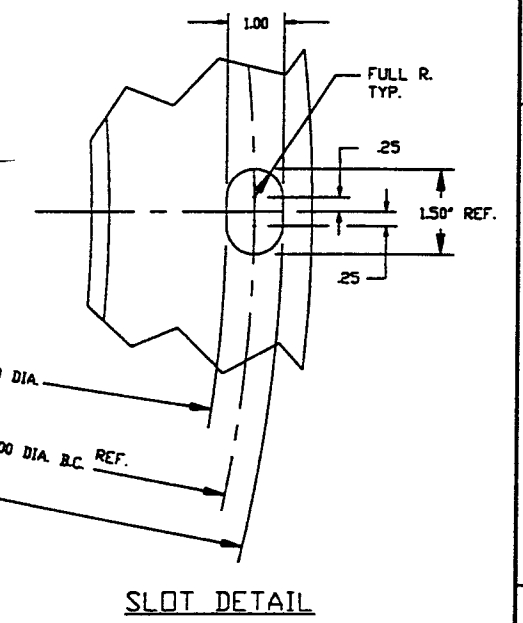


Professional Engineer
STATE OF MASSACHUSETTS
REGISTERED PROFESSIONAL ENGINEER
157
1/21/97
6/15/97



- 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.

THIS FLANGE TO BE MADE FROM P/N V049M247-1
WEIGHT: 274#

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DWG. NO.	DESCRIPTION	USED ON	REV.	DESCRIPTION	CHKD	DRAWN	DATE	DED
			0	ISSUED FOR FABRICATION			7/21/96	0218

PROCESS SYSTEMS INTERNATIONAL, INC.
20 WALSH DR. WESTBOROUGH, MASSACHUSETTS 01581 USA

72 1/4" I.D. FLANGE DETAIL
(FLAT FACED) W/SLOTS
LIGO VACUUM EQUIPMENT

CAD FILE: V0494099
SIZE: C
DWG. NO.: V049-4-099
REV.: 0

SCALE: 1 1/2"=1'-0"
SHEET: 1 OF 1

Sept 20, 1996 - 09:41:52