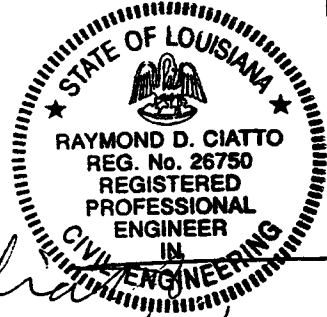


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS
  - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
  - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.
  - 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: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.

THIS FLANGE TO BE MADE FROM P/N V049M255-1  
WEIGHT: 451#



EXPIRES 8/5/97

1/29/97

PROPRIETARY AND CONFIDENTIAL

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DWG. NO.	DESCRIPTION	USED ON	REFERENCE DRAWINGS

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES:  
FRACTIONAL ± 1/16"  
ANGULAR ± 30° BEND ± 2°  
TWO PLACE DECIMAL ± .005  
THREE PLACE DECIMAL ± .005  
FINISHED SURFACE RMS 63  
SHARP CORNERS: IN-005 OUT-005  
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.

NEXT ASS'Y:

REV.	DESCRIPTION	ISSUE DESCRIPTION
2	RELEASED FOR FABRICATION/REVISED SECT. 'A-A'	QC REF DWORDC/EE PV 01/23/97 0421
1	RELEASED FOR FABRICATION	GS PEF DMW RDC REC PV 7/11/96 0218
0	ISSUED FOR FDR	DMW RDC REC MA 05-01-96 0150

CHKD	DRAWN	DATE	DED

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

61.06" I.D. RING DETAIL  
REDUCING UNION  
LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
V0494055	C	V049-4-055	2

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