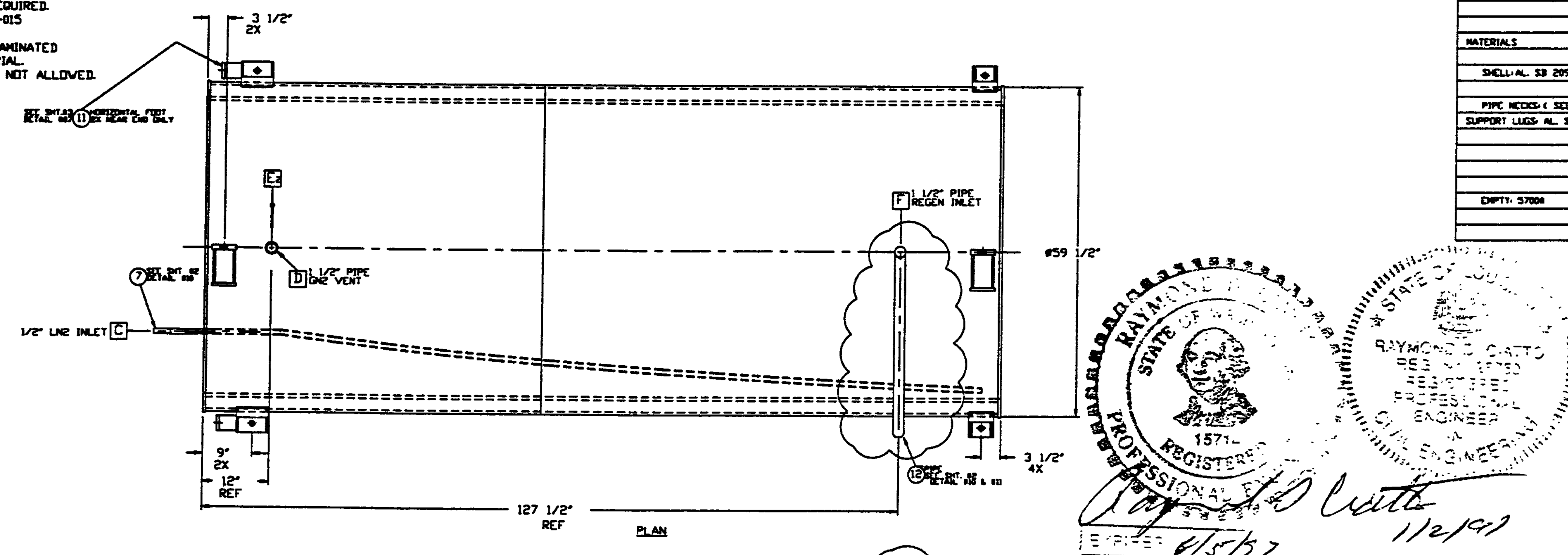
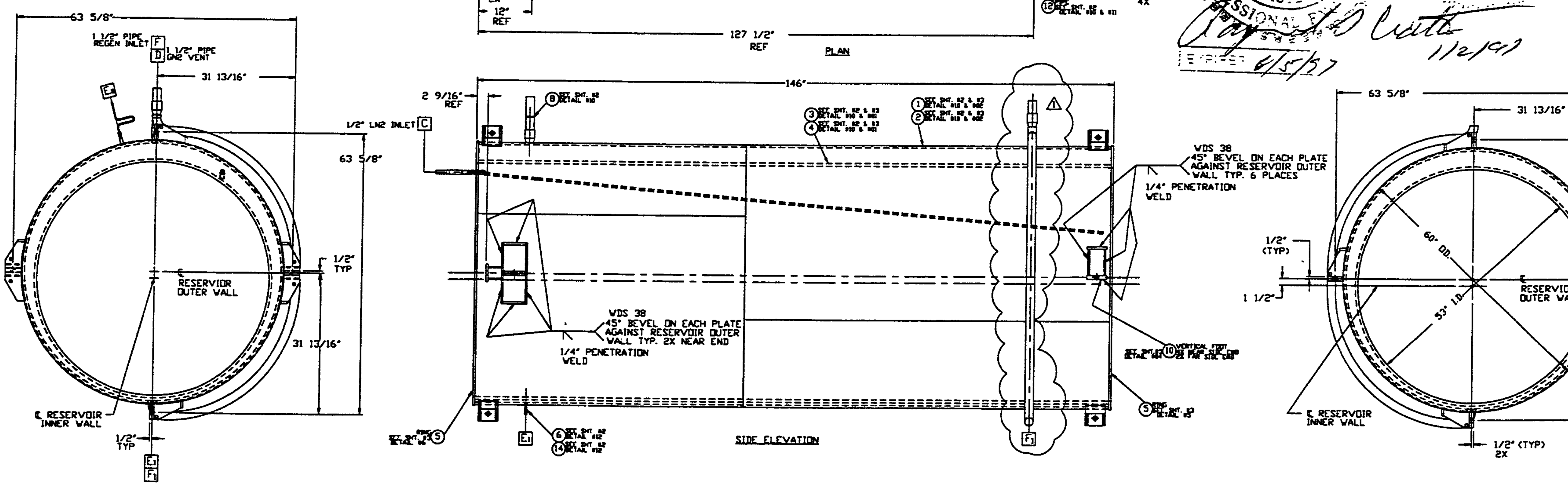
NOTES

12. WDS NO'S REFER TO WELD DATA SPEC. V049-2-084
11. 80K PUMP FABRICATION PLAN SPEC. V049-2-082
10. 80K PUMP QUALITY PLAN SPEC. V049-2-098
9. HANDLING TO BE ACCORDANCE WITH SPEC.V049-2-120
8. ROLLING & MACHINING TO BE IN ACCORDANCE WITH SPEC V049-2-136
7. EACH FINISHED WELDMENT IS TO BE MARKED WITH A UNIQUE SEQUENTIAL SERIAL NUMBER DEVELOPED FROM THE DRAWING NUMBER PLUS -01 ETC. NUMBER TO BE LOCATED AT OUTSIDE END PLATE
6. PRESSURE TEST: PNEUMATIC 38 PSIG AT 70° PER PSI PROCEDURE
5. LEAK TEST & METHOD PER PSI SPEC V049-2-014, BY PSI.
4. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
3. CLEAN INSIDE & OUTSIDE SURFACES PER SPEC. V049-2-015 INSIDE SURFACES TO BE CLEANED PRIOR TO WELD UP.
2. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL. GRINDING ON INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED.
1. 80K PUMP FABRICATION PLAN SPEC. V049-2-096.

DESIGN DATA	
MAX OPER. PRESS. 15 PSIG	
CORROSION ALLOWANCE: 0	
POSTWELD HEAT TREATMENT: NONE	
FIREPROOFING	N.A.
RADIOGRAPHING	NONE
MATERIALS	
SHELL: AL. SB 209 6061-T6	
PIPE NECKS: (SEE DETAILS)	
SUPPORT LUGS: AL. SB209 6061-T6	
EMPTY: 5700#	





DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION

REFERENCE DRAWINGS

SYMBOL	CHARACTERISTIC
⏥	FLATNESS
⌭	CYLINDRICITY
//	PARALLELISM
⊥	PERPENDICULARITY
∠	ANGULARITY
⊕	TRUE POSITION
◎	CONCENTRICITY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

DO NOT SCALE THIS DRAWING

USED ON

NEXT ASS'Y:

REV	DESCRIPTION	DN	PEF	RDC	GS	CHKD REC	DRWN TDV	DATE	DED#
1	REVISED FOR FABRICATION	GS		RDC	DW	REC	TDV	11/11/96	0343
0	ISSUED FOR FABRICATION	DN	PEF	RDC	GS	REC	TDV	10/11/96	0281

ISSUE DESCRIPTION

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

80K PUMP RESERVOIR -LONG- LEFT

LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
49409251	D	V049-4-092	1

SCALE NONE

SHEET 1 OF 3

Oct 31 1996 - 143344

LIGO-D970404-0 I V

STATE OF LOUISIANA
RAYMOND CIATTO
REG. No. 26750
REGISTERED
PROFESSIONAL
ENGINEER
IN
CIVIL ENGINEERING

STATE OF WASHINGTON
RAYMOND D. CIATTO
16714
REGISTERED
PROFESSIONAL ENGINEER
EXPIRES 1/1/97

1/1/97

DETAIL 10

SHOP TO VIBRO-ETCH HEAT/ LOT NO'S TO OUTSIDE SURFACES PRIOR TO WELDING LOCATE MARKING ON SIDE OF RESERVOIR NEAR ITEM 19

DETAIL #12

DETAIL 11

DETAIL #13
ALU. PLT. 6061 .5 THK (11)

PARTIAL VIEW "K"-"K"

SEE SHEET 1 FOR REVISIONS

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

80K PUMP RESERVOIR -LONG-LEFT
LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
49409252	D	V049-4-092	1
SCALE: NONE		SHEET 2 OF 3	

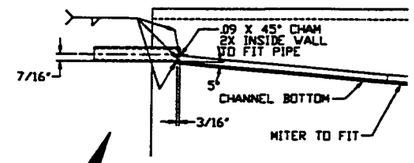
Oct 31, 1996 - 1336:37

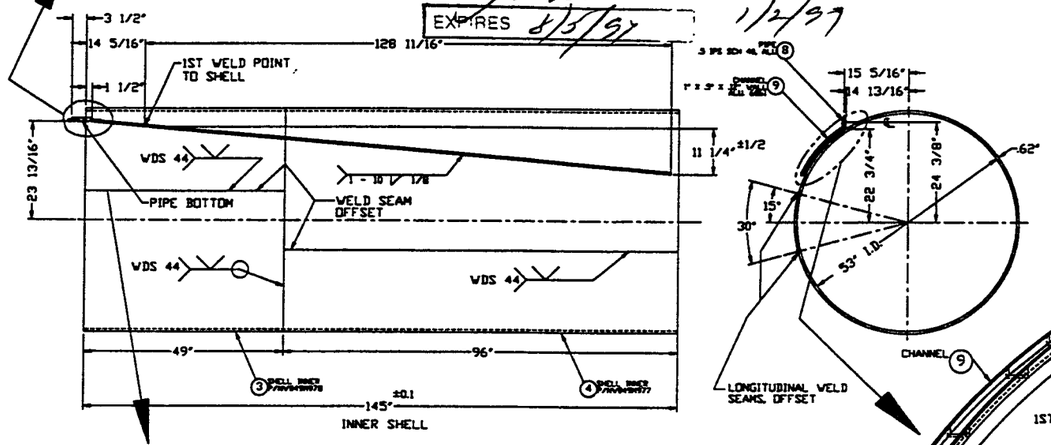
RAYMOND D. CIATTO
REG. No. 26750
REGISTERED
PROFESSIONAL
ENGINEER
IN
CIVIL ENGINEERING
STATE OF LOUISIANA

RAYMOND F. [illegible]
STATE OF WASHINGTON
15714
REGISTERED
PROFESSIONAL ENGINEER

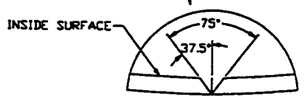
EXPIRES 8/3/97

1/2/97

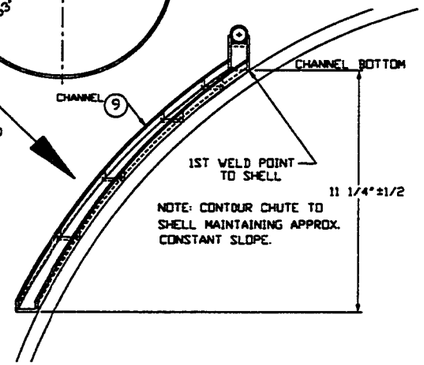




DETAIL -01
FROM SHT. #1

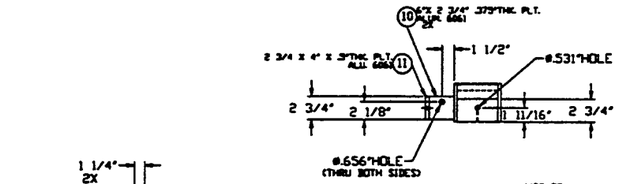


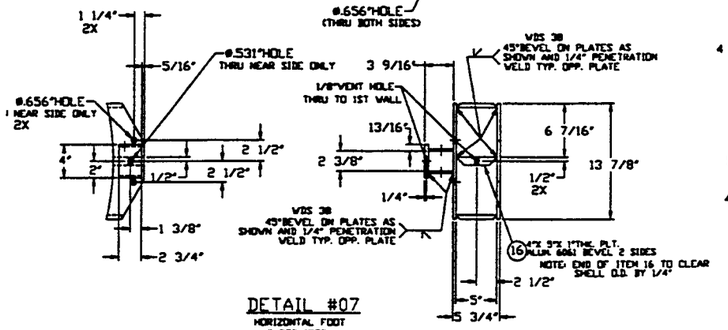
WELD SEAM DETAIL



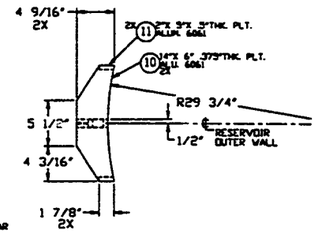
DETAIL -02
PLAN VIEW
FROM SHT. #1

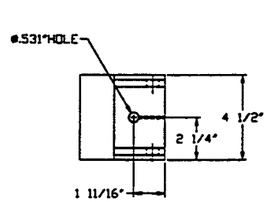
PLATE PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITH IN 1/16 OF EACH OTHER

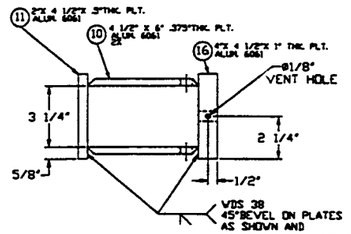


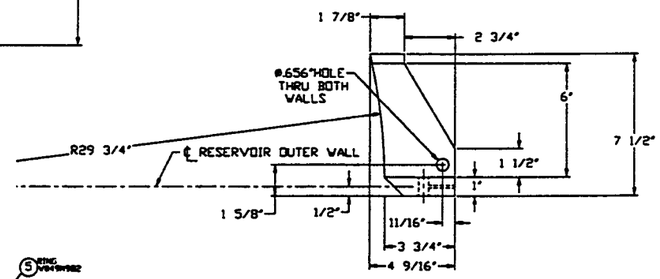


DETAIL #07
HORIZONTAL FOOT
2 REQUIRED

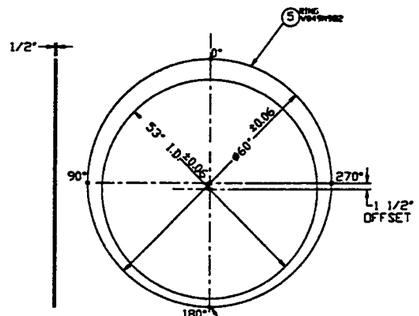




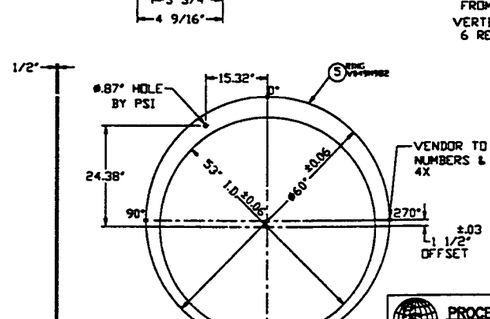




DETAIL #04
FROM SHT #1
VERTICAL FOOT
6 REQUIRED



DETAIL #05
STAMP P/N, HEAT/LOT NO. ON ONE SIDE



DETAIL #06
STAMP P/N, HEAT/LOT NO. ON ONE SIDE

SEE SHEET 1 FOR REVISIONS

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

80K PUMP RESERVOIR -LONG- LEFT

LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
49409253	D	V049-4-092	1
SCALE NONE		SHEET 3 OF 3	

Oct 31, 1996 - 14:58:11