



# DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D980691-00	I. O. BAFFLE, GLASS, TOP LEFT	A
D980692-00	I. O. BAFFLE, 2K, GLASS, TOP RIGHT	A
D980693-00	I. O. BAFFLE, GLASS, BOTTOM	A
D980694-00	I. O. BAFFLE, GLASS, TOP LEFT SEGMENT	A
D990568-00	I. O. BAFFLE, 2K, UPPER SUPPORT	A

**CHANGE DESCRIPTION (FROM/TO):** Document List Continued

D990570-00	I. O. BAFFLE, LOWER SUPPORT	A
D990571-00	I. O. BAFFLE, RIGHT TIE PLATE	A
D990573-00	I. O. BAFFLE, LEFT TIE PLATE	A
D990574-00	I. O. BAFFLE, LEFT CLIP	A
D990575-00	I. O. BAFFLE, RIGHT CLIP	A
D990576-00	I. O. BAFFLE, LEFT SUPPORT ANGLE	A
D990578-00	I. O. BAFFLE, RIGHT SUPPORT ANGLE	A
D990580-00	I. O. BAFFLE, RIGHT STRAP ASSEMBLY	A
D990582-00	I. O. BAFFLE, LEFT STRAP ASSEMBLY	A
D990583-00	I. O. BAFFLE, RIGHT STRAP PLATE	A
D990585-00	I. O. BAFFLE, LEFT STRAP PLATE	A
D990587-00	I. O. BAFFLE, RIGHT STRAP BASE	A
D990588-00	I. O. BAFFLE, LEFT STRAP BASE	A
D990589-00	I. O. BAFFLE, LEFT SUPPORT ASSEMBLY	A
D990590-00	I. O. BAFFLE, RIGHT SUPPORT ASSEMBLY	A

**REASON FOR CHANGE:** INITIAL RELEASE

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

**DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)**

- No hardware affected (record change only)
- List S/Ns which comply already:
- List S/Ns to be reworked or scrapped:
- List S/Ns to be built with this change: ALL, 001 & UP
- List S/Ns to be retested per this change:
- 
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**DCN DISTRIBUTION (X=incl. doc's)**

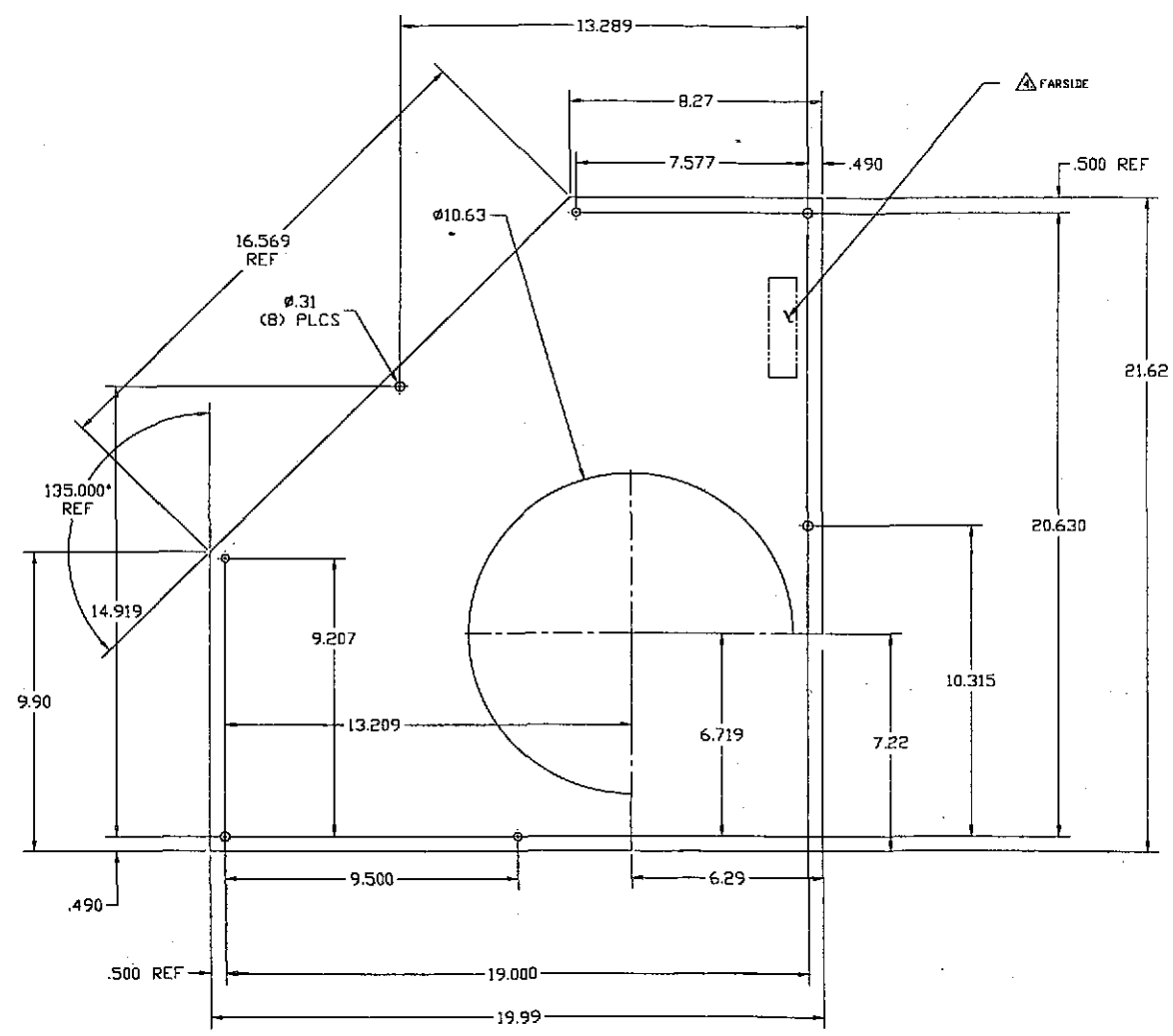
Althouse	Barish	Coles
Coyne	Lazzarini	Lindquist
Raab	Sanders	Shoemaker
Stapfer	Tyler	
Weiss	Whitcomb	
Camp	Smith	
Conley	Mailand	
Romic		

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

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: P. Kabot <i>P. Kabot</i>	10/28/99		
TASK LEADER: M. Smith <i>Michael Smith</i>	11/1/99		
GROUP LEADER: D. Coyne <i>D. Coyne</i>	10/28/99		
DCC RELEASE: <i>S. Small</i>	11-2-99		

- NOTES: (UNLESS OTHERWISE SPECIFIED)
- ⚠ ALL ABRASIVE CUTTING TO BE DONE FROM NEAR SIDE.
  - ⚠ GLASS TO BE COVERED BY VINYL MASK ON NEAR SIDE PRIOR TO START OF MACHINING, AND SHIPPED WITH MASK IN PLACE FOR SURFACE PROTECTION.
  - ⚠ MAKE FROM #12 WELDERS FILTER GLASS (SCHOTT) 0.12" THICK.
  - ⚠ ETCH OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 013 HIGH CHARACTERS. EXAMPLE: D990039-A S/N 001

PART & SERIAL NUMBER THIS FACE ONLY-REF



UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

TOLERANCES:  
FRACTIONAL ± 1/64  
ANGULAR ± 1/2°  
HOLE POSITION ± BEND ±  
TWO PLACE DECIMAL ± .01

THREE PLACE DECIMAL ± .005  
FINISHED SURFACE RMS  
BREAK CORNERS .002-.010  
REMOVE ALL BURRS

MATERIAL: ⚠ HEAT TREAT: FINISH: ⚠ ⚠ ⚠

REV	DESCRIPTION	ISSUE DESCRIPTION	DATE	BY	CHKD	APP'D
A	RELEASE	E990039	10-5-99	XASCT	-	-
00	PRI-RELEASE		12-14-98	A. ROSSA	-	-

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

I. O. BAFFLE,  
GLASS, TOP LEFT

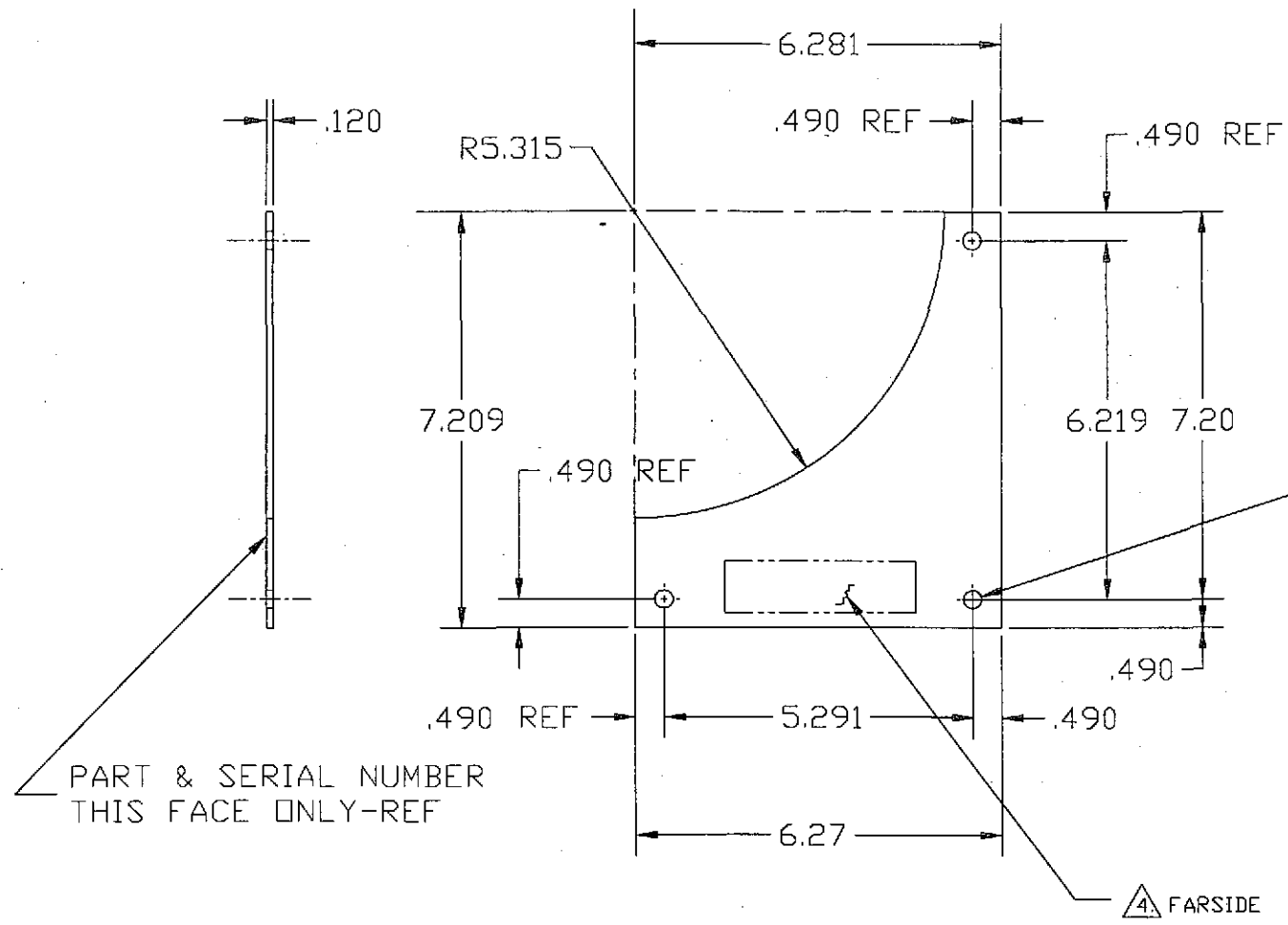
DWG. NO.	DESCRIPTION	USED ON	NEXT ASSY:	ISSUE DESCRIPTION	DATE	BY	CHKD	APP'D	DATE	REV	DATE	BY	CHKD	APP'D	DATE	BY	CHKD	APP'D	DATE	BY	CHKD	APP'D
	REFERENCE DRAWINGS		D990039, D990016																			

1980691-A  
1 OF 1





- NOTES: (UNLESS OTHERWISE SPECIFIED)
- ⚠ ALL ABRASIVE CUTTING TO BE DONE FROM NEAR SIDE.
  - ⚠ GLASS TO BE COVERED BY VINYL MASK ON NEAR SIDE PRIOR TO START OF MACHINING, AND SHIPPED WITH MASK IN PLACE FOR SURFACE PROTECTION.
  - ⚠ MAKE FROM: #12 WELDERS FILTER GLASS (SCHOTT) 0.12" THICK.
  - ⚠ ETCH OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE DIGIT SERIAL NUMBER, SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 0.13 HIGH CHARACTERS. EXAMPLE: D990036-A S/N 001



UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

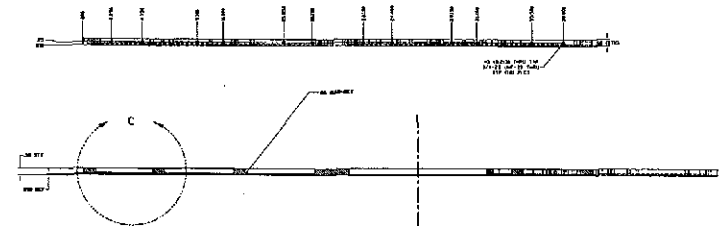
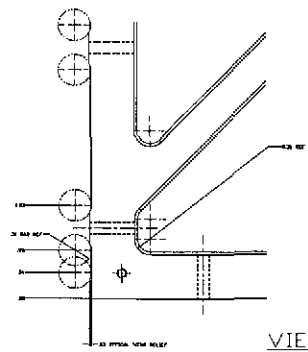
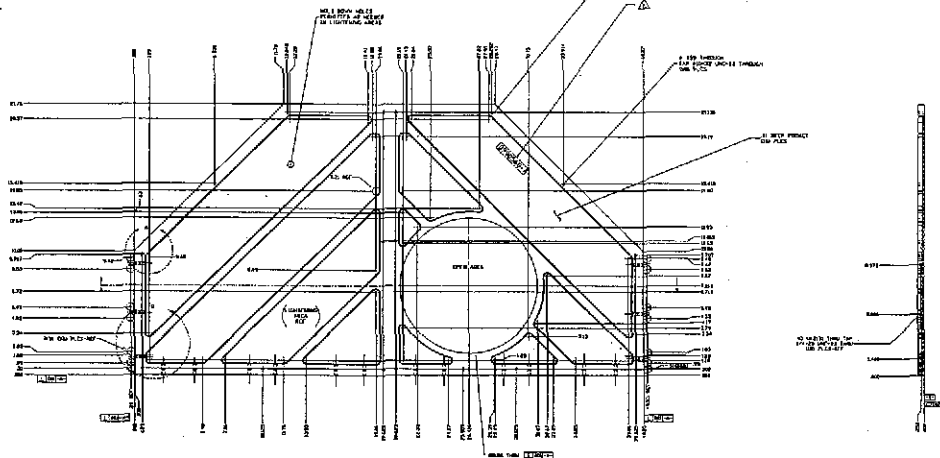
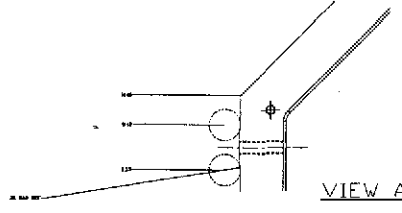
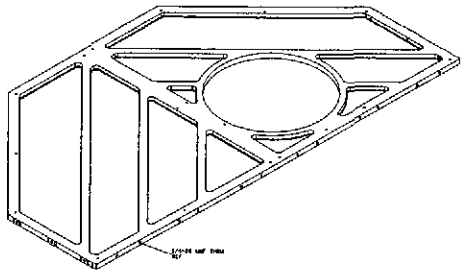
TOLERANCES:  
FRACTIONAL: ± 1/64  
ANGULAR: ± 1/2°  
BREAK CORNERS: .002-.010  
REMOVE ALL BURRS

THREE PLACE DECIMAL ± .005  
FINISHED SURFACE .010  
BREAK CORNERS .002-.010  
REMOVE ALL BURRS

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MOSKOWITZS INSTITUTE OF TECHNOLOGY

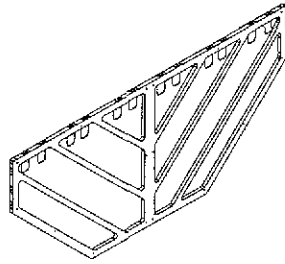
I. O. BAFFLE  
GLASS, TOP LEFT SEGMENT

DVG. NO.		DESCRIPTION		MATERIAL		HEAT TREAT		FINISH		REV		APPROV'D		CHECK		DATE		SCALE		SHEET		1 OF 1	
										A		B		C		D		E		F		G	
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										A		B											

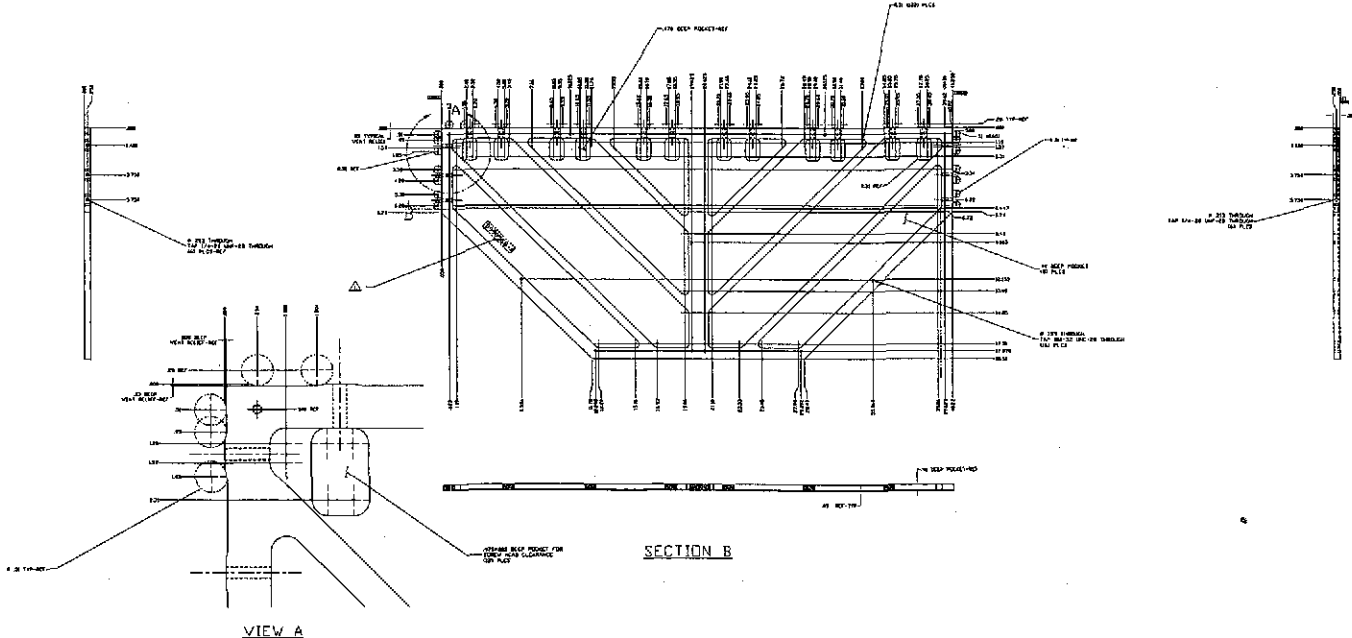


THIS APPLICABLE SPECIFICATION IS A FEDERAL STANDARD WHICH IS THE PROPERTY OF THE GOVERNMENT AND IS LOANED TO YOUR ORGANIZATION. IT IS TO BE USED IN CONNECTION WITH THE GOVERNMENT CONTRACT UNDER WHICH IT IS LOANED TO YOUR ORGANIZATION. IT IS TO BE RETURNED TO THE GOVERNMENT AT THE END OF THE CONTRACT PERIOD OR AT THE END OF THE PROJECT PERIOD, OR AT THE END OF THE PROJECT PERIOD, OR AT THE END OF THE PROJECT PERIOD.

TELESPHERES FRACTIONAL 3/16" X ANGLE 1/2" X 1/2" TWO PLATE BOLDS, 1/2" THREE PLATE BOLDS, 1/2" X 1/2"		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		INSIDE RADIUS ALL FINISHES SURFACE ARE BREAK CORNERS .005 TO .015 REMOVE ALL BURRS		A OR REV		RELEASE PAC-RELEASE DESCRIPTION		E992036		HADDT 2-18-99		1450 I. O. BAFFLE, PK UPPER SUPPORT	
MATERIAL: MADE FROM 30 THIN CAP ALUMINUM HOLDING PLATE		HEAT TREAT: NEXT ASS'Y: 0940097		FINISH: $\Delta$ $\Delta$		OR REV		DESCRIPTION		DCN NUMBER		APP'D: CNECC DRUM DATE		DATE: 18-19-98 FILE: 0990560-A	
FIG. NO.		REFERENCE DRAWING		USED ON		NEXT ASS'Y: 0940097		DESCRIPTION		ISSUE DESCRIPTION		DATE		FILE: 0990560-A	



1. THIS DRAWING IS THE PROPERTY OF  
 THE U.S. GOVERNMENT AND IS TO BE  
 REPRODUCED AND TRANSMITTED IN ANY  
 FORM AND BY ANY MEANS, ELECTRONIC  
 OR MECHANICAL, INCLUDING PHOTOCOPYING,  
 RECORDING, OR BY ANY INFORMATION  
 STORAGE AND RETRIEVAL SYSTEM,  
 WITHOUT PERMISSION IN WRITING FROM  
 THE U.S. GOVERNMENT.

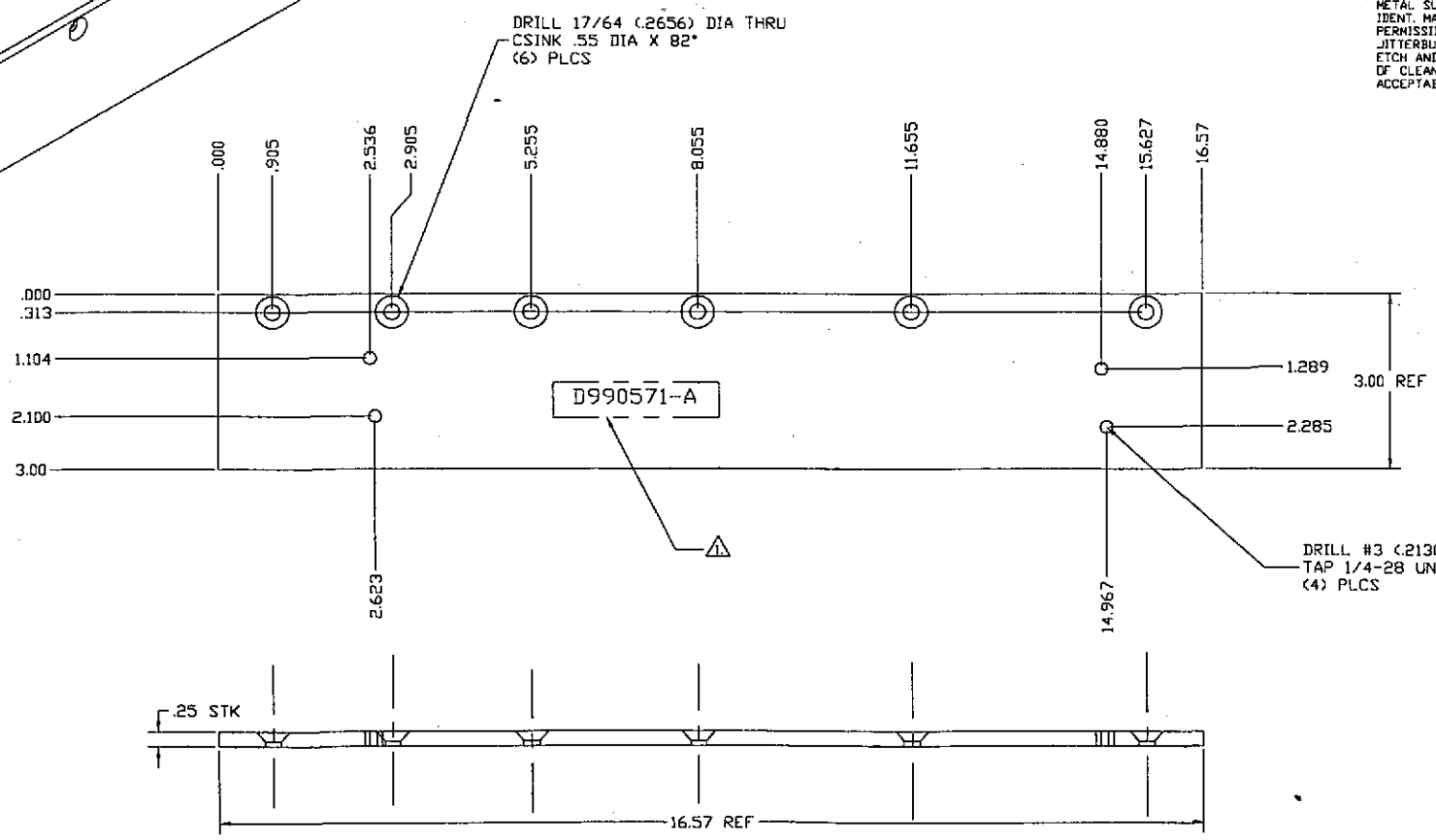
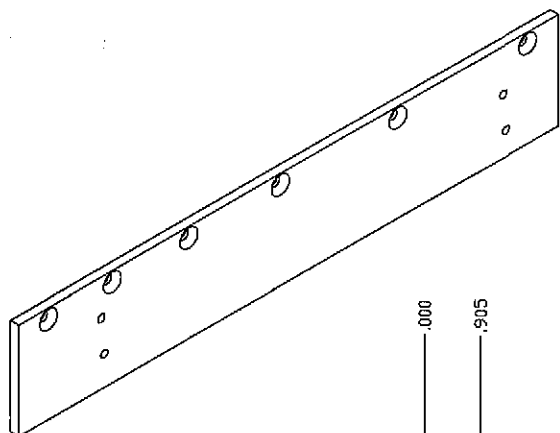


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES: FRACTIONS ± 1/64 DECIMALS ± .010 TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .003		FINISH: INSIDE Baffle JOINT FINISHED SURFACE AND BULKY CORNERS TO BE REMOVED ALL SURFACES		MATERIAL: 304 STAINLESS STEEL ALUMINUM 7075-T6		HEAT TREAT: H14		FINISH: AS SHOWN		REV: A DESCRIPTION: RELEASE E990036 DATE: 3-10-99 BY: KRB07 CHECK: A. RIDER DATE: 12-19-98		LOGO I. D. BAFFLE LOWER SUPPORT PART NUMBER: D990570-A SHEET: 1 OF 1	
8	7	6	5	4	3	2	1								

NOTES: (UNLESS OTHERWISE SPECIFIED)

⚠ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999. FOR EACH SUCCEEDING PART PRODUCED. USE 013 HIGH CHARACTER. EXAMPLE: D990000-A S/N 001

⚠ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES: FRACTIONAL ± 1/64 ANGULAR ± 1/2° TWO PLACE DECIMAL ±.003 THREE PLACE DECIMAL ±.000		INSIDE RADIUS ON FINISHED SURFACE .015 BREAK OUTSIDE CORNERS .005 - .015 REMOVE ALL BURRS		MATERIAL TYPE 304-304 STAINLESS STEEL 1/4 x 3 x 16.7 LONG		HEAT TREAT.		FINISH ⚠ ⚠		NEXT ASSY: D990597, D990616		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MARCH 1987	
DESCRIPTION		MATERIAL TYPE 304-304 STAINLESS STEEL 1/4 x 3 x 16.7 LONG		HEAT TREAT.		FINISH ⚠ ⚠		NEXT ASSY: D990597, D990616		RELEASE		C990036		KARDT 3-10-99	
REFERENCE DRAWINGS		USED ON		HEAT ASSY: D990597, D990616		ISSUE DESCRIPTION		ISSUE NUMBER		APPROV'D		CHECK		DATE	
I. O. BAFFLE RIGHT TIE PLATE		D990571-A		1 OF 1											



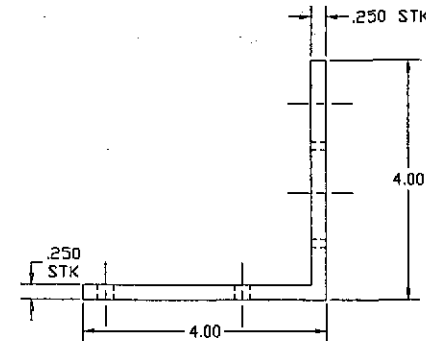
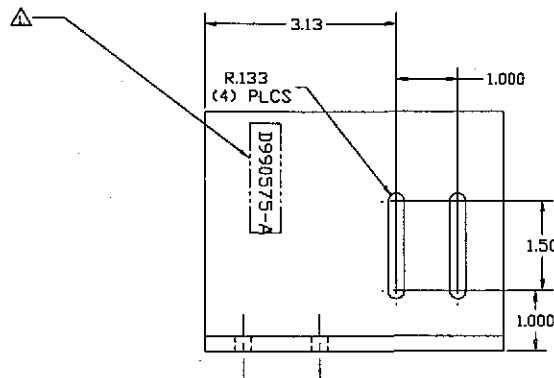
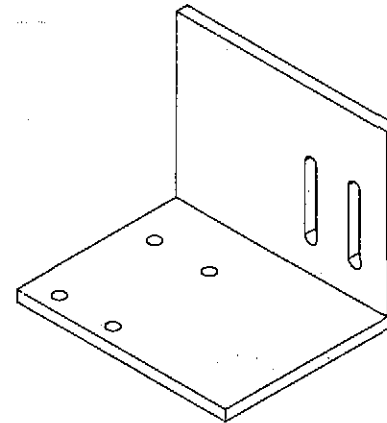
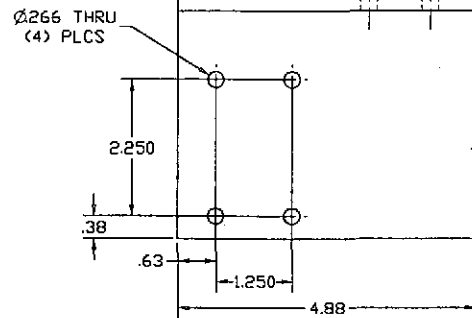




NOTES: (UNLESS OTHERWISE SPECIFIED)

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 EXAMPLE: D990038-A S/N 001

⚠ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES								MIL CALIFORNIA INSTITUTE OF TECHNOLOGY MIL MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± 1/64 ANGULAR ± 1/2° ANGULAR BEND ± .01 TWO PLACE DECIMAL ± .01		THREE PLACE DECIMAL ± .005 FINISHED SURFACE RING BREAK CORNERS .005-.015 REMOVE ALL BURRS						I. D. BAFFLE, RIGHT CLIP	
		MATERIAL: TYPIC 302-304 STAINLESS STEEL 4 x 4 x 1/4 x .50 LONG		HEAT TREAT:		FINISH: ⚠ ⚠				303 FILE	
REV		USED IN:		NEXT ASSY: D990290		REV		DESCRIPTION		ISSUE DESCRIPTION	
A		RELEASE		D990236		KABOT		3-10-99		SCALE	
30		PRE-RELEASE				A. REISA		12-28-98		D990575-A	
REV		DESCRIPTION		DCN NUMBER		APPROV CHECK		DATE		SHEET 1 OF 1	

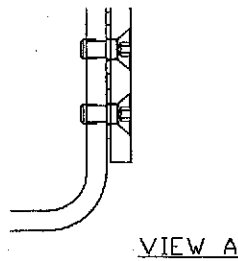
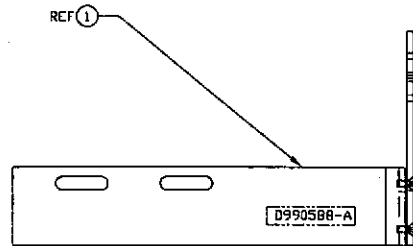
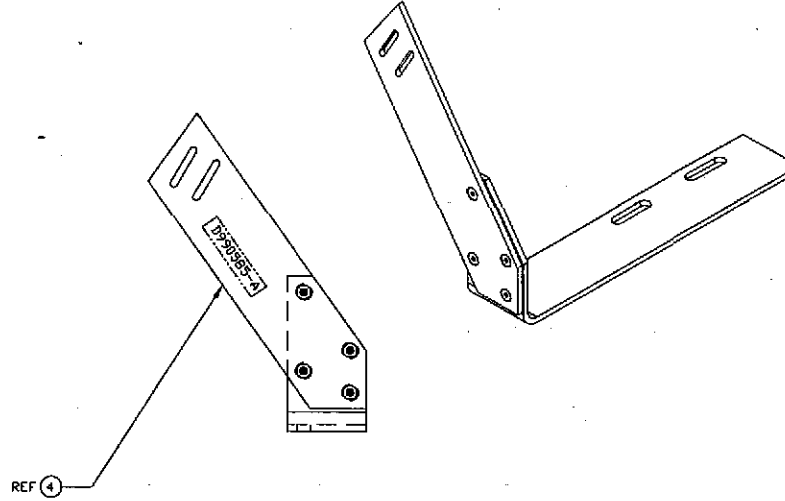
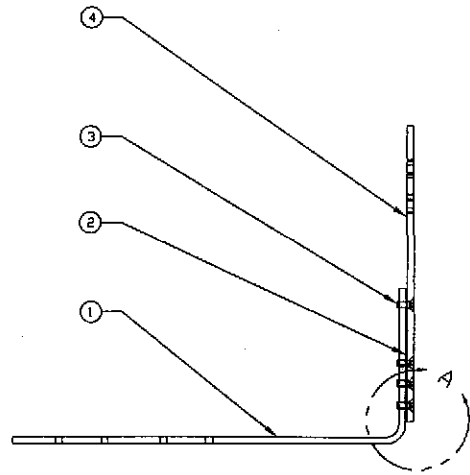






NOTES: UNLESS OTHERWISE SPECIFIED

1. THIS IS A UHV APPLICATION AND ALL PARTS ARE TO BE KEPT CLEAN AND FREE FROM CONTAMINANTS INCLUDING LUBRICANTS, PRIOR TO AND DURING ASSEMBLY.



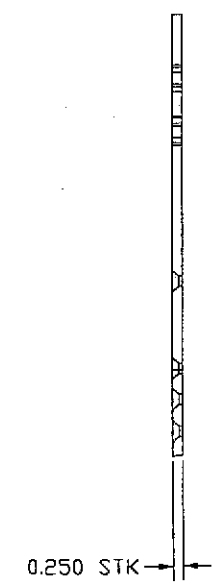
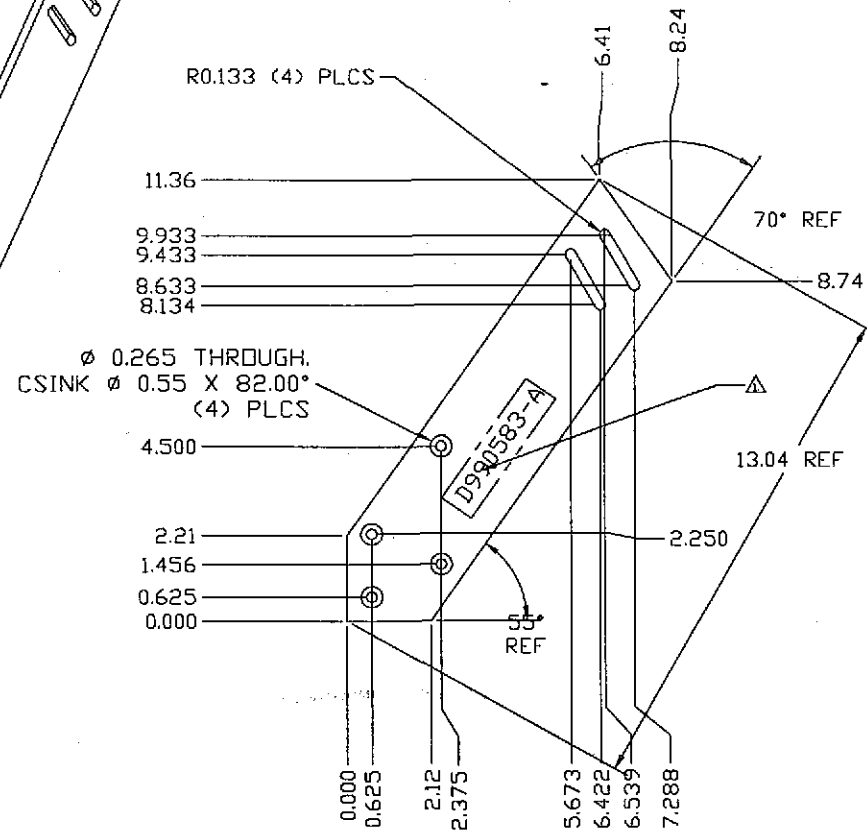
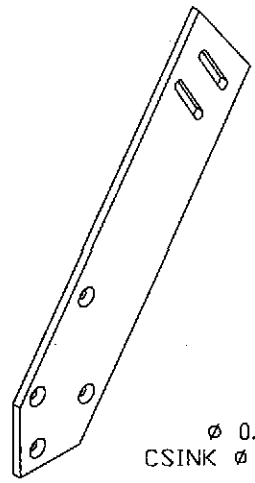
REF	QTY	PART or DRWG No.	DESCRIPTION	MATERIAL
4	1	D990585	LEFT STRAP PLATE	
3	4	UC COMPONENTS BFA-2810-NA	1/4"-28 x .53 UC STD PL HD SCREW	STAINLESS STEEL W/SILVER PL
2	4	UC COMPONENTS BWFV-25	1/4" NOM ID FLAT WASHER-VENTED	STAINLESS STEEL
1	1	D990588	LEFT STRAP BASE	

UNLESS OTHERWISE SPECIFIED				PARTS and MATERIAL LIST				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
FORMER	FRACTIONAL & DECIMALS	THREE PLACE DECIMAL & MILLIMETER & INCH	THREE PLACE DECIMAL & FRACTION SURFACE FINISH	FINISH	RELEASE	DATE	BY	DATE	DATE
					RELEASE	E99024	-	-	KASOT 2-18-99
					P&C-RELEASE	-	-	-	KASOT 1-5-99
					DESCRIPTION	ISSUE NUMBER	APPR'D	CHECK	DATE
DWG. NO.	DESCRIPTION	MATERIAL	HEAT TREAT	FINISH	REV	ISSUE DESCRIPTION	SCALE	NES	SHEET 1 OF 1
	REFERENCE DRAWINGS	USED ON	NEXT ASSY: D990597, D990616						

NOTES: (UNLESS OTHERWISE SPECIFIED)

△ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 013 HIGH CHARACTER. EXAMPLE: D990038-A S/N 001

△ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT, MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN FEET (END)

TOLERANCES:  
FRACTIONAL: 1/64"  
ANGULAR: ± 1/2°  
HOLE LENGTH: ± 0.005"  
TWO PLACE DECIMAL: ± 0.005"

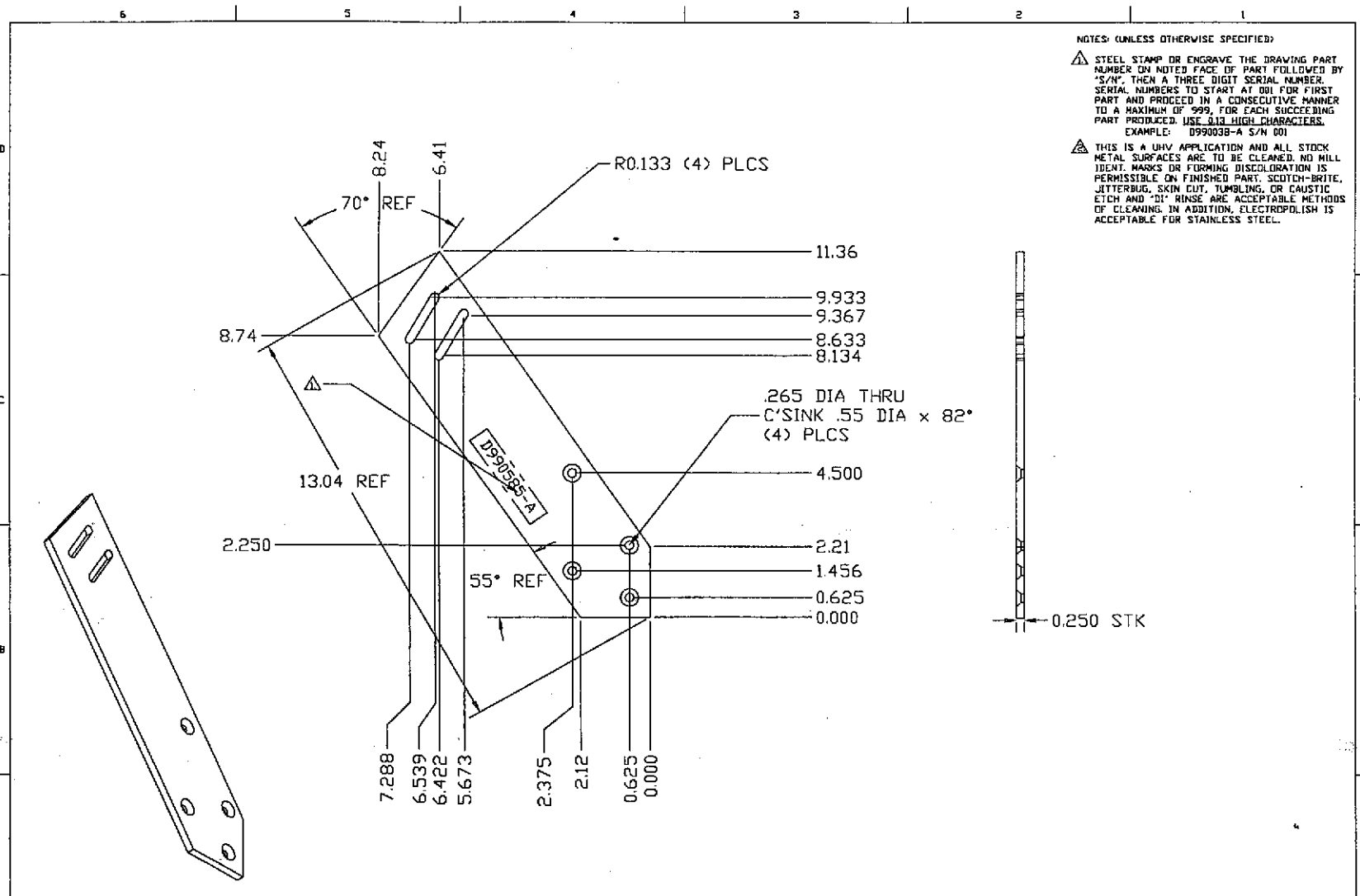
THREE PLACE DECIMAL: ± 0.005"  
FINISHED SURFACE: ± 0.005"  
HOLE CORNER: R0.015"  
REMOVE ALL BURRS

MATERIAL: TYPE 304-316 STAINLESS STEEL  
HEAT TREAT: 141 & 2 3/4 H  
FINISH: △ △  
NEXT ASSY: D990038

REV	DESCRIPTION	ISSUE DESCRIPTION	DATE
A	RELEASE	E990038	3-10-99
		DCN NUMBER	APPR'D
		CHECK	DRWN
			DATE

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
1. D. BAFFLE RIGHT STRAP PLATE	
DWG FILE STRAP_PLATE.DWG	SHEET NO C
DWG NO D990583-A	SHEET 1 OF 1





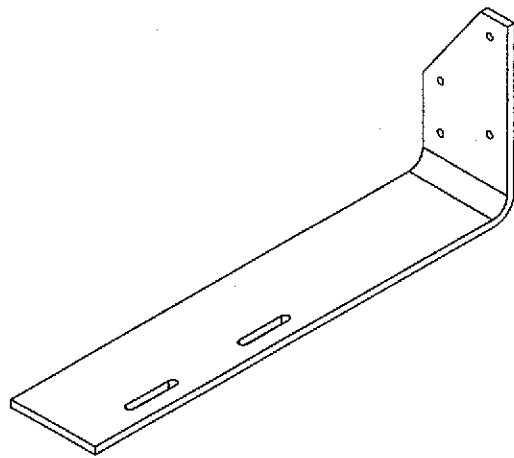
NOTES (UNLESS OTHERWISE SPECIFIED):

▲ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 3/16 HIGH CHARACTERS. EXAMPLE: D990038-A S/N 001

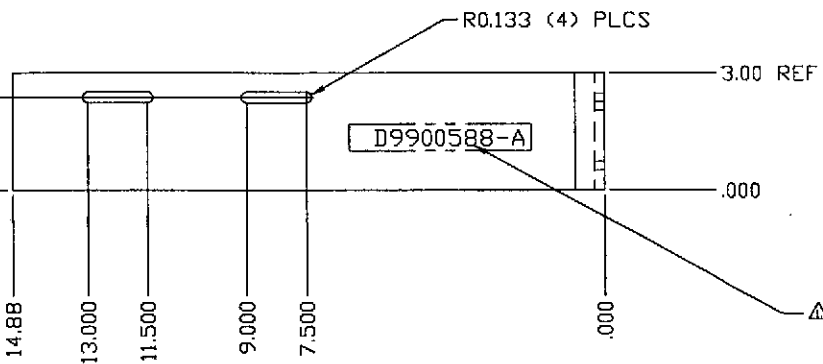
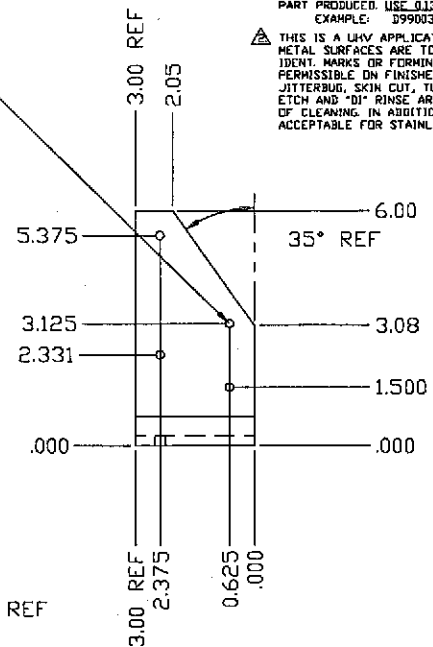
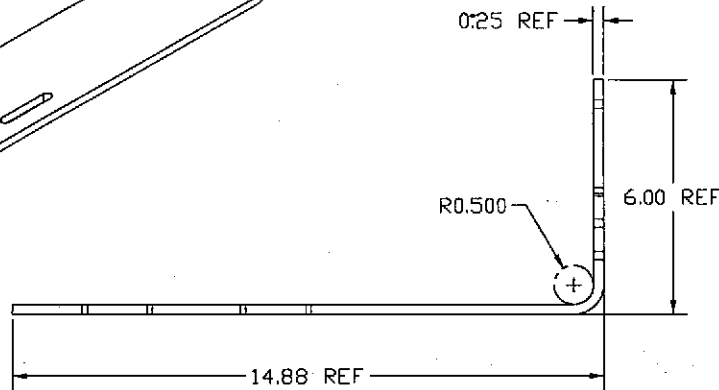
▲ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FURNING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN FEET (IN)								LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FUNCTIONAL SURF. MILLING & DRP MILLING & DRP TYP. PLACE DIMEN. & DR		THREE PLACE DIMEN. & DR FINISHED SURFACE DRP MESH CONTOUR, 30-20 REMOVE ALL BURRS						I.D. BAFFLE LEFT STRAP PLATE	
		MATERIAL: TYPE 304-304 STAINLESS STEEL 1/2" x 3" DRP		HEAT TREAT:		FINISH: ▲ ▲		RELEASE: E990836		DATE: 2-10-99	
DWG. NO.		DESCRIPTION		REV		DESCRIPTION		DCH NUMBER		DATE	
REFERENCE DRAWINGS		USED ON		NEXT ASSTY: 0990082		ISSUE DESCRIPTION		APPROV		CHECK	
6		5		4		3		2		1	
								SCALE		SHEET 1 OF 1	





DR #3 (.2130) DIA THRU  
TAP 1/4-28 UNC-2B THRU  
(4) PLCS



D9900588-A

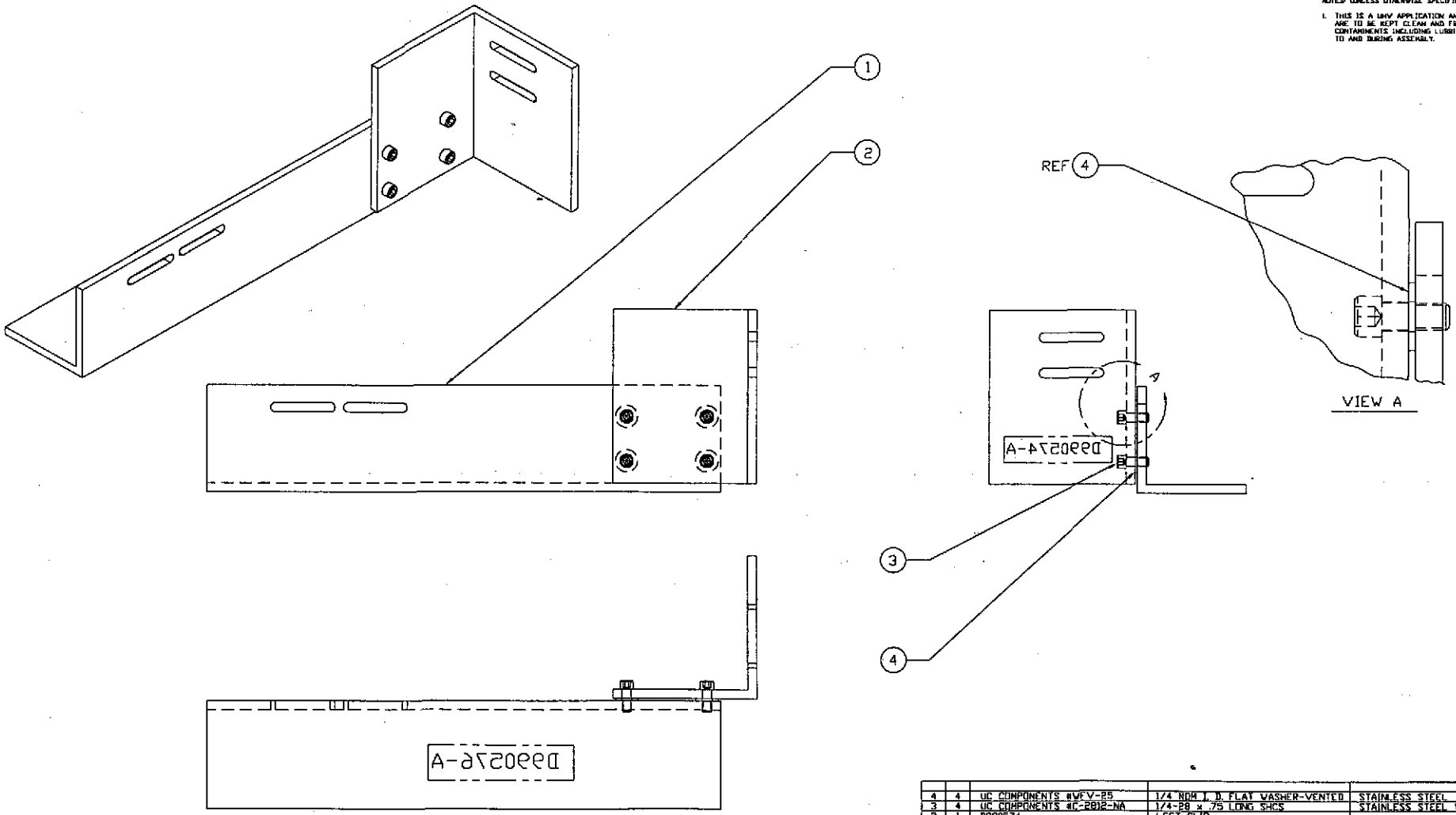
NOTES: UNLESS OTHERWISE SPECIFIED

⚠ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/N", THEN A THREE-DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 013 HIGH CHARACTERS. EXAMPLE: D990038-A S/N 001

⚠ THIS IS A UVV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.

<p>MAXIMUM DIMENSIONAL TOLERANCES UNLESS NOTED OTHERWISE</p> <p>TOLERANCES: FRACTIONS: ± .010 DECIMALS: ± .005 ANGLES: ± .125° THREE PLACE DECIMAL: ± .002 FOUR PLACE DECIMAL: ± .001 REMOVE ALL BURRS</p>		<p>RELEASE C990036</p>		<p>DATE: 3-10-99</p>		<p>LEG California Institute of Technology Massachusetts Institute of Technology</p>	
<p>MATERIAL: TYPE 304-304 STAINLESS STEEL 1/8" ± .005</p>		<p>HEAT TREAT: </p>		<p>FINISH: </p>		<p>I.O. BAFFLE, LEFT STRAP BASE</p>	
<p>USED ON: NEXT ASSY: D990382</p>		<p>REV: 00</p>		<p>DATE: 4-20-98</p>		<p>SCALE: NTS</p>	
<p>DESCRIPTION: REFERENCE DRAWINGS</p>		<p>ISSUE DESCRIPTION</p>		<p>DATE</p>		<p>SHEET: 1 OF 1</p>	

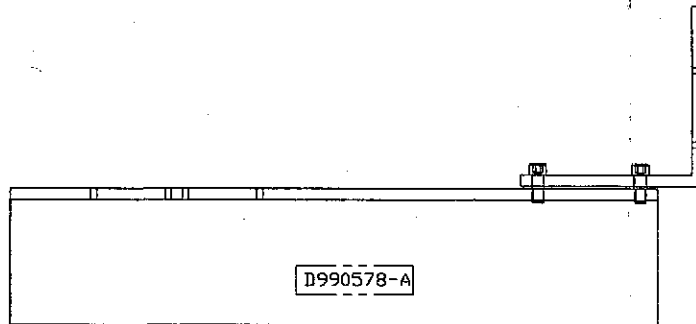
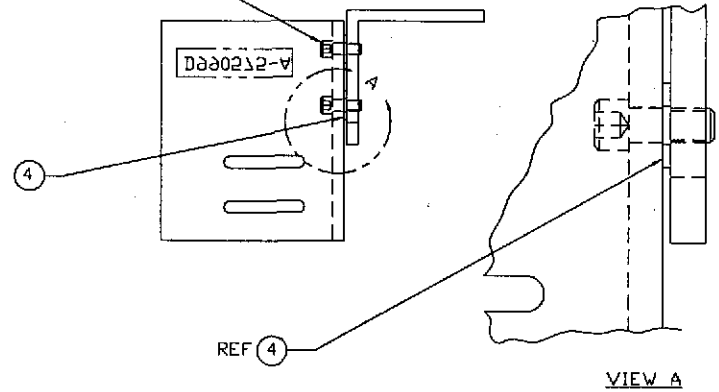
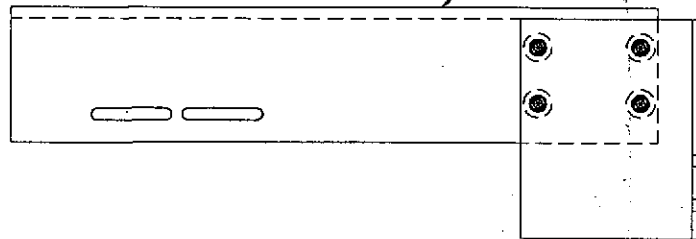
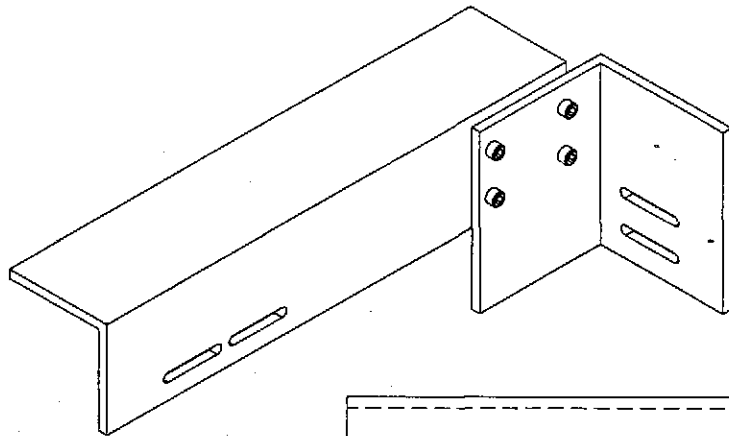
NOTES: UNLESS OTHERWISE SPECIFIED  
 1. THIS IS A LOW VOLTAGE APPLICATION AND ALL PARTS ARE TO BE KEPT CLEAN AND FREE FROM CONTAMINANTS INCLUDING LUBRICANTS, PRIOR TO AND DURING ASSEMBLY.



REF	QTY	PART OR DRWG No.	DESCRIPTION	MATERIAL
4	4	UC COMPONENTS #VFV-25	1/4 NDM J. D. FLAT WASHER-VENTED	STAINLESS STEEL
3	4	UC COMPONENTS #C-R012-NA	1/4-28 x .75 LONG SHCS	STAINLESS STEEL W/SILVER PL
2	1	D990574	LEFT CLIP	-
1	1	D990576	LEFT SUPPORT ANGLE	-

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				PARTS and MATERIAL LIST				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
TOLERANCES FRACTIONAL: # ANGULAR: 2 ANGULAR: 4 ANGULAR: 8 TWO PLACE DECIMAL: 3		THREE PLACE DECIMAL: 2 FINISHED SURFACE: 30S BREAK CORNERS: 1/16" DIA. REMOVE ALL BURRS		RELEASE C98036		MADOT 3-18-99		SHEET 11	
MATERIAL		HEAT TREAT		FINISH		APPRO'D CHECK DRAWN DATE		SHEET 11	
DWG. NO.		NEXT ASSY: D990577, D990616		ISSUE DESCRIPTION		DATE		D990589-A	
DESCRIPTION		USED ON		DESCRIPTION		DATE		D990589-A	
REFERENCE DRAWINGS								SHEET 1 OF 1	

NOTES: UNLESS OTHERWISE SPECIFIED  
 1. THIS IS A 18KV APPLICATION AND ALL PARTS ARE TO BE KEPT CLEAN AND FREE FROM CONTAMINANTS INCLUDING LUBRICANTS, PRIOR TO AND DURING ASSEMBLY.



REF	QTY	PART or DRWG No.	DESCRIPTION	MATERIAL
4	4	UC COMPONENTS H WFV-25	1/4 NOM I.D. FLAT WASHER-VENTED	STAINLESS STEEL
3	4	UC COMPONENTS H C-2812-NA	1/4-28 x .75 LONG SHCS	STAINLESS STEEL W/SILVER PL
2	1	D990575	RIGHT CLIP	-
1	1	D990578	RIGHT SUPPORT ANGLE	-

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		THREE PLACE DECIMAL ± FINISHED SURFACE RNS BREAK CORNERS 1/8" RADIUS REMOVE ALL BURRS		RELEASE		E99036		KABOT 3-10-99		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY					
TOLERANCES	FRACTIONAL ±	ANGULAR ±	ANGULAR/BEND ±	MATERIAL	HEAT TREAT.	FINISH	REV	DESCRIPTION	APP'R	CHECK	DATE	SCALE	ANGLES	REV	DATE
±.005	±.005	±.005	±.005												
REFERENCE DRAWINGS		NEXT ASSY: D990597, D990616		D990578-A		D990578-A		D990578-A		D990578-A		D990578-A		D990578-A	
DESCRIPTION		DESCRIPTION		DESCRIPTION		DESCRIPTION		DESCRIPTION		DESCRIPTION		DESCRIPTION		DESCRIPTION	
D990578-A		D990578-A		D990578-A		D990578-A		D990578-A		D990578-A		D990578-A		D990578-A	

I. D. BAFFLE  
RIGHT SUPPORT ASSEMBLY

D990590-A  
SHEET 1 OF 1