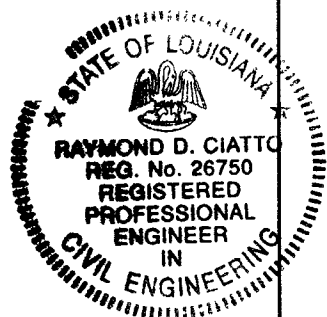


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
  - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
  - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN 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 OD ALL FORGING MANUFACT. NOS. TO BE LEFT INTACT.

D961109-01-V

THIS FLANGE TO BE MADE FROM P/N V049M247-1  
WEIGHT: 272#



EXPIRES 8/5/97

*Raymond D. Ciatto*  
1/2/97

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DVG NO. DESCRIPTION REFERENCE DRAWINGS		USED ON: NEXT ASSY:		REV. DESCRIPTION ISSUE DESCRIPTION		CAD FILE SIZE DVG NO. REV V0494028 C V049-4-028 1		SCALE 1 1/2"=1'-0" SHEET 1 OF 1	

Sept 20, 1996 - 10:52:01