 REQ'D.

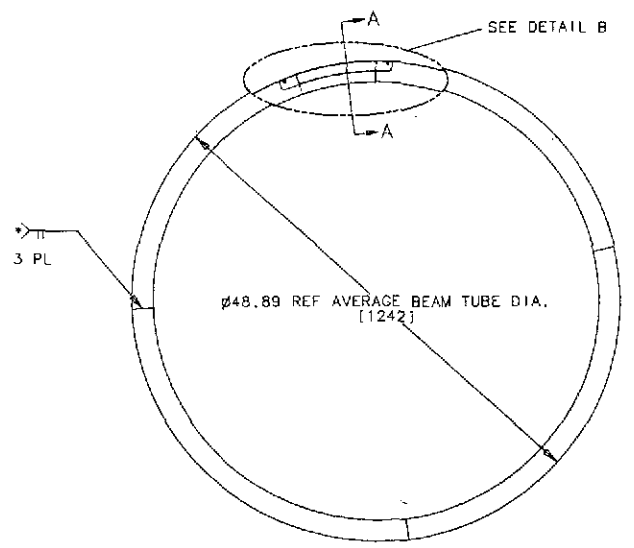
MATERIAL: 304L STAINLESS STEEL
THICKNESS: 20ga (.036 NOM)

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	
DIVISION OF ENGINEERING		LIGO PROJECT	
DATE:	4/25/96	DESCRIPTION:	BEAM TUBE BAFFLE, FULL SERRATION, FABRICATION AND PORCELAIN COVERAGE DETAIL
DRAWN:		CHECKED:	
SCALE:	MKS	TITLE:	CONSOLE NUMBER: 0960045 SHEET: 2 OF 2

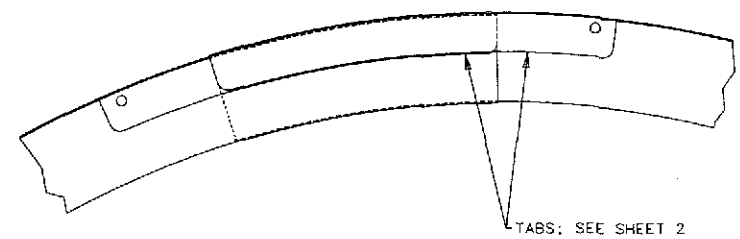
EDITION: 4/25/96

TOL. DETAIL ①
 & TAB
 ANGLE DETAIL ②



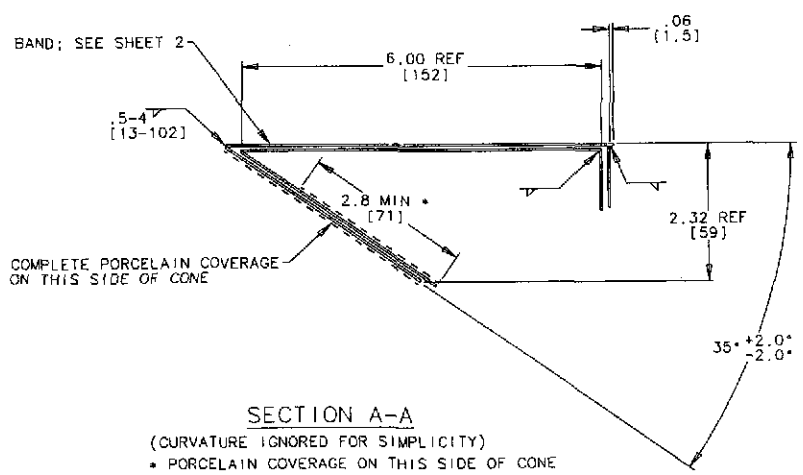
BAFFLE ASSEMBLY

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



DETAIL B

DRAWN INSTALLED IN MAXIMUM DIAMETER OF BEAM TUBE (ø49.18)
 7.5 OVERLAP AT BAND



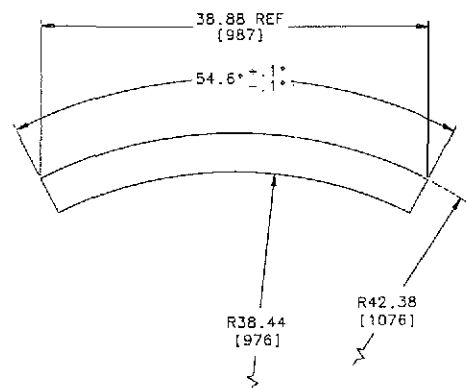
SECTION A-A

(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.

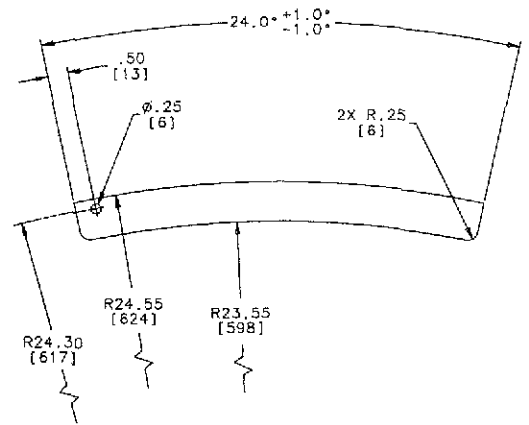
DESIGNED BY	C. COXLEY	PROJECT	LIGO PROJECT
DRAWN BY	A. STIBLEY	TITLE	BEAM TUBE BAFFLE, NON-SERRATED, FABRICATION AND PORCELAIN COVERAGE
CHECKED BY	A. LAZZARINI	SHEET NO.	1
DATE	12/25/94	TOTAL SHEETS	2



CONE SEGMENT

4 REQ'D.

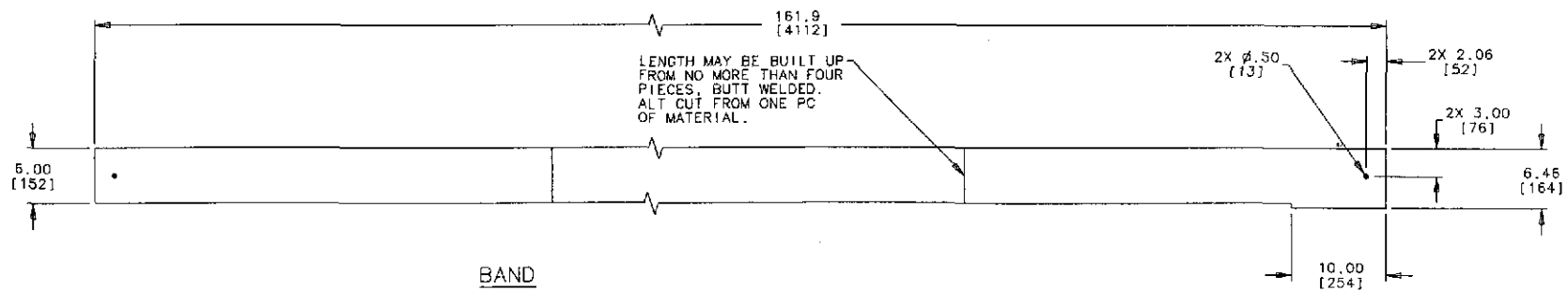
MATERIAL: 304L STAINLESS STEEL
 THICKNESS: 20ga (.036 NOM)
 CONE SEGMENTS TO BE CUT BY WATERJET
 OR LASER PROCESS.
 ALT METHOD TWO SECTIONS 109.2" EACH.



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		LIGO PROJECT	
INDUSTRIAL FACILITY OF CALIFORNIA			
DRN	C. CORLEW	BEAM TUBE BAFFLE, NON-	
ECN		SERRATED, FABRICATION	
APPD		AND PORCELAIN COVERAGE	
DATE		DETAIL	
SCALE: NTS	TYPE	ISSUE NUMBER	SHEET
		D960046	2

EDITION: 4/25/96