

EMPHATICALLY AND UNCONDITIONALLY					
THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATES COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED, NOR SHALL SUCH INFORMATION BE FURNISHED BY WHOMEVER OR BY WHATEVER MEANS EXCEPT IN ACCORDANCE WITH THE TERMS OF ANY AGREEMENT UNDER WHICH IT WAS SUPPLIED OR WITH THE PRIOR WRITTEN CONSENT OF PROCESS SYSTEMS INTERNATIONAL, INC. AND SHALL BE RETURNED UPON REQUEST.					
DRG. NO.	DESCRIPTION	REFERENCE DRAWINGS	DRG. NO.	DESCRIPTION	
			V049-4-101	BSC OVERALL ASSEMBLY	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ±.1					
ANNEALING 1010-1015 800-800 40°					
TEMPERATURE 1010-1015 720					
REMOVE ALL SURFS					
DO NOT SCALE THIS DRAWING					
USED ON					
NEXT ASS'Y:					
REV	DESCRIPTION	ISSUE DESCRIPTION			
3	REISSUED FOR FABRICATION/REVISED DET.11, SHT 3 OF 4	PV	01/23/97	0421	
2	REISSUED FOR FABRICATION	GS	PEF	BMV	RDC
1	DESIGN UPDATE	GS	PEF	BMV	RDC
0	ISSUED FOR FABRICATION	GS	PEF	DMC	REC
0A	AS NOTED/REISSUED FOR QUOTES 7/2/96 PER REC.	PEF	PEF	DMC	REC

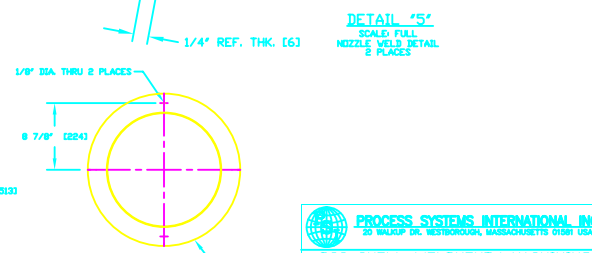
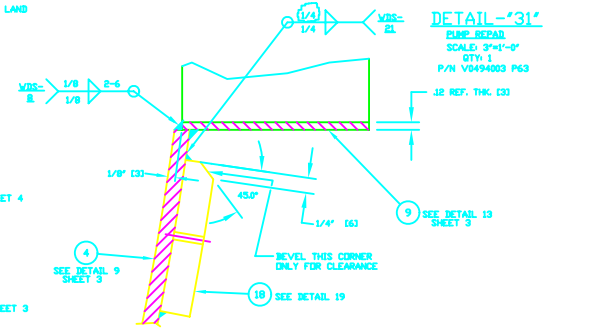
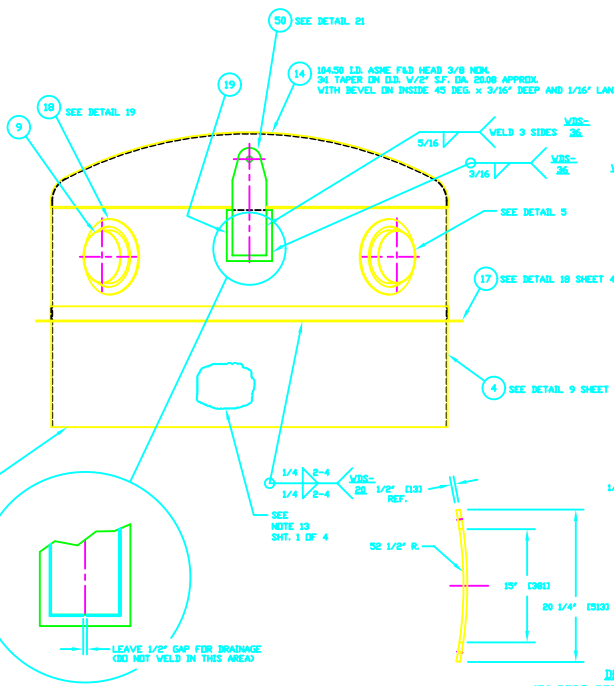
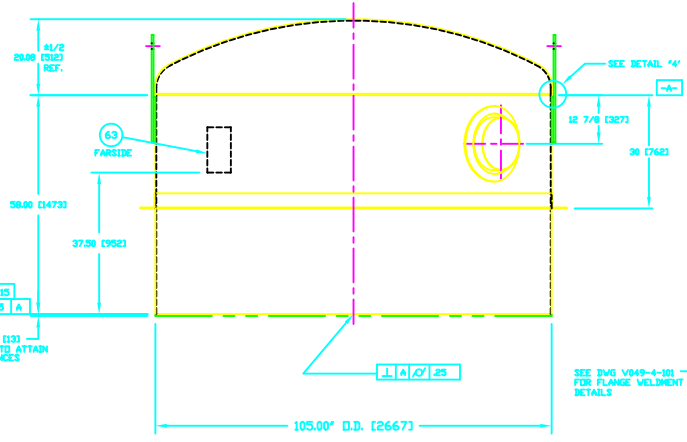
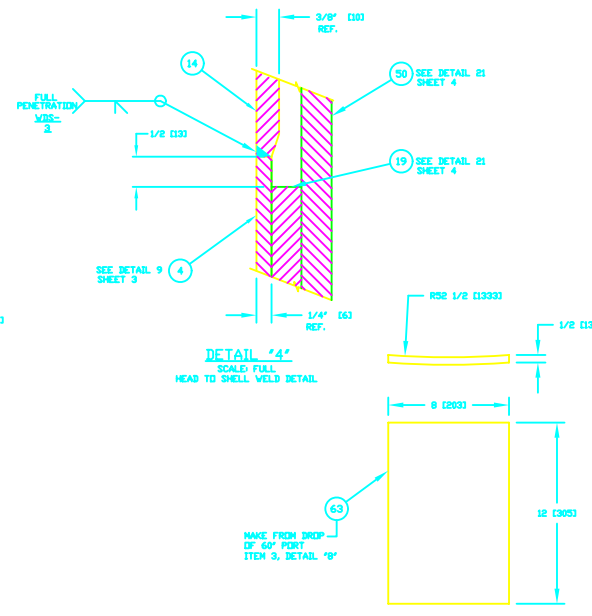
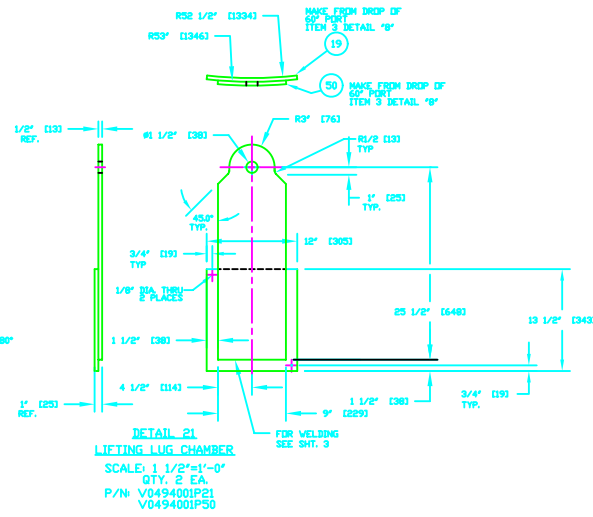
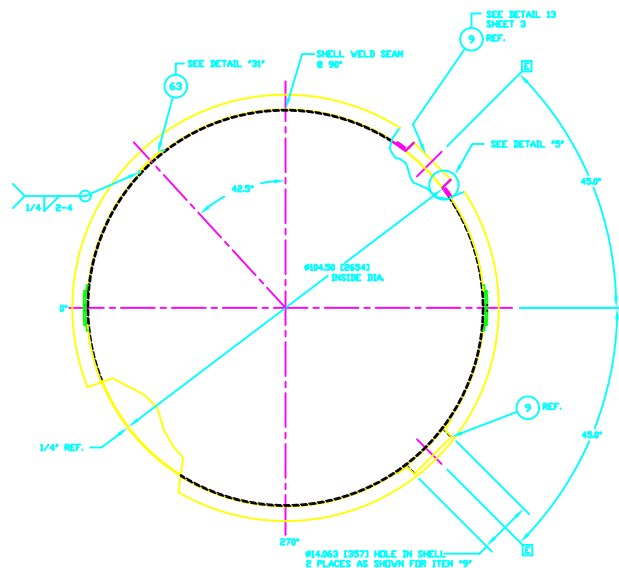
PV 01/23/97 0421
 GS PEF BMV RDC REC PV 10/30/96 0337
 GS PEF BMV RDC REC PV 9/27/96 0270
 GS PEF DMV REC GA 8/28/96 0230
 PV 7/19/96
 CHVD DRVN DATE ICDM

PROCESS SYSTEMS INTERNATIONAL, INC.
 20 SHILUP DR. NEEDHAMHAMS, MASSACHUSETTS 01946 USA

BSC SHELL WELDMENT/MACHINING LOWER SHELL LIGO VACUUM EQUIPMENT

DRG FILE 440351
 SHEET NO. V049-4-003
 SHEET 3 OF 3

SCALE AS NOTED SHEET 1 OF 4



.015 [131]
.015 [131]
MAX. MATERIAL REMOVAL TO ATTAIN FINAL MACHINING TOLERANCES

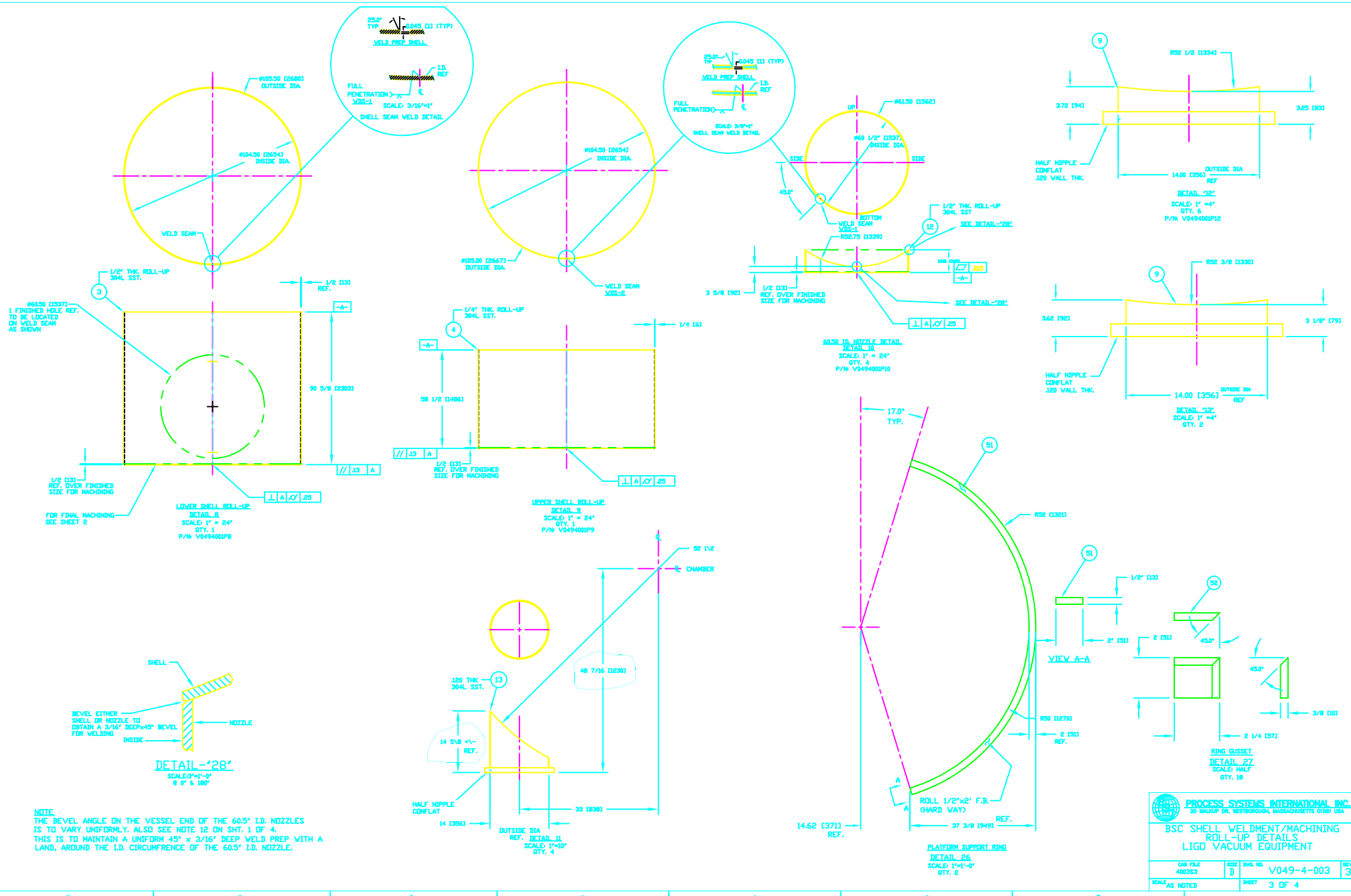
SEE DWG V049-4-101 FOR FLANGE WELDMENT DETAILS

LEAVE 1/8" GAP FOR DRAINAGE DO NOT WELD IN THIS AREA

PROCESS SYSTEMS INTERNATIONAL INC.
20 WALSH DR. WESTBOROUGH, MASSACHUSETTS 01581 USA

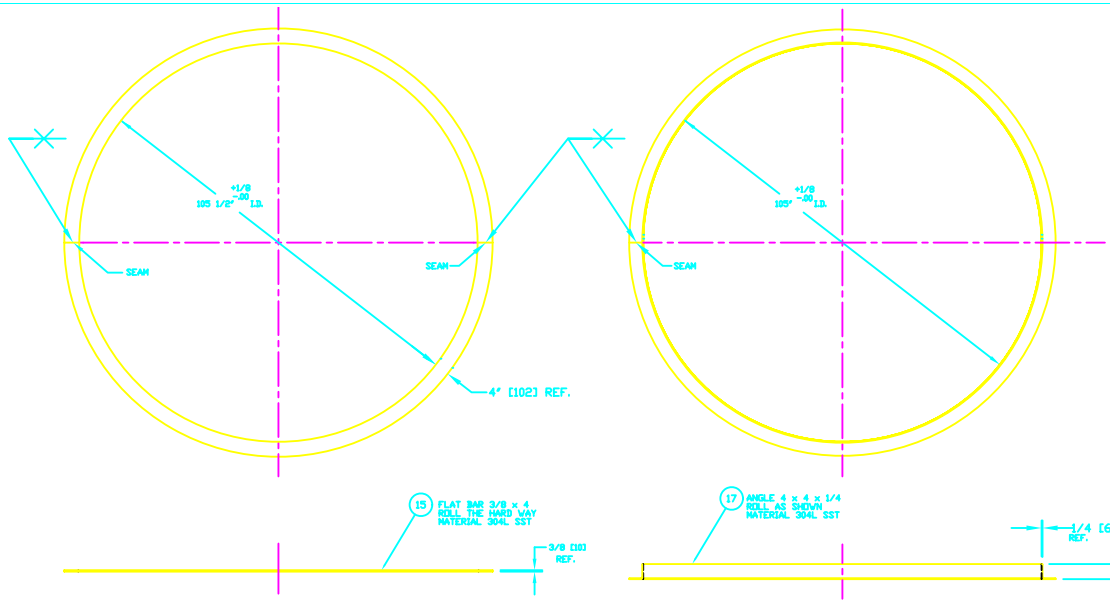
BSC SHELL WELDMENT / MACHINING
UPPER SHELL
LIGD VACUUM EQUIPMENT

DWG FILE 400352	REV D	REV. NO. V049-4-003	REV. 3
SCALE 1/16		SHEET 2 OF 4	



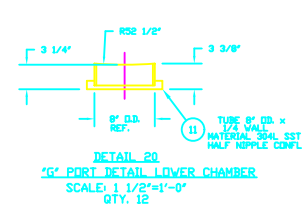
NOTE:
 THE BEVEL ANGLE ON THE VESSEL END OF THE 60.5° I.D. NOZZLES IS TO VARY UNIFORMLY. ALSO SEE NOTE 12 ON SHT. 1 OF 4. THIS IS TO MAINTAIN A UNIFORM 45° x 3/16" DEEP WELD PREP WITH A LAND, AROUND THE I.D. CIRCUMFERENCE OF THE 60.5° I.D. NOZZLE.

PROCESS SYSTEMS INTERNATIONAL INC. 20 WALSH DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
BSC SHELL WELDMENT/MACHINING ROLL-UP DETAILS LIGD VACUUM EQUIPMENT			
DRG FILE 400353	SHEET NO. D	P/N V049-4-003	REV. 3
SCALE AS NOTED		SHEET 3 OF 4	

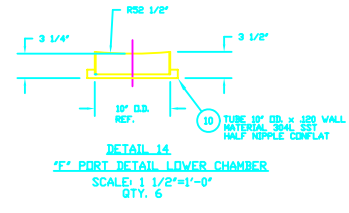


DETAIL 17
SHELL STIFFENERS LOWER CHAMBER
SCALE: 3/4"=1'-0"
QTY. 1

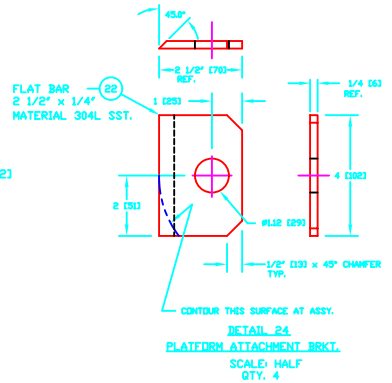
DETAIL 18
SHELL STIFFENERS UPPER CHAMBER
SCALE: 3/4"=1'-0"
QTY. 1



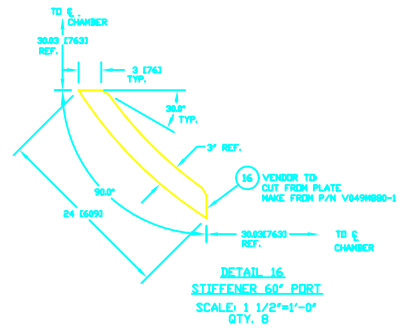
DETAIL 20
6" PORT DETAIL LOWER CHAMBER
SCALE: 1 1/2"=1'-0"
QTY. 12



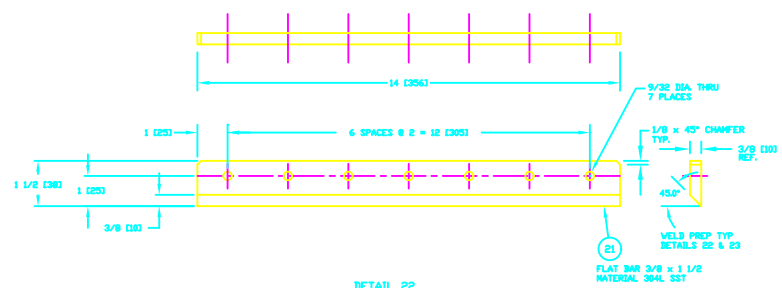
DETAIL 14
4" PORT DETAIL LOWER CHAMBER
SCALE: 1 1/2"=1'-0"
QTY. 6



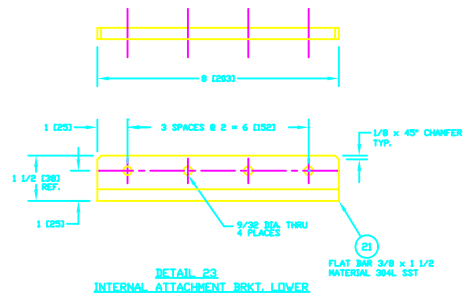
DETAIL 24
PLATFORM ATTACHMENT BRKT.
SCALE: HALF
QTY. 4



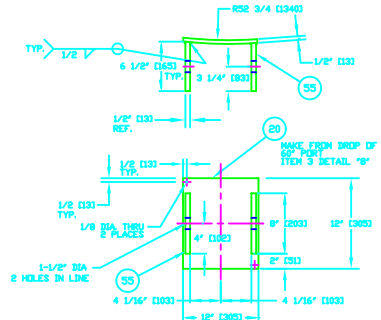
DETAIL 16
STIFFENER 60" PORT
SCALE: 1 1/2"=1'-0"
QTY. 8



DETAIL 22
INTERNAL ATTACHMENT BRKT. UPPER
SCALE: HALF
QTY. 12



DETAIL 23
INTERNAL ATTACHMENT BRKT. LOWER
SCALE: HALF
QTY. 12



DETAIL 15
SUPPORT PAD DETAIL
SCALE: 1 1/2"=1'-0"
QTY. 4

PROCESS SYSTEMS INTERNATIONAL INC. 20 WALSH DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
BSC SHELL WELDMENT/MACHINING STIFFENER & MISC. DETAILS LIGD VACUUM EQUIPMENT			
DWG FILE 400354	REV D	P/NL NO. V049-4-003	REV 3
SCALE AS NOTED	SHEET 4 OF 4		