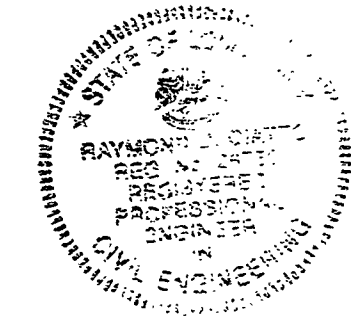


INNER O-RING .275 DIA. STOCK x 227 3/4" LG. VULCANIZED - BAKED VITON E-60C  
 OUTER O-RING .275 DIA. STOCK x 237 1/8" LG. VULCANIZED - BAKED VITON E-60C

- 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: FLANGE FINAL FACE CUTS AND O-RING GROOVES MUST BE MACHINED DURING THE SAME SETUP.
  - 9: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.

THIS FLANGE TO BE MADE FROM V049M246-1  
 WEIGHT: 376#



PROFESSIONAL ENGINEER  
 REGISTERED  
 15714  
 12/19/97

PROPRIETARY AND CONFIDENTIAL THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSE FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED FOR SHALL SUCH INFORMATION BE FURNISHED IN WHOLE OR IN PART TO OTHERS EXCEPT IN ACCORDANCE WITH THE TERMS OF ANY AGREEMENT UNDER WHICH IT WAS SUPPLIED OR WITH THE PRIOR WRITTEN CONSENT OF PROCESS SYSTEMS INTERNATIONAL, INC. AND SHALL BE RETURNED UPON REQUEST.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL: ± 1/16 DECIMAL: ± 0.005 HOLE: ± 0.005 TWO PLACE DECIMAL: ± 0.002 THREE PLACE DECIMAL: ± 0.001 FINISHED SURFACE: RING 32 BREAK CORNERS: ROUNDS OUT-BORES REMOVE ALL BURRS		1 REISSUED FOR FABRICATION 0 ISSUED FOR FABRICATION		DNV GS PEF RDC REC SPIDER PV DA 10/9/96 0294 7/31/96 0218		
DWG. NO.	DESCRIPTION	USED ON	REV.	DESCRIPTION	CHKD	DRAWN	DATE	DCD
	REFERENCE DRAWINGS	NEXT ASS'Y		ISSUE DESCRIPTION				

**PROCESS SYSTEMS INTERNATIONAL, INC.**  
 20 WALPOLE DR. WESTBOROUGH, MASSACHUSETTS 01581 USA  
 72 1/4" I.D. FLANGE DETAIL  
 (GROOVED) (.375 THK. SHELL)  
 LIGO VACUUM EQUIPMENT  
 CAD FILE: V0494096  
 SIZE: C  
 DWG. NO.: V049-4-096  
 SCALE: 1 1/2" = 1'-0"  
 SHEET: 1 OF 1

Oct 11, 1996 12:46:11