



- 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.

THIS FLANGE TO BE MADE FROM P/N V049M252-1
WEIGHT: 506#

Raymond D. Ciatto - PE - WA.

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DWG. NO.	DESCRIPTION	USED ON
	REFERENCE DRAWINGS	NEXT ASS'Y.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGULAR HATCH ± 0°-30' BEND ± 2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS ± 3.2
BREAK CORNERS: .04005 DIA ± .005
REMOVE ALL BURRS

REV	DESCRIPTION	CHKD	DRAWN	DATE	DED
1	DESIGN UPDATE/FABRICATION			7/31/96	0218
0	ISSUED FOR PDR-INFO			5/21/96	

PROCESS SYSTEMS INTERNATIONAL, INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA	
48.81" I.D. x 68.25 O.D. FLG DETAIL (FLAT FACED) LIGO VACUUM EQUIPMENT	
CAD FILE V0494070	SIZE C
DWG NO. V049-4-070	REV 1
SCALE 1 1/2"=1'-0"	SHEET 1 OF 1