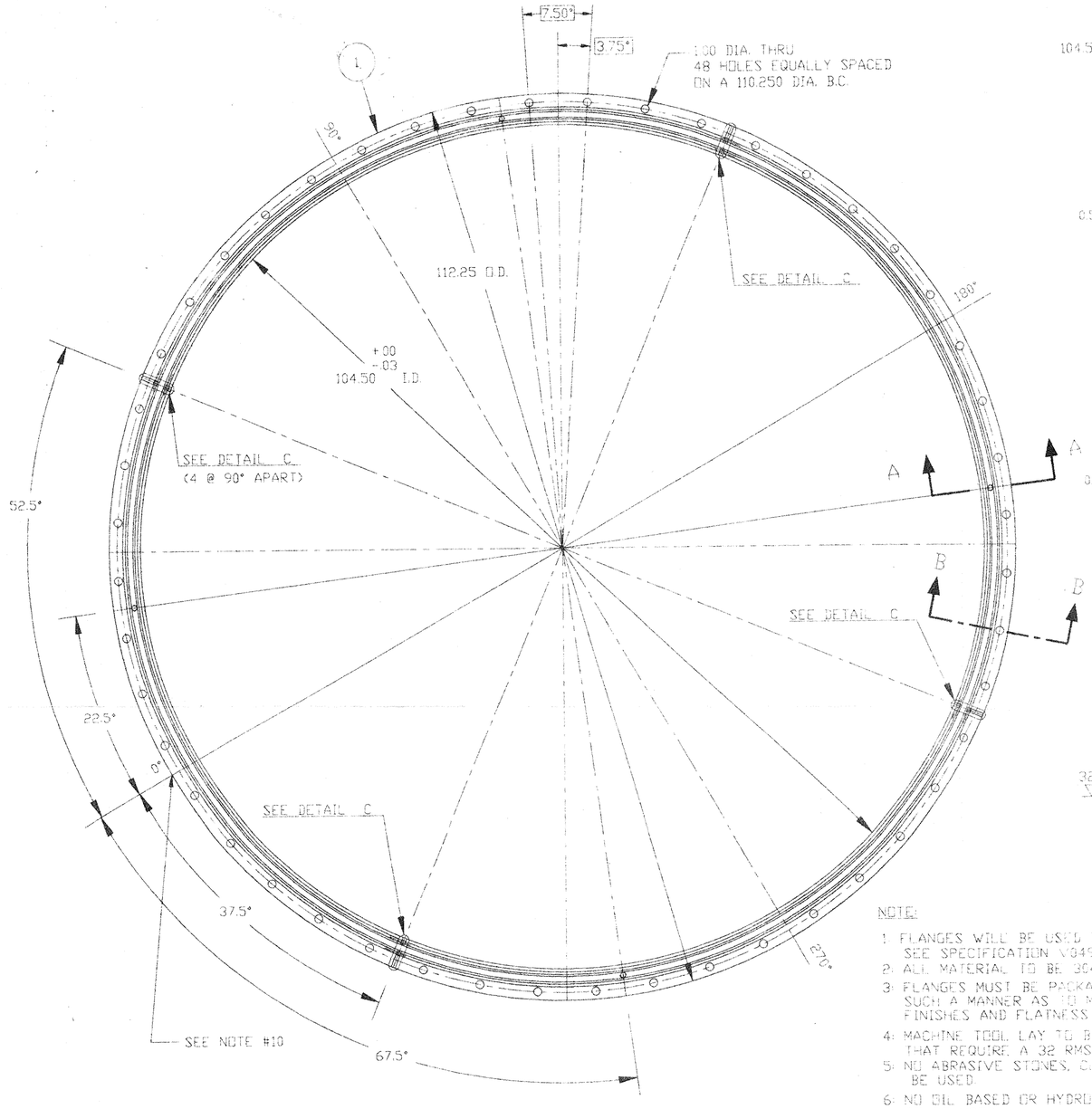
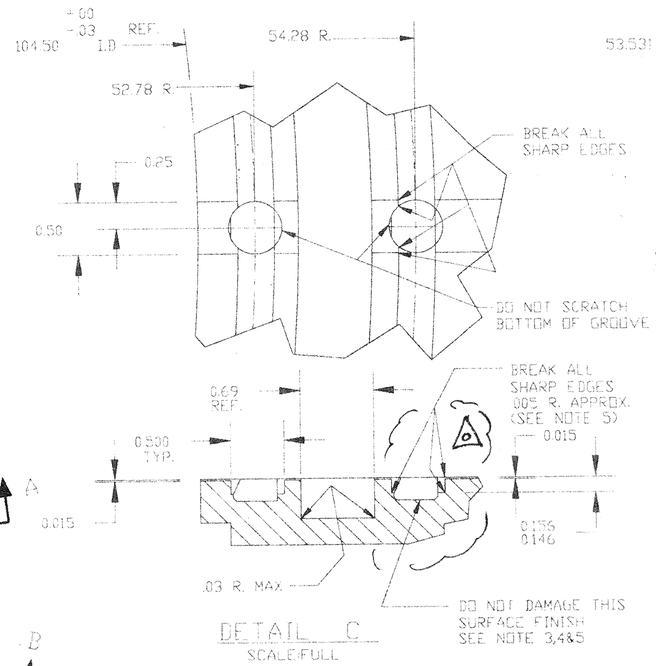
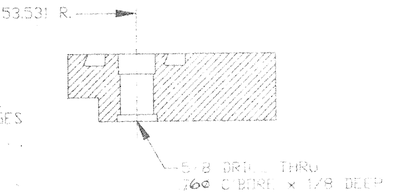


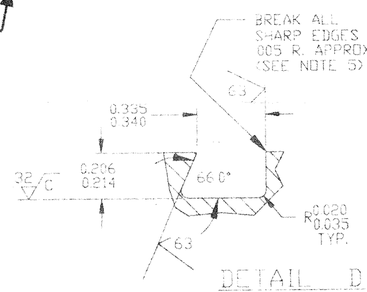
SCALE: 1 =1'-0



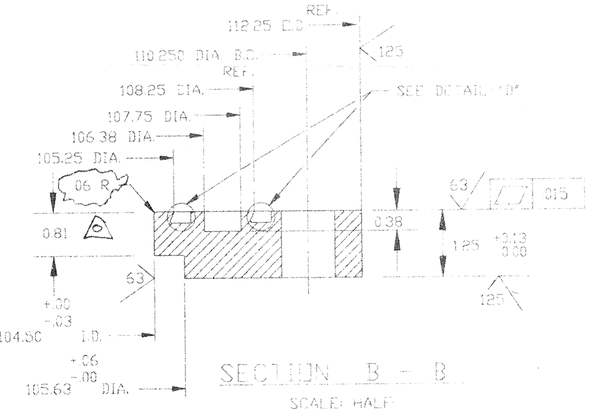
DETAIL C
SCALE:FULL



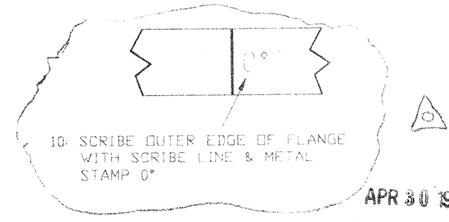
SECTION A - A
4 PLACES 90° APART
SCALE: HALF



DETAIL D
2 PLACES
SCALE: 2x



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.

INNER O-RING .275 DIA. STOCK x 328 1/8" LG. VULCANIZED - BAKED VITON E-60C
OUTER O-RING .275 DIA. STOCK x 337 1/2" LG. VULCANIZED - BAKED VITON E-60C

APR 30 1996

0961106-00-V

PROPRIETARY AND CONFIDENTIAL

THIS DOCUMENT 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.

DWG. NO.	DESCRIPTION

REFERENCE DRAWINGS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR MACH ± 30' BEND ±2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS 63
BREAK CORNERS: IN .005 OUT .005
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.

USED ON:

NEXT ASSY:

REV	DESCRIPTION	CHKD	DRAWN	DATE	DEO
0	ISSUED FOR FDR/FAB	REF	REO	PV 4-20-96	0121
P5	REVISED PER DEO 0104			PV 3-28-96	0104
P4	FOR PROTOTYPE FABRICATION			PV 3-18-96	0097
P3	RELEASE FOR QUOTES			KAR 12-14-95	
P2	UPDATE PRELIMINARY DESIGN			KAR 12-4-95	
P1	PRELIMINARY			KAR 10-24-95	

ISSUE DESCRIPTION

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

104 1/2" I.D. FLANGE DETAIL (BSC) GROOVED LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV
V049402	C	V049-4-022	0
SCALE AS NOTED		SHEET 1 OF 1	

8 7 6 5 4 3 2 1

Mon Apr 29 14:49:20 1996