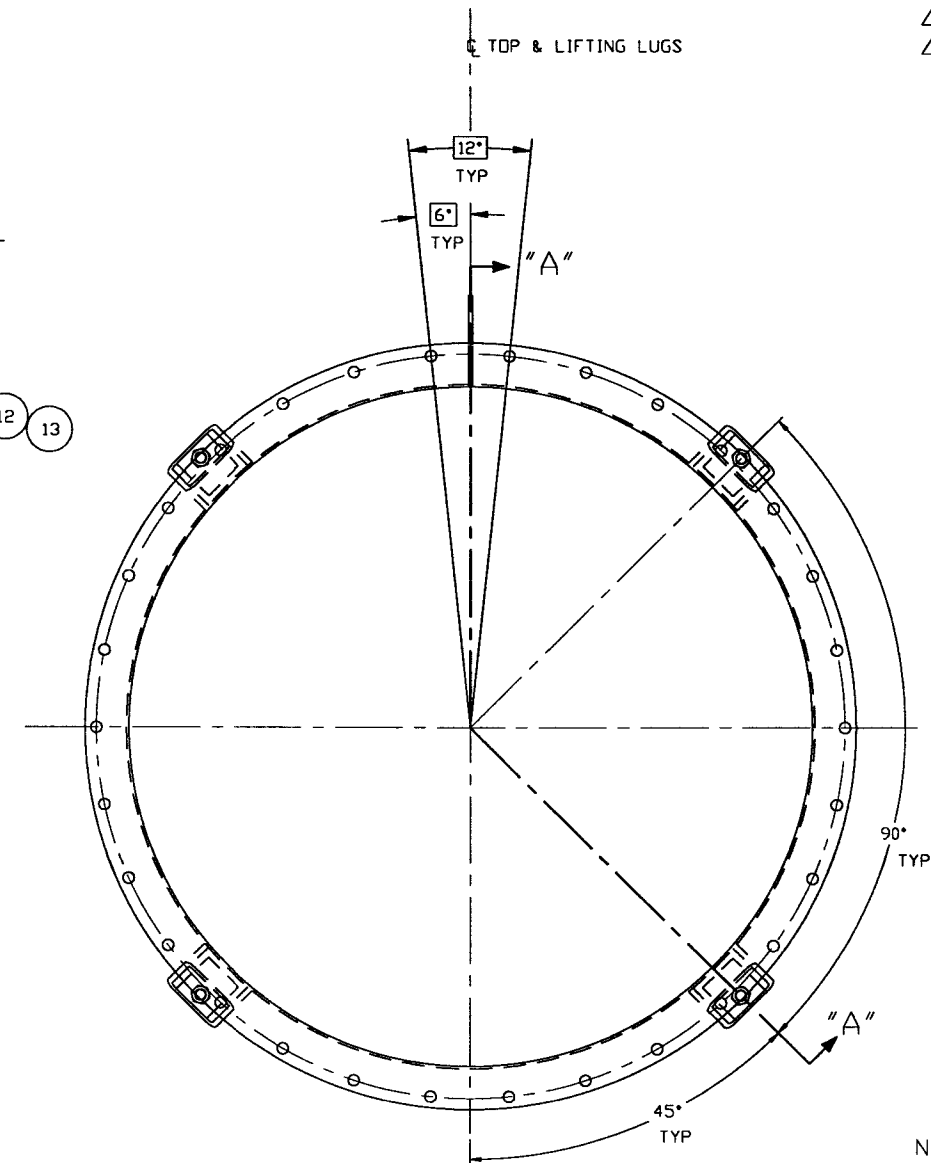
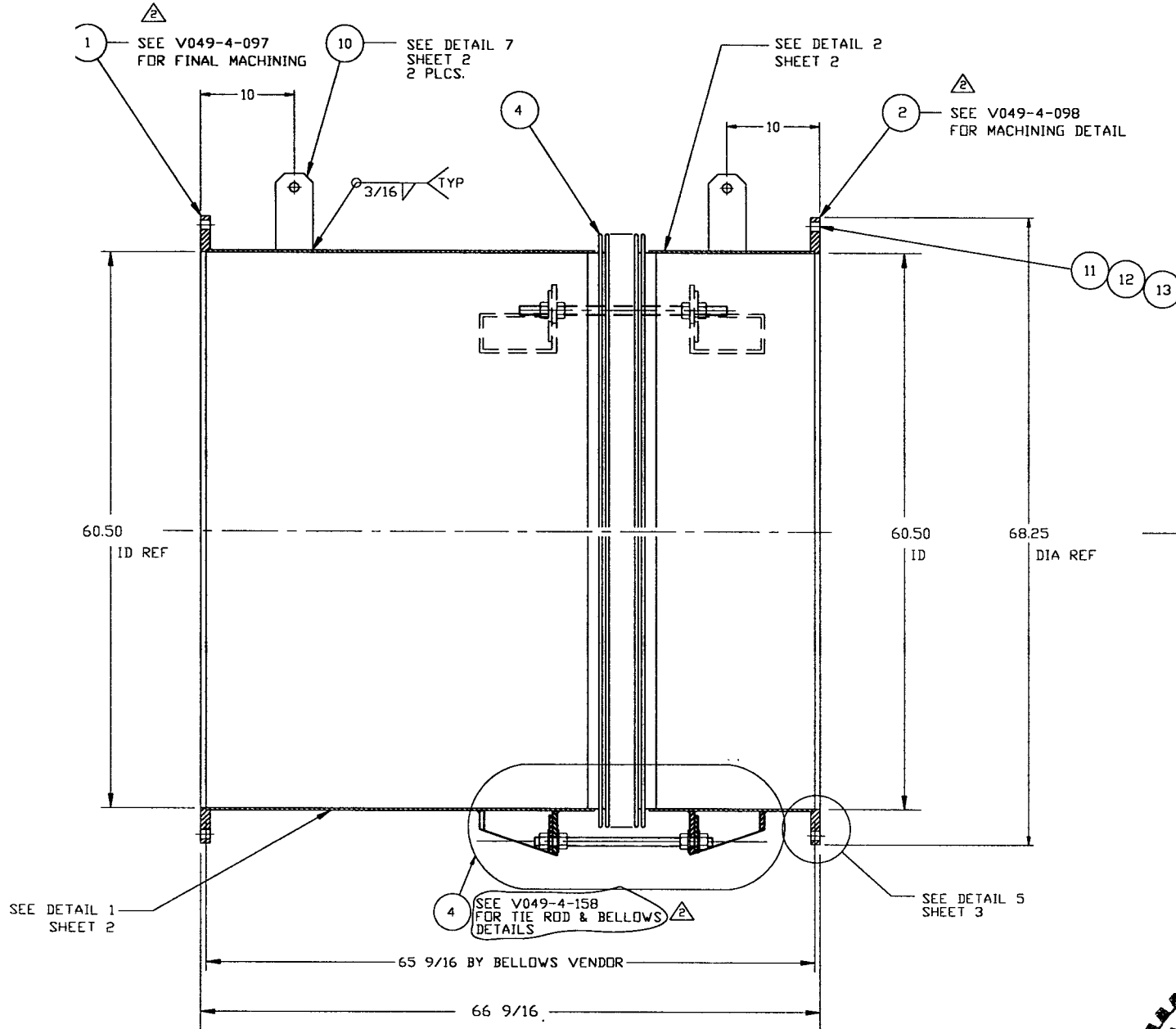
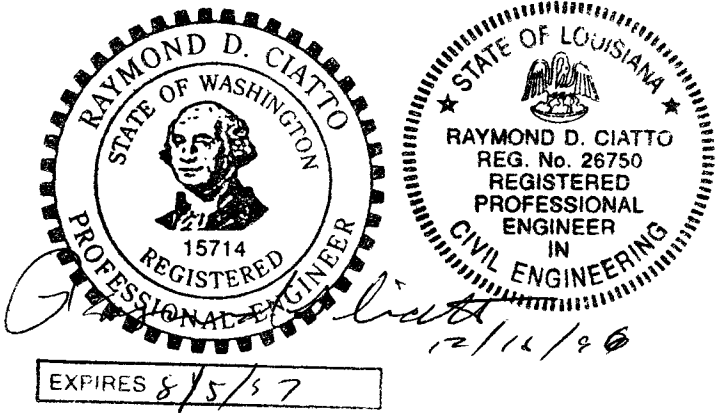


ITEM	PART NUMBER	SUFFIX	QTY	UM	DESCRIPTION
1	V0494097		1	EA	FLANGE, FLAT FACED, 60 1/2" ID x 68 1/4" OD x 1" THK
2	V0494098		1	EA	FLG. FLAT, SLOTTED, 60 1/2" ID x 68 1/4" OD x 1" THK
3	***		4	EA	TIE-ROD ASSY (PER V049-4-158)
4	V0494BE2P1		1	EA	BELLOWS ASSY (PER SPEC #V049-2-017)
5					
6					
7					
8					
9					
10	***	3	15	FT	BAR, 4" X 3/8" 304 SST (LIFTING LUGS)
11	202679	3	30	EA	NUT, SA 194 B7, HEX 7/8-9UNC
12	202678	3	30	EA	BOLT, SA 193 2H, HEX HD 7/8-9UNC x 4" LG
13	202581	3	60	EA	WASHER, STL, 1 3/4 OD x 1 5/16 ID x 1/4" THK

* ELECTROLESS NICKEL PLATE
 *** SUPPLIED BY BELLOWS VENDOR



SECTION "A"-"A"



- NOTES:
10. PLATES PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITHIN 1/16" OF EACH OTHER.
 9. 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. V0494BE2-01, -02 ETC.
 8. TIGHTEN TIE-ROD NUTS WITH BELLOWS IN "FREE" POSITION TO 100 FT.LB. PRIOR TO LEAK TEST
 7. LEAK TEST & METHOD PER PSI SPEC: V049-2-014
 6. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED, AS NOTED.
 5. BOLT HOLES OF ALL FLANGES TO STRADDLE VERTICAL CENTERLINE ± .015
 4. CLEAN PER SPEC: V049-2-015.
 3. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
 2. FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-097.
 1. FOR FLANGE DETAILS SEE DWG. V049-4-097

0961160-02-V
 APPROX. WEIGHT: 1386#

RAYMOND D. CIATTO PE-WA.

SYMBOL	CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	REV	DESCRIPTION	DATE	BY	CHKD	DRWN	DATE	DEC#
□	FLATNESS	FRACTIONAL ± .1	2	DESIGN UPDATE/ISSUED FOR FABRICATION	11/22/96	PV				0180
○	CYLINDRICITY	ANGULAR MAX ± .0030° BEND ± .002	1	DESIGN UPDATE /FABRICATION (BELLOWS ASSY ONLY)	9/11/96	MA				0191
∥	PARALLELISM	TWO PLACE DECIMAL ± .003	0	ISSUED FOR FDR	4/29/96	MA				0146
⊥	PERPENDICULARITY	FINISHED SURFACE RMS BREAK CORNERS IN OUT-REMOVE ALL MARKS	P1	PRELIMINARY	4/17/96	DA				
∠	ANGULARITY	DO NOT SCALE THIS DRAWING	REV							
⊕	TRUE POSITION	USED ON:								
○	CONCENTRICITY	NEXT ASS'Y:								

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

SPOOL BE-2
 60.50" ID
 LIGO VACUUM EQUIPMENT

CAD FILE: V0494BE2/4BE2S1
 SIZE: D
 DWG NO: V049-4-BE2
 SCALE: 1-1/2" = 1"
 SHEET: 1 OF 2

015
// A 03

0.25

40.75
REF

.015
-A-

* NOTE: FINAL FINISHED LENGTH TO BE DETERMINED BY BELLOWS VENDOR

* NOTE: FINAL FINISHED LENGTH TO BE DETERMINED BY BELLOWS VENDOR

+03
-00

61.00
OUTSIDE DIA

0.25

.015
// A .03

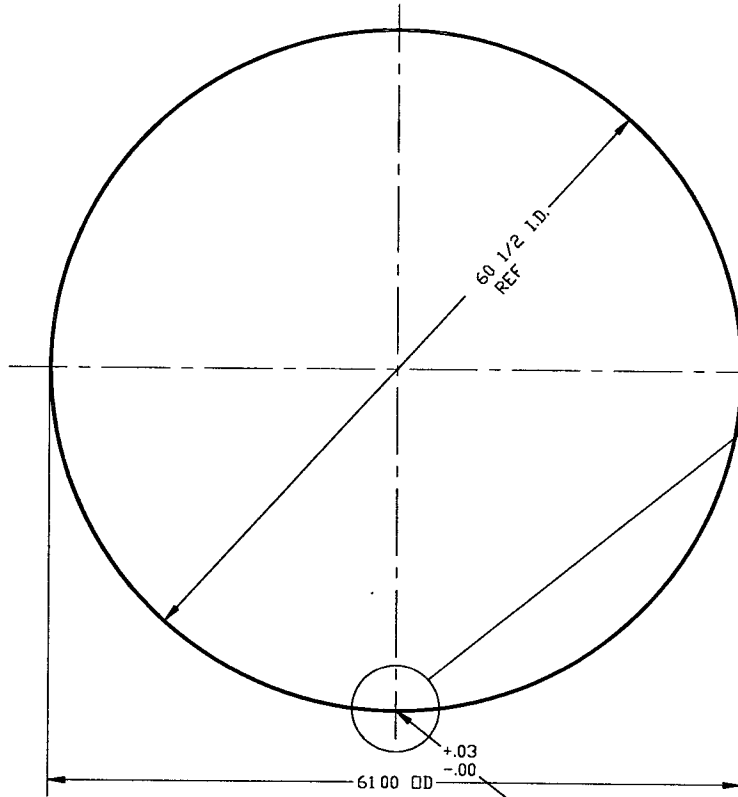
17.81
REF

.015
-A-

DETAIL "2"

QTY. 1

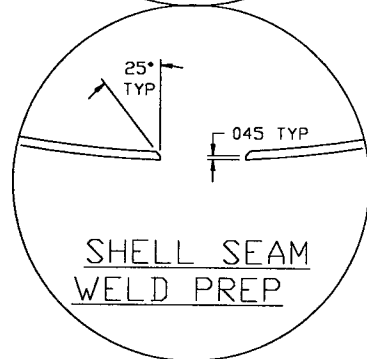
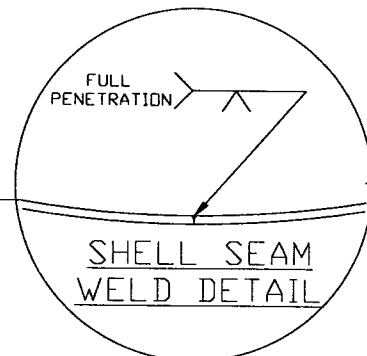
MAKE FROM V049M153-1



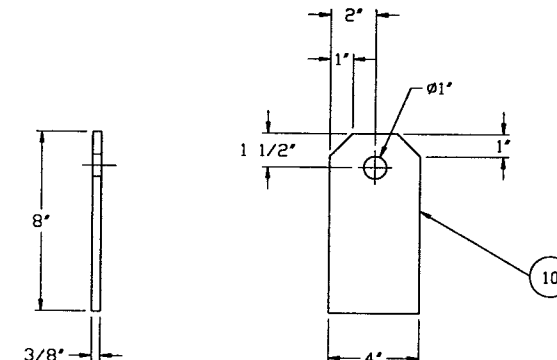
DETAIL "1"

QTY 1

MAKE FROM V049M153-1

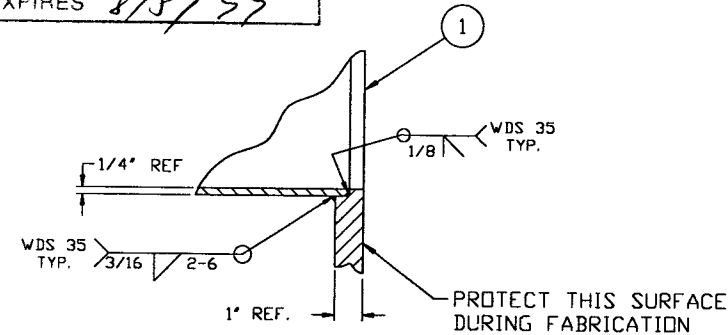


EXPIRES 8/5/97



DETAIL #7

QTY: 2



DETAIL #5

TYP. BOTH END

PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
SPOOL BE-2 60.50" ID LIGD VACUUM EQUIPMENT			
CAD FILE 43E2S2	SIZE D	DWG. NO. V049-4-BE2	REV 2
SCALE AS NOTED	SHEET 2 OF 2		

8 7 6 5 4 3 2 1

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