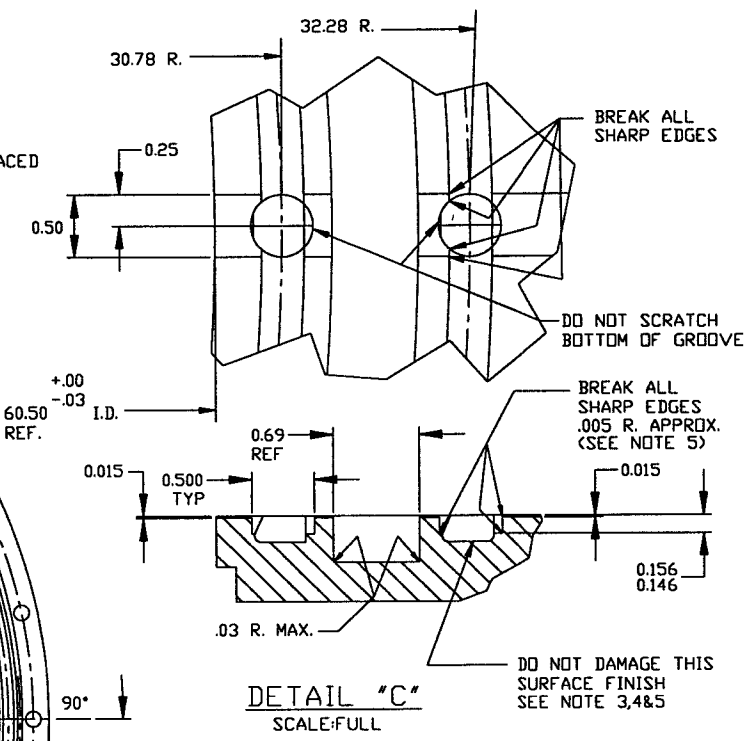
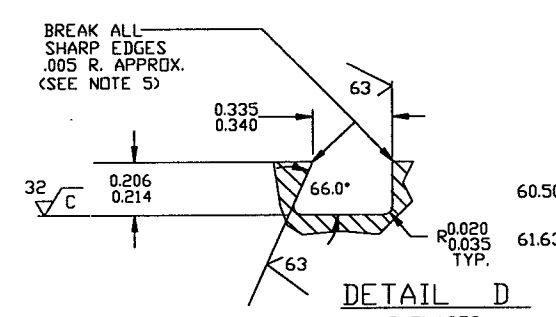


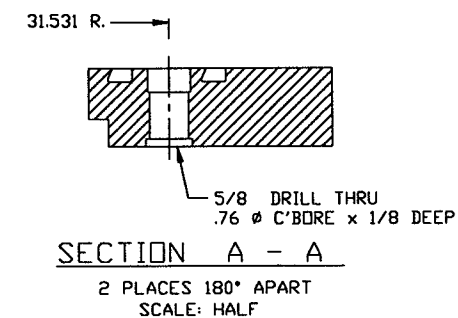
SCALE: 1 1/2 -1'-0



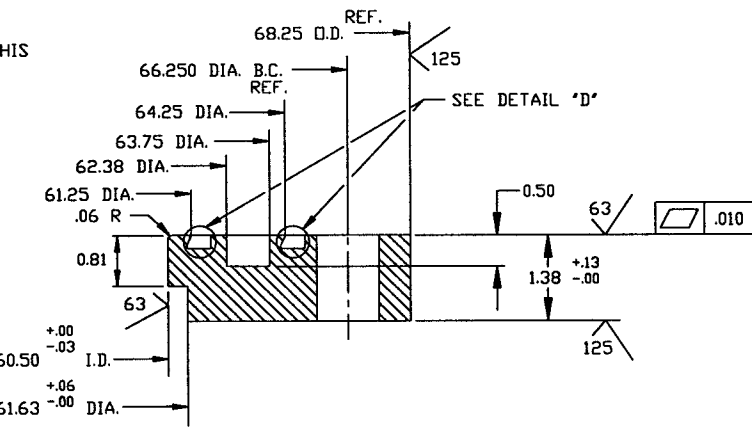
DETAIL "C" SCALE: FULL



DETAIL "D" SCALE: 2x



SECTION A-A SCALE: HALF



SECTION "B"-"B" SCALE: HALF

- 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: 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.

10: SCRIBE OUTER EDGE OF FLANGE WITH SCRIBE LINE & METAL STAMP 0°.

**NOT FOR CONSTRUCTION**  
*Raymond A. Latta, P.E.*  
 5/6/96 LIGO 0961102-00-V

INNER O-RING .275 DIA. STOCK x 191 1/4' LG. VULCANIZED - BAKED VITON E-60C  
 OUTER O-RING .275 DIA. STOCK x 200 5/8' LG. VULCANIZED - BAKED VITON E-60C

PROPS  
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DWG. NO.	DESCRIPTION	USED ON	REV.	DESCRIPTION
	REFERENCE DRAWINGS	NEXT ASS'Y.		ISSUE DESCRIPTION

REV.	DESCRIPTION	CHKD	DRAWN	DATE	DEO
0	ISSUED FOR FDR				
P5	REVISED PER DEO 0104				
P4	FDR PROTOTYPE FABRICATION				
P3	RELEASE FOR QUOTE				
P2	UPDATE PRELIMINARY DESIGN				
P1	PRELIMINARY				

SIZE	DWG. NO.	REV.
C	V049-4-019	0

SCALE AS NOTED SHEET 1 OF 1

Oct 02, 1995 - 09:37:04