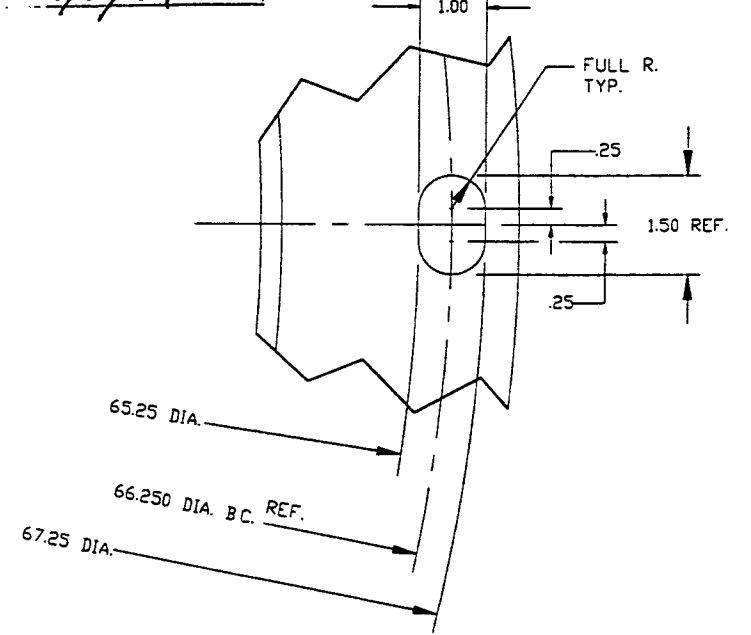


RAYMOND D. CIATTO
STATE OF WASHINGTON
REGISTERED PROFESSIONAL ENGINEER
15714
5/5/97

STATE OF LOUISIANA
RAYMOND D. CIATTO
REG. No. 26750
REGISTERED PROFESSIONAL ENGINEER
5/24/97



SLOT DETAIL

THIS FLANGE TO BE MADE FROM P/N V049M243-1
WEIGHT: 230#

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

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DWG. NO.	DESCRIPTION	USED ON:
	REFERENCE DRAWINGS	NEXT ASS'Y:

UNLESS OTHERWISE SPECIFIED									
DIMENSIONS ARE IN INCHES									
TOLERANCES:									
FRACTIONAL = 1/16									
ANGULAR MACH = 30°-30' BEND ±2°									
TWO PLACE DECIMAL = .010									
THREE PLACE DECIMAL = .005									
FINISHED SURFACE RMS 63									
BREAK CORNERS INWARDS OUT.005									
REMOVE ALL BURRS									
DO NOT SCALE THIS DWG									
REV	DESCRIPTION	CHKD	DRAWN	DATE	DEO				
2	REISSUED FOR FABRICATION AS NOTED								
1	RELEASED FOR FABRICATION								
0	ISSUED FOR FDR								

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

60.50" I.D. FLANGE DETAIL
(FLAT FACED) W/ SLOTS
LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
V0494098	C	V049-4-098	2

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

May 14, 1997 - 16:54:31