

ELECTRONIC COPY

NOTES:
1) WELDING PROCESS TO MINIMIZE DISTORTION/FLATNESS OF PLATE. VENDOR TO FLATTEN ASSY AFTER WELDING.

LIGO-D990308-00-V

ITEM	PART NUMBER	QTY	U/M	DESCRIPTION
3	304 S/S	1	EA	HALF NIPPLE, 3/4" OD TUBE X 2 3/4" CF
3	304 S/S	1	EA	HALF NIPPLE, 6" OD TUBE X 8" CF X 5" LG
2		195	SF	PLATE, 3/4" THK X 5'-9" SQ, 304 SST
1		11'-1"	FT	"V" BEAM, W6 X 12, MAT'L A36

BILL OF MATERIALS

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DWG NO	DESCRIPTION	DWG NO	DESCRIPTION
	REFERENCE DRAWINGS		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± ANGULAR APPROX 10°-30° BEND ±2°
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS
BREAK CORNERS IN OUT REMOVE ALL BURRS

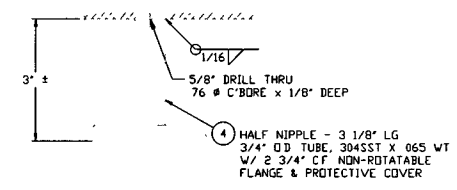
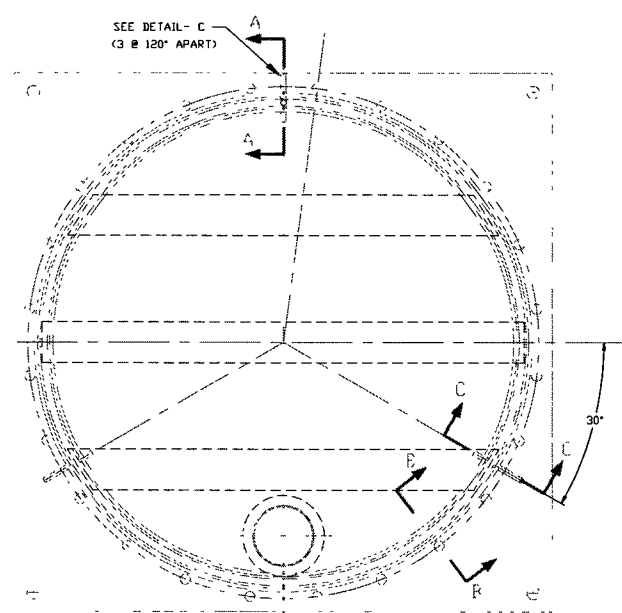
DO NOT SCALE THIS DRAWING	REV	ISSUED FOR FABRICATION	CHKD	BRWN	DATE	DCDR
	0				1/14/96	
USED ON	REV	DESCRIPTION	CHKD	BRWN	DATE	DCDR
NEXT ASS'Y						

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

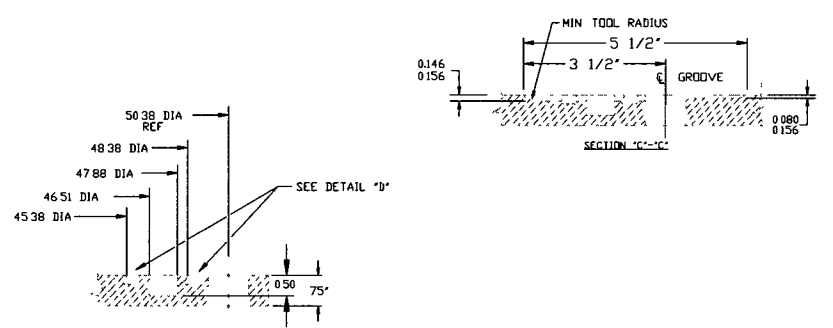
TESTING COVERS, 44 X 50.38" NOMINAL
LIGO VACUUM EQUIPMENT

CAD FILE: V0494191
SIZE: D
DWG NO: V049-4-191
REV: 0

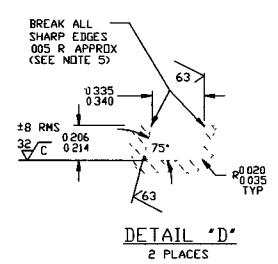
SCALE: 1/8" SHEET: 1 OF 2



SECTION 'A'-'A'



SECTION 'B'-'B'



DETAIL 'D'
2 PLACES

- NOTE**
- 1 FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL 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

INNER O-RING 275 DIA STOCK x 141.93' LG - P/N V049M033
 OUTER O-RING 275 DIA STOCK x 151.25' LG - P/N V049M032

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SEE SHEET 1 FOR REVISIONS

PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA			
TESTING COVERS, 44" X 50.38 B.C. GROOVE MACHINING			
LIGO VACUUM EQUIPMENT			
CAD FILE	SIZE	DWG. NO.	REV.
419152	D	V049-4-191	0
SCALE	1/8	SHEET	2 OF 2

ELECTRONIC VERSION - NOT FOR COMMERCIAL USE

Feb 08, 1997 - 140711