

NOTE: SHIPPING RODS MUST BE REMOVED AT THE SITE BY THE CONTRACTOR BEFORE OPERATION. (10 PER PUMP)

REV	DESCRIPTION	DATE	BY	CHKD	APPV	ISSUE DESCRIPTION	DATE	BY	CHKD	APPV
4	REVISED FOR FABRICATION AS NOTED	11/21/97	0274							
3	REVISED AS NOTED FOR SPEC V049-041, 050 & 066	07/21/97	0216							
2	REVISED FOR FABRICATION AS NOTED	8/2/97	0220							
1	REVISED FOR FABRICATION	1/22/97	0417							
0	ISSUED FOR PFD UPDATE & FAB	1/15/97	0217							

DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION
8		7	
6		5	
4		3	
2		1	

ISSUE NO.	DESCRIPTION	DATE	BY	CHKD	APPV
3	V049-4-005,007				

DATE	BY	CHKD	APPV
11/21/97	0274		
07/21/97	0216		
8/2/97	0220		
1/22/97	0417		
1/15/97	0217		

FILE NO.	REV	DATE	BY	CHKD	APPV
V049-004	3				

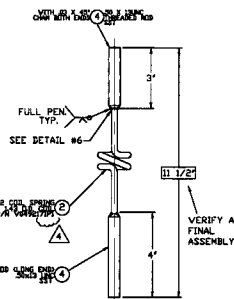
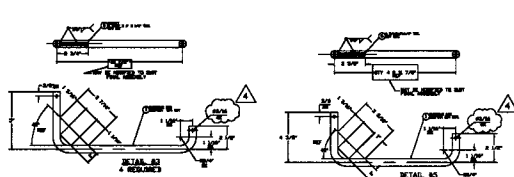
NO.	REV	DATE	BY	CHKD	APPV
1	4				

PROCESS SYSTEMS INTERNATIONAL INC.  
 60K PUMP RESERVOIR SUPPORT ASS'Y  
 SHORT - LEFT & RIGHT -  
 LIGO VACUUM EQUIPMENT  
 V049-4-094

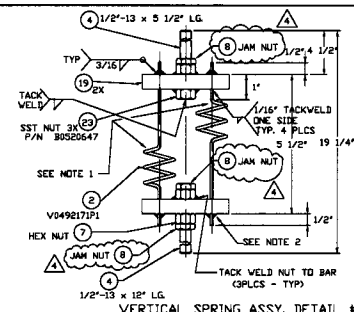
REPRODUCTION PROHIBITED - NOT FOR COMMERCIAL USE

WELD PREP THREADED ROD WITH 15° TO 20° BEVEL.  
 MACHING OFF 1/2" LENGTH OF THREAD  
 WELD PREP SPRING END WITH 45° BEVEL TO POINT

DETAIL #6  
 4 REQ'D



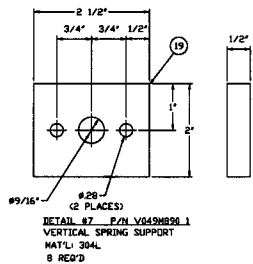
DETAIL #2  
 2 REQUIRED



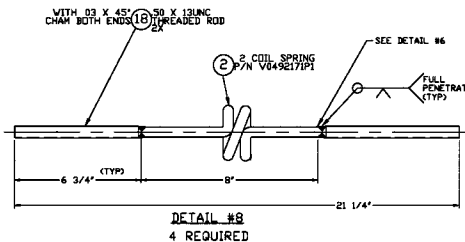
VERTICAL SPRING ASSY. DETAIL #1

NOTES

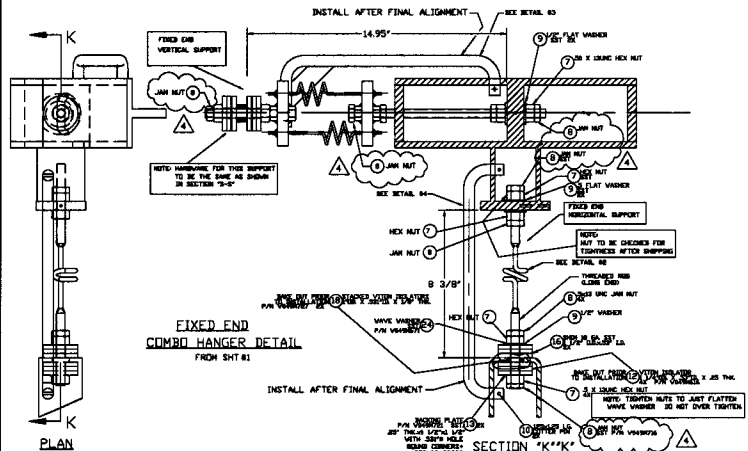
- 1) POSITION FIRST BENDS AWAY FROM EACH OTHER FOR MAXIMUM CLEARANCE
- 2) BEFORE WELDING SPRINGS INTO BAR ASSEMBLIES, THE TWO SPRINGS MUST BE MATCHED FOR SIMILAR SPRING RATES. ALL SPRINGS MUST BE CHECKED AND PAIRED-OFF WITH SIMILAR SPRING RATES AND RECORDED FOR ENGINEERING TO VERIFY USE BEFORE WELDING INTO BARS
- 3) NO THREADS BEYOND END OF NUT



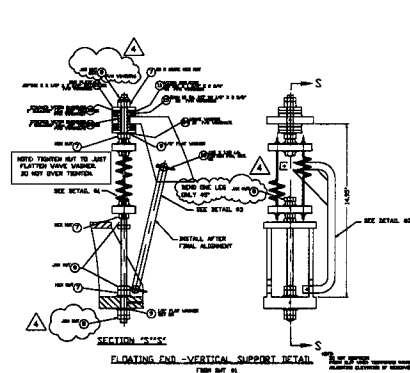
DETAIL #7 P/N V0498858.1  
 VERTICAL SPRING SUPPORT  
 MAT'L 304L  
 8 REQ'D



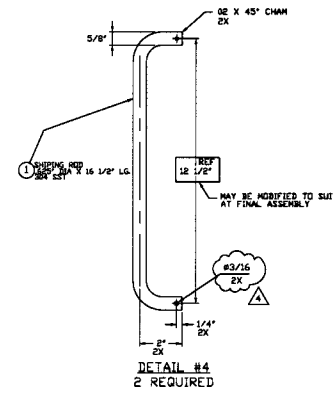
DETAIL #8  
 4 REQUIRED



PLAN



SECTION "K-K"  
 FLOATING END - VERTICAL SUPPORT DETAIL



DETAIL #4  
 2 REQUIRED

SEE SHEET 1 FOR REVISIONS

PROCESS SYSTEMS INTERNATIONAL, INC.  
 20 SOUTH ST., WILMINGTON, MASSACHUSETTS 01890

BOK PUMP RESERVOIR SUPPORT ASSY  
 SHORT - LEFT & RIGHT -

LIGD VACUUM EQUIPMENT

REV	DATE	BY	CHK
4	10/11/84	JD	WV
3	10/11/84	JD	WV
2	10/11/84	JD	WV
1	10/11/84	JD	WV

SCALE: NONE SHEET: 1 OF 2

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