



- 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.

THIS FLANGE TO BE MADE FROM P/N V049M254-1
WEIGHT: 823#

Raymond D. Ciatto PE-WA

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.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES FRACTIONAL ± 1/16" ANGULAR ± 10°-20° BOND ± 2° TWO PLACE DECIMAL ± .010 THREE PLACE DECIMAL ± .005 FINISHED SURFACE RNS 63 BREAK CORNERS IN .005 OUT .005 REMOVE ALL BURRS										PROCESS SYSTEMS INTERNATIONAL, INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA	
DWG. NO.		DESCRIPTION		DO NOT SCALE THIS DWG.		USED ON:		REV.		DESCRIPTION		CAD FILE V0494056	
REFERENCE DRAWINGS		NEXT ASS'Y:		1 DESIGN UPDATE/FABRICATION 0 ISSUED FOR FDR		CS RVD.WW.RER		SPIDER PV 7/31/96 0218 MA 04/30/96		SIZE C		DWG. NO. V049-4-056	
										SCALE 1 1/2"=1'-0"		SHEET 1 OF 1	

Nov 23, 1996 - 14:31:23