



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D990002-n/a	Eliptical LOS Baffle Assembly	A
D990003-n/a	Eliptical LOS Baffle Clamp Bracket	A
D990004-n/a	Eliptical LOS Baffle Clamp Bracket Catch	A
D990005-n/a	Eliptical LOS Baffle Left Frame Member	A
D990006-n/a	Eliptical LOS Baffle Right Frame Member	A
D990007-n/a	Eliptical LOS Baffle Bottom Frame Member	A
D990008-n/a	Eliptical LOS Baffle Top Frame Member	A
D9900011-n/a	Eliptical LOS Baffle Swivle Nut	A
D9900012-n/a	Eliptical LOS Baffle Locating Tab	A
D9900013-n/a	Eliptical LOS Baffle Glass	A
D9900014-n/a	Eliptical LOS Baffle Material List	A

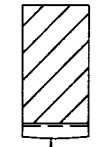
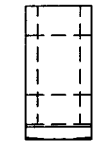
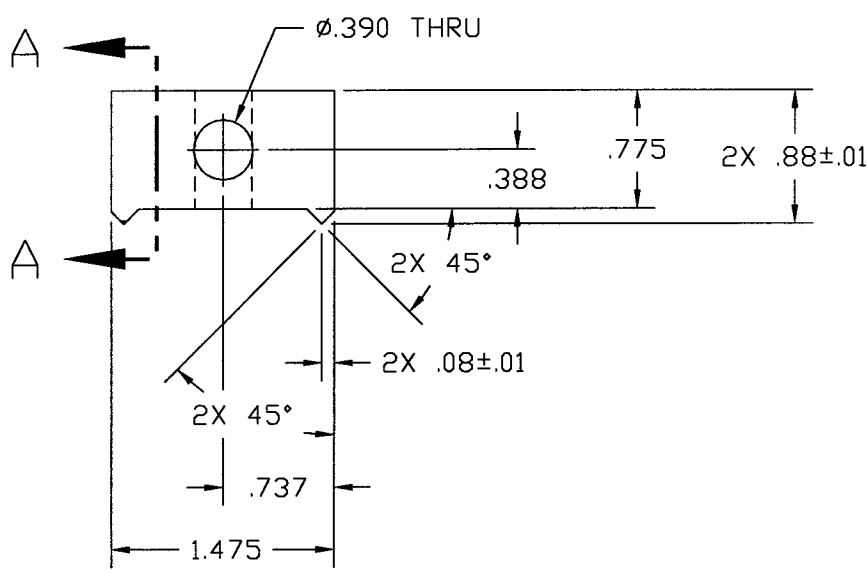
CHANGE DESCRIPTION (FROM/TO):
 Initial release, all documents.

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

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION (X=incl. docs)																					
<input type="checkbox"/> No hardware affected (record change only) <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: All <input type="checkbox"/> List S/Ns to be retested per this change: <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	<table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Althouse</td> <td style="width: 33%;">Barish</td> <td style="width: 33%;">Coles</td> </tr> <tr> <td>X Coyne</td> <td>Lazzarini</td> <td>Lindquist</td> </tr> <tr> <td>Sanders</td> <td>Shoemaker</td> <td>Stapfer</td> </tr> <tr> <td>Tyler</td> <td>Weiss</td> <td>Whitcomb</td> </tr> <tr> <td colspan="3" style="padding-top: 10px;">Camp</td> </tr> <tr> <td>x Smith</td> <td></td> <td>x Conley</td> </tr> <tr> <td></td> <td></td> <td>x JONES</td> </tr> </table>	Althouse	Barish	Coles	X Coyne	Lazzarini	Lindquist	Sanders	Shoemaker	Stapfer	Tyler	Weiss	Whitcomb	Camp			x Smith		x Conley			x JONES
Althouse	Barish	Coles																				
X Coyne	Lazzarini	Lindquist																				
Sanders	Shoemaker	Stapfer																				
Tyler	Weiss	Whitcomb																				
Camp																						
x Smith		x Conley																				
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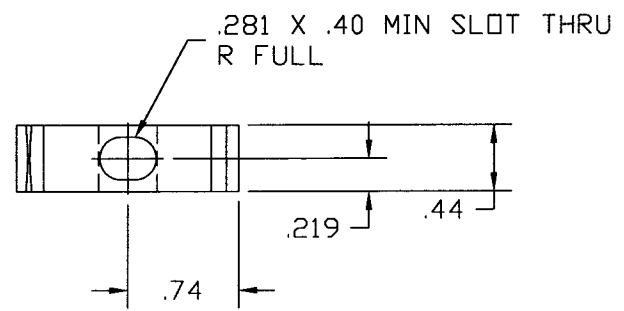
SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (If yes, enter Change Request number)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: C. Conley	1-21-99		
TASK LEADER: <i>Michael R. Smith</i>	<i>2/9/99</i>		
GROUP LEADER: <i>Jan K. Jones</i>	<i>3/23/99</i>		
DCC RELEASE: <i>Jan K. Jones</i>	<i>3/26/99</i>		



R2.00 MAX \triangle

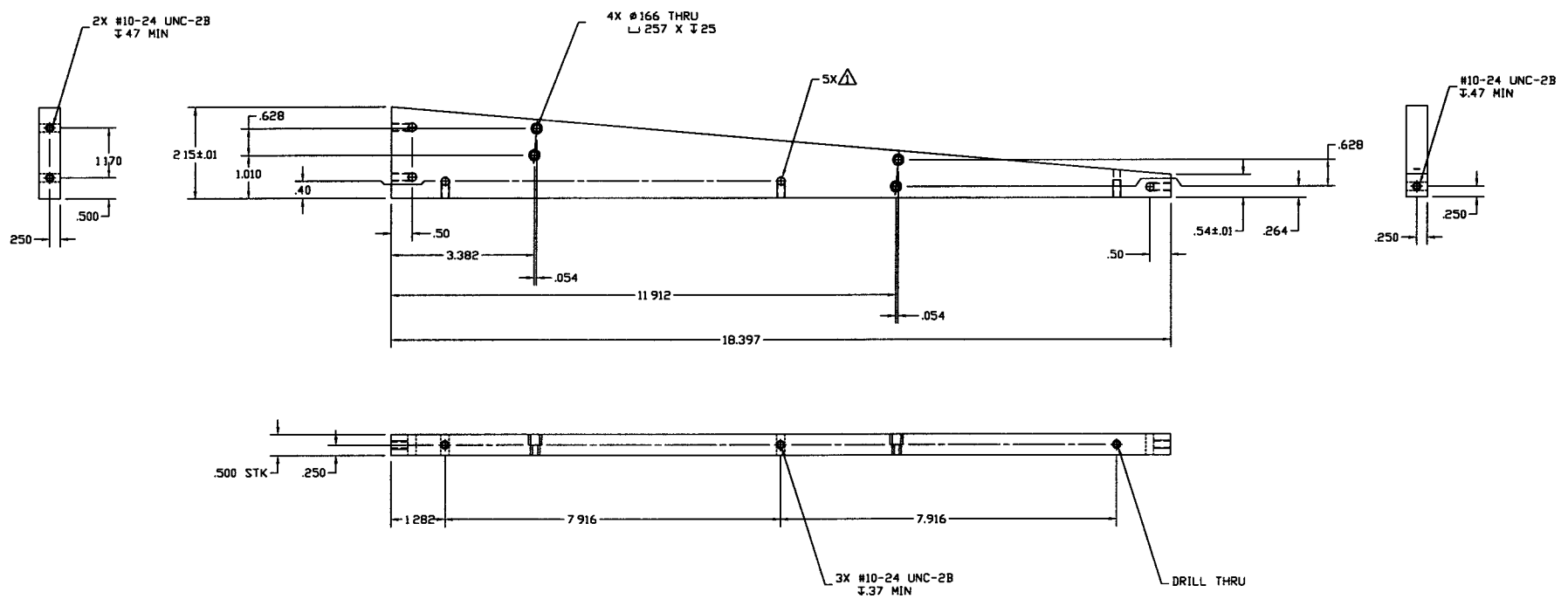
SECTION A-A



NOTES: UNLESS OTHERWISE SPECIFIED
 \triangle .02 MAX FLAT AT MIDPOINT OF RADIUS.
 2 ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)

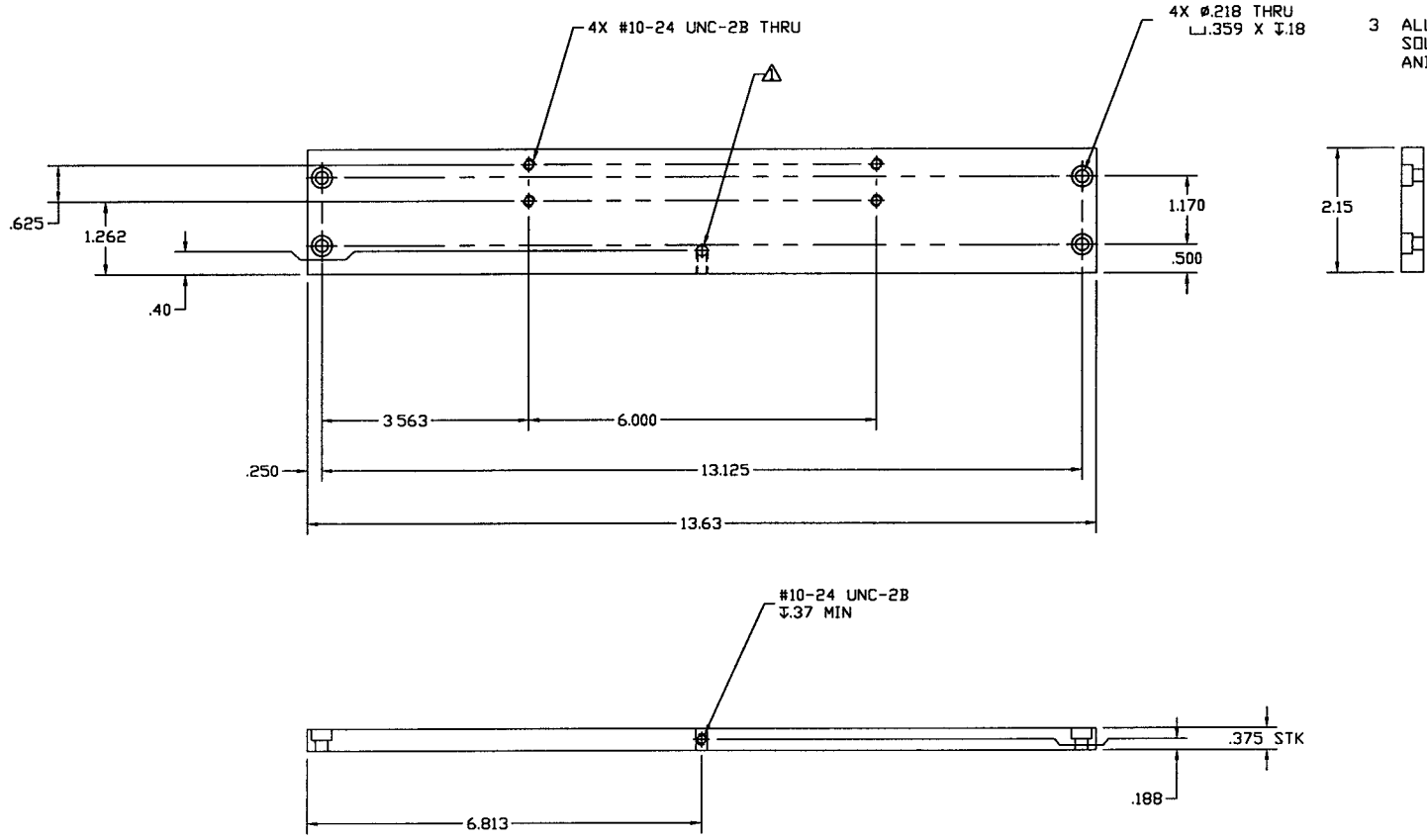
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASONQUARTER INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL .01 ANGULAR .1° ANGULAR BEND ± BEND ± TWO PLACE DECIMAL .003		THREE PLACE DECIMAL .005 FINISHED SURFACE RB SHARP CORNERS TO CUT. .005-.010 REMOVE ALL BURRS				ELLIPTICAL BAFFLE CLAMP BRACKET CATCH	
MATERIAL: 300 SERIES STAINLESS STEEL		HEAT TREAT:		FINISH:		A 10N E990107		CONLEY 1-18-99	
NEXT ASSY: D990002						REV		DATE	
DESCRIPTION		DESCRIPTION		ISSUE DESCRIPTION		DRWN		DATE	
REFERENCE DRAWINGS		USED ON				SCALE		DATE	
						D990004-A.dwg		D990004-A	
						SCALE		1 OF 1	

- NOTES: (UNLESS OTHERWISE SPECIFIED)
 △ Ø.190-.203 VENT HOLE. DRILL WHERE SHOWN ON CENTERLINE OF BLIND HOLE.
2. STAMP OR ENGRAVE SERIAL NUMBER ON PART PER LIGO L970196.
 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE.



		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± ANGULAR ±1° HORIZONTAL & VERT ± TWO PLACE DECIMAL ±.03	THREE PLACE DECIMAL ±.003 FINISHED SURFACE RMS NEAR CORNERS TO QTY: .005-.010 REMOVE ALL BURRS					ELLIPTICAL BAFFLE LEFT FRAME MEMBER	
		MATERIAL: 6061-T6 ALUMINUM PER 60-61-250/11 OR ASTM-B209	HEAT TREAT: F15000	A DCH E99007		COMLEY 1-19-99		JOB FILE D99005-A.dwg	
DWG. NO.		DESCRIPTION		REV		DATE		D99005-A	
REFERENCE DRAWINGS		USED DRG		NEXT ASSY: D99002		ISSUE DESCRIPTION		SCALE: NTS	
								1 OF 1	

- NOTES: (UNLESS OTHERWISE SPECIFIED)
1. \triangle \emptyset .190-203 VENT HOLE. DRILL THRU WHERE SHOWN ON CENTERLINE OF BLIND HOLE.
 2. STAMP OR ENGRAVE SERIAL NUMBER ON PART PER LIGO L970196.
 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE.



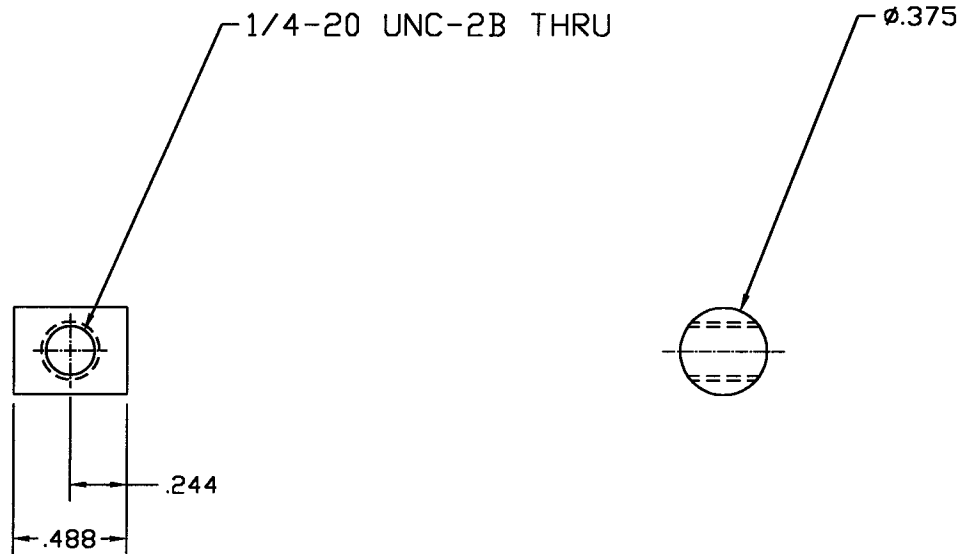
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL .2 ANGULAR .1° HOLE LOC. .005/0.010 TWO PLACE DECIMAL .003	THREE PLACE DECIMAL .005 FINISHED SURFACE RMS BREAK CORNERS .010 (D11) .005-.010 REMOVE ALL BURRS					ELLIPTICAL BAFFLE BOTTOM FRAME MEMBER	
		MATERIAL: 6061-T6 ALUMINUM PER QQ-A-250/11 OR ASTM-B209	HEAT TREAT: T3	FINISH: ANODIZED	A	DCN E99007	CONLEY	1-19-99	REV
DRWG. NO.	DESCRIPTION	USED ON	NEXT ASSY	ISSUE DESCRIPTION	DRWN	DATE	CHECK	DATE	SCALE
	REFERENCE DRAWINGS		ISSY 099002						1 OF 1

REV A B
DESCRIPTION
ISSUE DESCRIPTION
SCALE
1 OF 1

NOTES: (UNLESS OTHERWISE SPECIFIED)

△ MATERIAL: 300 SERIES STAINLESS STEEL

2. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE; SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).

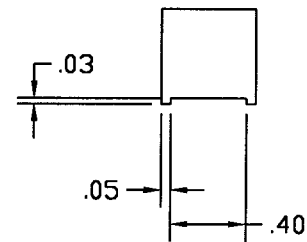
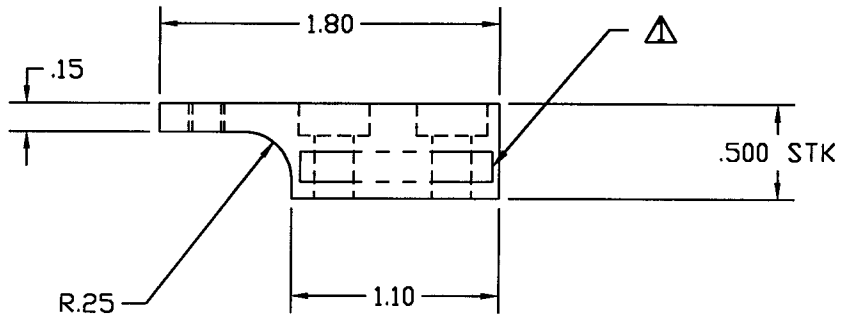
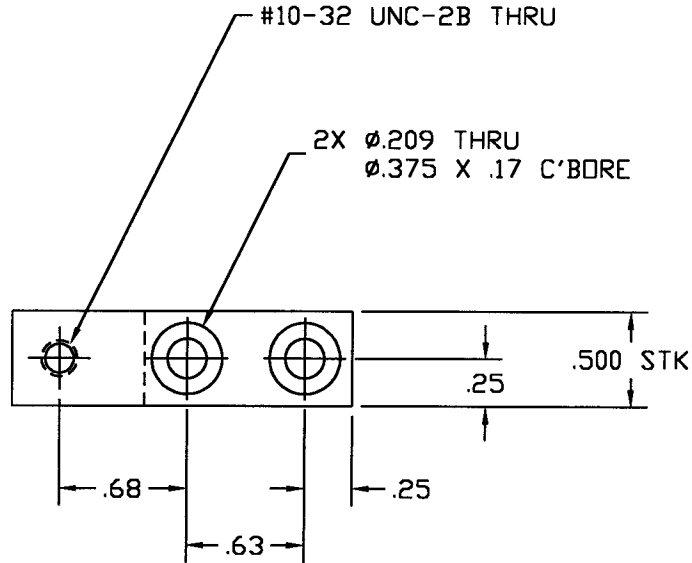


<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p>							<p>MIT CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>			
<p>TOLERANCES: FRACTIONAL ± ANGULAR ± 0.5° ANGULAR/HATCH ± BEND ± TWO PLACE DECIMAL ± .03</p>			<p>THREE PLACE DECIMAL ± .005 FINISHED SURFACE 32 microinch average BREAK CORNERS IN OUT: .005-.010 REMOVE ALL BURRS</p>				<p>ELLIPTICAL BAFFLE SWIVEL NUT</p>			
MATERIAL: △	HEAT TREAT:	FINISH:	A	DCN E990107		C. Conley	1-19-99	CAD FILE	SIZE DWG. NO.	
USED ON:	NEXT ASS'Y: D990002		REV	DESCRIPTION	CHECK	DATE	DRWN	DATE	D990011-A.dwg	
			ISSUE DESCRIPTION				SCALE	NTS	SHEET	1 OF 1

NOTES: (UNLESS OTHERWISE SPECIFIED)

△ STAMP OR ENGRAVE SERIAL NUMBER ON PART PER LIGO L970196.

2. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE.



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±
ANGULAR ± 0.5°
ANGULAR MACH ± BEND ±
TWO PLACE DECIMAL ± .01

THREE PLACE DECIMAL ± .005
FINISHED SURFACE 32 microinch average
BREAK CORNERS IN: DUT. .005-.010
REMOVE ALL BURRS

MATERIAL:
6061-T6 ALUMINUM
.500 SD BAR

HEAT TREAT:

FINISH:

A DCN E990107

C. Conley 3-24-99

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

ELLIPTICAL BAFFLE
LOCATING TAB

CAD FILE
D990012-A.dwg

SIZE DWG. NO.
A D990012-A

USED ON:

NEXT ASS'Y: D990002

ISSUE DESCRIPTION

SCALE
NTS

SHEET
1 OF 1



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

D990014-A

DRWG NO. REV. GID

SHEET 1 OF 1

ASSY NO. D990002

MATERIAL LIST

TITLE

Eliptical LOS Baffle Assembly

APPROVALS:	DATE	REV	DCN NO	BY	CHK	DCC	DATE
DRAWN: C. Conley	1-21-99	A	E990107	C.C.			
CHECKED:							
APPROVED:							
DCC RELEASE:							

REF.	QTY.	PART No.	DESCRIPTION
1	4	D990004	Clamp Bracket Catch
2	4	D990003	Clamp Bracket
3	4	C-2064-NA	1/4-20 UNC-3A X 4.00 Socket Head Cap Screw - 8-18 stainless steel, silver plated (U-C Components special order)
5	4	D990011	Swivel Nut
6	1	D990006	Right Frame Member
7	1	D990005	Left Frame Member
8	1	D990008	Top Frame Member
9	1	D990007	Bottom Frame Member
10	1	D990013	Glass
11	2	D990012	Locating Tab
12	10	C-2410-N	#10-24 UNC-3A X .625 Socket Head Cap Screw - 8-18 stainless steel, (U-C Components)
13	2	92765A999	#10-32 X .50 Oval Head Socket Set Screw - 8-18 stainless steel, (McMaster Carr special order)
14	8	90298A534	Shoulder Screw, .250 shoulder dia X .250 shoulder length, 10-24 UNC-3A X .375 lg. thread - 18-8 stainless steel (McMaster Carr)
15	8	999	1/4 nominal Custom Order Flat Washer - .263 ID, .560 OD, .040 thk, 302-304 stainless steel, annealed & tumbled (Boker's Inc. - Minneapolis)
16	16	9716K77	Curved Disc Spring Washer, .265 ID, .490 OD, .063 relaxed height, .011 thick - 301 stainless steel
17	8	C-610-NA	#6-32 UNC-3A X .625 Socket Head Cap Screw - 8-18 stainless steel, silver plated (U-C Components)