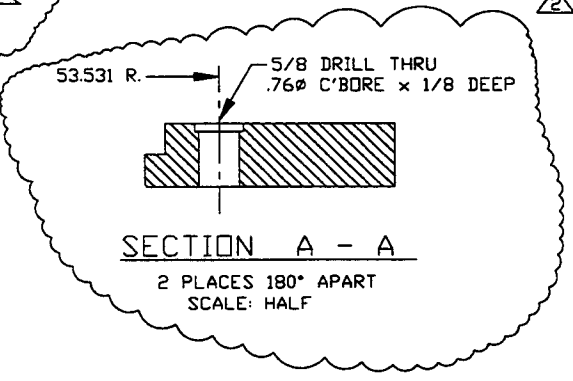
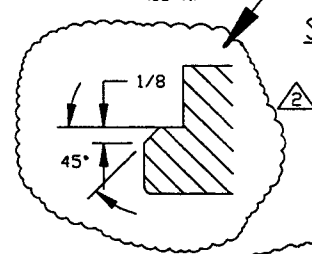
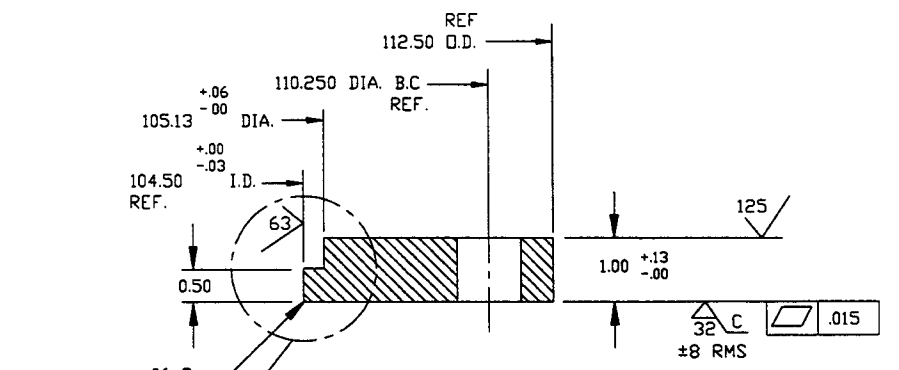
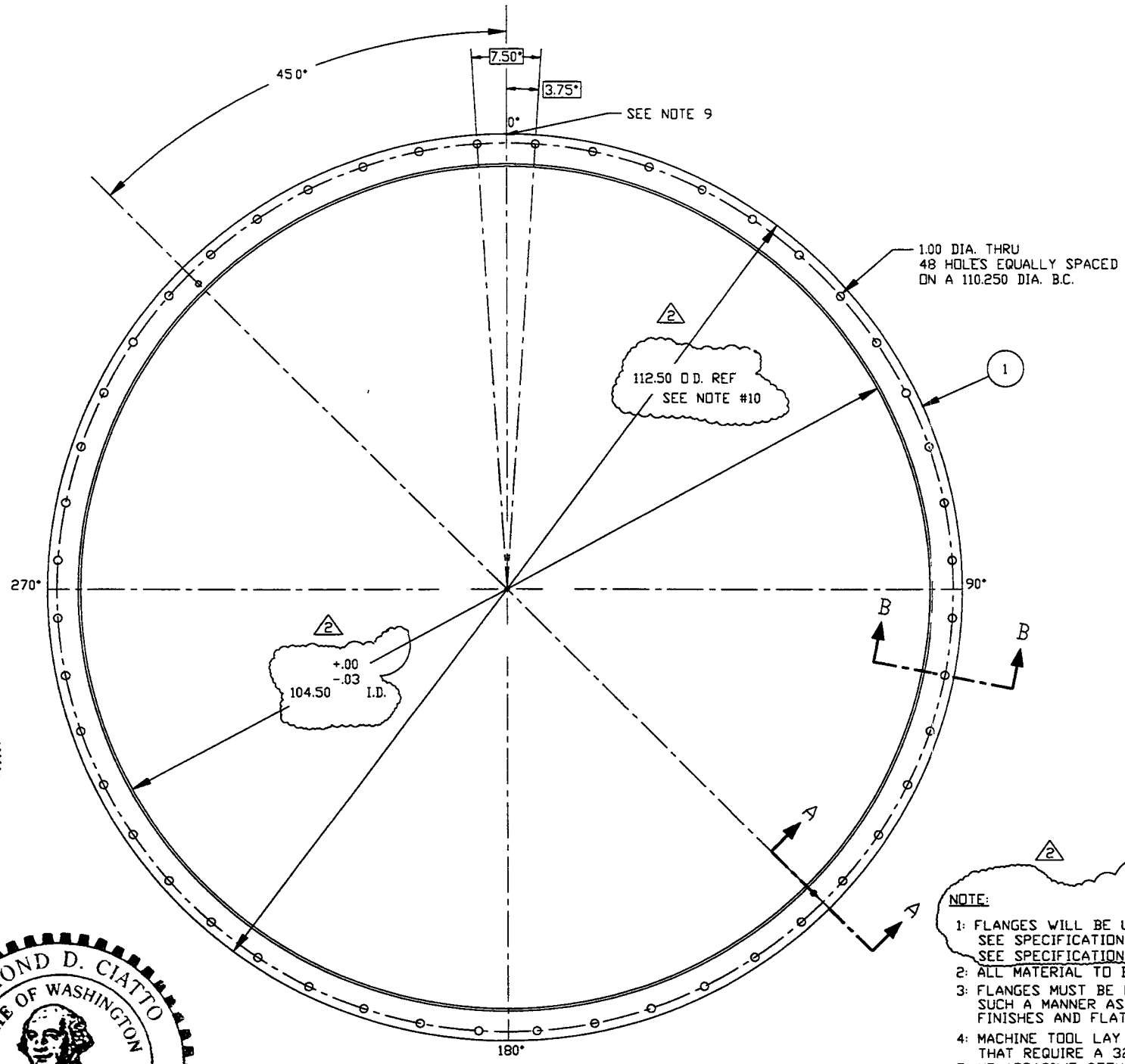


Raymond D. Ciatto 1/2/97
 -VDPIRES 8/5/97



- 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: SCRIBE OUTER EDGE OF FLANGE WITH SCRIBE LINE & METAL STAMP 0°

10. DO NOT MACHINE FLANGE O.D. ALL FORGING MANUFACT. NOS. TO BE LEFT INTACT.

THIS FLANGE TO BE MADE FROM V049M004-1
 WEIGHT: 387#

RAYMOND D. CIATTO PE-WA

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DWG. NO.	DESCRIPTION	USED ON:	REV.	DESCRIPTION	CHKD.	DRAWN.	DATE	DEC.
			2	ADDED CHAMFER, REVISED SECTION A-A / FABRICATION	GS	DMW	6/20/96	0203
			1	ADDED 2 PORT HOLES AS NOTED	PEP	DMW	6/14/96	0191
			0	ISSUED FOR FDR/FAB			4/22/96	0150
			P1	FDR PROTOTYPE FABRICATION			3/18/96	0097

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

104 1/2" I.D. FLANGE DETAIL
 (BSC) FLAT FACED
 LIGO VACUUM EQUIPMENT

CAD FILE: V0494041
 SIZE: C
 DWG. NO.: V049-4-041
 REV.: 2

SCALE: 1"=1'-0"
 SHEET: 1 OF 1

Aug 16, 1996 - 11:19:16