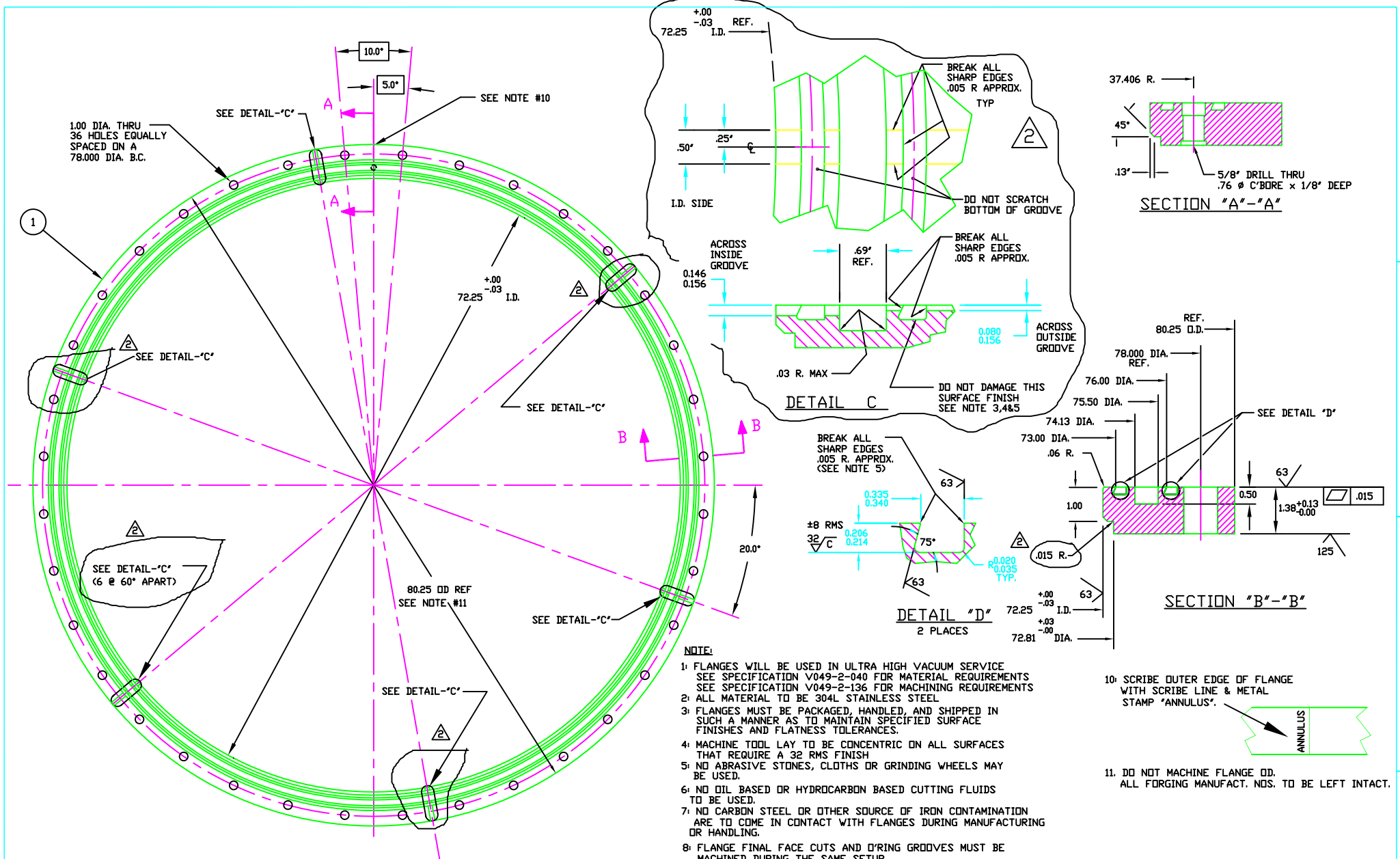


72.25 INCH FLANGE _ GROOVED - ADVANCED LIGO # LIGO D961104-v1



- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE. SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS. SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS.
 - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL.
 - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.
 - 4: MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH.
 - 5: NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.
 - 6: NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS TO BE USED.
 - 7: NO CARBON STEEL OR OTHER SOURCE OF IRON CONTAMINATION ARE TO COME IN CONTACT WITH FLANGES DURING MANUFACTURING OR HANDLING.
 - 8: FLANGE FINAL FACE CUTS AND O'RING GROOVES MUST BE MACHINED DURING THE SAME SETUP.
 - 9: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.
 - 10: SCRIBE OUTER EDGE OF FLANGE WITH SCRIBE LINE & METAL STAMP "ANNULUS".
 - 11: DO NOT MACHINE FLANGE OD. ALL FORGING MANUFACT. NDS. TO BE LEFT INTACT.

**THIS FLANGE TO BE MADE FROM P/N V049M246-1
WEIGHT: 376#**

INNER O-RING .275 DIA. STOCK x 227 3/4' LG. VULCANIZED - BAKED VITON E-60C
OUTER O-RING .275 DIA. STOCK x 237 1/8' LG. VULCANIZED - BAKED VITON E-60C

<p>PROPRIETARY AND CONFIDENTIAL</p> <p>THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSE FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED, NOR SHALL SUCH INFORMATION BE FURNISHED IN WHOLE OR IN PART TO OTHERS 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.</p>		<p>UNLESS OTHERWISE SPECIFIED</p> <p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES:</p> <p>FRACTIONAL ± 1/16</p> <p>ANGULAR DIMENSIONS ± 30" UNLESS NOTED</p> <p>TWO PLACE DECIMAL ± .010</p> <p>THREE PLACE DECIMAL ± .005</p> <p>FINISHED SURFACE ± .005</p> <p>HEAVY CONTOUR DIMENSIONS ± .010 UNLESS OTHERWISE NOTED</p>		<p>2 REISSUED FOR FABRICATION</p> <p>1 DESIGN UPDATE/ISSUED FOR FABRICATION</p>		DA	10/8/96	0294	
<p>DO NOT SCALE THIS DWG.</p>		<p>0 ISSUED FOR FDR/FAB</p>		RDC	DMV	REC	PV	7/31/96	0218
DWG. NO.	DESCRIPTION	USED ON:	REV.	DESCRIPTION	CHKD	DRAWN	DATE	DEC	
	REFERENCE DRAWINGS	NEXT ASS'Y:		ISSUE DESCRIPTION					
8	7	6	5	4	3	2	1		

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

72 1/4" I.D. FLANGE DETAIL
(GROOVED) (.25 THK. SHELL)
LIGO VACUUM EQUIPMENT

CAD FILE: V0494020 SIZE: C DWG. NO.: V049-4-020 REV.: 2

SCALE: 1 1/2"=1'-0" SHEET: 1 OF 1

Oct 11, 1996 - 11:39:01