



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

DCN No. E990232-00-D

SHEET 1 OF 2

DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D990356-00	BOTTOM RIGHT PLATE	A
D990357-00	TOP RIGHT PLATE	A
D990358-00	TOP LEFT PLATE	A
D990359-00	MIDDLE RIGHT PLATE	A
D990360-00	BOTTOM LEFT PLATE	A
D990361-00	MIDDLE LEFT PLATE	A
D990362-00	HORIZONTAL EDGE STRIP, TOP & BOTTOM	A
CHANGE DESCRIPTION (FROM/TO): (DOCUMENT LIST CONTINUED)		
D990363-00	SLANT EDGE STRIP, TOP LEFT & BOTTOM RIGHT	A
D990364-00	SLANT EDGE STRIP, TOP RIGHT & BOTTOM LEFT	A
D990365-00	VERTICAL EDGE STRIP, LEFT END	A
D990366-00	VERTICAL EDGE STRIP, RIGHT END	A
D990367-00	VERTICAL ANGLE, BOTTOM LEFT	A
D990368-00	VERTICAL ANGLE, MIDDLE LEFT	A
D990369-00	VERTICAL ANGLE, TOP RIGHT	A
D990370-A	CONNECTOR ANGLE, TOP SIDE	B
D990371-A	CONNECTOR ANGLE, UNDER SIDE	B
D990372-00	VERTICAL ANGLE, BOTTOM RIGHT	A
D990373-00	VERTICAL ANGLE, TOP LEFT	A

REASON FOR CHANGE: INITIAL RELEASE-ARM CAVITY BAFFLE,
 INNER SUPPORT FRAME DETAILS

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)	Barish Coles
<input type="checkbox"/> List S/Ns which comply already:	Coyne Lazzarini Lindquist
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	Raab Sanders Shoemaker
<input checked="" type="checkbox"/> List S/Ns to be built with this change: all, 001 & UP	Stapfer Tyler Weiss
<input type="checkbox"/> List S/Ns to be retested per this change:	Whitcomb Scislowicz
<input type="checkbox"/>	P. Kabot M. Smith
<input type="checkbox"/>	B. Weaver K. Mailand
<input type="checkbox"/>	J. Camp L. Jones
<input type="checkbox"/>	J. Kern

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (If yes, enter Change Request number)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: P.Kabot	11/29/99		
TASK LEADER: M. Smith <i>ms</i>	12/7/99		
GROUP LEADER: D. Coyne <i>D. Coyne</i>	1/4/00		
DCC RELEASE: L. Turner <i>L. Turner</i>	1-24-00		



DOCUMENT CHANGE NOTICE

CHANGE DESCRIPTION (FROM/TO):

(DOCUMENT LIST CONTINUED)

DOCUMENT NO.	TITLE	NEW REV
D990374-A	SPLICE CLIP, FLAT ANGLE	B
D990375-00	SPLICE CLIP, CORNER ANGLE	A
D990376-00	HORIZONTAL ANGLE, TOP LEFT & BOTTOM RIGHT	A
D990377-00	HORIZONTAL ANGLE, TOP RIGHT & BOTTOM LEFT	A
D990378-00	VERTICAL ANGLE, MIDDLE RIGHT	A
D990379-00	CONNECTOR PLATE	A



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D990356-00	BOTTOM RIGHT PLATE	A
D990357-00	TOP RIGHT PLATE	A
D990358-00	TOP LEFT PLATE	A
D990359-00	MIDDLE RIGHT PLATE	A
D990360-00	BOTTOM LEFT PLATE	A
D990361-00	MIDDLE LEFT PLATE	A
D990362-00	HORIZONTAL EDGE STRIP, TOP & BOTTOM	A
CHANGE DESCRIPTION (FROM/TO): (DOCUMENT LIST CONTINUED)		
D990363-00	SLANT EDGE STRIP, TOP LEFT & BOTTOM RIGHT	A
D990364-00	SLANT EDGE STRIP, TOP RIGHT & BOTTOM LEFT	A
D990365-00	VERTICAL EDGE STRIP, LEFT END	A
D990366-00	VERTICAL EDGE STRIP, RIGHT END	A
D990367-00	VERTICAL ANGLE, BOTTOM LEFT	A
D990368-00	VERTICAL ANGLE, MIDDLE LEFT	A
D990369-00	VERTICAL ANGLE, TOP RIGHT	A
D990370-A	CONNECTOR ANGLE, TOP SIDE	B
D990371-A	CONNECTOR ANGLE, UNDER SIDE	B
D990372-00	VERTICAL ANGLE, BOTTOM RIGHT	A
D990373-00	VERTICAL ANGLE, TOP LEFT	A

REASON FOR CHANGE: INITIAL RELEASE-ARM CAVITY BAFFLE,
 INNER SUPPORT FRAME DETAILS

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)	Althouse Barish Coles
<input type="checkbox"/> List S/Ns which comply already:	Coyne Lazzarini Lindquist
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	Sanders Shoemaker Stafter
<input checked="" type="checkbox"/> List S/Ns to be built with this change: all, 001 & UP	Tyler Weiss Whitcomb
<input type="checkbox"/> List S/Ns to be retested per this change:	Camp Smith
<input type="checkbox"/>	Mailand Conley
<input type="checkbox"/>	Romic
<input type="checkbox"/>	
<input type="checkbox"/>	

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (If yes, enter Change Request number)

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>J. Sullivan</i>	11-2-99		

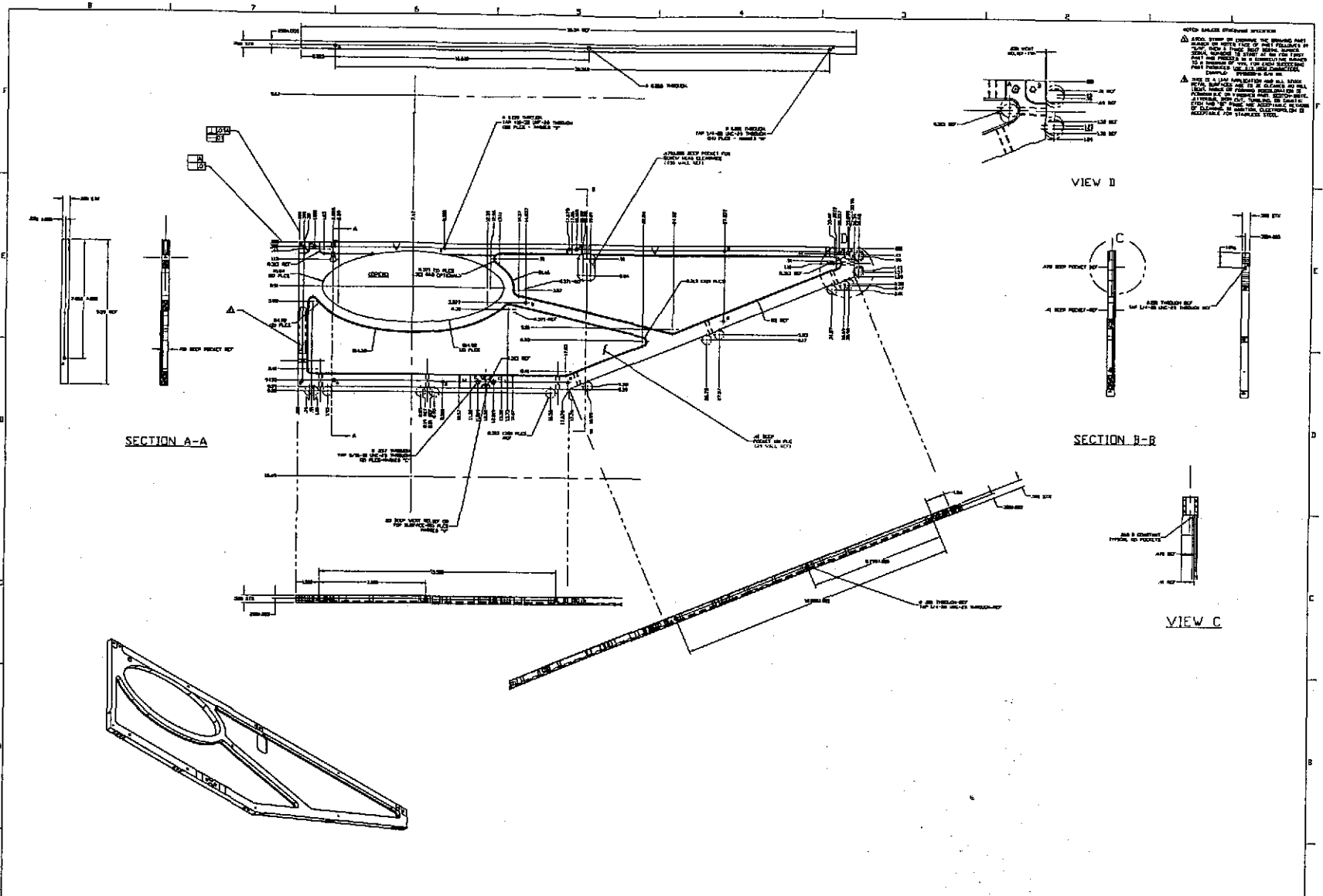


DOCUMENT CHANGE NOTICE

CHANGE DESCRIPTION (FROM/TO):

(DOCUMENT LIST CONTINUED)

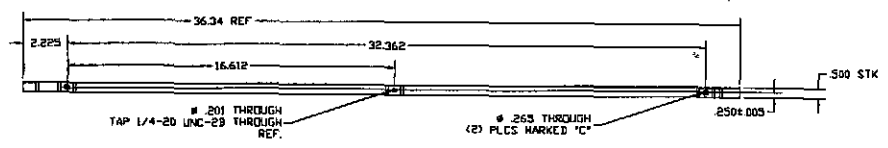
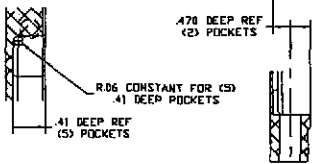
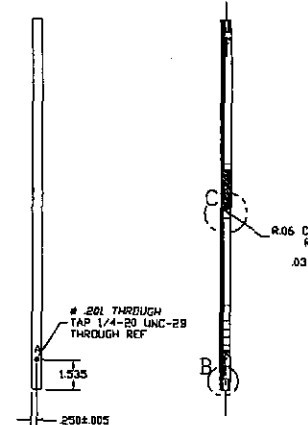
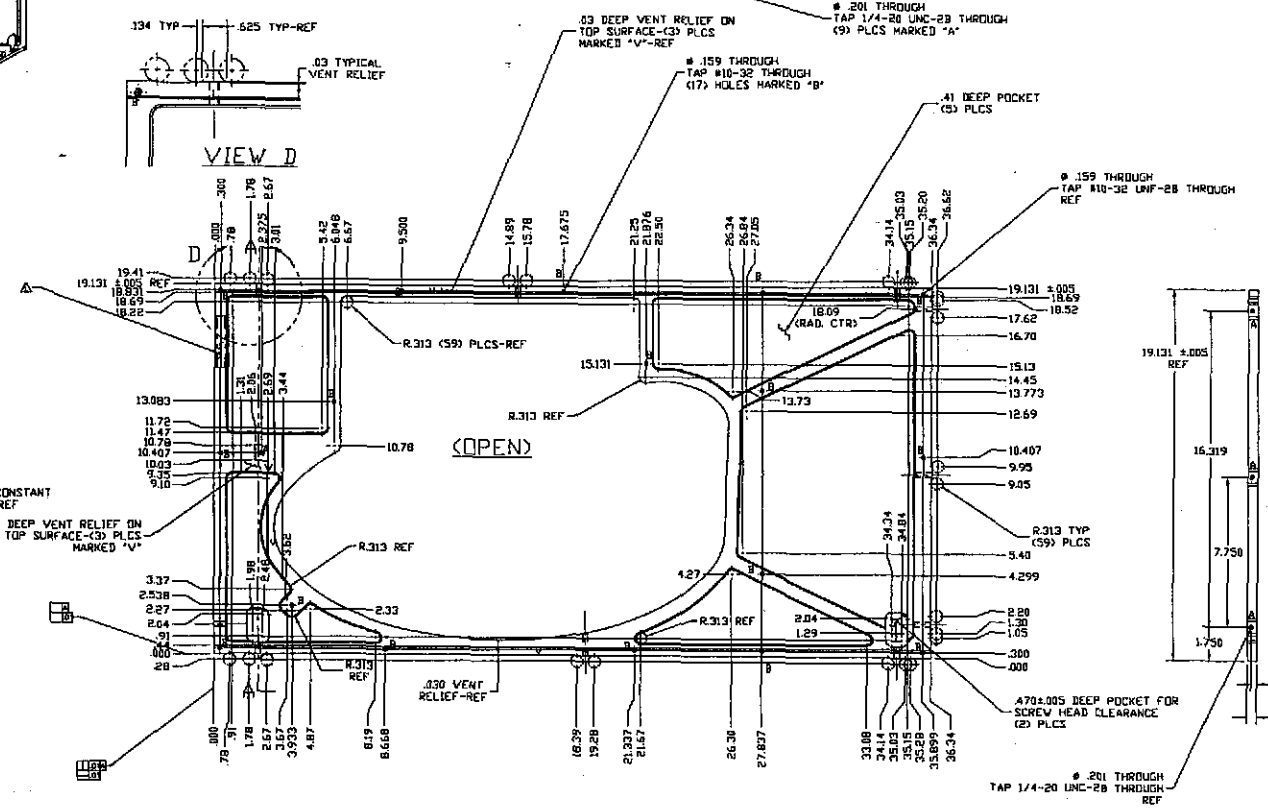
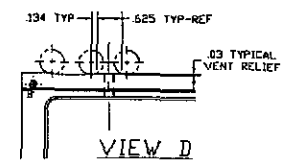
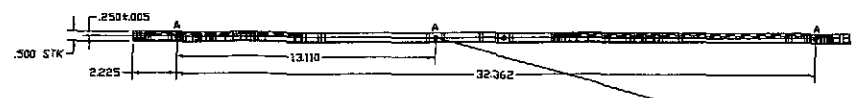
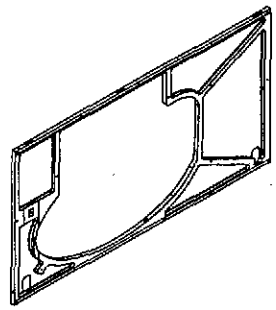
DOCUMENT NO.	TITLE	NEW REV
D990374-A	SPLICE CLIP, FLAT ANGLE	B
D990375-00	SPLICE CLIP, CORNER ANGLE	A
D990376-00	HORIZONTAL ANGLE, TOP LEFT & BOTTOM RIGHT	A
D990377-00	HORIZONTAL ANGLE, TOP RIGHT & BOTTOM LEFT	A
D990378-00	VERTICAL ANGLE, MIDDLE RIGHT	A
D990379-00	CONNECTOR PLATE	A



NOTE: DIMENSIONS SHOWN UNLESS OTHERWISE SPECIFIED ARE IN INCHES (FRACTIONS).
 1. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 2. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 3. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 4. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 5. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 6. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 7. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.
 8. ALL DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.

TOLERANCES: FRACTIONS 1/16" - 3/64" DECIMALS 0.005" - 0.015" HOLE DIA. 0.015" - 0.030" THREE PLACE DECIMAL 0.005"		FINISHES: UNFINISHED SURFACE AND BORE SURFACES UNLESS OTHERWISE SPECIFIED REMOVE ALL BURRS		MATERIAL: 2024-T3 ALUMINUM CAST TOOLING PLATE		HEAT TREAT: T3		FINISH: NONE		RELEASE DESCRIPTION C990232 DCN NUMBER APPROV CHECK DRAWN DATE 6-7-99		100 (continued sheets of this drawing) ARMS CAVITY BAFFLE, GLASS SUPPORT, BOTTOM RIGHT PLATE Dwg No. 8990356-A Scale 1/1" = 1"	
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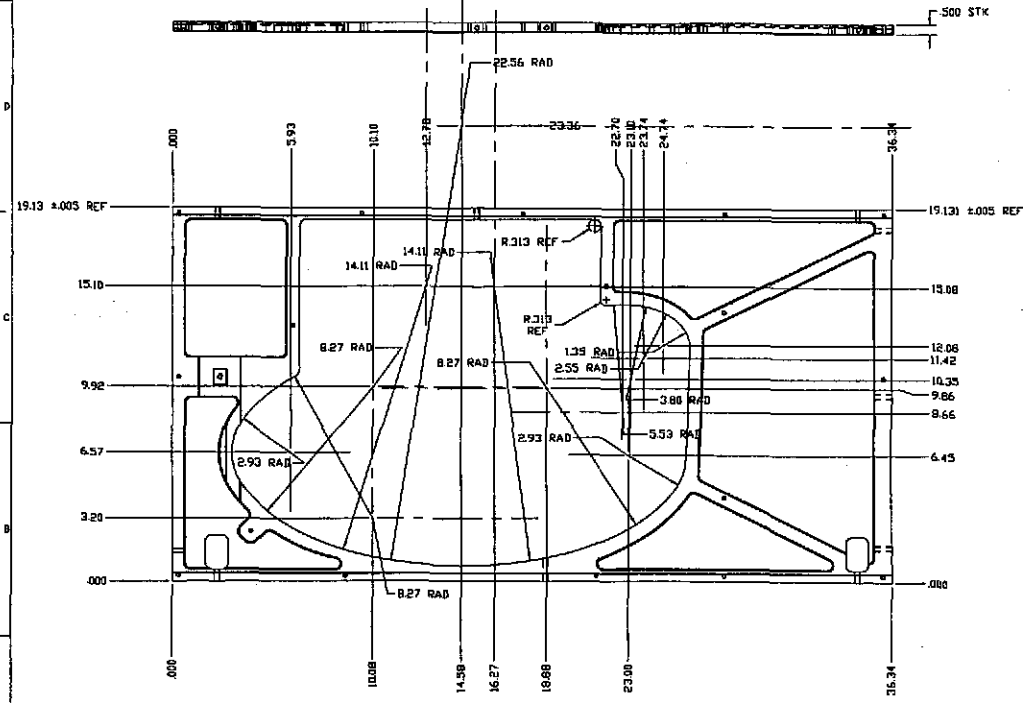
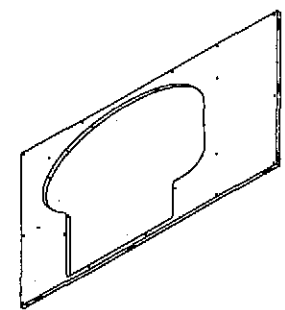
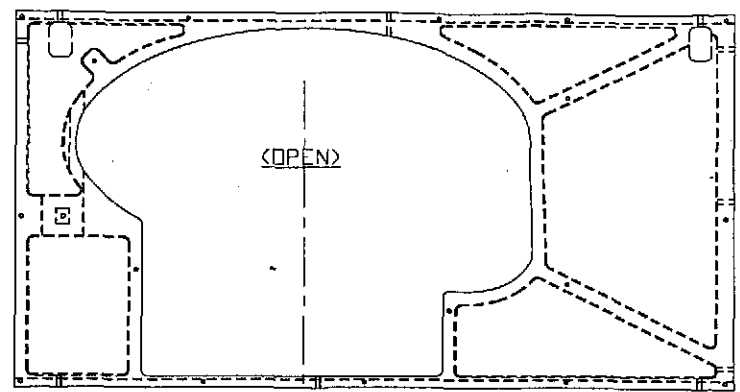
NOTES: (1) THIS DRAWING IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. (2) THE COMPANY ASSUMES NO LIABILITY FOR DAMAGES OF ANY KIND, INCLUDING CONSEQUENTIAL DAMAGES, ARISING FROM THE USE OF THIS DRAWING. (3) THE COMPANY ASSUMES NO LIABILITY FOR DAMAGES OF ANY KIND, INCLUDING CONSEQUENTIAL DAMAGES, ARISING FROM THE USE OF THIS DRAWING.



TOLERANCES:		UNLESS OTHERWISE SPECIFIED		RELEASE		DATE		SCALE	
FRACTIONAL: 1/64		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		EPROG22		6-15-99		1:1	
DECIMAL: 0.005		HOLE: H9/D9		KARDIT		6-15-99		1:1	
HOLE: H9/D9		HOLE: H9/D9		KARDIT		6-15-99		1:1	
HOLE: H9/D9		HOLE: H9/D9		KARDIT		6-15-99		1:1	
ENG. NO.	DESCRIPTION	DATE	REV.	DESCRIPTION	ISSUE DESCRIPTION	APP'D	CHECK	DATE	SCALE
	ARM CAVITY Baffle, Glass Support, Middle Right Plate								

ARM CAVITY Baffle, Glass Support, Middle Right Plate
 19900359-A

WITH APPROVED PROCESS
 THIS DRAWING IS TO BE USED FOR THE PURPOSES OF
 IDENTIFICATION ONLY. IT IS NOT TO BE USED FOR
 CONSTRUCTION OR REPAIR OF THE ORIGINAL
 PART. THE USER SHALL BE RESPONSIBLE FOR
 VERIFYING THE DIMENSIONS AND TOLERANCES
 OF THE PART AS SHOWN ON THIS DRAWING.
 THIS DRAWING IS THE PROPERTY OF THE
 GOVERNMENT AND IS NOT TO BE REPRODUCED
 OR TRANSMITTED IN ANY FORM OR BY ANY
 MEANS, ELECTRONIC OR MECHANICAL, INCLUDING
 PHOTOCOPYING, RECORDING, OR BY ANY
 INFORMATION STORAGE AND RETRIEVAL SYSTEM.
 WITHOUT PERMISSION IN WRITING FROM THE
 GOVERNMENT.

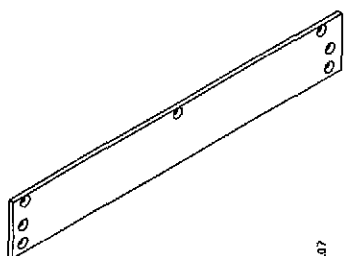


TELEPHONE: _____ FUNCTIONAL: _____ MATERIAL: _____ TWO PLACE DECIMAL, 1/8 THREE PLACE DECIMAL, 1/32		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES ±.010		DIVIDED PARTS AS FINISHED SURFACE AND BREAK OUTSIDE CORNERS .015 - .015 REMOVE ALL BURRS		PARTIAL: _____ 300 THICK ALUMINUM CAST TOOLING PLATE		HEAT TREAT: _____ FINISH: _____		RELEASE REV: _____		DESCRIPTION C990232		APPR: _____ CHECK: _____ DRAWN: _____ DATE: 4-17-99		QTY PER ORDER: _____ UNIT: _____ PART NO: D990359-A	
DWS NO: _____ REFERENCE DRAWINGS: _____		UNITS IN: _____ NEXT ASSEMBLY APPROVAL APPROVED: _____		ISSUE DESCRIPTION: _____		REV: _____		DESCRIPTION: _____		ISSUE DESCRIPTION: _____		APPR: _____ CHECK: _____ DRAWN: _____ DATE: _____		QTY PER ORDER: _____ UNIT: _____ PART NO: D990359-A			

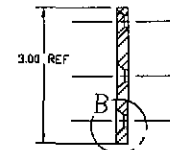
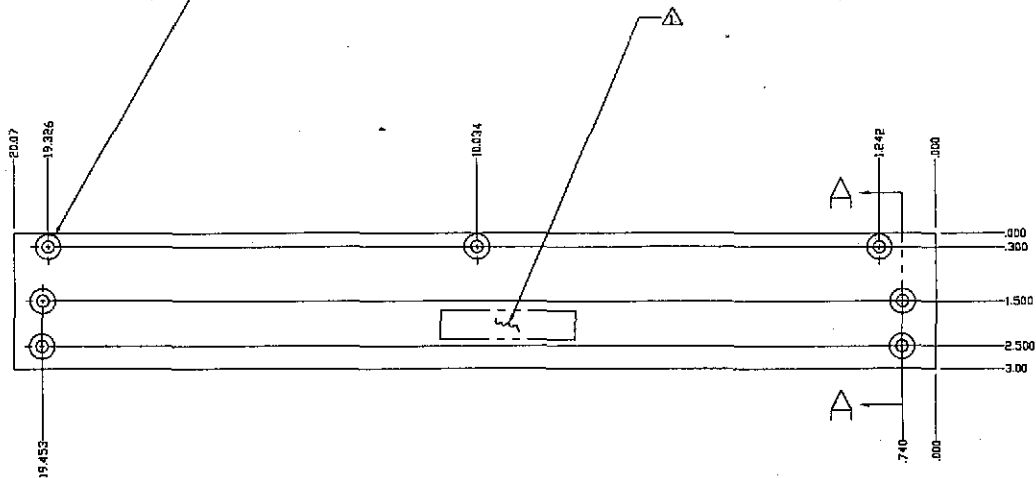
NOTES UNLESS OTHERWISE SPECIFIED

△ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "S/P", 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 SUCCESSING PART PRODUCED. USE ALL NUMERICAL CHARACTERS. EXAMPLE: 790030-A 001 S/P

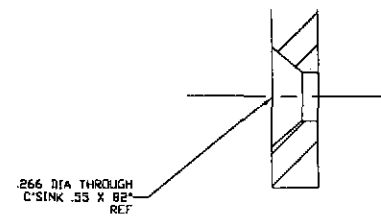
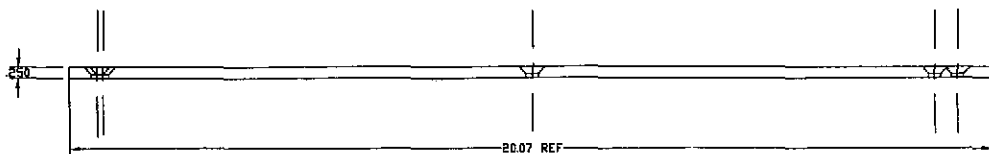
△ THIS IS A LOW APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED AND MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR ELASTIC ETCH AND 10% RISE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



Ø .266 THROUGH
CSINK Ø .55 X .82"
(7) PLCS



SECTION A-A



VIEW B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (IN)		TOLERANCES: FRACTIONAL ± 1/64 ANGULAR ± 1/2° TWO PLACE DECIMAL ± .02 THREE PLACE DECIMAL ± .002		INSIDE RADIUS .06 FINISHED SURFACE RMS BREAK OUTSIDE CORNERS .005 - .015 REMOVE ALL BURRS		MATERIAL: TYPE 6061-T6 ALUMINUM BAR 1/4 X 3/8		HEAT TREAT: T6		FINISH: △ △		RELEASE: C99032		HABOT: 7-1-99		SND FILE: BDR_PLT3.dwg		DRAWING NO: D990364-A	
DWG NO:	DESCRIPTION	USED ON:	REFERENCE DRAWINGS	NEXT ASSY: D990341, D990350	ISSUE DESCRIPTION	APPR'D:	CHECK:	DATE:	SCALE:	NTS	SHEET:	1	OF 1						

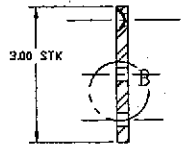
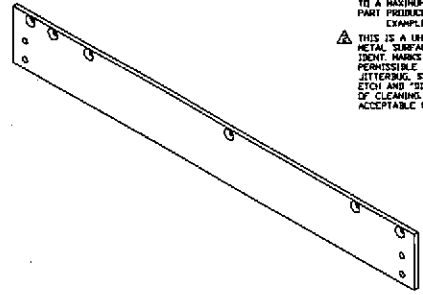
UCR CALIFORNIA INSTITUTE OF TECHNOLOGY
RANDOLPHSITE WEST OF TECHNOLOGY

ARM CAVITY BAFFLE,
GLASS SUPPORT
SLANT EDGE STRIP
TOP RIGHT & BOTTOM LEFT

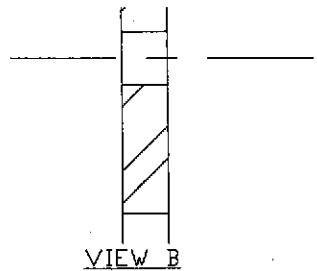
NOTES UNLESS OTHERWISE SPECIFIED

△ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON HATED 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 PRODUCE IN THE HIGH CHARACTER. EXAMPLE: D99038-A S/N 001

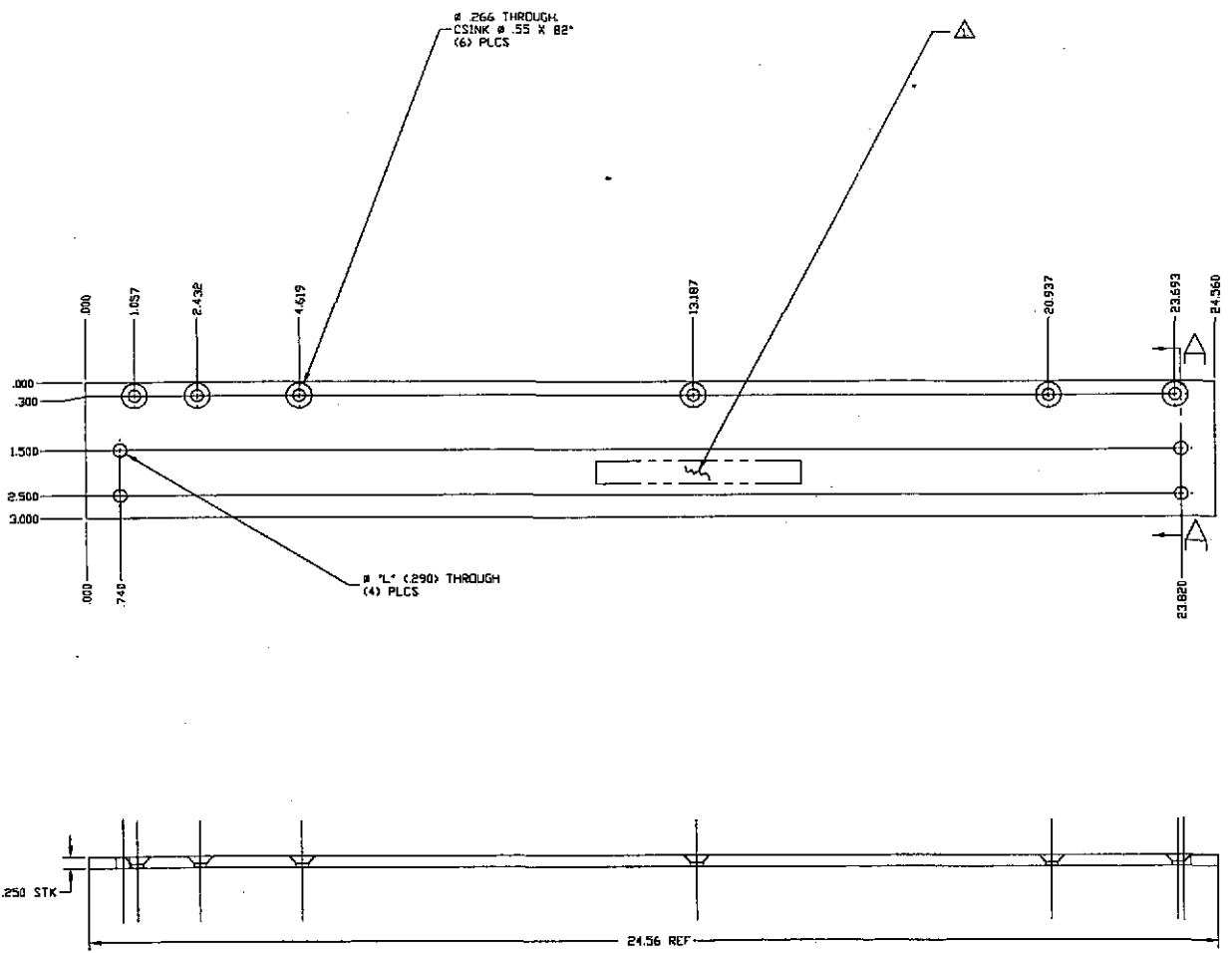
△ THIS IS A URV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED AND MILL FRONT MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, LETTERING, SWIN CUT, TIMING, OR CAUSTIC ETCH AND "SI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTRO-POLISH IS ACCEPTABLE FOR STAINLESS STEEL.



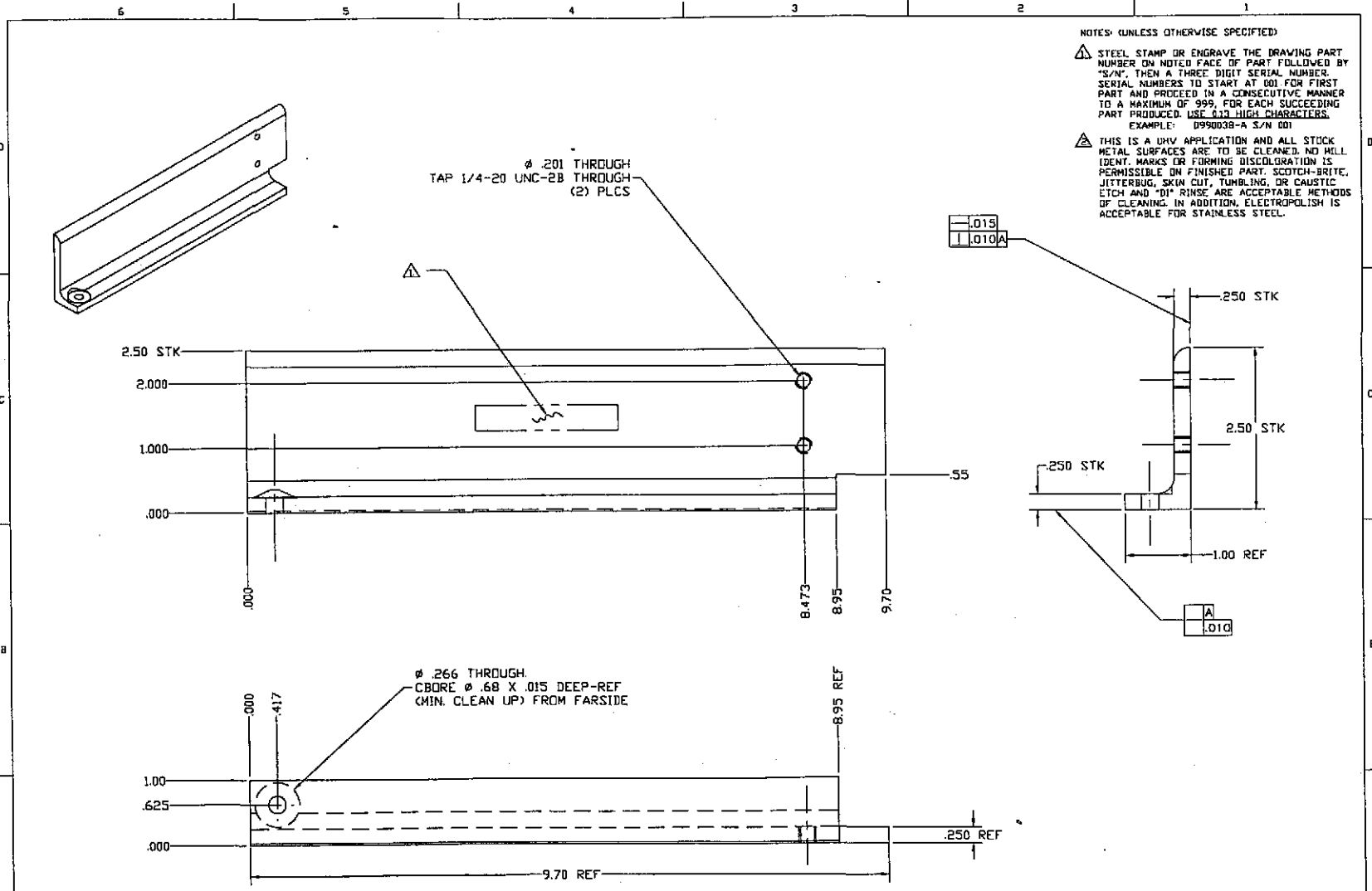
SECTION A-A



VIEW B



		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (IN)								LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± 1/64 ANGULAR ± 1/2° TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL .003		INSIDE RADIUS .06 FINISHED SURFACE RMS MAXIAL OUTSIDE CORNERS .005 - .015 REMOVE ALL BURS						ARM CAVITY BAFFLE, GLASS SUPPORT VERTICAL EDGE STRIP, RIGHT END	
		MATERIAL: TYPE 6061-T6 ALUMINUM BAR 1/4 X 3		HEAT TREAT:		FINISH:		A		RELEASE	
		USED ON:		NEXT ASSY: D990241, D990250		E990232		KABOT		7-1-99	
DWG NO.		DESCRIPTION		ISSUE DESCRIPTION		DCN NUMBER		APPR'S		CHECK	
REFERENCE DRAWINGS								DATE		SCALE	
								DRWN		DATE	
								NTE		D990356-A	
								SHEET		1 OF 1	

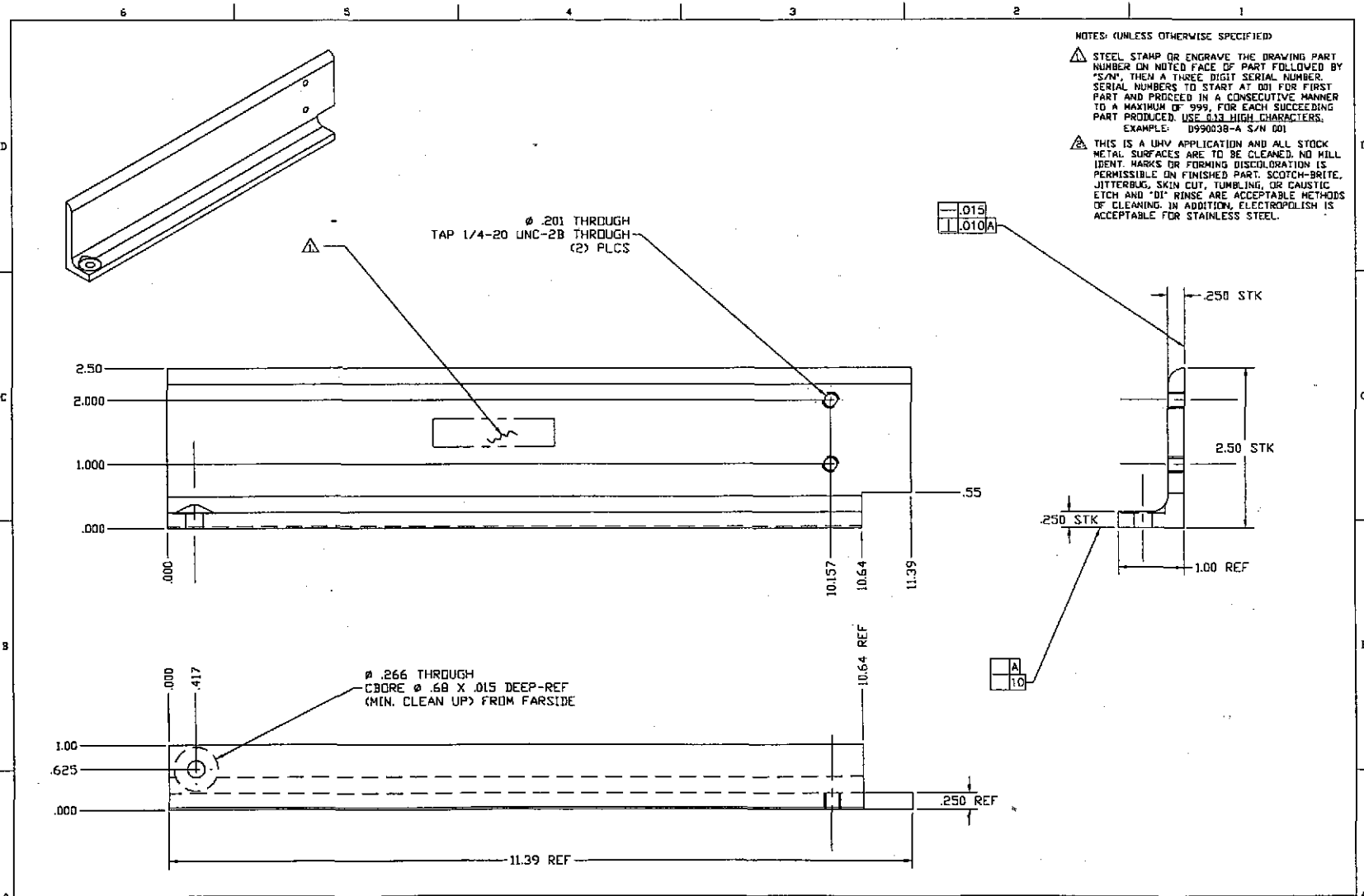


NOTES: (UNLESS OTHERWISE SPECIFIED)

⚠ 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 010 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 "D" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.

		UNLESS OTHERWISE SPECIFIED INCLUDES ARE OF SOURCE ONLY								LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONS: ± 1/64 DECIMALS: ± 1/100 TWO PLACE DECIMALS: AS SHOWN THREE PLACE DECIMALS: AS SHOWN	FINISH: MILL FINISH UNLESS OTHERWISE SPECIFIED POLISH: EXCEPT WHERE SHOWN OTHERWISE							ARM CAVITY BAFFLE, GLASS SUPPORT, VERTICAL ANGLE, BOTTOM LEFT (1/4"-7/8" ETM)	
		MATERIAL: TYPE 304-16 ALUMINUM ANGLE 2 1/8" x 2 1/8" x 1/4"	HEAT TREAT:	FINISH: ⚠	REV: A	RELEASE:	0990038	-	-	KARDT	7-6-99
DWG. NO.		DESCRIPTION	USED ON	NEXT ASSY: D990039	DESCRIPTION	ISSUE DESCRIPTION	APP'D	CHECK	DOWN	DATE	SCALE
REFERENCE DRAWINGS											D99 FILE L-9-84028g D990367-A 1 OF 1



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		RELEASE C990038		DATE 7-6-99		SCALE NFS		SHEET NO. C		PART NO. D990369-A	
MATERIAL: TYPE 304-SS ALUMINUM BRASS 2 PLCS @ 2 1/2" X 1/4"		HEAT TREAT: FINISH		APPROV'D CHECK DRWN		DATE		SCALE		SHEET	
EVS. NO.		DESCRIPTION		ISSUE DESCRIPTION		DATE		SCALE		SHEET	
REFERENCE DRAWINGS		NEXT ASSY: D990341		ISSUE DESCRIPTION		DATE		SCALE		SHEET	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MARCUSGRAFTS INSTITUTE OF TECHNOLOGY

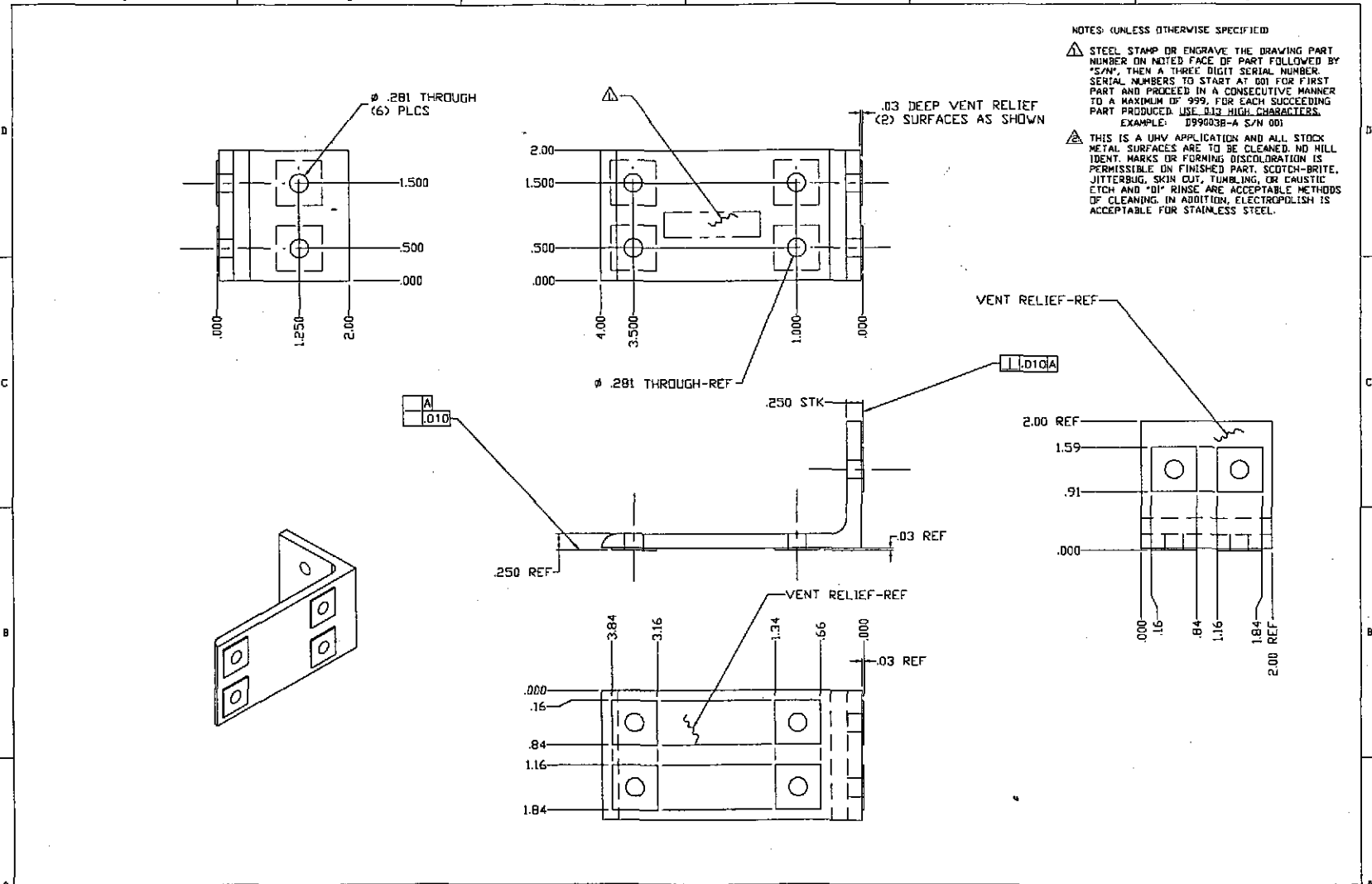
ARM CAVITY BAFFLE,
GLASS SUPPORT,
VERTICAL ANGLE,
TOP RIGHT (1TH-X)

6 5 4 3 2 1

D
C
B
A

D
C
B
A

6 5 4 3 2 1



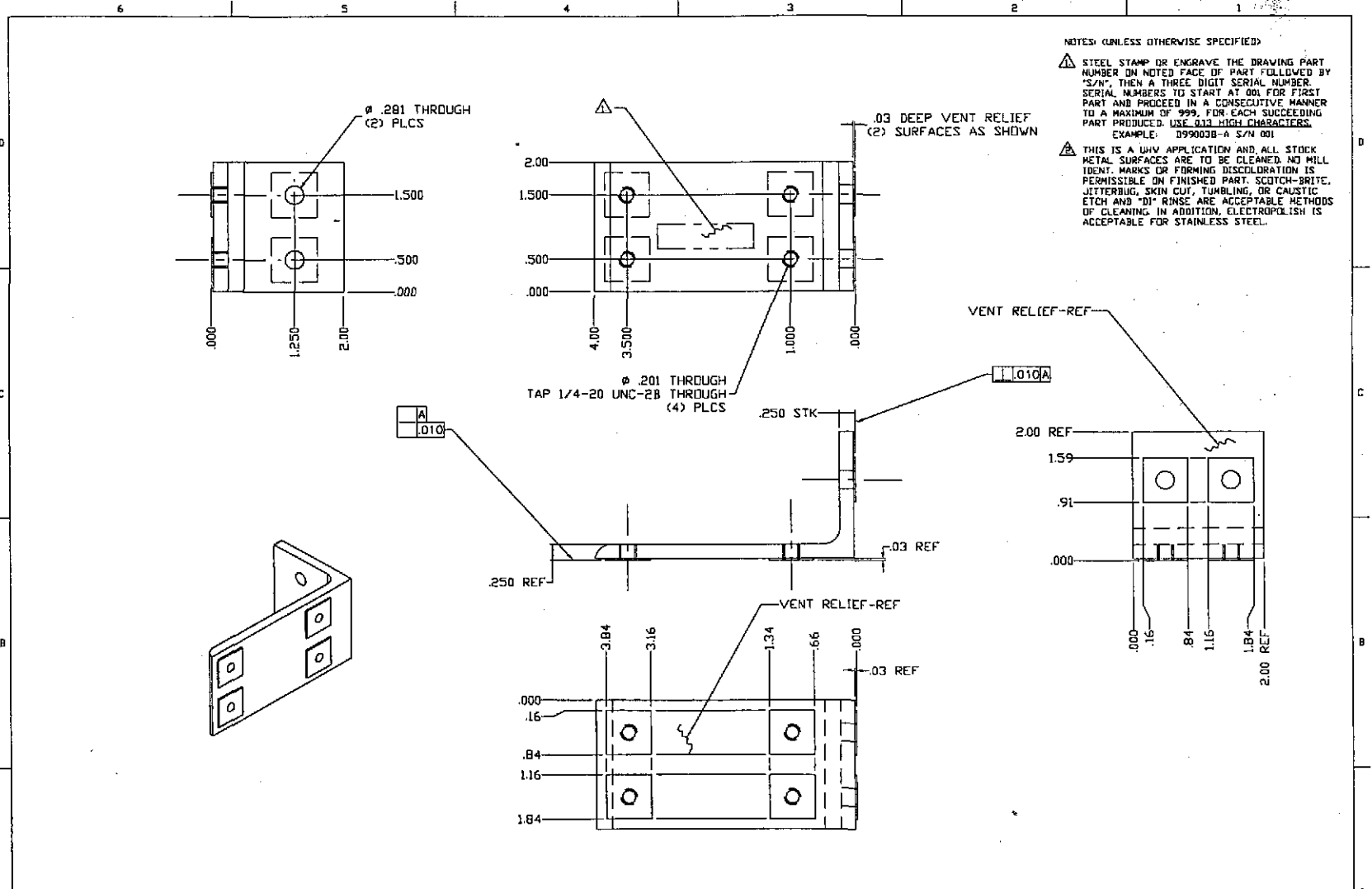
NOTES: (UNLESS OTHERWISE SPECIFIED)

▲ 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 012 HIGH CHARACTERS. EXAMPLE: D990370-A S/N 001

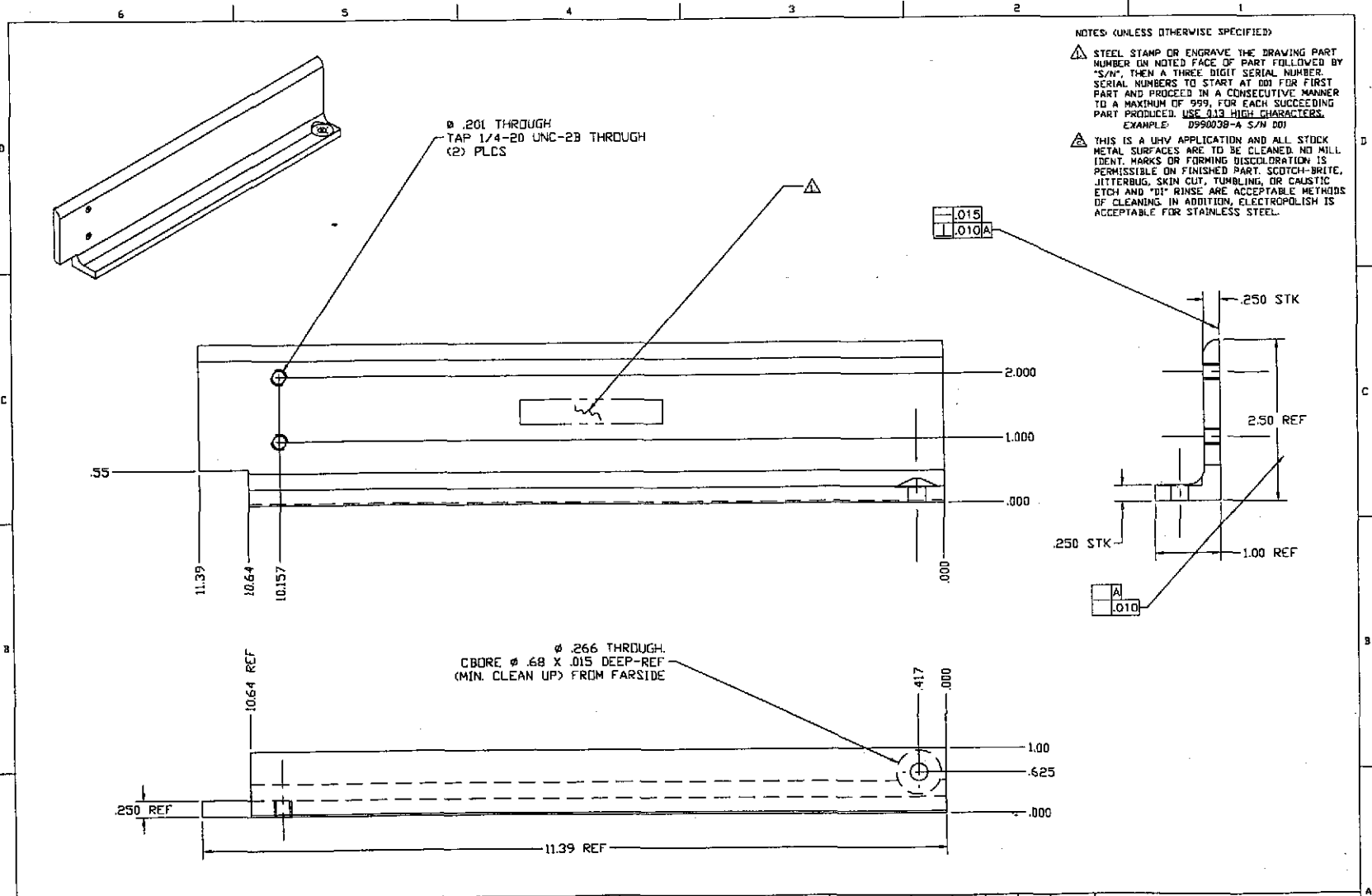
▲ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN OUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTRO-POLISH IS ACCEPTABLE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

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN FEET (INCH)								<small>100% CONTROL METHOD OF VERIFICATION UNLESS OTHERWISE SPECIFIED BY OTHERS</small> ARM CAVITY BAFFLE, GLASS SUPPORT CONNECTOR ANGLE, TOP SIDE	
		TELEMARKED FUNCTIONAL #	THREE PLACE DECIMAL #							<small>REV</small> <small>DATE</small>	
		ASSEMBLY #	THICKNESS SURFACES AND THICK CHARACTERS TO REMOVE ALL BURRS							<small>REV</small> <small>DATE</small>	
		VIEW PLACE DECIMAL #	REMOVE ALL BURRS							<small>REV</small> <small>DATE</small>	
		MATERIAL TYPE 6061-T6	HEAT TREAT: H14	FINISH: ▲ ▲						<small>REV</small> <small>DATE</small>	
		ALUMINUM W/STAIN H = 2.0 ± 0.12								<small>REV</small> <small>DATE</small>	
Dwg. No.		DESCRIPTION		NEXT ASSY: D990341, D990350		ISSUE DESCRIPTION		SCALE		<small>REV</small> <small>DATE</small>	
REFERENCE DRAWINGS		USED ON:						<small>REV</small> <small>DATE</small>		<small>REV</small> <small>DATE</small>	

SCALE: NTS
 SHEET: 1 OF 1
 Dwg. No. D990370-B



		DIMENSIONS OTHERWISE SPECIFIED (DIMENSIONS ARE IN FEET (IN))										UCD (UNLESS OTHERWISE SPECIFIED) CAPABILITIES: 8000 PSI STRESS ARM CAVITY BAFFLE, GLASS SUPPORT, CONNECTOR ANGLE, UNDER SIDE	
		TELEVISIONS FRONT VIEW: 1 ANGULAR: 2 REAR VIEW: 3 SIDE VIEW: 4	THREE PLACE DECIMAL FRACTION SURFACE AND BASIC DIMENSIONS SHOWN INDICATE ALL DIMS									Dwg File # 0990371-B Rev # 0 Date 0990371-B	
		MATERIAL: TYPE 304-16 ALUMINUM ANGLE 1/2 x 3/4 x 1/8	HEAT TREAT:	FINISH: ▲ ▲								SCALE: NTS SHEET: 1 OF 1	
Dwg. No.		DESCRIPTION		NEXT ASSY: 0990341, 0990350		REV		DESCRIPTION		REV NUMBER		ISSUE DESCRIPTION	
REFERENCE DRAWINGS						B		RELEASE		0990332		KANT 10-13-99	
						A		PRE-RELEASE				KANT 4-20-98	

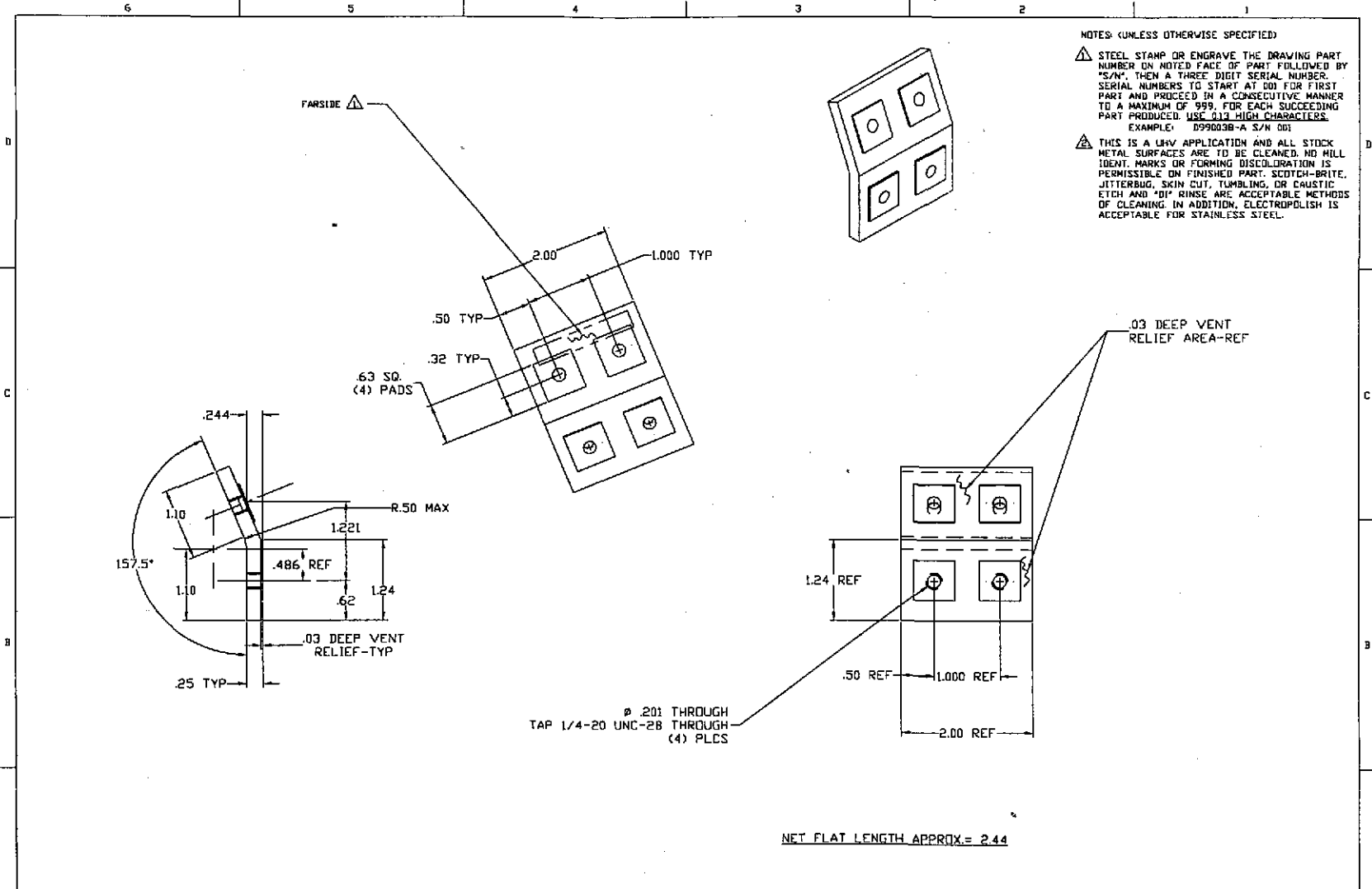


NOTES: (UNLESS OTHERWISE SPECIFIED)

⚠ 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: D9900373-A S/N 001

⚠ THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED AND 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 EXPRESSIONS ARE IN DIMENSIONS UNLESS OTHERWISE NOTED				UCR CALIFORNIA INSTITUTE OF TECHNOLOGY MASONIC AVENUE INSTITUTE OF TECHNOLOGY	
		TELEPHONE: (714) 948-5000	DATE: 7-7-99			ARM CAVITY BAFFLE, GLASS SUPPORT, VERTICAL ANGLE, TOP LEFT (ITH-Y/ETM)	
		FRACTIONAL: 1/32"	DRAWN: J. W. HARRIS			DWG NO: D990373-A	
		DECIMAL: .001"	FINISH: 32			REV: C	
		THREE PLACE DECIMAL: .001"	REMOVE ALL BURRS			DATE: 7-7-99	
		MATERIAL: 6061-T6 ALUMINUM	HEAT TREAT: T6			ISSUE DESCRIPTION: RELEASE	
		FINISH: 32	REMOVE ALL BURRS			DCN NUMBER: E990373	
		MATERIAL: 6061-T6 ALUMINUM	HEAT TREAT: T6			APPR'D: [Signature]	
		FINISH: 32	REMOVE ALL BURRS			CHECK: [Signature]	
		MATERIAL: 6061-T6 ALUMINUM	HEAT TREAT: T6			DRWN: [Signature]	
		FINISH: 32	REMOVE ALL BURRS			DATE: 7-7-99	
		MATERIAL: 6061-T6 ALUMINUM	HEAT TREAT: T6			DATE: 7-7-99	
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		FINISH: 32	REMOVE ALL BURRS			DATE: 7-7-99	
		MATERIAL: 6061-T6 ALUMINUM	HEAT TREAT: T6			DATE: 7-7-99	
		FINISH: 32	REMOVE ALL BURRS			DATE: 7-7-99	
		MATERIAL: 6061-T6 ALUMINUM					



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 0.12 HIGH CHARACTERS. EXAMPLE: D990338-A S/N 001

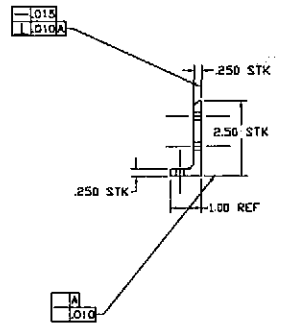
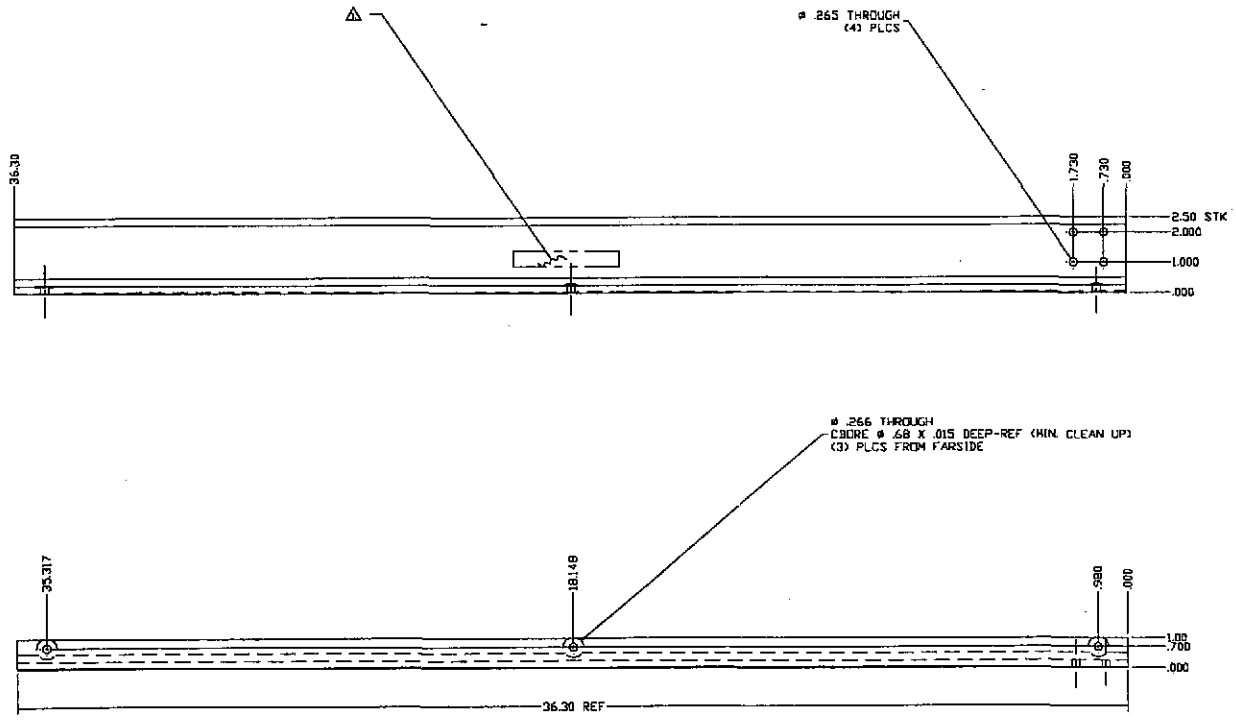
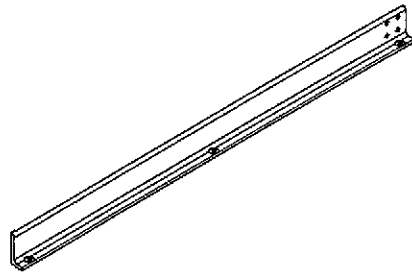
⚠ THIS IS A LHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE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

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNO								LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± 1/16 ANGULAR ± 1/2° TWO PLACE DECIMAL .005 THREE PLACE DECIMAL .0005		HOLE SIZE ± .005 FINISHED SURFACE UNO BREAK OUTLINE DIMENSIONS .005 - .010 REMOVE ALL BARRS						ARM CAVITY BAFFLE, GLASS SUPPORT, SPLICE CLIP, FLAT ANGLE	
		MATERIAL: TYPE 304/316 ALUMINUM BAR 1/2" x 2"		HEAT TREAT:		FINISH: ⚠ ⚠				CAR FILE 04.dwg SIZE: 3.00 x 4.00 C D9903374-B	
DWG. NO.		DESCRIPTION		NEXT ASSY: D990341, D990350		ISSUE DESCRIPTION		DATE		SHEET 1 OF 1	
REFERENCE DRAWINGS		USED ON									

NOTES: UNLESS OTHERWISE SPECIFIED

△ STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY "SPV" TAKEN 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 PRODUCE USE 010 SERIAL NUMBERS. EXAMPLE: 0990020-A SPV 001

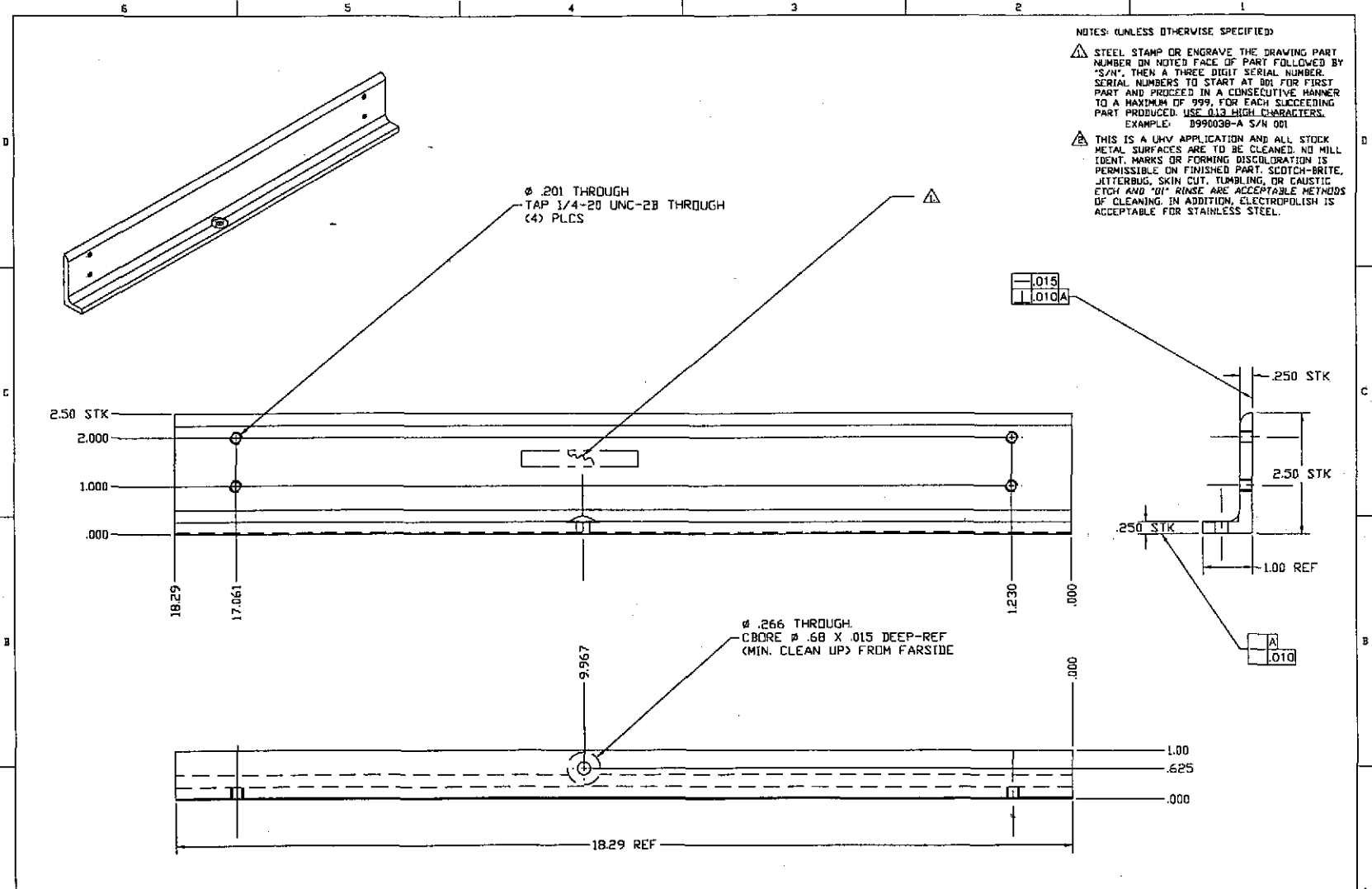
△ THIS IS A LFV APPLICATION AND ALL STEEL METAL SURFACES ARE TO BE CLEANED AND ALL LIGHT MARKS ON FORMING DISCRETION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, HUMBING, OR CAUSTIC ETCH AND "D" RISE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (IN)		TOLERANCES: FRACTIONAL: ± 1/64 ANGULAR: ± 1/2° TWO PLACE DECIMAL: ± .01 THREE PLACE DECIMAL: ± .003		INSIDE RADIUS AS FINISHED SURFACE RNS BREAK OUTSIDE CORNERS .005 ± .015 REMOVE ALL BURRS		MATERIAL: TYPE 6061-T6 ALUMINUM ANGLE 2 1/2 x 2 1/2 x 1/4		HEAT TREAT:		FINISH: △ △		A		RELEASE		E990232		KABOF		7-9-99		CAB FILE		L48 Job		REV: II		D990377-A	
REFERENCE DRAWINGS		USED IN:		NEXT ASSY: 0990341, 090333								REV		DESCRIPTION		ISSUE DESCRIPTION		APPR'D		CHECK		DRWN		DATE		SCALE		SHEET 1 OF 1	

MIT CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

ARM CAVITY Baffle,
GLASS SUPPORT
HORIZONTAL ANGLE
TOP RIGHT & BOTTOM LEFT



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 BUILT CHARACTERS.
EXAMPLE: D99003B-A S/N 001

⚠ THIS IS A UNV 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 "UP" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.

Ø .201 THROUGH
TAP 1/4-20 UNC-2B THROUGH
(4) PLCS

Ø .266 THROUGH
CBORE Ø .68 X .015 DEEP-REF
(MIN. CLEAN UP) FROM FAR SIDE

015
1010A

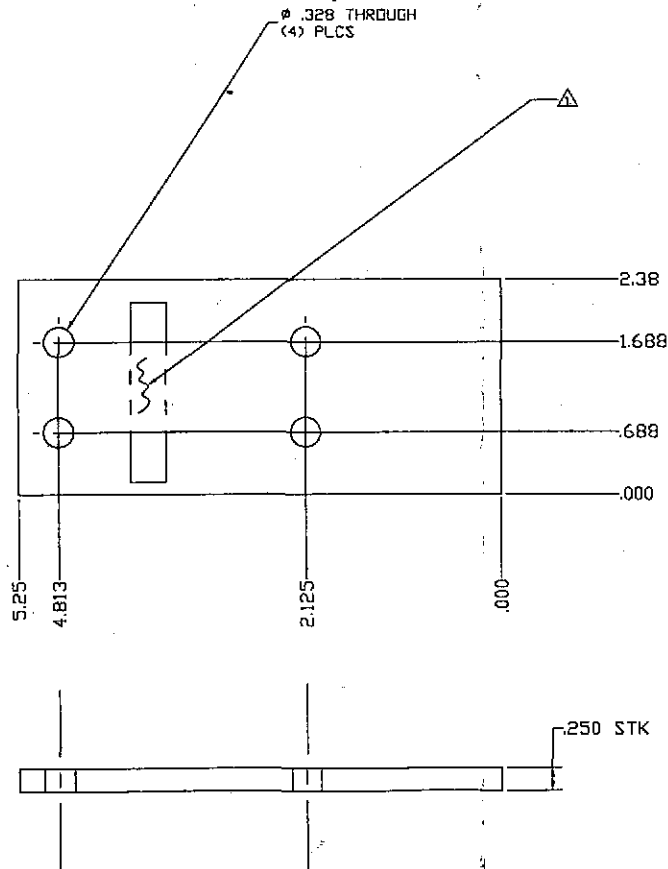
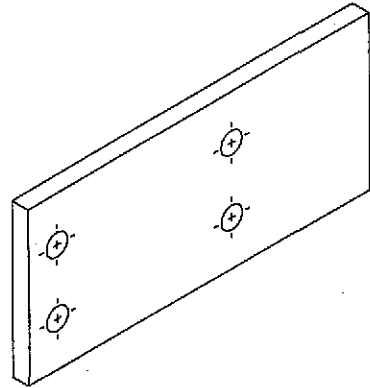
A
010

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (mm)						CALIFORNIA INSTITUTE OF TECHNOLOGY HADDONSBETHA INSTITUTE OF TECHNOLOGY	
		FINISHES: FRACTIONS: 1/64 DECIMALS: 0.0005 TWO PLACE DECIMALS: AS THREE PLACE DECIMALS: AS	SMOOTH AS SHOWN FINISH SURFACE RING BREAK OUTSIDE CORNERS 0.05 - 0.10 REMOVE ALL BURRS				ARM CAVITY BAFFLE, GLASS SUPPORT, VERTICAL ANGLE, MIDDLE RIGHT (ITM-X)		
		MATERIAL: 304-1A ALUMINUM ANGLE E 1/2 X 2 1/2 X 1/4	HEAT TREAT:	FINISH: ⚠ ⚠	A		RELEASE	E99023E	KASDI 7-7-99
DWG. NO.		DESCRIPTION	USED ON	NEXT ASSY: D990241	REV	DESCRIPTION	ISSUE DESCRIPTION	SCALE	DATE
6		5		4		3		2	
REFERENCE DRAWINGS								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 0.13 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 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 (IN)								1100 CALIFORNIA INSTITUTE OF TECHNOLOGY MATERIALS RESEARCH CENTER	
		TOLERANCES: FRACTIONAL: ± 1/64 ANGULAR: ± 1/2° TWO PLACE DECIMAL: ± .01 THREE PLACE DECIMAL: ± .003		FINISH: RAZOR SS FINISHED SURFACE RMS BREAK OFFSIDE CORNERS .015 - .015 REMOVE ALL BURRS						ARM CAVITY BAFFLE, GLASS SUPPORT CONNECTOR PLATE	
		MATERIAL: 304 SERIES STAINLESS STEEL BAR 1/4 X 2 1/2		HEAT TREAT:		FINISH: ⚠ ⚠		A REV		RELEASE DESCRIPTION	
DWS NO.		DESCRIPTION REFERENCE DRAWINGS		USED IN		NEXT ASSY: E990241, D990230		E990232		7-12-99	
						ISSUE DESCRIPTION		APPR'D CHECK DRWN DATE		SAC FILE ATT_P177.dwg B D990379-A 1 OF 1	