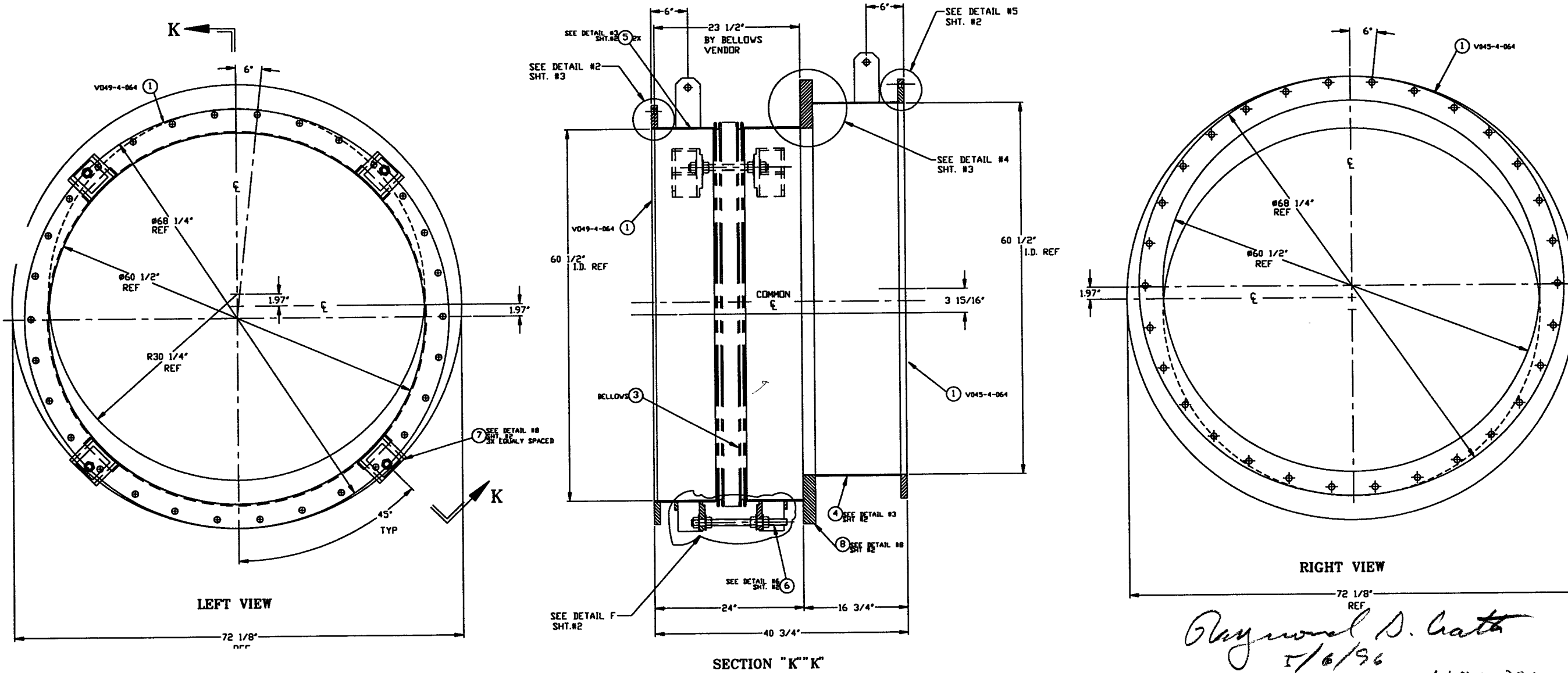


NOTES:

9. LEAK TEST & METHOD PER PSI SPEC. V049-2-014
8. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
7. BOLT HOLES TO STRADDLE NATURAL CENTERLINES AS SHOWN ± .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. SPOOL FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-097.
3. FOR FLANGE DETAILS SEE DWGS.
2. THESE FLANGES EACH INCLUDE AN ANNULAR CHANNEL BETWEEN O-RINGS, MANIFOLD TO A SINGLE PUMPOUT PORT ON EACH CHAMBER, SEE DWG V049-4-
1. REGISTERED TRADEMARK, VARIAN VACUUM PRODUCTS; COMPATIBLE ALTERNATIVES ARE ACCEPTABLE.

ITEM	PART NUMBER	SUFFIX	QTY	UM	DESCRIPTION
1	V049-4-064	3	2		60.5" ID FLANGE DETAIL (FLAT)
2	-	-	-	-	
3	-	3	1		BELLOWS
4	DETAIL #3	3	1		60.5 I.D. SHELL; 304L SST.
5	DETAIL #3	3	2		60.5 I.D. SHELL; 304L SST.
6	DETAIL #6	3	3		TIE ROD; 1-BUNC THREADED ROD 304L SST.
7	DETAIL #7	3	6		8" X 6" X .38" THK. REC. TUBE 304 SST.
8	DETAIL #8	3	1		UNION; 2" THK. 304L SST.
9	-	3	12		NUT, HEX 1-BUNC 304 SST.
10	-	3	8		8" X 6" X .5 THK. REC. TUBE 304 SST.
11	-	3	8		4" X 3.75" X .38 PLAT 304 SST.

**NOTED
CONSTRUCTION**



Raymond D. Gath
5/6/96

LIGD D96116100-V

PROCESS SYSTEMS INTERNATIONAL, INC.
30 WALUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA

OFFSET SPOOL BE-3
60 1/2" ID X 60 1/2" ID
LIGD VACUUM EQUIPMENT

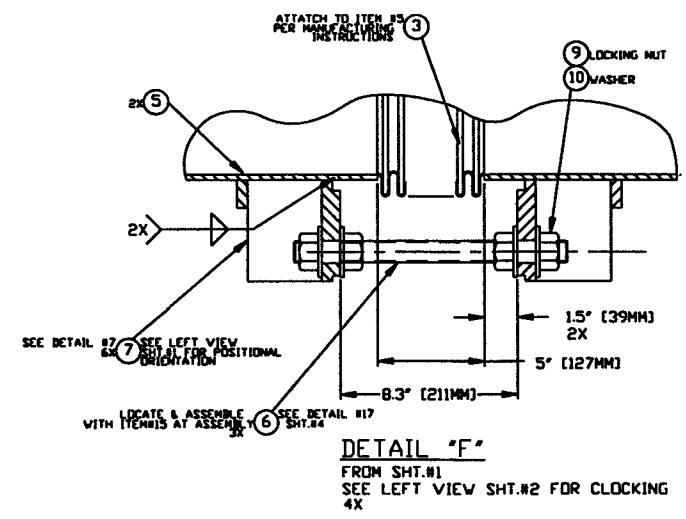
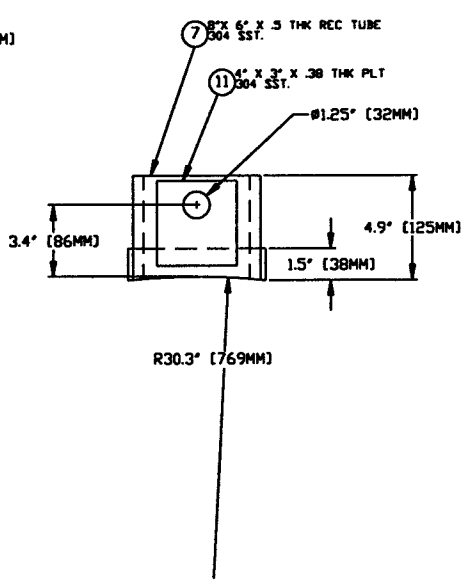
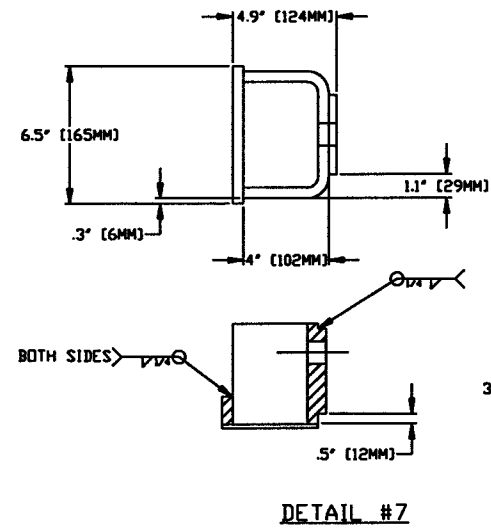
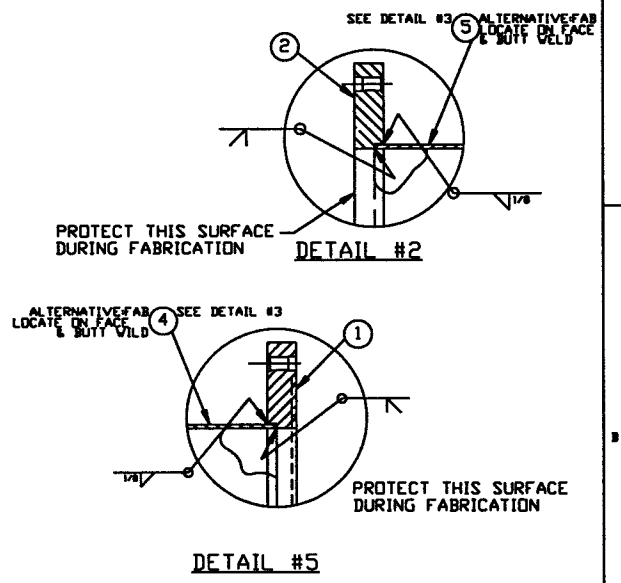
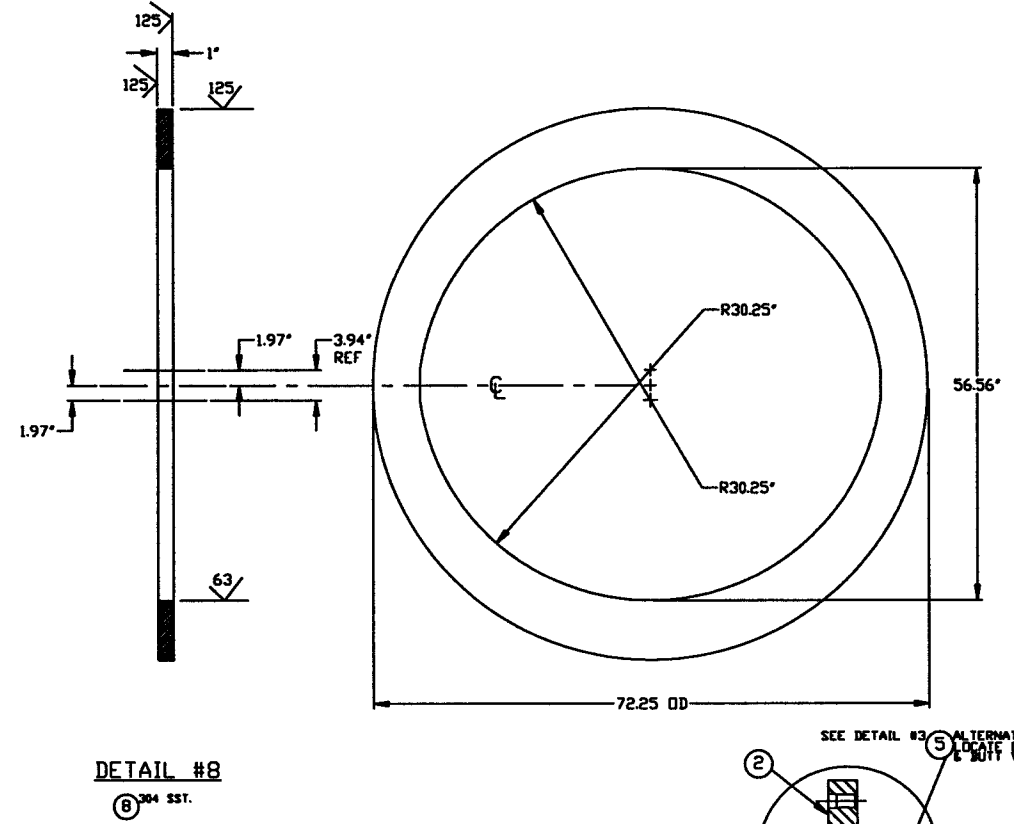
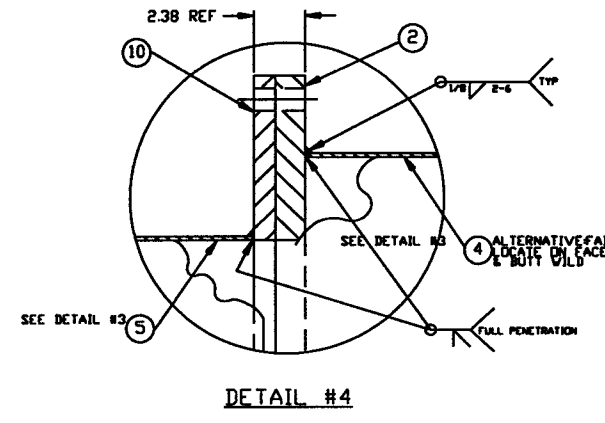
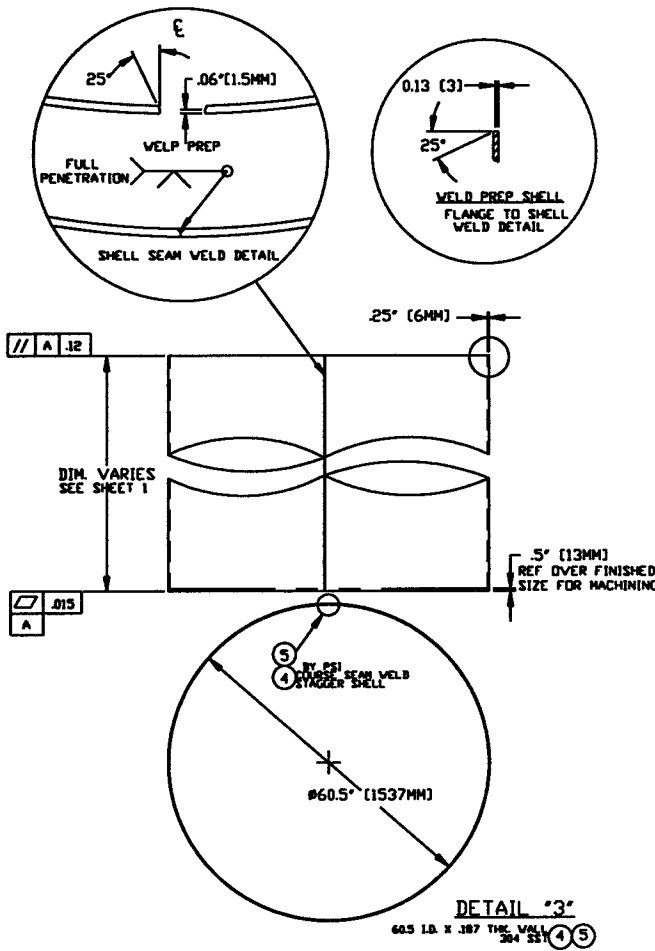
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SCALE: NONE
SHEET: 1 OF 2

DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION
7	REFERENCE DRAWINGS	6	
5		4	
3		2	
1			

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± .01
ANGULAR ± .5°
HOLE POSITION ± .015
HOLE SIZE ± .005
FRESH SURFACE ± .005
SHARP CORNERS ± .005
REMOVE ALL BURRS

DO NOT SCALE THIS DRAWING
USED ON: REV
NEXT ASS'Y:

May 06, 1996 - 074404



NOT FOR CONSTRUCTION
Raymond D. Gatto, PE
 5/6/96
 HOLD

PROCESS SYSTEMS INTERNATIONAL INC. <small>20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA</small>			
OFFSET SPOOL BE-3 60.50"ID x 60.50"ID LIGO VACUUM EQUIPMENT			
CAD FILE 494BE3SE	SIZE D	REV. NO. VD49-4-BE3	REV. 0
SCALE NONE	SHEET 2 OF 2		REV. 0

LIGO 1D961161-00-V

May 06, 1996 - 074353