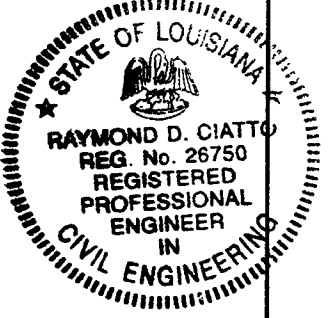


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
  - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
  - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN 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.



*R. Ciatto*  
11/2/97

EXPIRES 6/5/97  
 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

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DWG. NO	DESCRIPTION	USED ON	DO NOT SCALE THIS DWG.
	REFERENCE DRAWINGS		
		NEXT ASS'Y	

REV.	DESCRIPTION	CHKD	DRAWN	DATE	DEO
2	REISSUED FOR FABRICATION / FDR UPDATE			10/8/96	0294
1	DESIGN UPDATE/FABRICATION	GS	PEF	7/31/96	0218
0	ISSUED FOR FDR		DMV	5/1/96	0150
P4	PRELIMINARY UPDATE		DMV	2/21/96	
P3	PRELIMINARY		RDC	12/28/95	
P2	PRELIMINARY		REC	12/5/95	
P1	PRELIMINARY		KAR	10-24-95	

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

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

CAD FILE: V0494018  
 SIZE: C  
 DWG. NO: V049-4-018  
 REV: 2

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

Oct 02, 1995 - 09:36:12