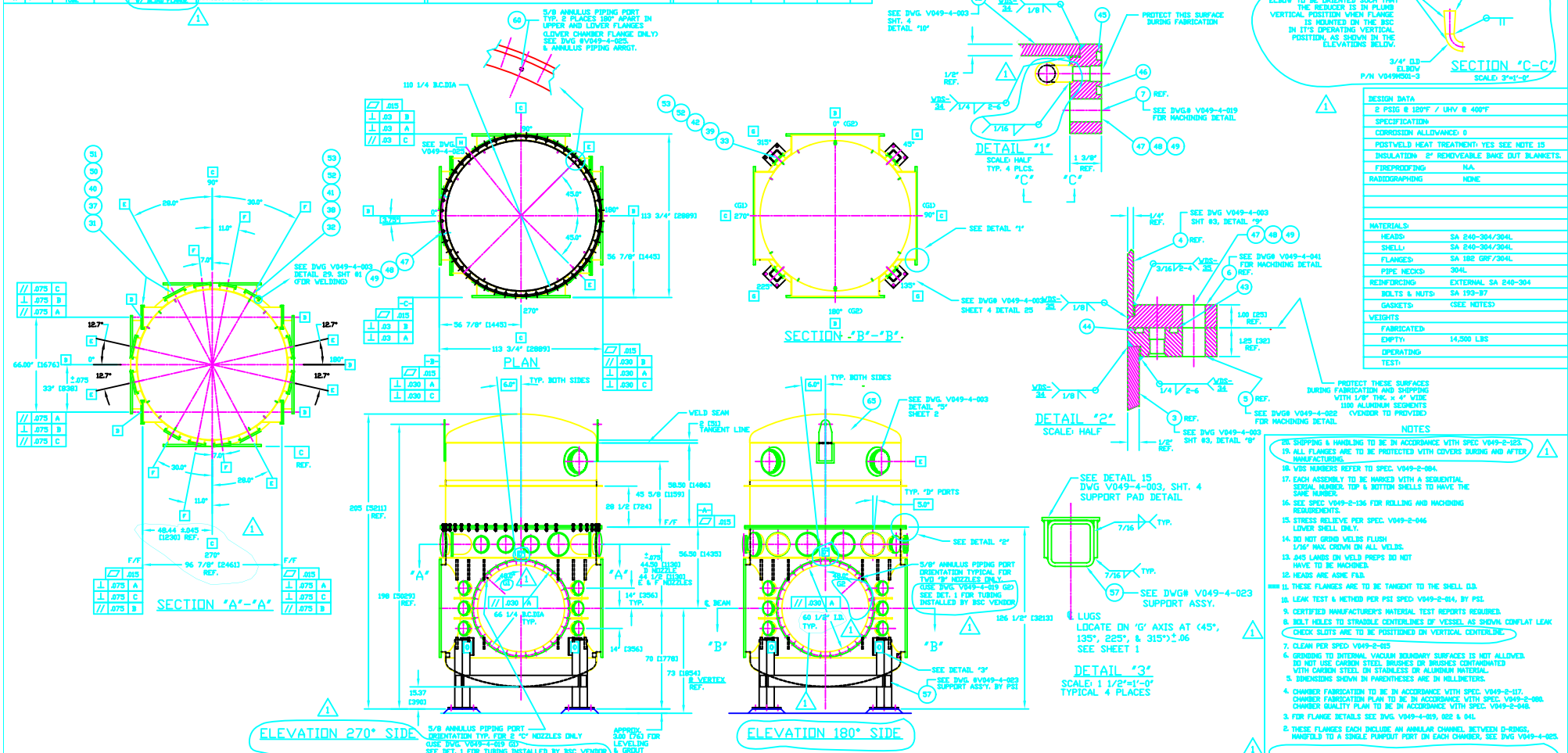
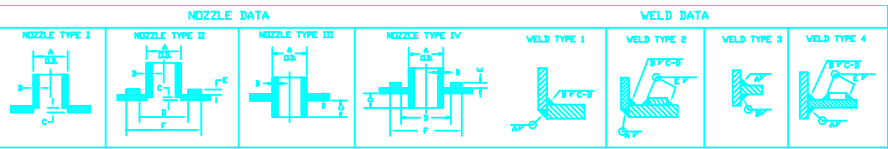


MARK	QTY	SIZE	NOZZLE SCHEDULE		DESCRIPTION	NOZZLE TYPE							WELD TYPE						
			TYPE	TYPE		A	B	C	D	E	F	TYPE	A	B	C	D	E		
A	1	104 1/2" I.D.	SEE NOTES 2, 6 & 9		MAJOR ACCESS	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
B	2	60 1/2" I.D.	SEE NOTES 2, 6 & 9		LASER BEAM ACCESS	SEE DETAIL 83 SHEET 81, DWG V049-4-003													
C	2	60 1/2" I.D.	SEE NOTES 2, 6 & 9		ACCESS	SEE DETAIL 83 SHEET 81, DWG V049-4-003													
D	4	1 1/2" O.D. TUBE	1/2" O.D. CONFLAT 1/2" B.U.M. FLANGE		SUPPORT BEAMS	1	1/4"	100	1/4"										
E	8	1 1/2" O.D. TUBE	1/2" O.D. CONFLAT 1/2" B.U.M. FLANGE		AIR SHAWL, HOODING & ION PUMPS, UTILITY	1	1/4"	100	SEE DETAIL 2 & 2										
F	6	1 1/2" O.D. TUBE	1/2" O.D. CONFLAT 1/2" B.U.M. FLANGE		ELECTRODIAL FEEDTHROUGHS	1	1/4"	100	1/4"										
G	10	1 1/2" O.D. TUBE	1/2" O.D. CONFLAT 1/2" B.U.M. FLANGE		OBSERVATION BEAM PICK-OFFS	1	1/4"	100	1/4"										
H	1	2 1/2" O.D. TUBE	1 1/2" O.D. CONFLAT 1/2" B.U.M. FLANGE		ANNUALUS PIPES/OUT CONN.	SEE DWG V049-4-005													



NOTE: THESE PARTS ARE TO BE INSTALLED BY SSC VENDOR. ELBOW TO BE ORIENTED SUCH THAT THE REDUCER IS IN PLUMB VERTICAL POSITION WHEN FLANGE IS MOUNTED IN THE BSC IN ITS OPERATING VERTICAL POSITION, AS SHOWN IN THE ELEVATIONS BELOW.

REDUCER 1 1/2" O.D. P/N V049060-3

3/4" O.D. ELBOW P/N V049060-3

SECTION "C-C" SCALED 3/4"=1'-0"

DESIGN DATA

DESIGN SPECIFICATION	2 PSIG @ 180°F / UNV @ 400°F
SPECIFICATION	
CORROSION ALLOWANCE	0
POSTWELD HEAT TREATMENT	YES SEE NOTE 15
INSULATION	2" REMOVABLE BAKE OUT BLANKETS
FIREPROOFING	NA
RADIOGRAPHING	NONE

MATERIALS:

HEADS	SA 240-304/304L
SHELL	SA 240-304/304L
FLANGES	SA 182 GRF/304L
PIPE NEEDS	304L
REINFORCING	EXTERNAL SA 240-304
BOLTS & NUTS	SA 193-B7
GASKETS	(SEE NOTES)

WEIGHTS

FABRICATED	
EMPTY	14,500 LBS
OPERATING	
TEST	

NOTES

1. SHOPPING & HANDLING TO BE IN ACCORDANCE WITH SPEC V049-2-023.
2. ALL FLANGES ARE TO BE PROTECTED WITH COVERS DURING AND AFTER MANUFACTURING.
3. WBS NUMBERS REFER TO SPEC V049-2-064.
4. EACH ASSEMBLY TO BE MARKED WITH A SERIAL/IDENTIFICATION NUMBER, TOP & BOTTOM SHELLS TO HAVE THE SAME NUMBER.
5. SEE SPEC V049-2-136 FOR ROLLING AND MACHINING REQUIREMENTS.
6. STRESS RELIEVE PER SPEC V049-2-046.
7. LOWER SHELL ONLY.
8. DO NOT BRID WELLS FLUSH 1/8" MAX. CROWN ON ALL WELLS.
9. OWS LANDS ON WELD PREPS TO NOT HAVE TO BE WACHED.
10. HEADS ARE ASSE F.B.W.
11. THESE FLANGES ARE TO BE TAKEN TO THE SHELL O.D.
12. LEAK TEST & METHOD PER PSE SPEC V049-2-014, BY PSE.
13. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
14. BOLT HOLES TO STRABLE CENTERLINES OF VESSEL, AS SHOWN CONFLAT LEAK CHECK SLOTS ARE TO BE POSITIONED ON VERTICAL CENTERLINE.
15. CLEAN PER SPEC V049-2-045.
16. GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
17. DIMENSIONS SHOWN IN PARENTHESES ARE IN MILLIMETERS.
18. CHAMFER FABRICATION TO BE IN ACCORDANCE WITH SPEC V049-2-017.
19. CHAMFER FABRICATION PLAN TO BE IN ACCORDANCE WITH SPEC V049-2-006.
20. CHAMBER QUALITY PLAN TO BE IN ACCORDANCE WITH SPEC V049-2-048.
21. 3 FOR FLANGE DETAILS SEE DWG V049-4-005, 002 & 041.
22. THESE FLANGES EACH INCLUDE AN ANNUALUS CHANNEL BETWEEN D-RINGS, W/ANGLES TO A SINGLE PURPORT PORT ON EACH CHAMBER. SEE DWG V049-4-005.

DISCREPANCY AND CONFIDENTIAL	REV	DATE	DESCRIPTION	ISSUE DESCRIPTION
V049-4-077	1	1/27/97	75 L/S ION PUMP	ISSUED FOR FABRICATION
V049-4-023	1	8/28/96	BSC SUPPORT ASSEMBLY	ISSUED FOR FABRICATION
V049-4-014	1		60" COVER TYPE I	
V049-4-036	1		BSC FLOOR ASSY.	
V049-4-025	1		BSC ANNUALUS PIPING ARRGT.	
V049-4-122	1		LIGD BEAM SPLITTER CHAMBER	
V049-4-003	1		BSC WELDMENT	
V049-4-003	1		BSC-75 ION PUMP SUPPORT	
DWG. NCL			DESCRIPTION	ISSUE DESCRIPTION

PROCESS SYSTEMS INTERNATIONAL INC.
 100 WILSON ST. WESTBOROUGH, MASSACHUSETTS 01581 USA

BSC OVERALL ASSEMBLY
 LIGD VACUUM EQUIPMENT

SCALE: 3/4"=1'-0"

DATE: 1/27/97

REV: 1

SHEET: 1 OF 1