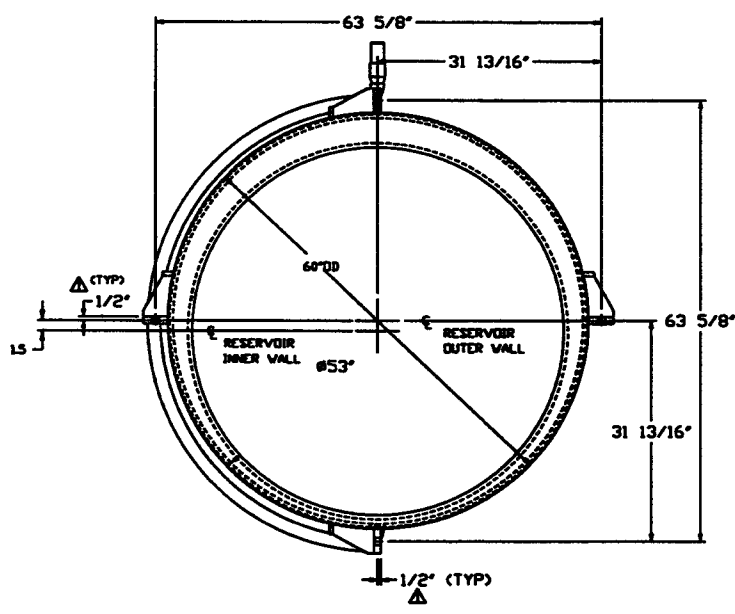
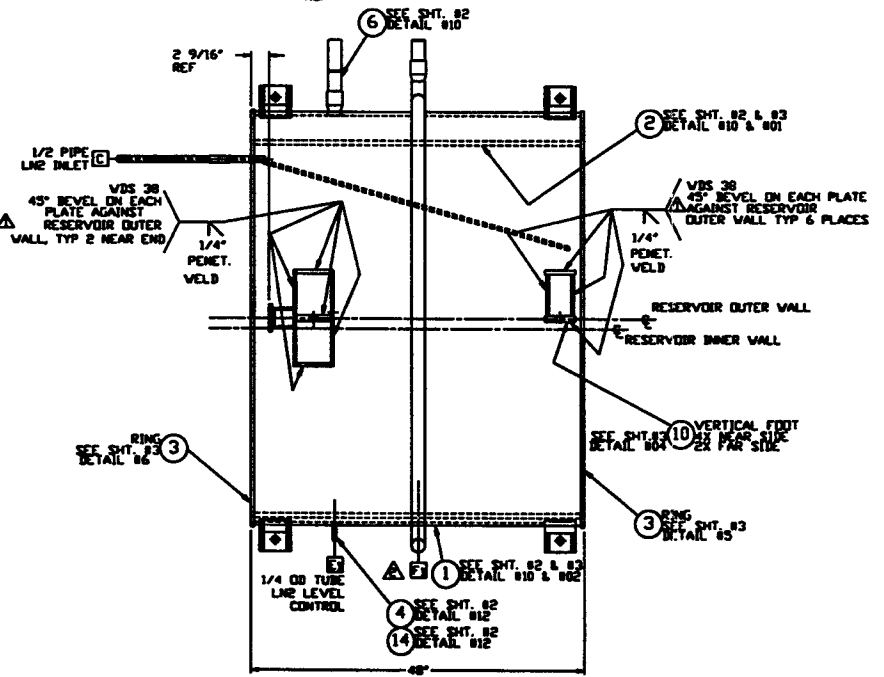
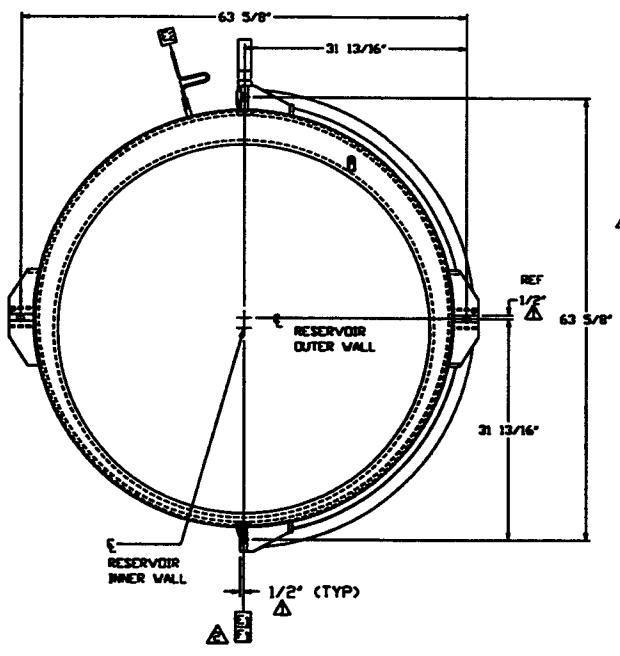
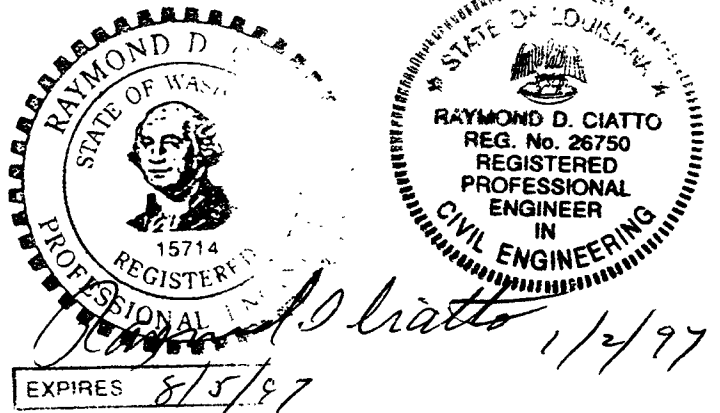
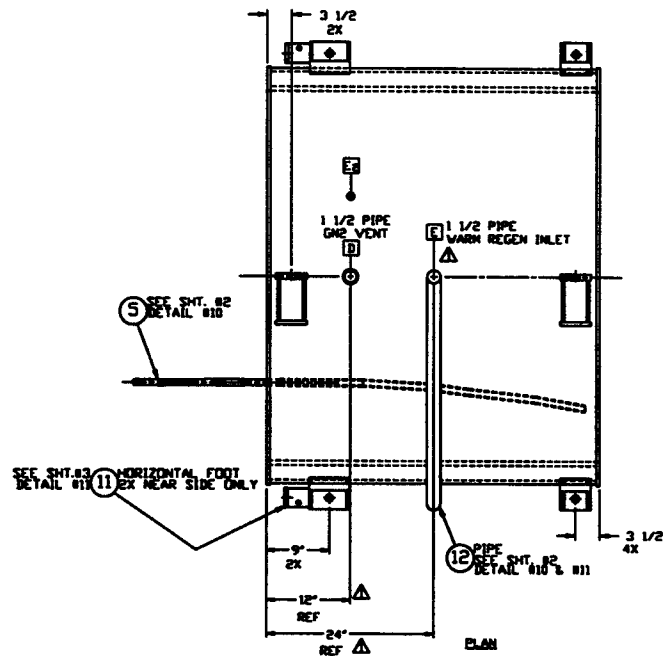


- NOTES
12. VDS NO'S REFER TO WELD DATA SPEC. V049-2-084
 11. 80K PUMP FABRICATION PLAN SPEC. V049-2-082
 10. 80K PUMP QUALITY PLAN SPEC. V049-2-098
 9. HANDLING TO BE ACCORDANCE WITH SPEC. V049-2-120
 8. ROLLING & MACHINING TO BE IN ACCORDANCE WITH SPEC. V049-2-136
 7. EACH FINISHED WELDMENT IS TO BE MARKED WITH A UNIQUE SEQUENTIAL SERIAL NUMBER DEVELOPED FROM THE DRAWING NUMBER PLUS -01 ETC. NUMBER TO BE LOCATED AT OUTSIDE END PLATE
 6. PRESSURE TEST: PNEUMATIC 38 PSIG AT 70° PER PSI PROCEDURE
 5. LEAK TEST & METHOD PER PSI SPEC. V049-2-014, BY PSI.
 4. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
 3. CLEAN INSIDE & OUTSIDE SURFACES PER SPEC. V049-2-015
INSIDE SURFACES TO BE CLEANED PRIOR TO WELD UP.
 2. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
GRINDING ON INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED.
 1. 80K PUMP FABRICATION PLAN SPEC. V049-2-096.

DESIGN DATA	
MAX. OPER. PRESS	15 PSIG
CORROSION ALLOWANCE	0
POSTWELD HEAT TREATMENT	NONE
FIREPROOFING	N/A
RADIOGRAPHING	NONE
MATERIALS	
SHELL	AL. SB209 6061-T6
PIPE NECKS (SEE DETAIL D)	
SUPPORT LUGS	AL. SB209 6061-T6
WEIGHTS EMPTY: 1200#	



<p>PROPRIETARY AND CONFIDENTIAL</p> <p>THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED AND SHALL BE RETURNED TO THE SUPPLIER IN WHOLE OR IN PART TO THE SUPPLIER UPON REQUEST. THE USER SHALL BE RESPONSIBLE FOR THE PROTECTION OF THIS INFORMATION FROM UNAUTHORIZED DISCLOSURE TO OTHERS.</p>				<p>SYMBOL CHARACTERISTIC</p> <p>□ FLATNESS</p> <p>○ CYLINDRICITY</p> <p>// PARALLELISM</p> <p>⊥ PERPENDICULARITY</p> <p>∠ ANGULARITY</p> <p>⊕ TRUE POSITION</p> <p>⊙ CONCENTRICITY</p>	<p>UNLESS OTHERWISE SPECIFIED</p> <p>WELDMENTS ARE TO BE WELDED TO THE FOLLOWING TOLERANCES:</p> <p>1. 1/4" BEVEL ON 1/2" TO 1" DIA. TUBES TO BE WELDED TO THE RESERVOIR SURFACE AND 60° BEVEL ON ALL OTHERS.</p> <p>2. DO NOT SCALE THIS DRAWING</p> <p>3. NEXT ASS'Y: DV049-4-085</p>	<p>2 RE-ISSUED FOR FABRICATION AS NOTED</p> <p>1 REVISED FOR FABRICATION</p> <p>P REVISED FOR PROTOTYPE TEST</p> <p>8 ISSUED FOR FABRICATION</p>
<p>DWG. NO. DESCRIPTION REFERENCE DRAWINGS</p>	<p>DWG. NO. DESCRIPTION</p>	<p>ISSUE DESCRIPTION</p>	<p>DATE</p>			

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80K PUMP RESERVOIR-SHORT-RIGHT

LIGO VACUUM EQUIPMENT

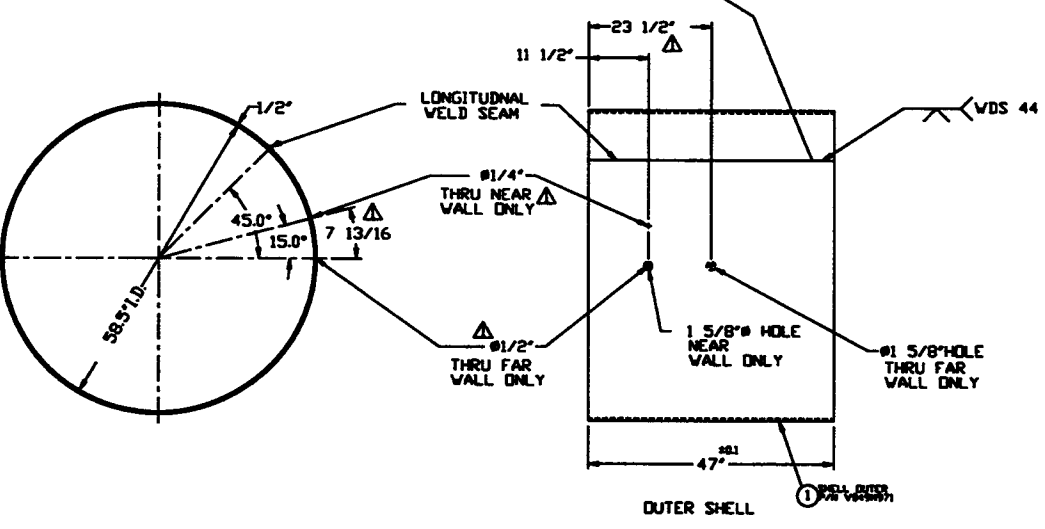
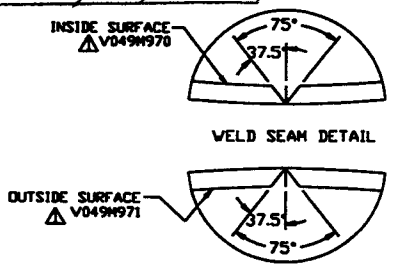
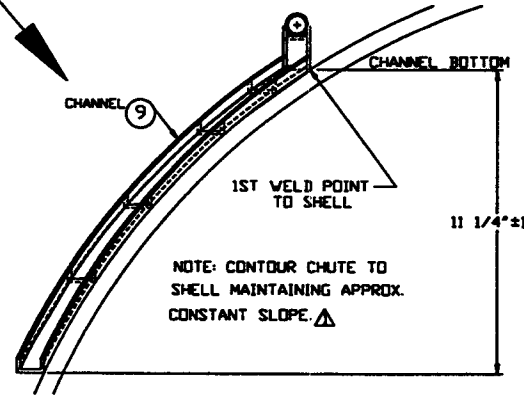
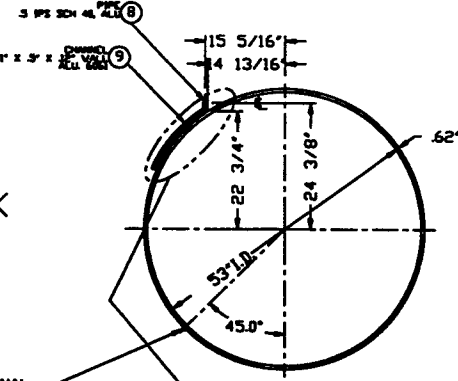
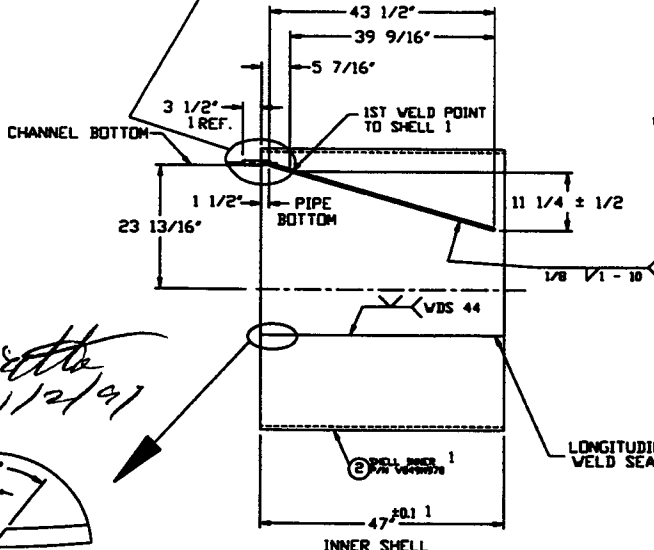
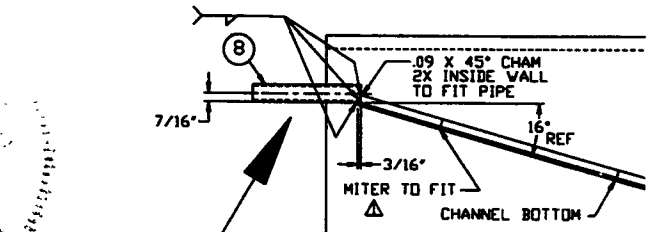
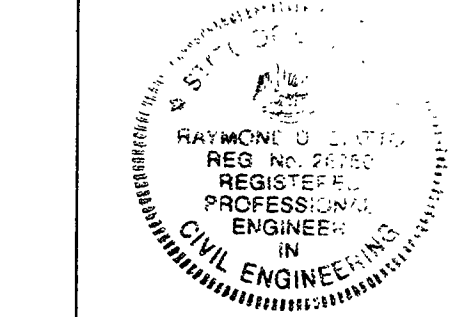
DWG. NO. V049-4-090

REV. 2

SCALE: 1"=1'

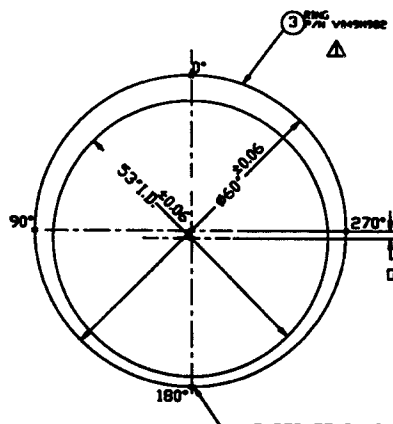
SHEET: 1 OF 3

LIGO-D970362-02-V

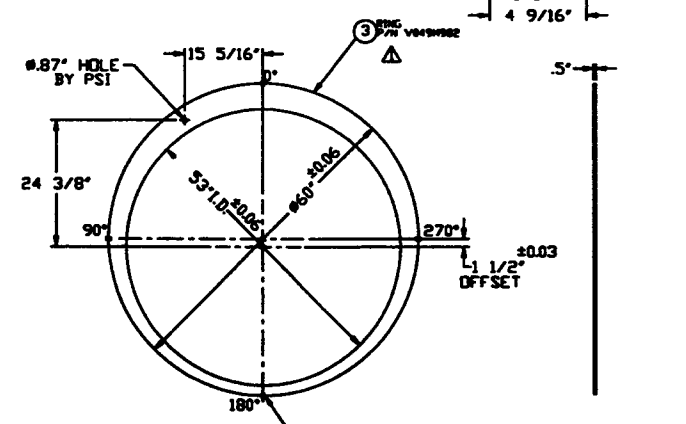


DETAIL #02 FROM SHT. #1

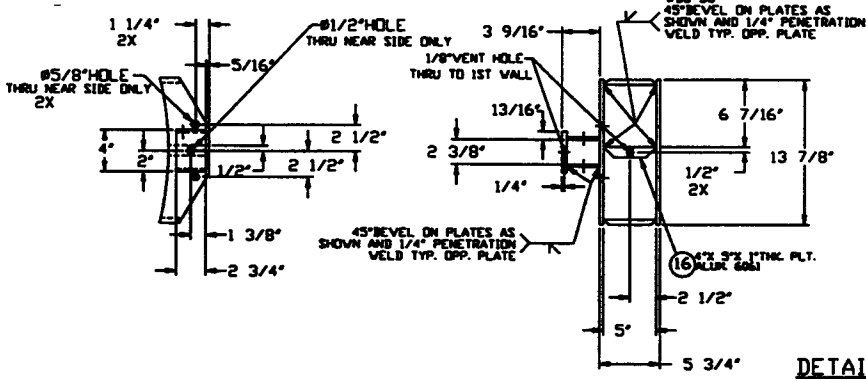
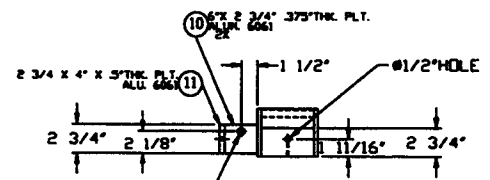
PLATE PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITH IN 1/16 OF EACH OTHER



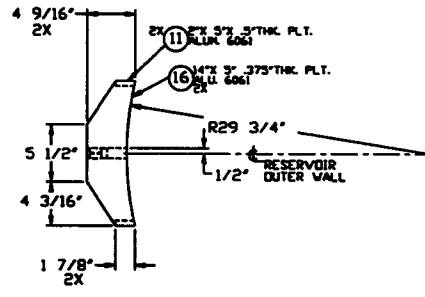
DETAIL #05 STAMP P/N HEAT/LOT NO. ON ONE SIDE



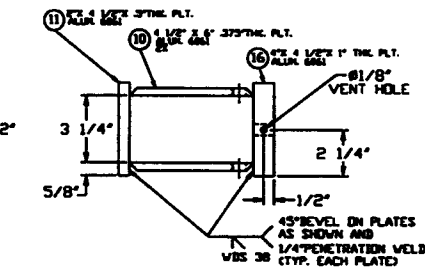
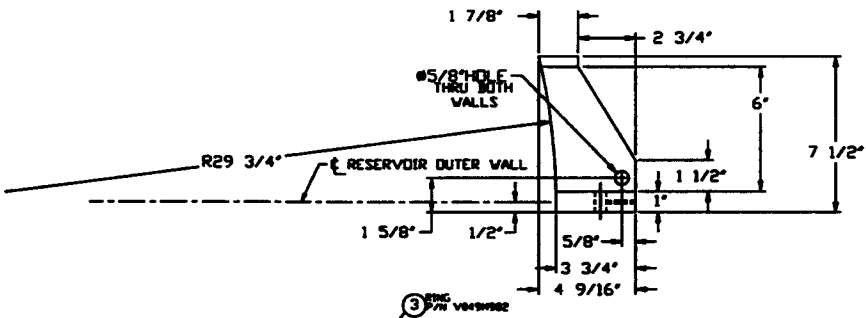
DETAIL #06 STAMP P/N HEAT/LOT NO. ON ONE SIDE



DETAIL #07A HORIZONTAL FOOT 2 REQUIRED



DETAIL #04 FROM SHT. #1 VERTICAL FOOT 6 REQUIRED



SEE SHEET 1 FOR REVISIONS

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80K PUMP RESERVOIR SHORT -RIGHT-			
LIGO VACUUM EQUIPMENT			
ORD. FILE #	SIZE	DWG. NO.	REV.
49489823	D	V049-4-090	2
SCALE	NONE	SHEET	3 OF 3