

ELECTRONIC COPY

ELEVATION

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

LIGO-D990309-00-V

ITEM	PART NUMBER	QTY	UOM	DESCRIPTION
4	334 S/S	1	EA	HALF NIPPLE, 3/4" OD TUBE X 2 3/4" OD CF
3	394 S/S	1	EA	HALF NIPPLE, 6" OD TUBE X 6" OD LF X 5' LG
2		1	EA	PLATE, 3/4" THK X 7'-9" SQ 304 SST
1		17-7'	FT	"V" BEAM, W8 X 18 MAT'L A36

BILL OF MATERIALS

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

TESTING COVERS, 84" NOMINAL WITH O-RING GROOVES LIGO VACUUM EQUIPMENT

CAD FILE: V0494193
SIZE: 0
DWG NO: V049-4-193
REV: 0

APPROX WEIGHT = 2250 LBS

DWG NO	DESCRIPTION	DWG NO	DESCRIPTION

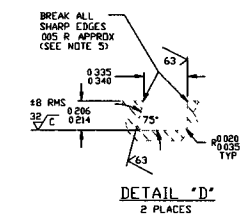
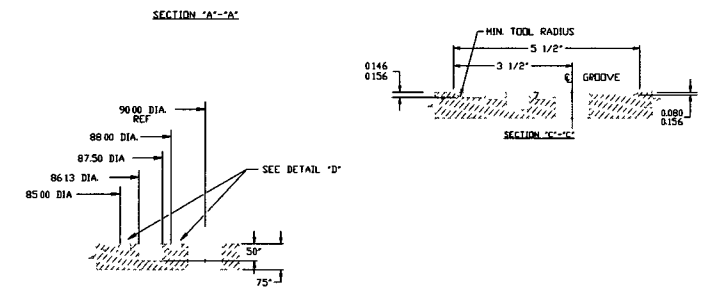
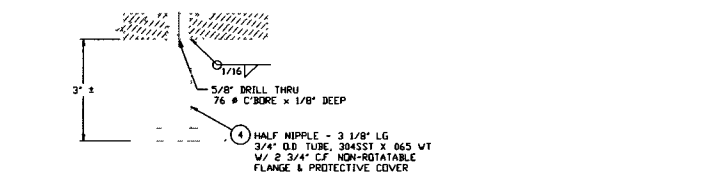
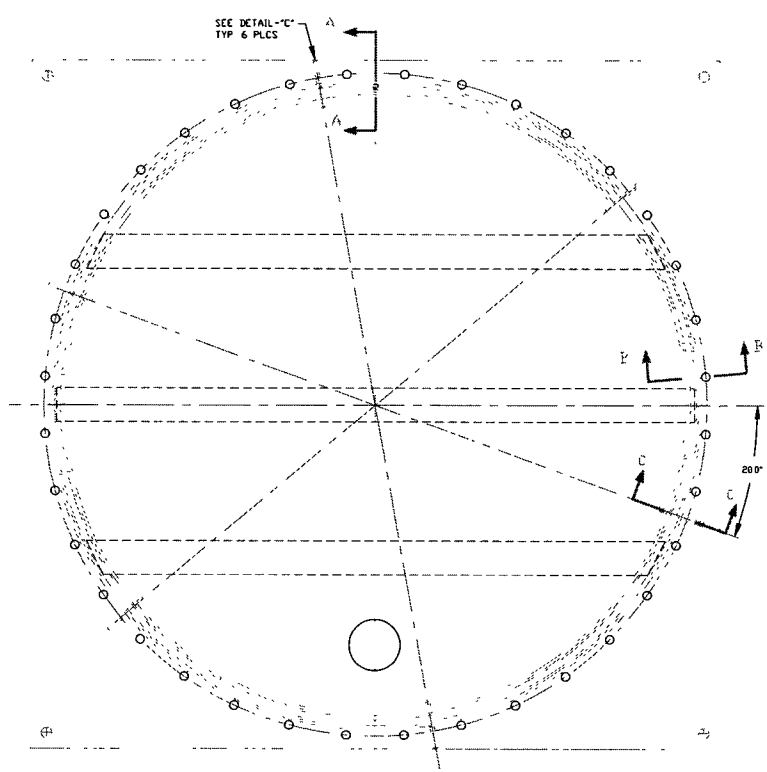
REFERENCE DRAWINGS

REV	DESCRIPTION	CHKD	DRWN	DATE	DESN
0	ISSUED FOR FABRICATION			04/04/97	0454

DO NOT SCALE THIS DRAWING
USED ON: _____
NEXT ASS'Y: _____

SCALE: NONE SHEET: 1 OF 2

FOR COMMERCIAL USE



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- 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 265125 LG P/N V049M019
 OUTER O-RING 275 DIA STOCK x 274375 LG P/N V049M018

SEE SHEET 1 FOR REVISIONS

PROCESS SYSTEMS INTERNATIONAL INC. <small>20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA</small>			
TESTING COVERS, 84" NOMINAL GROOVE MACHINING LIGD VACUUM EQUIPMENT			
CAD FILE	SIZE	REV. NO.	REV.
41935E	D	V049-4-193	0
SCALE	NONE	SHEET	2 OF 2