

**ELECTRONIC COPY**

NOTES:  
 1) SEE SHEET #2 FOR GROOVE MACHINING DETAIL  
 2) WELDING PROCESS TO MINIMIZE DISTORTION/FLATNESS OF PLATE VENDOR TO FLATTEN ASSEMBLY AFTER WELDING

LIGO-D990307-02-V

ITEM	PART NUMBER	QTY	U/M	DESCRIPTION
4	304 S/S	1	EA	HALF NIPPLE, 3/4" OD TUBE X 2 3/4" LF
3	304 S/S	1	EA	HALF NIPPLE, 6" OD TUBE X 8" CF X 5" LG
2	3326	SF		PLATE, 3/4" THK X 5'-9" SQ, 304 SS
1	34'-11" FT			W/ BEAM, W6 X 16 MAT. A36

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

TESTING COVERS, 60" NOMINAL GROOVED WITH PORT LIGO VACUUM EQUIPMENT

CAB FILE: V0494190  
 SHEET: 1 OF 2  
 SCALE: 1/8"

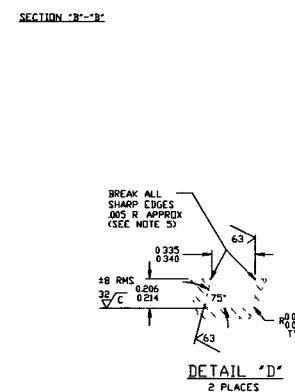
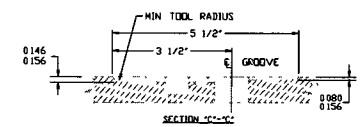
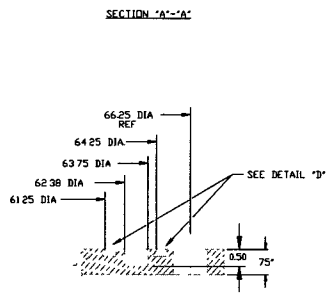
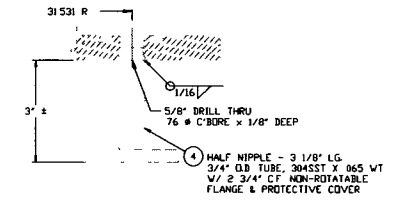
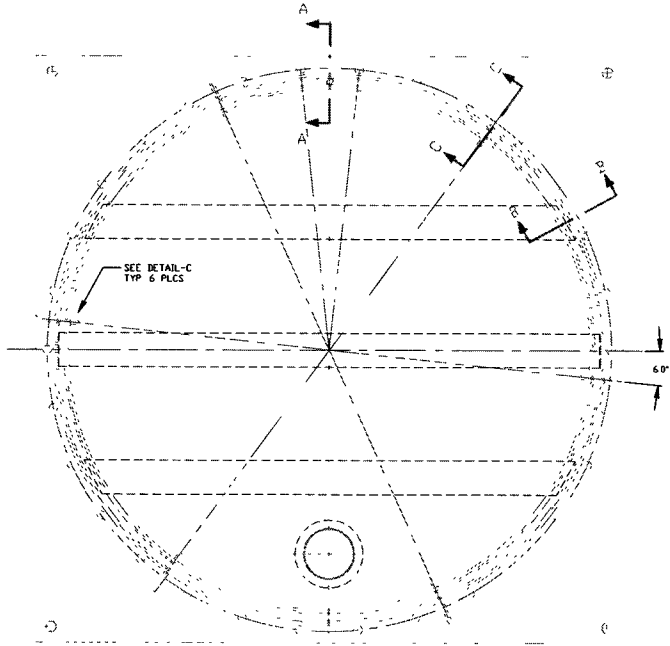
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DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION
8	REFERENCE DRAWINGS	6	
7		5	

REV	DESCRIPTION	CHKD	DRWN	DATE	DESN
2	REISSUED FOR FABRICATION / AS NOTED			05/20/97	D488
1	ISSUED FOR FABRICATION	PEF	GS	2/8/97	0405
0	ISSUED FOR FABRICATION			1/14/96	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES: FRACTIONS & ANGULAR APPROX. 15'-30" NOM. 12" TYP. PLATE DECIMAL & 0.005 FINISHED SURFACE AND BREAK CORNERS BY REMOVE ALL DIMS
DO NOT SCALE THIS DRAWING
USED ON
NEXT ASS'Y

ANY REV. 1997 - 090826



# ELECTRONIC COPY

- NOTE**
1. FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE. SEE SPECIFICATION V049-2-840 FOR MATERIAL REQUIREMENTS.
  2. ALL MATERIAL TO BE 304L STAINLESS STEEL. SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS.
  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.

INNER O-RING .275 DIA STOCK x 191.25 LG - P/N V049M023  
 OUTER O-RING .275 DIA STOCK x 200.625 LG - P/N V049M022

SEE SHEET 1 FOR REVISIONS

<b>PROCESS SYSTEMS INTERNATIONAL INC.</b> 20 WALCUP DR WESTBOROUGH MASSACHUSETTS 01581 USA			
TESTING COVERS, 60° NOMINAL GROOVE MACHINING			
LIGO VACUUM EQUIPMENT			
CAD FILE	SIZE	ENG. NO.	REV
4190S2	D	V049-4-190	2
SCALE	SHEET		2 OF 2
1/8			

EDUCATION VERSION - NOT FOR COMMERCIAL USE

May 20, 1997 - 090058