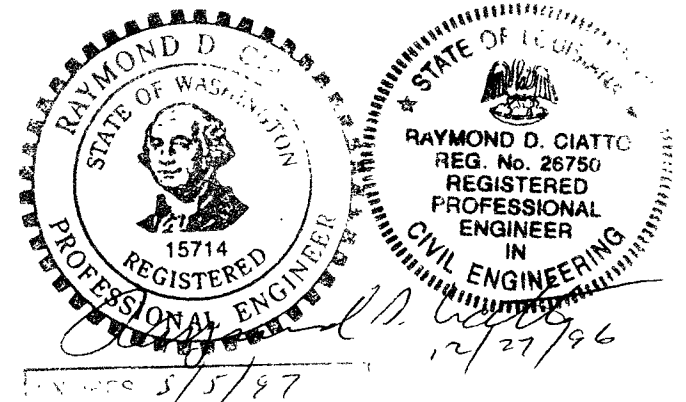
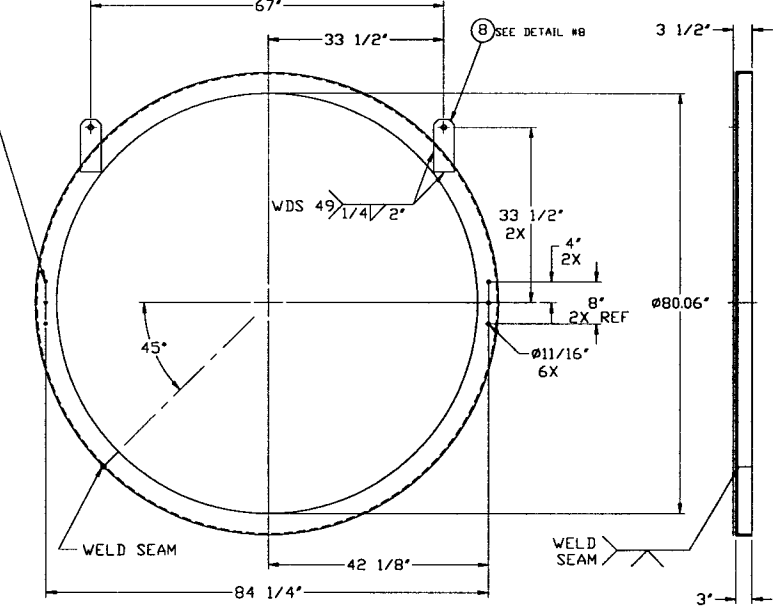
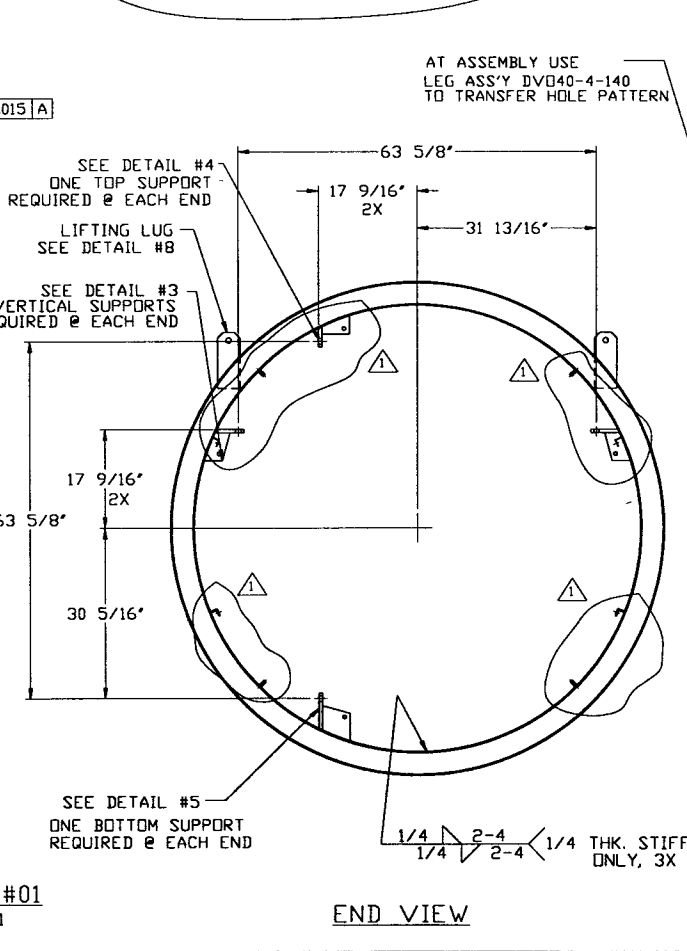
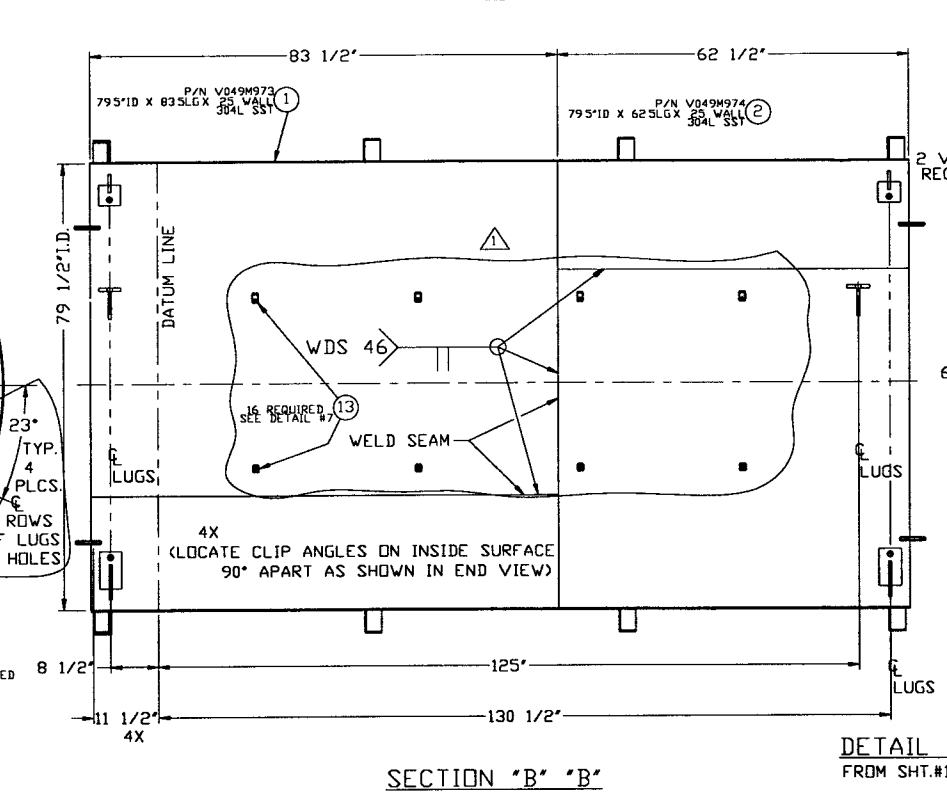
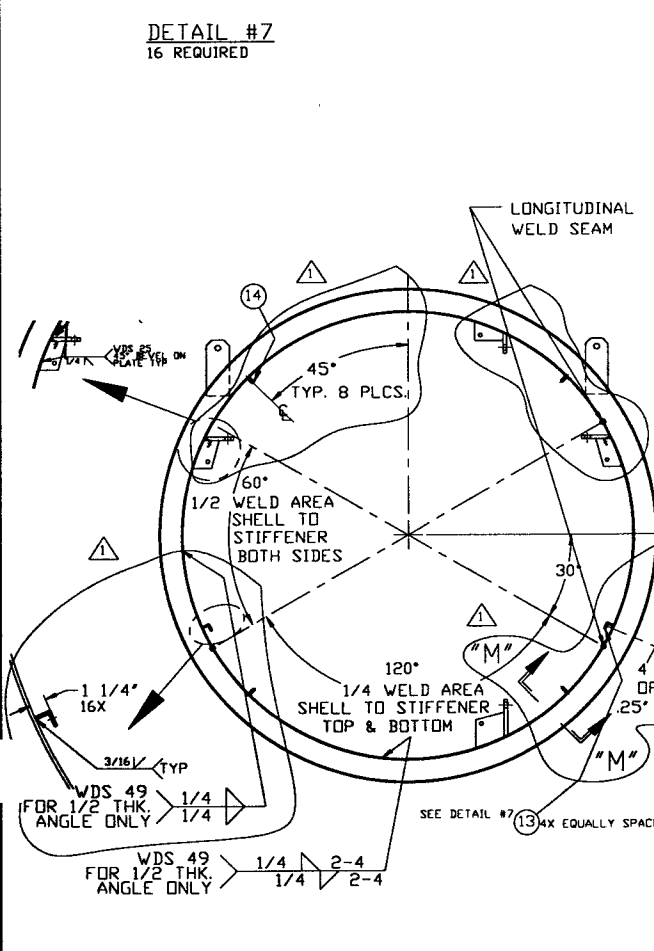
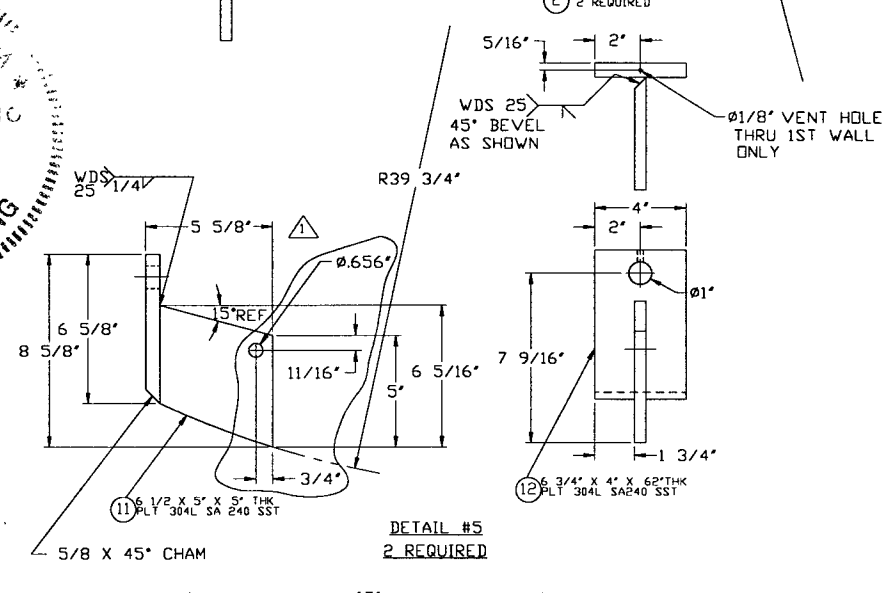
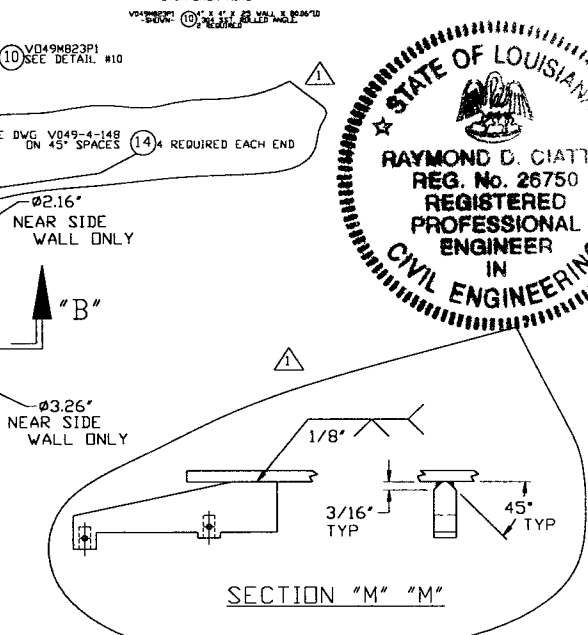
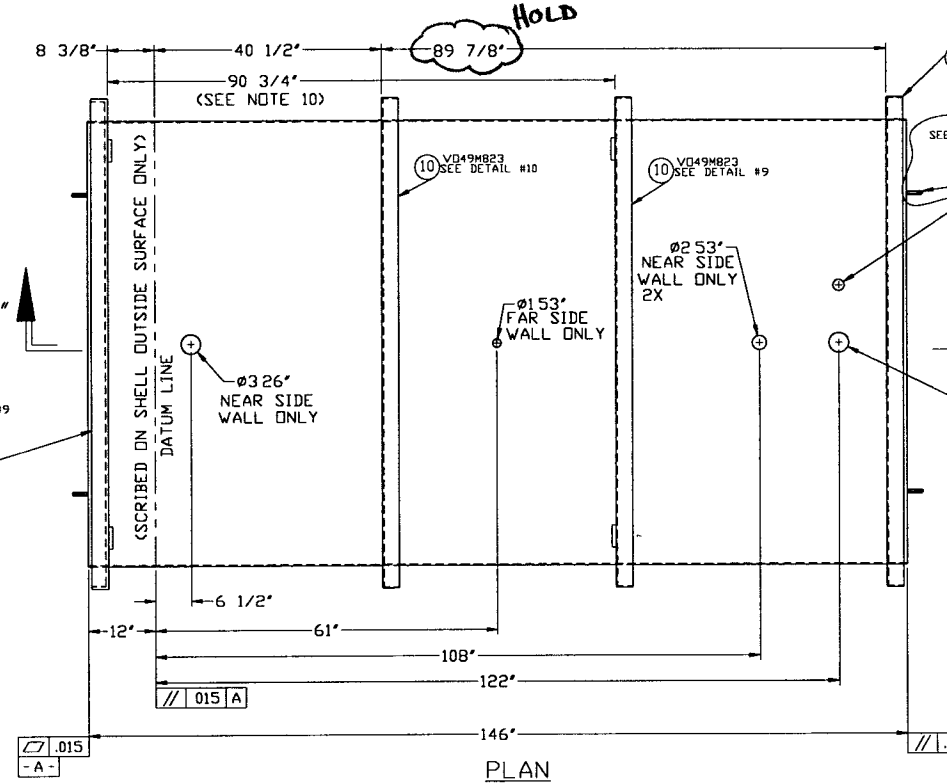
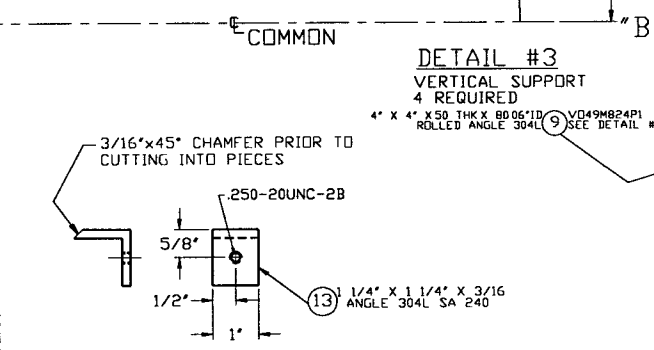
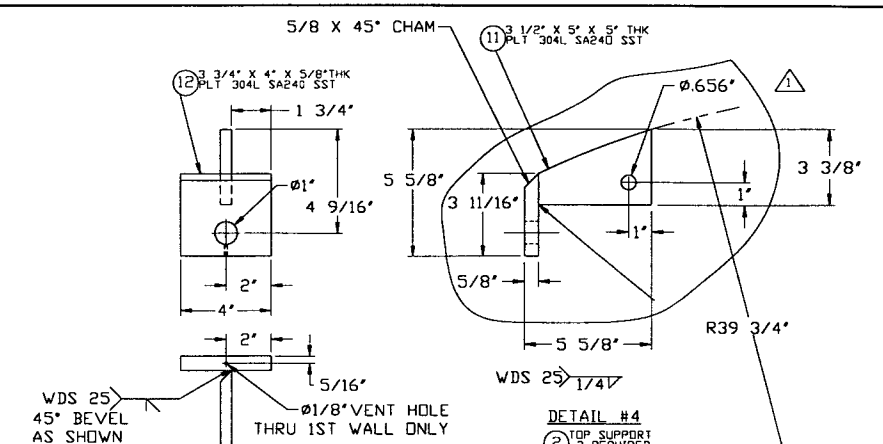
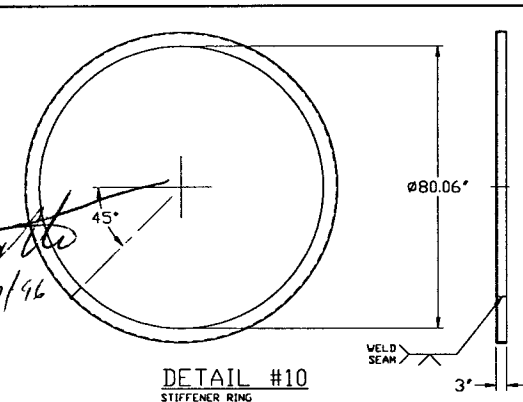
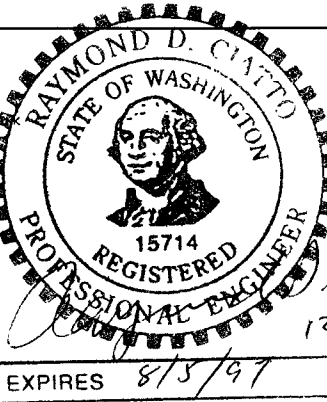
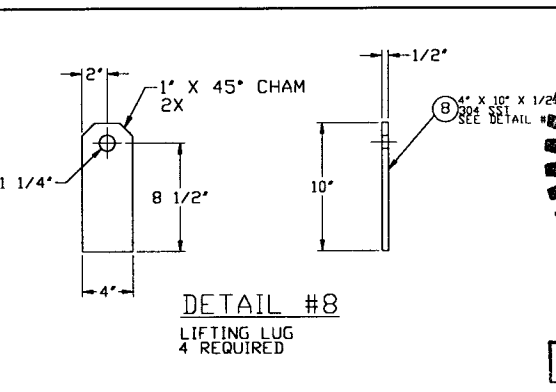
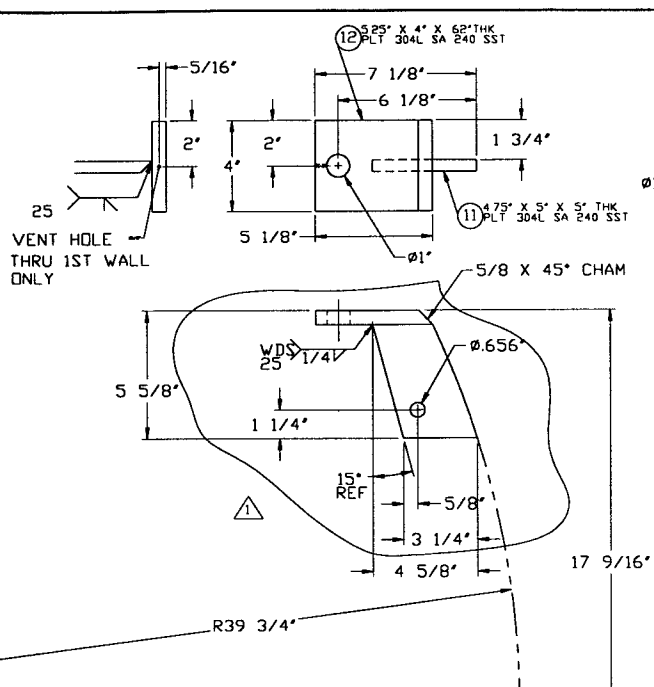


- 11 WDS NO'S REFER TO WELD DATA SPEC V049-2-084
 - 10 USE LEG ASSEMBLY FOR STIFFENER ALIGNMENT SPACING
 - 9 ID'S ARE TO BE ALIGNED ALONG THEIR COMMON CENTER LINE TO WITHIN ±.06
 - 8 LEAK TEST & METHOD PER PSI SPEC: V049-2-014, BY PSI
 - 7 CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED, AS NOTED
 - 6 FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL UNLESS NOTED
 - 5 CLEAN PER SPEC: V049-2-015
 - 4 NOZZLES "B" TO BE CONTOURED TO INSIDE DIAMETER OF SHELL OR TO CURVATURE OF HEAD, UNLESS OTHERWISE NOTED
 - 3 DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED
 - 2 HEADS ARE ASME F&D
 - 1 CHAMBER FABRICATION TO BE IN ACCORDANCE WITH SPEC V049-2-096
- WEIGHTS: SHELL ASSY = 3100 LBS
SUPPORTS = 600 LBS
TOTAL = 3700 LBS



PROPERTY AND CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES: FRACTIONAL ± .1 ANGULAR MACH ±.30° BEND ±.2° TWO PLACE DECIMAL ± .03 THREE PLACE DECIMAL ± .015 FINISHED SURFACE RMS 6.3 BREAK CORNERS IN OUT REMOVE ALL BURRS		1 ISSUED FOR FABRICATION		GS PEF DMW RD-LEG PV 12/9/96 0379	
THIS DRAWING CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSE FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED, NOR SHALL SUCH INFORMATION BE FURNISHED IN WHOLE OR IN PART TO OTHERS EXCEPT IN ACCORDANCE WITH THE TERMS OF ANY AGREEMENT UNDER WHICH IT WAS SUPPLIED OR WITH THE PRIOR WRITTEN CONSENT OF PROCESS SYSTEMS INTERNATIONAL, INC. AND SHALL BE RETURNED UPON REQUEST.		DO NOT SCALE THIS DRAWING		USED ON:		0 ISSUED FOR FABRICATION		DMW GS PEF DMW RDC REC JT 11/11/96 0341	
DWG NO	DESCRIPTION	DWG NO	DESCRIPTION	REV	DESCRIPTION	CHKD	DRWN	DATE	DESN
	REFERENCE DRAWINGS				ISSUE DESCRIPTION				
SCALE NONE		SHEET 1 OF 2		PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA		80K PUMP WELDMENT, LONG -RIGHT-		LIGD VACUUM EQUIPMENT	
CAD FILE 494119S1		SIZE D		DWG NO V049-4-119		REV 1			

0970421-01-V



PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
80K PUMP WELDMENT, LONG -RIGHT-			
LIGD VACUUM EQUIPMENT			
CAD FILE 494119S2	SIZE D	DWG NO. V049-4-119	REV 1
SCALE NONE	SHEET 2 OF 2		

DOC 27, 1996 - 08323.95