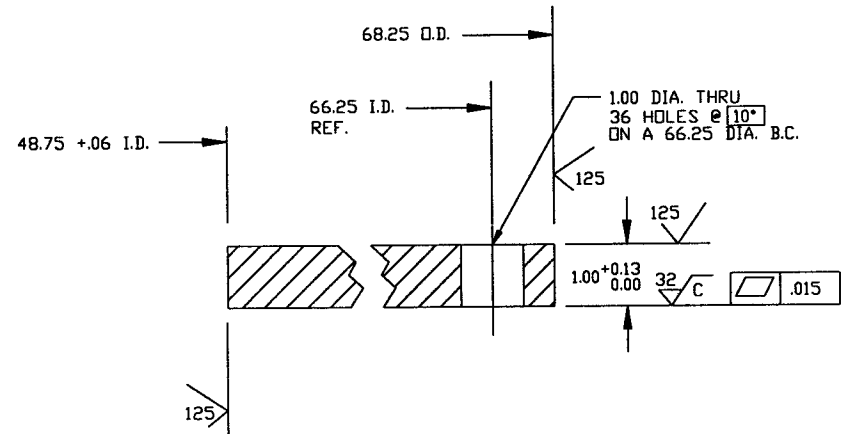


3.01 DIA. THRU
6 HOLES SPACED AS SHOWN
ON A 55.25 DIA. B.C.

Ø68.25 O.D.
REF.

48.75"
Ø48.75 I.D.
REF.



SECTION "A"- "A"
SCALE: HALF

**NOT FOR
CONSTRUCTION**

- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL 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.

Raymond D. Cirillo, PE
5/6/96
LIGO D961139-00-V

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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGULAR APPROX 10°-30° BEND ± 2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS 32
BREAK CORNERS: IN+.005 OUT+.003
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.
USED ON:
NEXT ASS'Y:

| REV. | DESCRIPTION | CHKD | DRAWN | DATE | DEO |
|------|----------------|------|-------|--------|------|
| 0 | ISSUED FOR FDR | | | 5/6/96 | 0150 |

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

48 1/4" I.D. FLANGE DETAIL
(FLAT FACED)
LIGO VACUUM EQUIPMENT

| | | | |
|----------------------|-----------|------------------------|-----------|
| CAD FILE V0494079 | SIZE C | DWG. NO. V049-4-079 | REV. 0 |
|----------------------|-----------|------------------------|-----------|

SCALE AS NOTED SHEET 1 OF 1

Feb 28, 1996 - 152946