



- 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: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.
 9. DO NOT MACHINE FLANGE O.D. ALL FORGING MANUFACT. NOS. TO BE LEFT INTACT.

RAYMOND D. CIATTO - PE - WA.
 THIS FLANGE TO BE MADE FROM P/N V049M243-1
 WEIGHT: 230#

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DWG. NO.	DESCRIPTION	USED ON:	REV	DESCRIPTION	CHKD	DRAWN	DATE	DED
	REFERENCE DRAWINGS	NEXT ASS'Y:						
			1	DESIGN UPDATE/FABRICATION	65 RAC DMW RES	SPIDER PV	7/31/96	0218
			0	ISSUED FOR FDR	RDC DMW REC	PV	4/20/96	

PROCESS SYSTEMS INTERNATIONAL, INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
60.5" I.D. X 68.25" O.D. FLANGE DET. (BE-3/BE-3A) (FLAT FACED) LIGO VACUUM EQUIPMENT			
CAD FILE V0494064	SIZE C	DWG NO. V049-4-064	REV. 1
SCALE 1 1/2"=1'-0"		SHEET 1 OF 1	

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