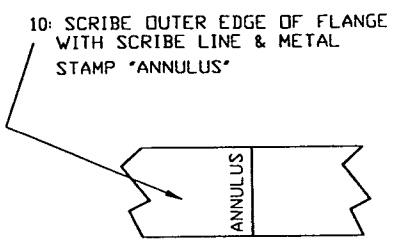


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
 - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
 - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN 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: FLANGE FINAL FACE CUTS AND O'RING GROOVES MUST BE MACHINED DURING THE SAME SETUP.
 - 9: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.



Raymond D. Ciatto - PE - WA.

THIS FLANGE TO BE MADE FROM P/N V049M248-1
WEIGHT: 480#

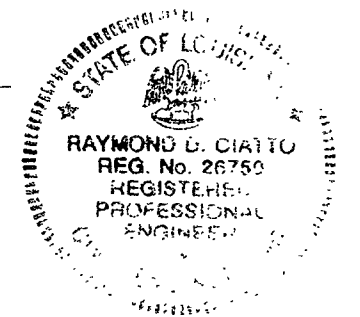
D970354-02-V

INNER O-RING .275 DIA. STOCK x 203 3/4' LG. VULCANIZED - BAKED VITON E-60C
OUTER O-RING .275 DIA. STOCK x 213' LG. VULCANIZED - BAKED VITON E-60C

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DWG. NO.	DESCRIPTION	USED ON	REV.	DESCRIPTION	ISSUE DESCRIPTION
			2	REISSUED FOR FABRICATION	
			1	DESIGN UPDATE/FABRICATION	
			0	ISSUED FOR FDR/FAB	

61.31" I.D. X 72.25 O.D. BE-3A FLANGE (GROOVED) LIGO VACUUM EQUIPMENT			
CAD FILE V0494067	SIZE C	DWG. NO. V049-4-067	REV. 2
SCALE 1 1/2"=1'-0"		SHEET 1 OF 1	



Oct 11, 1996 - 12:41:21