



CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

DCN No. **E91031-00-D**

SHEET **1** OF **1**

# DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D980451-A	Cryo-Pump Cone Baffle	B

**CHANGE DESCRIPTION (FROM/TO):**

- i Lengthened slots on part item 4 (Tab).
- ii Changed overall length of part item 5 (Band) from 148.1 to 147.60 and removed removed drawing note 7 callout from dimension.
- iii Changed drawing notes 7 & 8.
- iv Added drawing note 8 callout on sheet 2.
- v Added drawing note 15.

**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:	x Coyne Lazzarini Lindquist
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	Sanders Shoemaker Stapfer
<input type="checkbox"/> List S/Ns to be built with this change:	Tyler Weiss Whitcomb
<input type="checkbox"/> List S/Ns to be retested per this change:	Camp x Conley
<input type="checkbox"/>	x Jones x Smith
<input type="checkbox"/>	
<input type="checkbox"/>	
<input type="checkbox"/>	

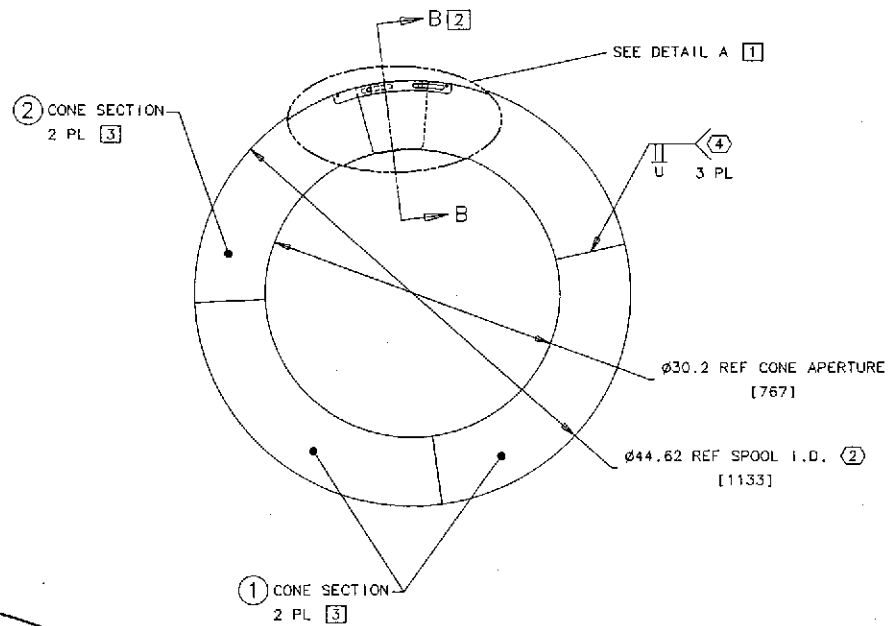
**SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT?**  No  Yes (if yes, enter Change Request number )

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: C. Conley	8-31-99		
TASK LEADER: <i>Michael R Smith</i>	8/31/99		
GROUP LEADER: <i>Jordan Camp</i>	9-1-99		
DCC RELEASE: <i>Linda Swan</i>	9-7-99		

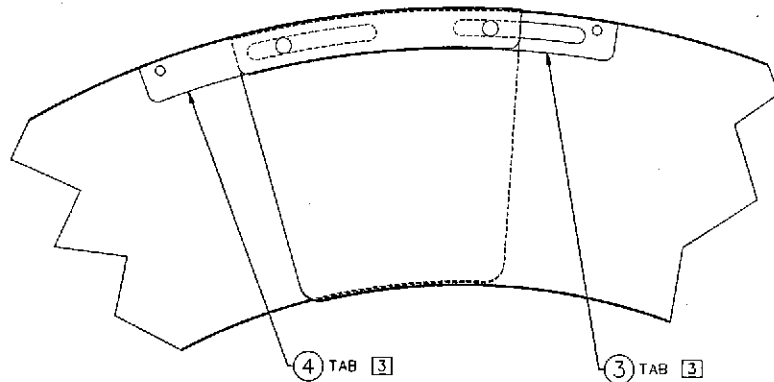
NOTES: (UNLESS OTHERWISE SPECIFIED)

1. BREAK ALL SHARP EDGES.
- ② USE THIS DIMENSION  $\pm 1/4$  FOR ROLLING AND WELD FIXTURING.
- ③ GTAW (3 WELDS FOR EACH \*TAB\*).
- ④ 100% PENETRATION GTAW-BACKSTEP WELD IN UPWARD DIRECTION, FAR SIDE. USE ARGON GAS FOR SHIELDING & BACKING.
- ⑤ NOTE THAT THESE RADI! ARE SLIGHTLY DIFFERENT ON EITHER TAB (ITEM 3 & ITEM 4).
- ⑥ ITEM 2 ONLY.
- ⑦ ALT: STANDARD 304L STAINLESS, POLISHED #8 FINISH, 20ga.
- ⑧ NOTED SIDE TO BE POLISHED SIDE.
- ⑨ STAMP OR ENGRAVE BASIC PART NUMBER AND SERIAL NUMBER IN THIS REGION AS FOLLOWS \*D980451 s/p-XXX\*, WHERE \*XXX\* IS A CONSECUTIVE INTEGER 001 ETC., LETTERING TO BE .12 HIGH MIN.
- ⑩ CLEANING AND BAGGING TO BE PERFORMED BY ALLIED ENGINEERING, ALAMEDA, CA, ACCORDING TO EXISTING PROCEDURES USED BY ALLIED FOR LIGO SEISMIC COMPONENTS.
- ⑪ FIRE BAFFLE IN A PASS THROUGH AIR BAKE OVEN IN A HYDROCARBON FREE ENVIRONMENT, TWO 20 MINUTE CYCLES RAMPING FROM ROOM TO ABOVE 800 C TO ROOM. BAG PER LIGO-E960022 SECTION 5 (OMIT PART (a)). FIRING TO BE PERFORMED BY WEST COAST PORCELAIN, CORONA, CA.
- ⑫ FOR ALL SHIPPING, PACKAGE BAFFLE IN A PROTECTIVE WOODEN CRATE WHICH RIGIDLY SUPPORTS ITS FORM, AND WILL NOT PUNCTURE THE SEALED BAGS (SEE ⑩ ⑪ FOR BAGGING).
- ⑬ WIPE DOWN BAFFLE THOROUGHLY (THREE COMPLETE PASSES) WITH ALCOHOL AND POLY CLEANWIPES IN A LIGO SITE CLASS 100 CLEAN ROOM BEFORE INSTALLATION.
- ⑭ ALT: TWO SECTIONS 109.0° ± .1° ARC EACH.
15. THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED, NO MILL IDENT. MARKS, OR FORMING DISCOLORATION IS PERMISSIBLE ON PART.

REV/DATE	DRAWN BY	CHECKED	DEC	DIS/DESCRIPTION
A 7-15-99	C. Conley			E980287-00/INITIAL RELEASE
B 8-31-99	C. Conley			E990331-00/INITIAL RELEASE



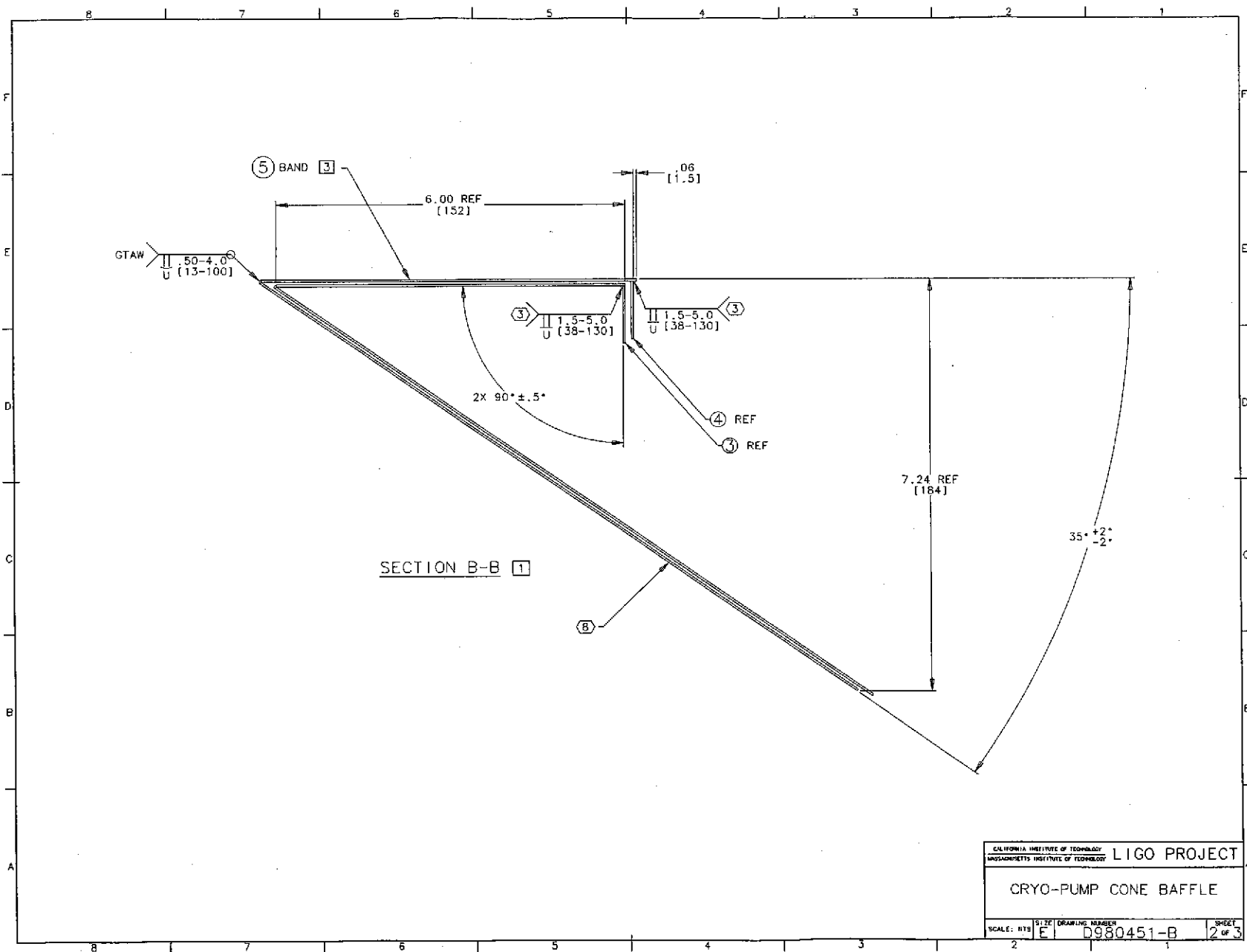
BAFFLE ASSEMBLY ⑩ ⑪ ⑫ ⑬



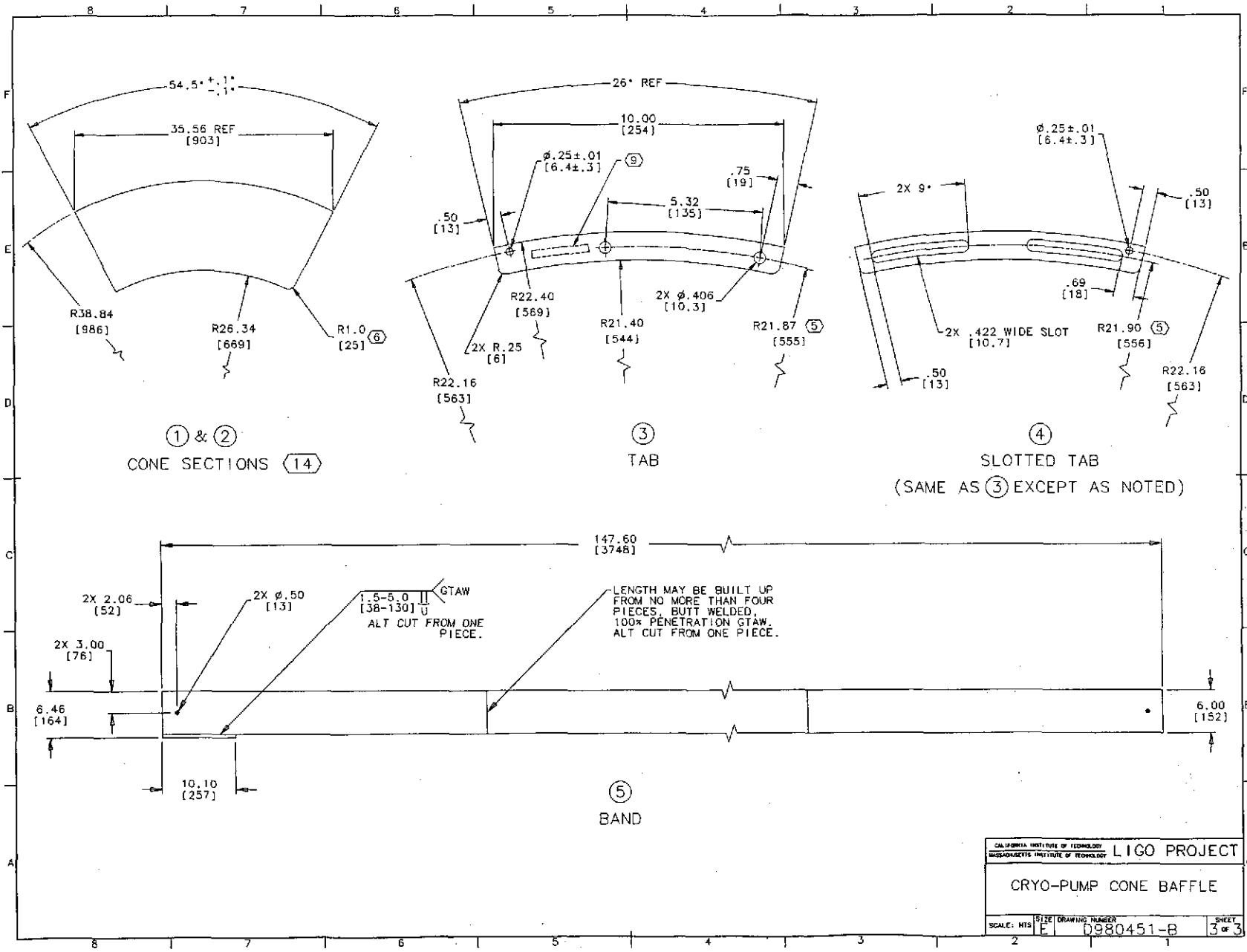
DETAIL A

DRAWN INSTALLED IN SPOOL (44.62 I.D.)  
7.5 OVERLAP AT BAND

PARTS LIST		DATE		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1	BAND	8-31-99	LIGO PROJECT		
1	TAB				
1	TAB				
2	CONE SECTION 2				
2	CONE SECTION 1				
1	TAB				
1	TAB				
UNLESS OTHERWISE SPECIFIED:		SCALE: NTS			
DIMENSION UNITS ARE inches (mm)		SIZE		DRAWING NUMBER	
TOLERANCES ARE:		E		D980451-B	
X-RAY: ± 0.005		1		SHEET	
Z-DIM: ± 0.03		1		1 OF 3	
ANGLES: ± 0.5°		1			
NEXT ASSEMBLY: D980537, D990475					



CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
CRYO-PUMP CONE BAFFLE			
SCALE: NTS	SIZE	DRAWING NUMBER	SHEET
E		D980451-B	2 of 3



CALIFORNIA INSTITUTE OF TECHNOLOGY		LIGO PROJECT	
MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
CRYO-PUMP CONE BAFFLE			
SCALE: NTS	SIZE	DRAWING NUMBER	SHEET
E	E	0980451-B	3 OF 3