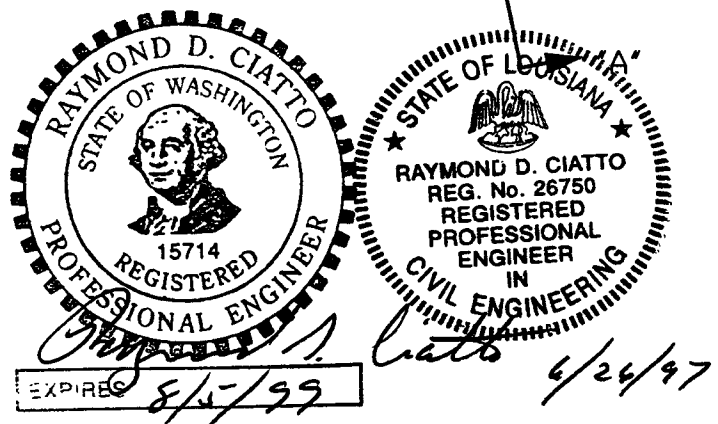


ITEM	PART NUMBER	SUFFIX	QTY	UM	DESCRIPTION
1	V0494018		1	EA	FLANGE, GROOVED, 48 1/4" ID X 56" OD X 1-1/4" THK
2	V0494079		1	EA	FLANGE, FLAT FACE, 48 1/4" ID X 68 1/4" OD X 1" THK
3	V0494A15P3		1	EA	SHELL, 48.25" I.D. X 1/4" WALL SST 304/304L
4	V049M315	3	6	EA	HALF NIPPLE, SST 304L, WITH CONFLAT FLANGE, 6" O.D. X 4 O.D. TUBE X .083 WT
5	V0494159		1	EA	LIFTING LUG
6					
7	202632	3	6	EA	BLANK, CONFLAT, SST 304L, 6" O.D.
8	202633	3	6	EA	GASKET, COP COFH, CONFLAT, 6" O.D.
9	V049M776		96	EA	BOLT, 18-8 SST, HEX HD, 5/16"-18x2 1/4" LG.
* 10	202678	3	54	EA	BOLT, SA 193 B7, HEX, 7/8-9UNCx4" LG
* 11	202679	3	54	EA	NUT, SA 194 2H, HEX, 7/8-9UNC
* 12	202581	3	138	EA	WASHER, STL, 1 3/4 O.D.x15/16 I.D.x1/4 THK
13	V049M024		1	EA	O-RING, VITRON OPER SPEC V049-2-045
14	V049M025		1	EA	O-RING, VITRON OPER SPEC V049-2-045
15	V049M782		96	EA	NUT, SILICON BRZ, HEX HD, 5/16"-18x2 1/4" LG.
16	V049M785		192	EA	WASHER, 18-8 SST, FLAT 5/16"
17	V0494061		1	EA	3/4" O.D. ELBOW X 2 3/4" O.D. CF.
18	V0494080G3		1	EA	SHIPPING COVER ASSY
19	V0494059G4		1	EA	SHIPPING COVER ASSY
20	(V049M740)		1	EA	PSI NAME PLATE, 2" X 3"

\* ELECTROLESS NICKEL PLATE

- NOTES:
15. WDS NO'S. REFER TO WELD DATA SPEC. V049-2-084.
  14. CONFLAT LEAK CHECK SLOTS ARE TO BE POSITIONED ON VERTICAL CENTERLINE.
  13. CONFLAT FLANGES TO HAVE PROTECTIVE COVERS AT ALL TIMES DURING & AFTER MANUFACTURING.
  12. EACH FINISHED SHELL IS TO BE MARKED WITH A SEQUENTIAL PSI SERIAL NUMBER. THE NUMBER IS TO BE MADE FROM THE DRAWING PLUS THE SEQUENTIAL NUMBER. V0494A15-01, 02 ETC.
  11. PLATES PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITHIN 1/16" OF EACH OTHER.
  10. MACHINING & ROLLING PER SPEC V049-2-136.
  9. LEAK TEST & METHOD PER PSI SPEC: V049-2-014
  8. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED AS NOTED.
  7. BOLT HOLES OF ALL FLANGES TO STRADDLE VERTICAL CENTERLINE, +/- .015
  6. CLEAN PER SPEC: V049-2-015
  5. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
  4. THE CENTER LINES OF ALL SHELLS AND END FLANGES ARE TO LIE ON THE COMMON CENTER LINE WITHIN +/- 1/16
  3. SPOOL FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-097.
  2. FOR FLANGE DETAILS SEE DWG. V049-4-018 & 079.
  1. THESE FLANGES EACH INCLUDE AN ANNULAR CHANNEL BETWEEN O-RINGS, MANIFOLD TO A SINGLE PUMPOUT PORT ON EACH CHAMBER, SEE DWG V049-4-061

APPROX. WEIGHT: 1025#



TAG NO'S: WA-15A, WA-15B

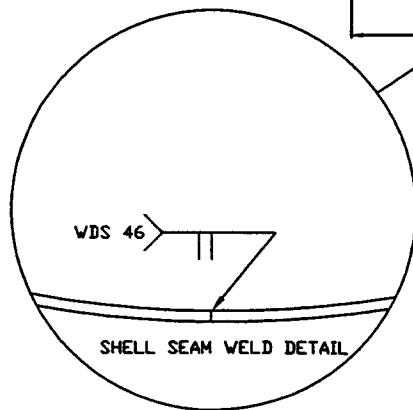
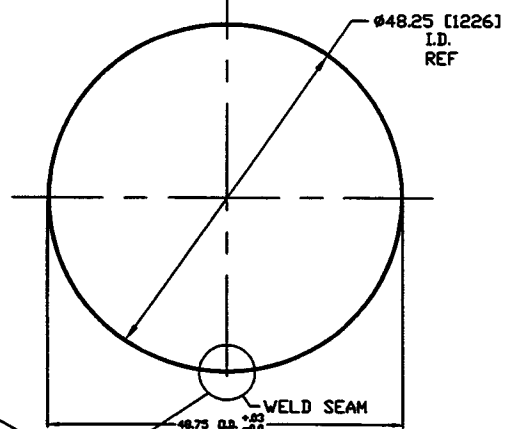
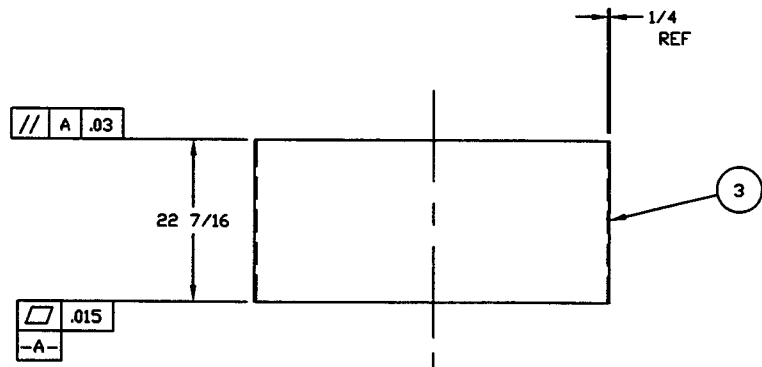
SYMBOL	CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES	REV	DESCRIPTION	DATE	BY	CHKD	DRWN	DATE	DCDR
□	FLATNESS	FRACTIONAL ± .1	4	REISSUED FOR FAB/SHIPPING AS NOTED	5/15/97	SPIDER			0485	
○	CYLINDRICITY	ANGULAR ± .1	3	REISSUED FOR FABRICATION	11/22/96	PV			0180	
∥	PARALLELISM	TWO PLACE DECIMAL ± .01	2	DESIGN UPDATE/ISSUED FOR FAB	10/9/96	PV			0339	
⊥	PERPENDICULARITY	THREE PLACE DECIMAL ± .001	1	DESIGN UPDATE/FABRICATION (SHELL ONLY)	10/1/96	MA			0283	
∠	ANGULARITY	FRACTIONAL ± .1	0	ISSUED FOR FAB	5/4/96	PA			0145	
⊕	TRUE POSITION	DO NOT SCALE THIS DRAWING								
⊙	CONCENTRICITY	USED ON NEXT ASSY								

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

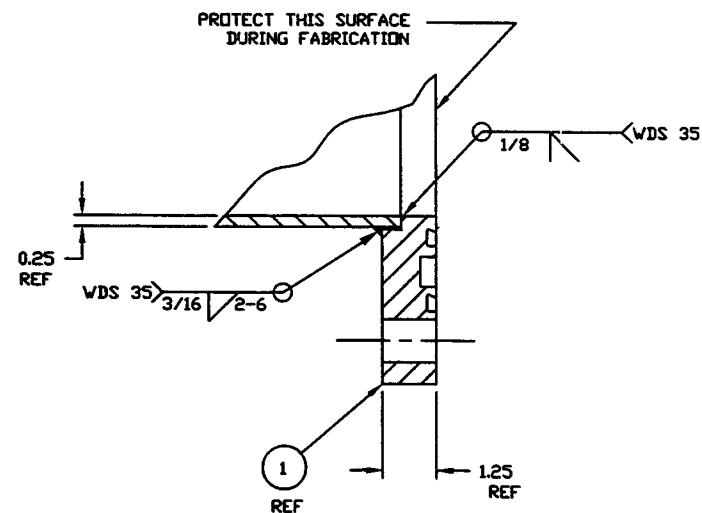
**ADAPTER A-15**  
 48.25 ID x 60.50 ID  
 LIGO VACUUM EQUIPMENT

CAD FILE: V0494A15-4A15S1  
 SIZE: D  
 DWG NO.: V049-4-A15  
 SHEET: 1 OF 2

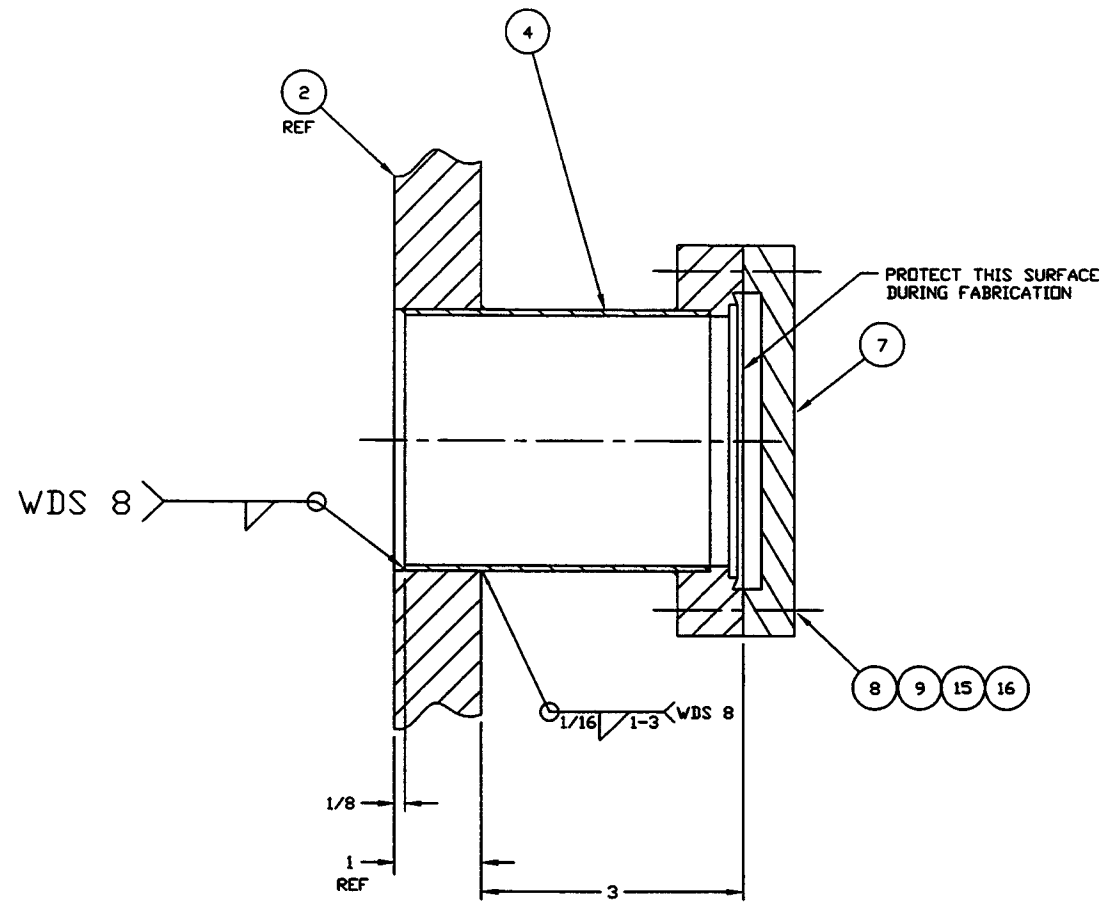
LIGO-D961149-04-V



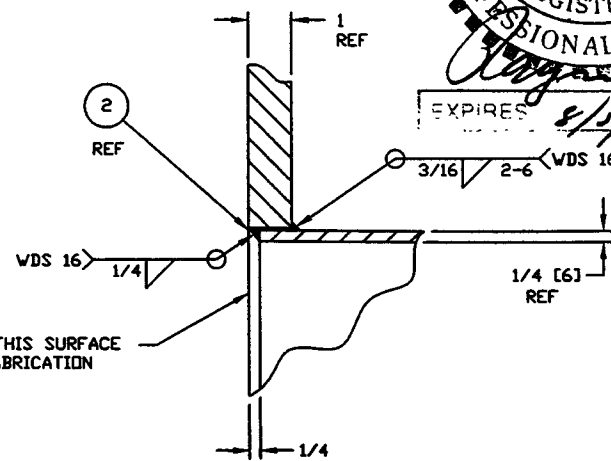
**DETAIL "1"**  
QTY: 1  
MAKE FROM V049M166-1



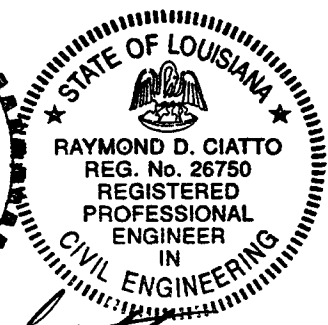
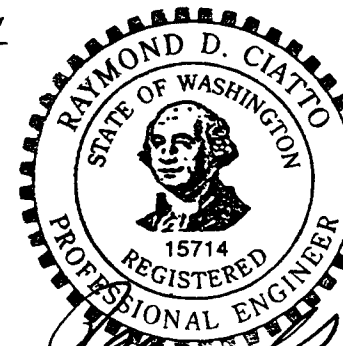
**DETAIL "4"**



**DETAIL "3"**  
TYP 6 PLCS



**DETAIL "5"**



EXPIRES 8/5/93  
4/26/97

<b>PROCESS SYSTEMS INTERNATIONAL, INC.</b> <small>30 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA</small>			
<b>ADAPTER A-15</b> 48.25" ID x 60.50" ID LIGD VACUUM EQUIPMENT			
<small>CHG FILE</small> V049A15/4A15S2	<small>SIZE</small> D	<small>ENG NO.</small> V049-4-A15	<small>REV.</small> 4
<small>SCALE</small> AS NOTED	<small>SHEET</small> 2 OF 2		

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