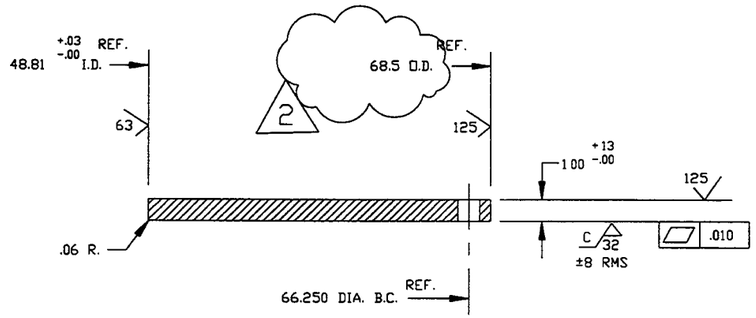
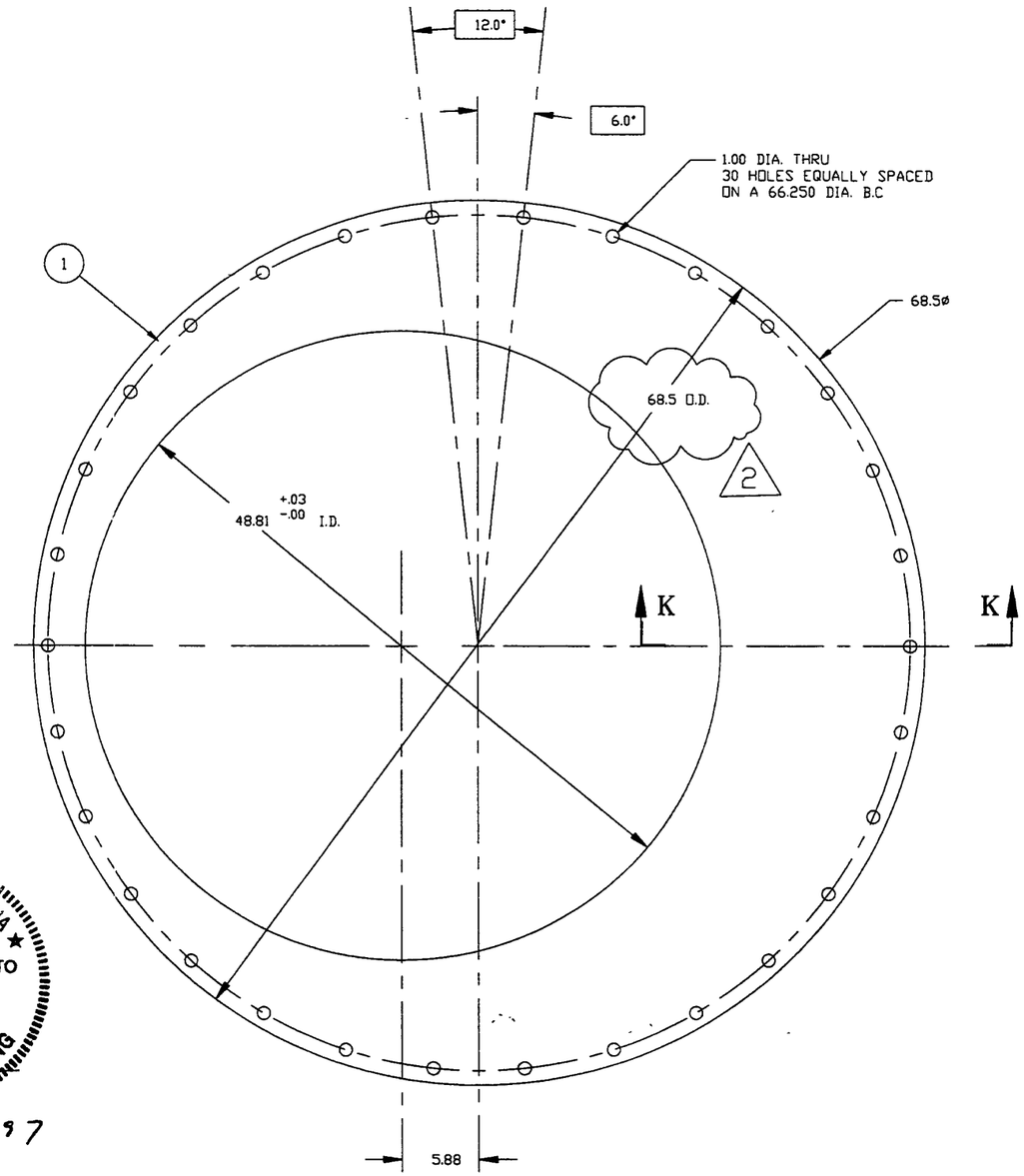
NOTE:

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 POLYETHELENE TO PREVENT CONTAMINATION DURING SHIPPING.



SECTION "K"-"K"



RAYMOND D. CIATTO
STATE OF WASHINGTON
15714
REGISTERED PROFESSIONAL ENGINEER
EXPIRES 8/5/97

STATE OF LOUISIANA
RAYMOND D. CIATTO
REG. No. 26750
REGISTERED PROFESSIONAL ENGINEER IN CIVIL ENGINEERING
4/29/97

THIS FLANGE TO BE MADE FROM P/N V049M253-1

WEIGHT: 506#

PROPRIETARY AND CONFIDENTIAL

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DWG NO.	DESCRIPTION
REFERENCE DRAWINGS	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR MACH 30°-20' BEND ±2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS 63
BREAK CORNERS: .1A-.005 OUT-.005
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.

USED ON:

NEXT ASS'Y:

REV	DESCRIPTION								
2	REISSUED FOR FAB, REVISED FLG. O.D	GS	PEF	RDC	REC	SPIDER	PV	7/29/97	0476
1	DESIGN UPDATE/FABRICATION DMW	GS	PEF	RDC	REC	SPIDER	PV	7/31/96	0218
0	ISSUED FOR FDR						PV	5-8-96	
						CHKD	DRAWN	DATE	DEO

ISSUE DESCRIPTION

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

48.81" I.D. X 68.5" O.D.
5.88 OFFSET FLANGE (FLAT)
LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG NO	REV.
V0494068	C	V049-4-068	2

SCALE 1 1/2"=1'-0" SHEET 1 OF 1

Apr 29, 1997 - 11:17:03

LIGO-D961132-02-V