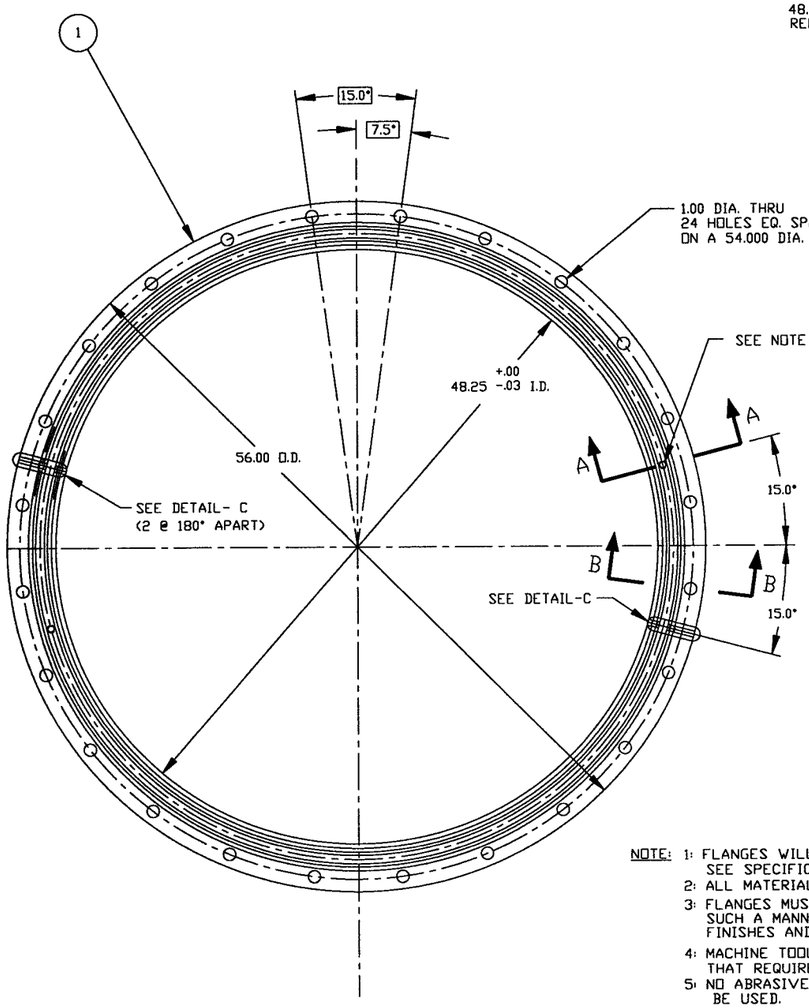
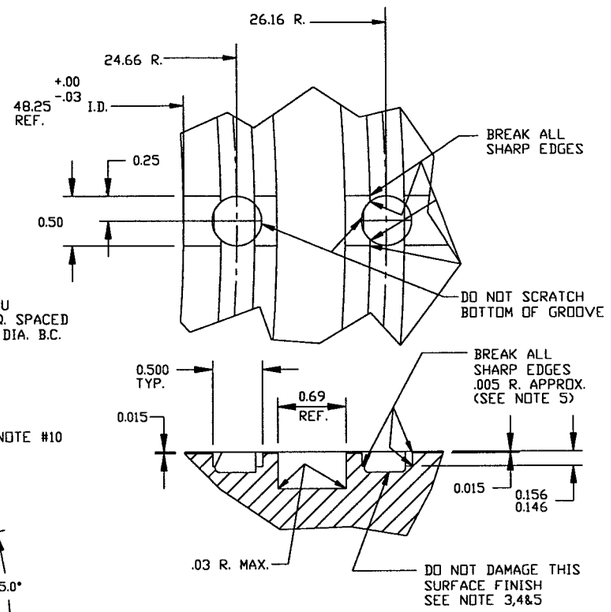
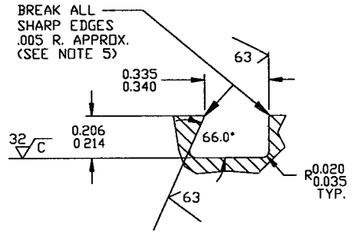


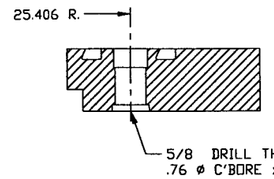
SCALE: 1 1/2 -1'-0



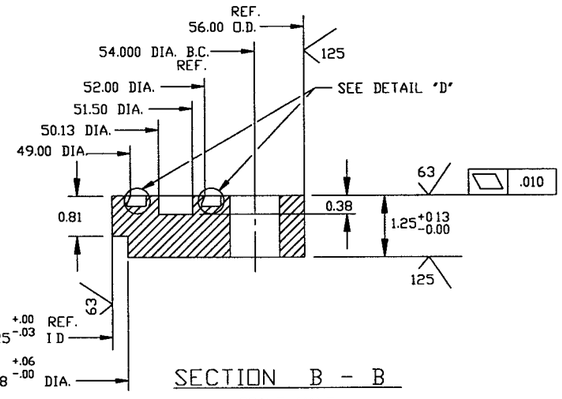
DETAIL C
SCALE:FULL



DETAIL D
2 PLACES
SCALE: 2x

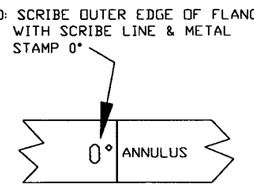


SECTION A - A
2 PLACES 180° APART
SCALE: HALF



SECTION B - B
SCALE: HALF

NOTE:
1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL 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 0°



INNER O-RING .275 DIA. STOCK x 153 1/8" LG. VULCANIZED - BAKED VITON E-60C
OUTER O-RING .275 DIA. STOCK x 162 1/2" LG. VULCANIZED - BAKED VITON E-60C

NOT FOR CONSTRUCTION

Raymond D. Cirillo, PE
5/6/96

LIGO D961103-00-V

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DWG. NO.	DESCRIPTION
REFERENCE DRAWINGS	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGULAR/MACH 45°-30' BEND ±2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISHES SURFACE RMS 63
BREAK CORNERS: IN-005 OUT-005
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.

USED ON:

NEXT ASS'Y:

REV	DESCRIPTION	CHKD	DRAWN	DATE	DEO
0	ISSUED FOR FDR	RDC	PV	5/1/96	0150
P4	PRELIMINARY UPDATE		PV	2/21/96	
P3	PRELIMINARY		PV	12/28/95	
P2	PRELIMINARY		PV	12/5/95	
P1	PRELIMINARY		KAR	10-24-95	

ISSUE DESCRIPTION

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

48 1/4" I.D. FLANGE DETAIL (GROOVED) LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG NO	REV
V049018	C	V049-4-018	0
SCALE AS NOTED		SHEET 1 OF 1	

Oct 02, 1995 - 09:36:12

8 7 6 5 4 3 2 1
D C B