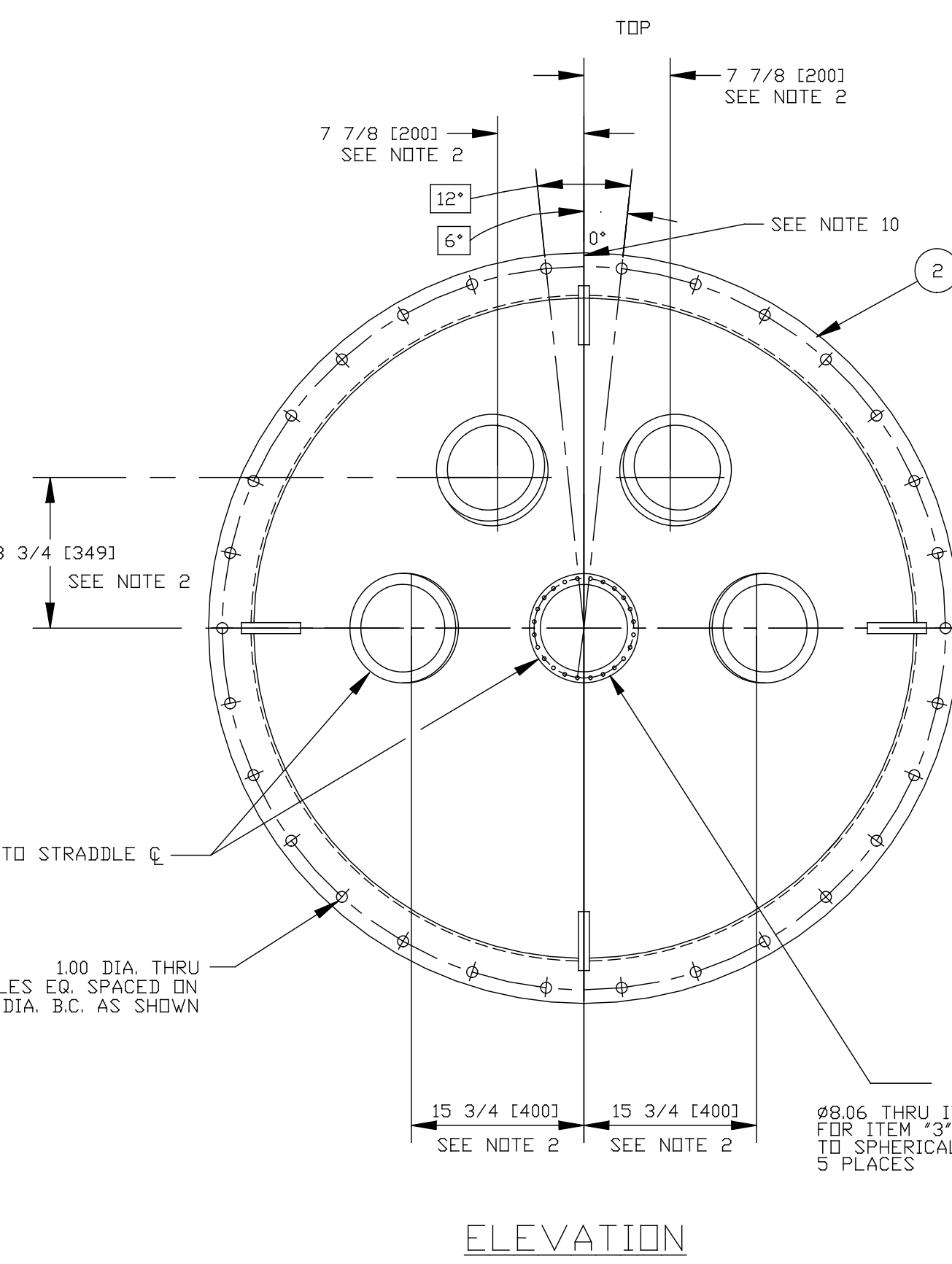


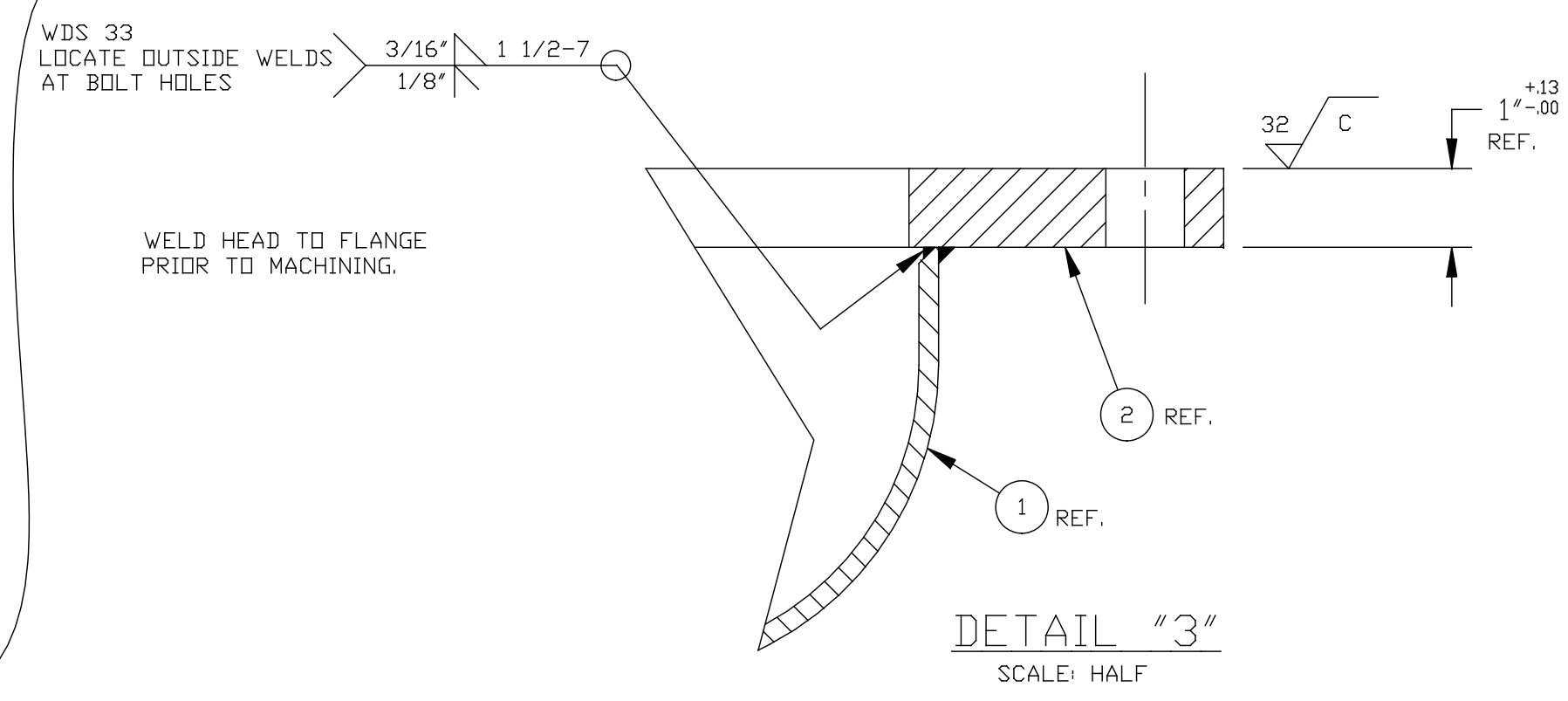
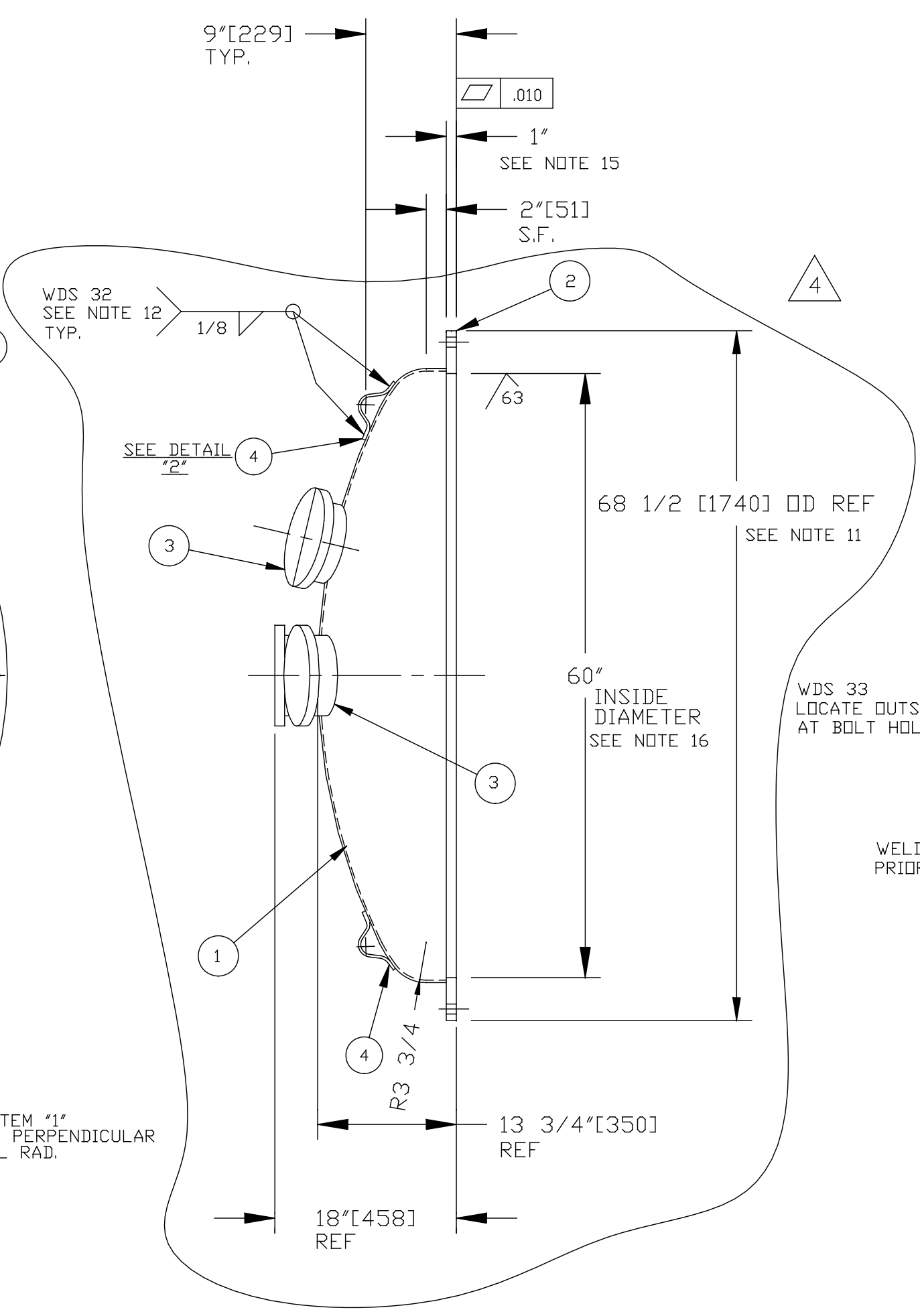
DETAIL "1"
TYP. (5) PLCS.
SCALE: HALF

DETAIL "2"
SCALE: HALF

LIFTING LUG
QTY. (4) REQ'D.
P/N: V0494014P4-3
MAT'L: 304 SST, 3/4" WIDE x 1/4" THK. FLAT BAR, ASTM A479



ELEVATION



DETAIL "3"
SCALE: HALF

- NOTES**
16. DO NOT FINISH MACHINE I.D. OF FLANGE FORGING.
 15. DO NOT MACHINE THE BACKSIDE TO THE FINISHED THICKNESS. LEAVE THE #200 RMS FINISH AS SUPPLIED BY THE FLANGE FORGING VENDOR, UNLESS THE BACK SURFACE PARALLELISM EXCEEDS 0.030 AS MEASURED FROM THE FINISHED SEALING SURFACE. IF MACHINING IS REQUIRED, THEN CLEAN OFF MINIMUM MATERIAL COMPLETELY ACROSS THE BACKSIDE AND STOP 1/2" CLEAR OF EXISTING WELD LEG. IF A STEP OCCURS, FINISH WITH 1/8" RADIUS.
 14. EACH FINISHED COVER IS TO BE MARKED WITH A UNIQUE SEQUENTIAL PSI NUMBER. THE NUMBER IS TO BE MADE FROM THE DRAWING NO. PLUS THE SEQUENTIAL NO. V0494128-01, -02 ETC.
 13. CONFLAT FLANGES ARE TO HAVE PROTECTIVE COVERS AT ALL TIMES DURING AND AFTER MANUFACTURING, PER PSI SPEC V049-2-123.
 12. IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
 11. DO NOT MACHINE FLANGE OD. ALL FORGING MFG. NOS. TO BE LEFT INTACT.
 10. MACHINING VENDOR TO USE PSI'S CENTER PUNCH MARK LOCATED AT 0° ON EACH HEAD AS THE STARTING POINT FOR THE NATURAL CENTERLINE BOLT PATTERN. BOLT HOLES TO STRADDLE THE VERTICAL CENTERLINE AS SHOWN IN THE ELEVATION.
 9. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
 8. FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL UNLESS NOTED.
 7. CLEAN PER SPEC: V049-2-015.
 6. MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH + 8 RMS.
 5. 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.
 4. FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-117, & 136.
 3. HEADS ARE ASME F&D.
 2. PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII ITEM '1'.
 1. HELIUM LEAK TEST PER SPEC V049-2-014 BY PSI.

MAKE FLANGE FROM P/N V049M243-1

WEIGHT ASSEMBLED: 585#

PROPRIETARY AND CONFIDENTIAL				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				4 REVISED AS NOTED/I.D. PER RFC V049-051				PV 4/18/97 0464			
THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSE FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED, NOR SHALL SUCH INFORMATION BE FURNISHED IN WHOLE OR IN PART TO OTHERS EXCEPT IN ACCORDANCE WITH THE TERMS OF ANY AGREEMENT UNDER WHICH IT WAS SUPPLIED OR WITH THE PRIOR WRITTEN CONSENT OF PROCESS SYSTEMS INTERNATIONAL, INC. AND SHALL BE RETURNED UPON REQUEST.				TOLERANCES: FRACTIONAL ± .1 ANGULAR MACH ± 0°-30' BEND ± 2° TWO PLACE DECIMAL ± .030 THREE PLACE DECIMAL ± .015 FINISHED SURFACE RMS BREAK CORNERS IN OUT REMOVE ALL BURRS 63				3 REVISED PER RFC V049-018 / ISSUED FOR FABRICATION				BAR 11/22/96 0366			
DWG. NO. DESCRIPTION REFERENCE DWG. NO. DESCRIPTION				DO NOT SCALE THIS DRAWING				2 REISSUED FOR FABRICATION				PV 10/10/96 0299			
V049-2-040 SPEC. FOR ST.ST. FLANGE FORGINGS.				USED ON:				1 ISSUED FOR FABRICATION				PV 9/6/96 0194			
V049-2-039 SPEC. FOR VESSEL HEADS.				NEXT ASSY:				0 ISSUED FOR FDR				PV 4-25-96 0121			
REFERENCE DRAWINGS				REV DESCRIPTION DESCRIPTION				GS PEF RDC REC PV 4-25-96 0121				CHKD DRWN DATE DEC#			
8				4				SCALE AS NOTED				SHEET 1 OF 1			

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

60" BSC COVER TYPE I BEAM SPLITTER CHAMBER LIGO VACUUM EQUIPMENT

CAD FILE: V0494014/4014S2
SIZE: D
DWG. NO.: V049-4-014
REV: 4

1116
Apr 17, 1997 - 11:05:44