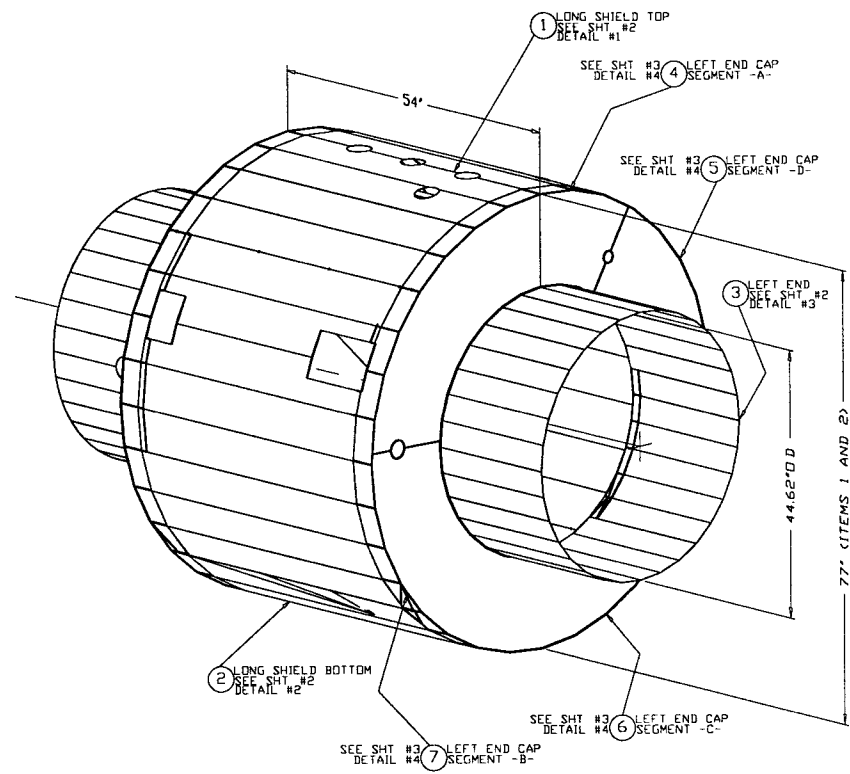


RIGHT END ISO VIEW



ISO VIEW LEFT END

RIGHT SHIELD ASS'Y V049-4-117-G1 AS SHOWN  
LEFT SHIELD ASS'Y V049-4-117-G2 OPPOSITE HAND

NOTE:

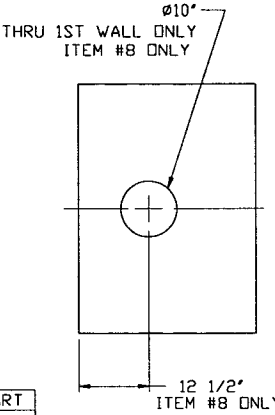
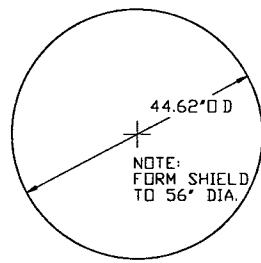
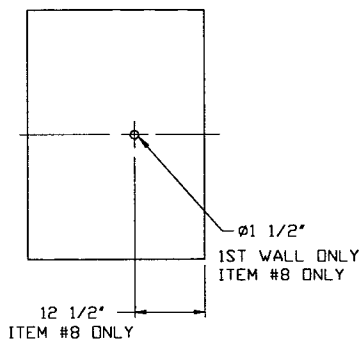
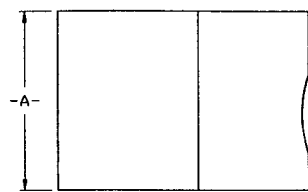
- 1 ALL ALUMINUM SHEET MATERIAL TO BE 5000 SERIES VENDOR TO CONFIRM MATERIAL ALLOY SPECIFICATION, WITH PSI, PRIOR TO FABRICATION
- 2 SEE ADDITIONAL NOTES ON SHT 2 OF 2.

D9770419-02-V

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±0.1 ANGULAR MACH ±0°-30' BEND ±2° TWO PLACE DECIMAL ±0.03 THREE PLACE DECIMAL ±0.015 FINISHED SURFACE RMS BREAK CORNERS IN REMOVE ALL BURRS		2 REISSUED FOR FABRICATION 1 REISSUED FOR FABRICATION 0 ISSUED FOR FABRICATION		DnW PEF GS RDC REC PV TOV DnW PEF GS DM REC TOV DnW PEF GS DM REC TOV		1/31/97 0426 1/3/97 0397 6/18/96 0388		80K PUMP-SHORT-SHIELD DETAIL ASS'Y RIGHT HAND AND LEFT HAND LIGO VACUUM EQUIPMENT	
DO NOT SCALE THIS DRAWING USED ON NEXT ASS'Y: V049-4-005/007		REV DESCRIPTION 2 REISSUED FOR FABRICATION 1 REISSUED FOR FABRICATION 0 ISSUED FOR FABRICATION		ISSUE DESCRIPTION DnW PEF GS DM REC TOV DnW PEF GS DM REC TOV DnW PEF GS DM REC TOV		SCALE NONE SHEET 1 OF 3		CAD FILE 494117S1 SIZE D DWG NO. V049-4-117 REV 2	

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. DATE 01/15/99 BY 1010/30

ANY AND CONFIDENTIAL THIS DRAWING 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, NOR 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.		DWG NO. DESCRIPTION DWG NO. DESCRIPTION REFERENCE DRAWINGS	
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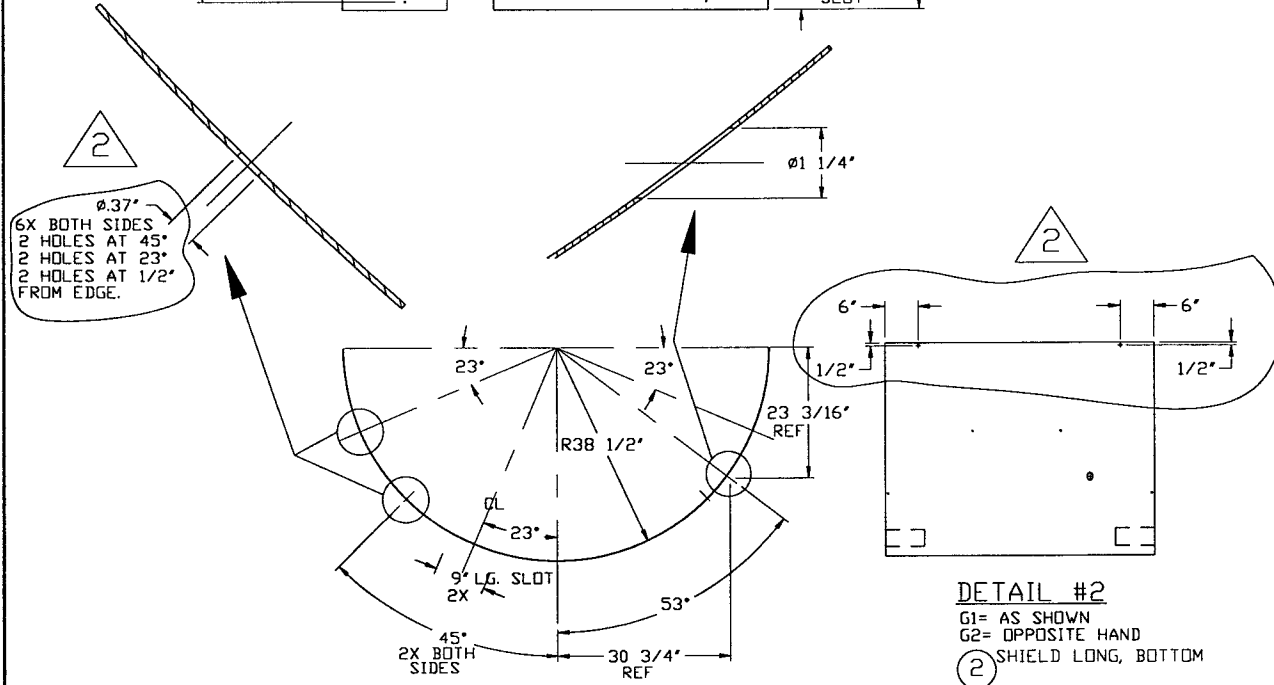
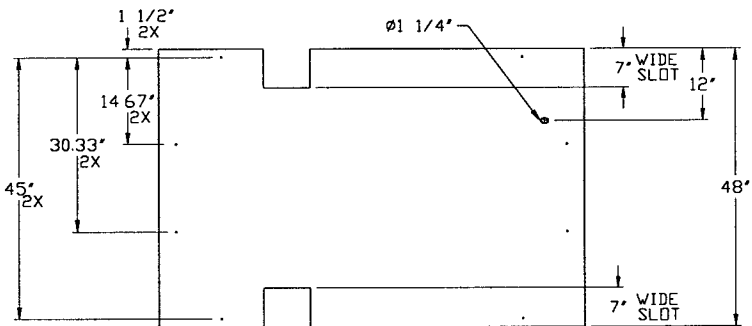
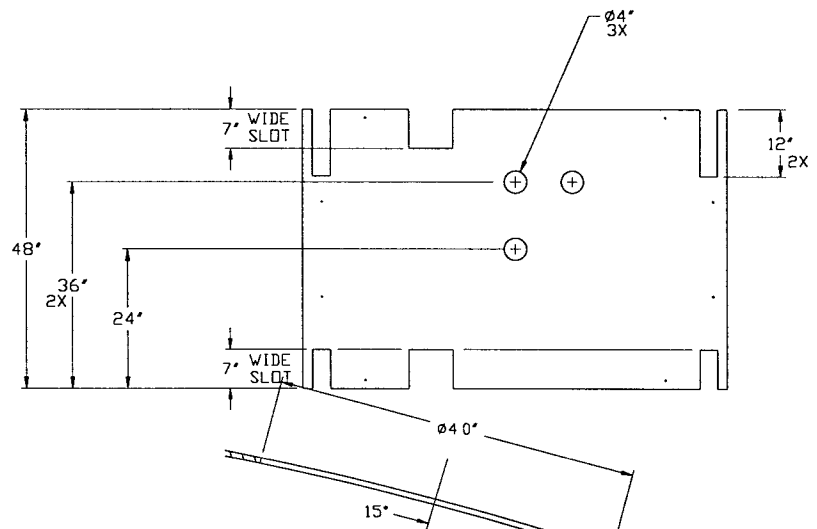


ITEM NO.	DIM -A-
#3	23 1/2"
#8	31 1/2" (SHOWN)

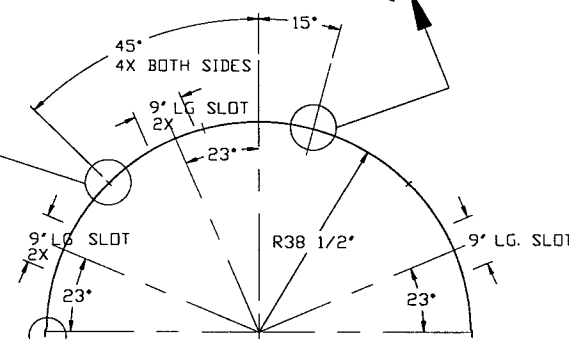
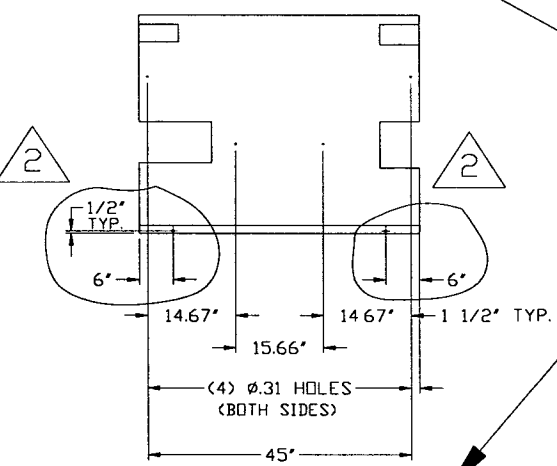
#3-G1 & #8-G1= AS SHOWN  
 #3-G2 & #8-G2= OPPOSITE HAND

NOTE: SHIELDS TO BE PERFERATED WITH 7/16\"/>

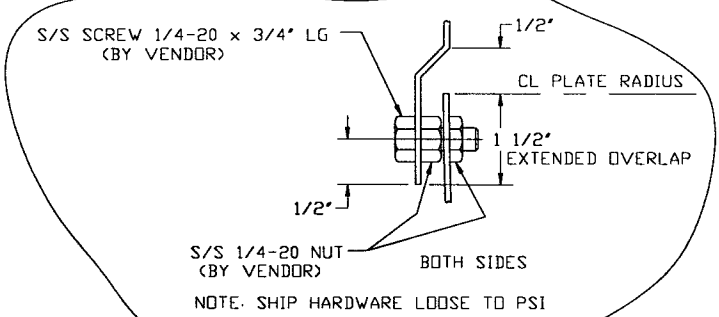
6X BOTH SIDES  
 2 HOLES AT 45°  
 2 HOLES AT 23°  
 2 HOLES AT 1/2\"/>



**DETAIL #2**  
 G1= AS SHOWN  
 G2= OPPOSITE HAND  
 SHIELD LONG, BOTTOM



**DETAIL #1**  
 G1= AS SHOWN  
 G2= OPPOSITE HAND  
 SHIELD LONG, TOP



S/S 1/4-20 NUT (BY VENDOR)  
 BOTH SIDES  
 NOTE: SHIP HARDWARE LOOSE TO PSI

- NOTE
- 1 ALL ALUMINUM SHEET MATERIAL TO BE 5000 SERIES. VENDOR TO CONFIRM MATERIAL ALLOY SPECIFICATION, WITH PSI, PRIOR TO FABRICATION
  - 2 USE TIG WELD PROCESS
  - 3 COVER ROWER/FORMING EQUIPMENT TO PREVENT IRON CONTAMINATION OF SHIELDS
  - 4 COVER DURING STORAGE & SHIPMENT TO PREVENT CONTAMINATION FROM HYDROCARBUNS, CLORIDES & DIRT

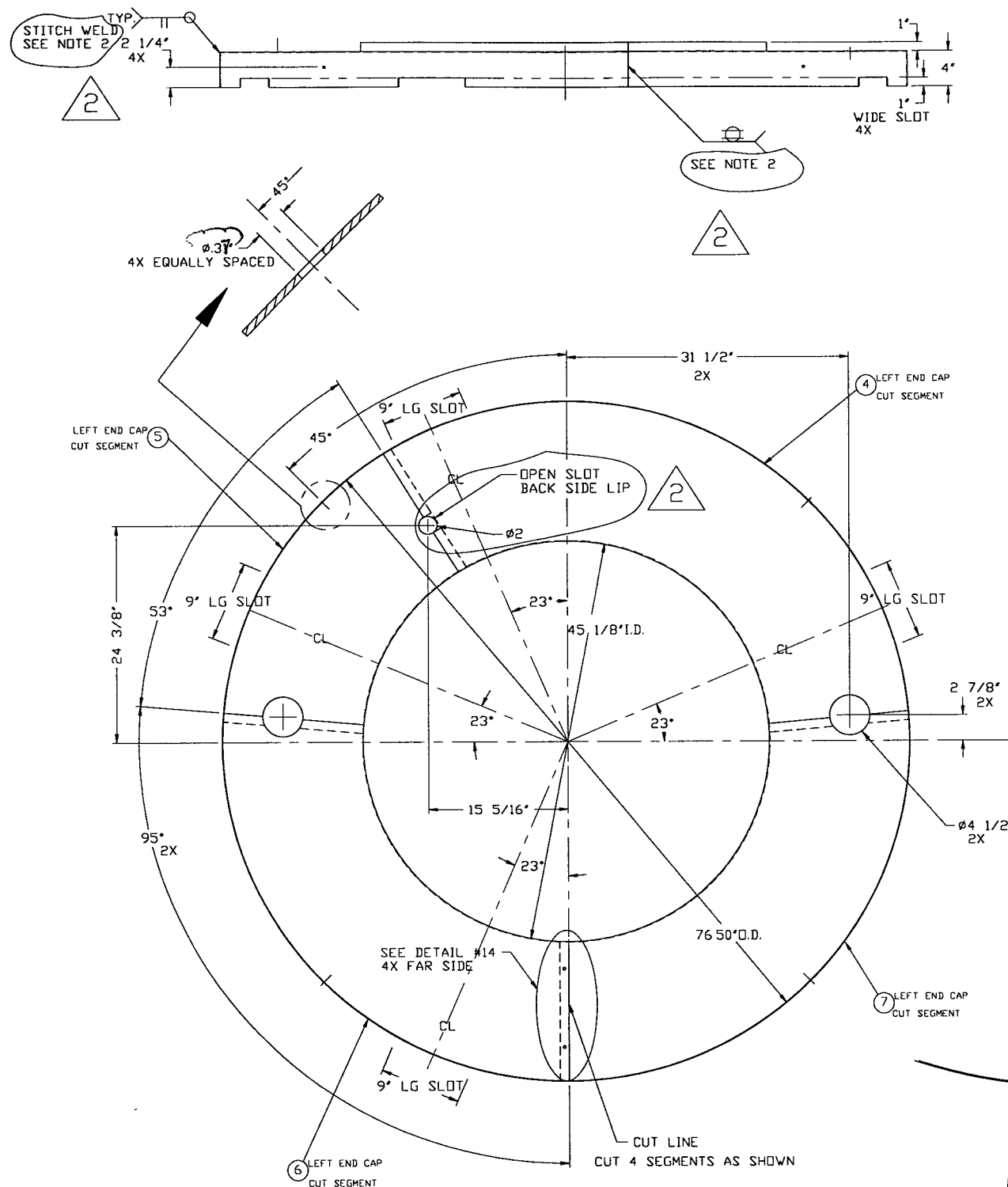
SEE SHEET 1 FOR REVISIONS

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

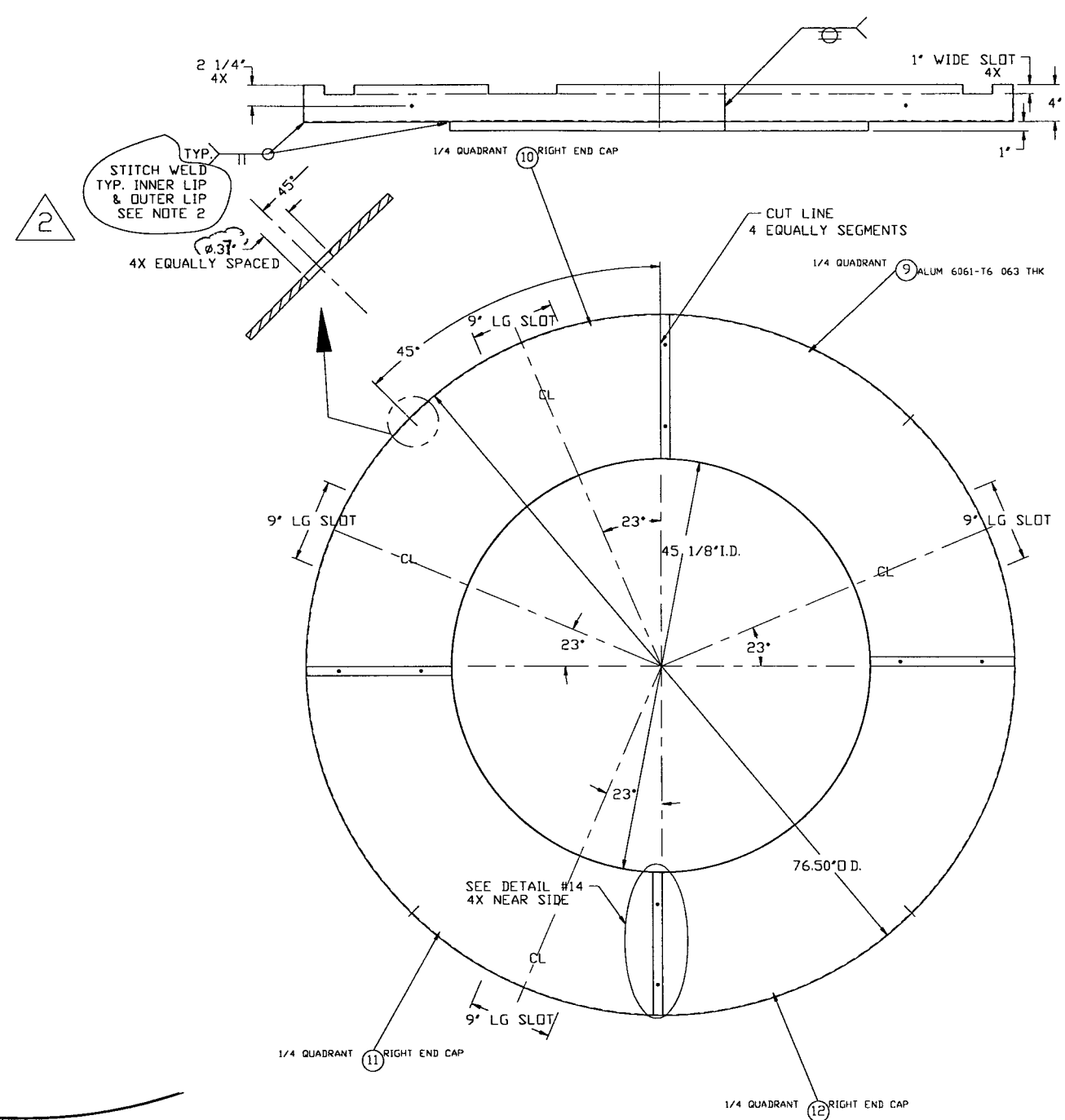
**BOK PUMP-SHORT-SHIELD DETAIL ASSY**  
 RIGHT HAND & LEFT HAND

**LIGD VACUUM EQUIPMENT**

CAD FILE 494117S2	SIZE D	DWG NO V049-4-117	REV 2
SCALE NONE	SHEET 2	OF 3	

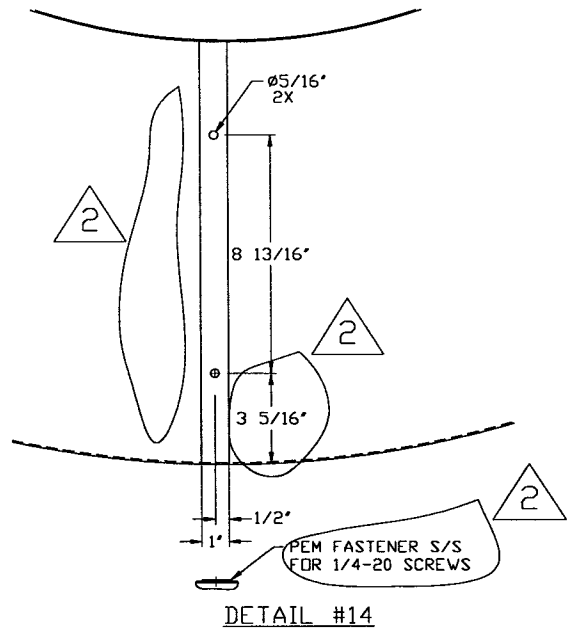


**DETAIL #4 (VIEW INSIDE-OUT)**  
 G1-AS SHOWN  
 G2-OPPOSITE HAND



**DETAIL #9 (VIEW OUTSIDE-IN)**  
 G1-AS SHOWN  
 G2-OPPOSITE HAND

**NOTE**  
 1 ALL ALUMINUM SHEET MATERIAL TO BE 5250 SERIES. VENDOR TO CONFIRM MATERIAL ALLOY SPECIFICATION, WITH PSI, PRIOR TO FABRICATION  
 2 USE TIG WELD PROCESS  
 3 SEE ADDITIONAL NOTES ON SHT 2 OF 3



**DETAIL #14**

SEE SHEET 1 FOR REVISIONS

<b>PROCESS SYSTEMS INTERNATIONAL INC.</b> 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA			
<b>80K PUMP-SHORT-SHIELD DETAIL ASSY</b> <b>RIGHT HAND &amp; LEFT HAND</b>			
<b>LIGD VACUM EQUIPMENT</b>			
CAD FILE 494117S3	SIZE D	DWG NO. V049-4-117	REV 2
SCALE NDNE	SHEET 3 OF 3		