



- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING 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: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING
  - 9: DO NOT MACHINE FLANGE O.D. ALL FORGING MANUFACT. NDS. TO BE LEFT INTACT.

THIS FLANGE TO BE MADE FROM P/N V049M243-1  
WEIGHT: 230#

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8	7	6	5	4	3	2	LIGO-D970409-01-V				

60.5 X 68.5 INCH FLANGE\_FLAT ADVANCED LIGO # LIGO D970409-v1