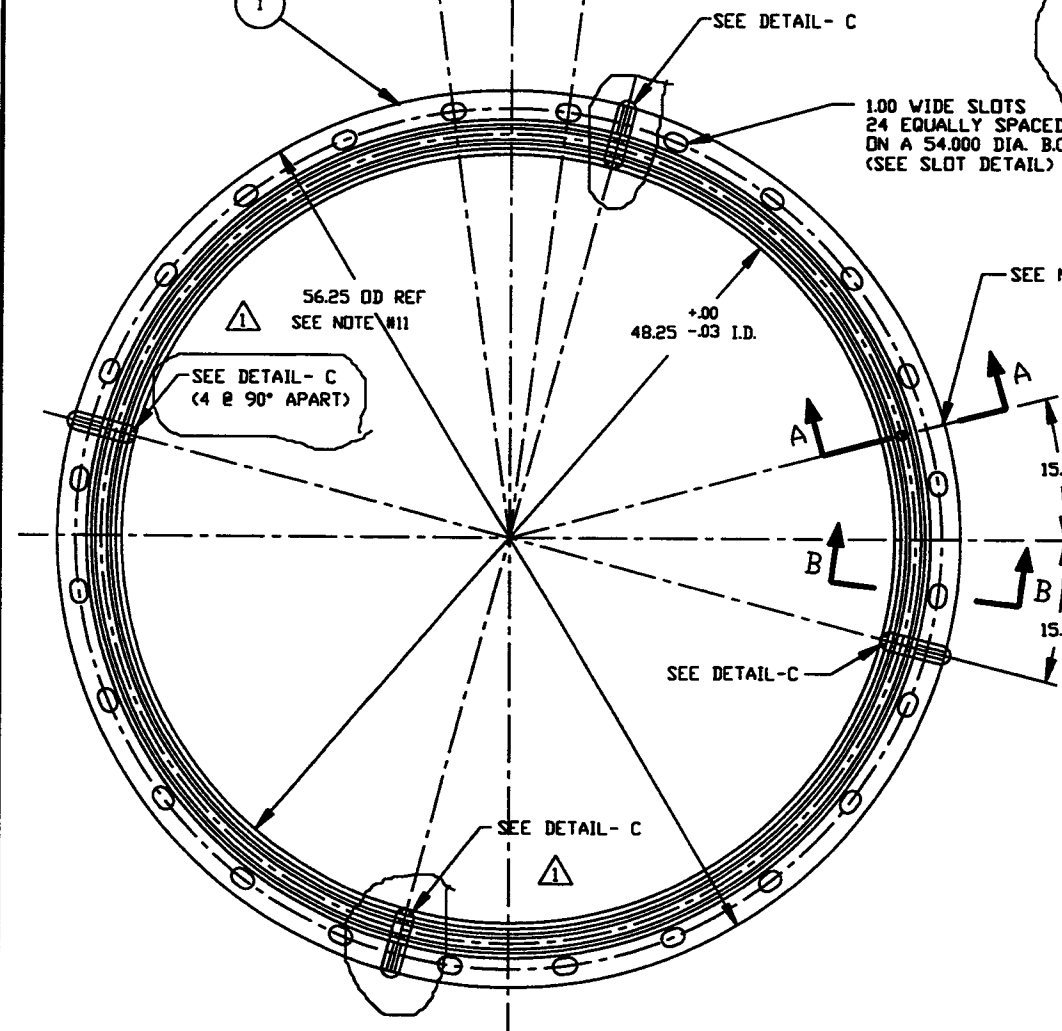
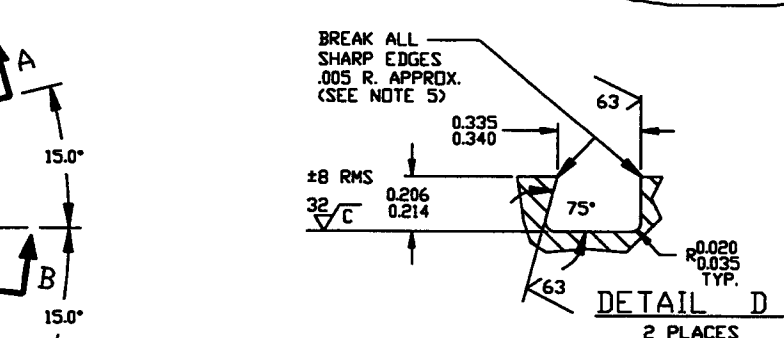
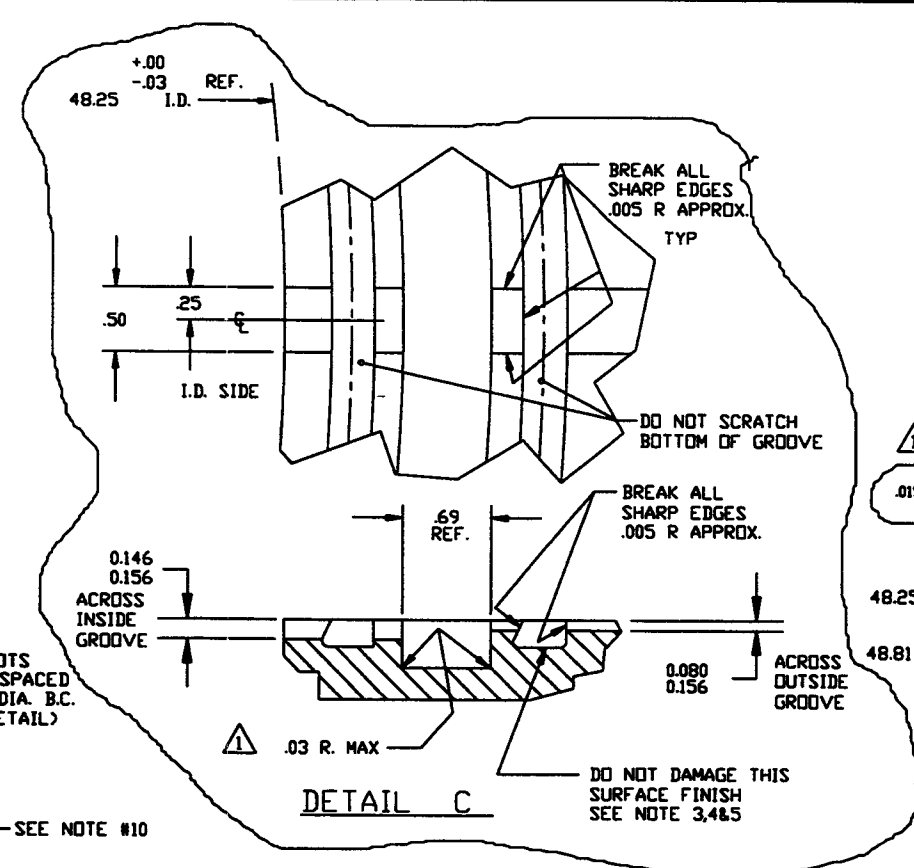




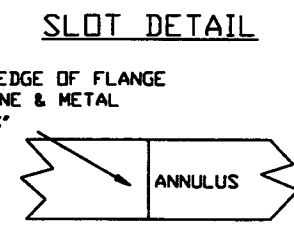
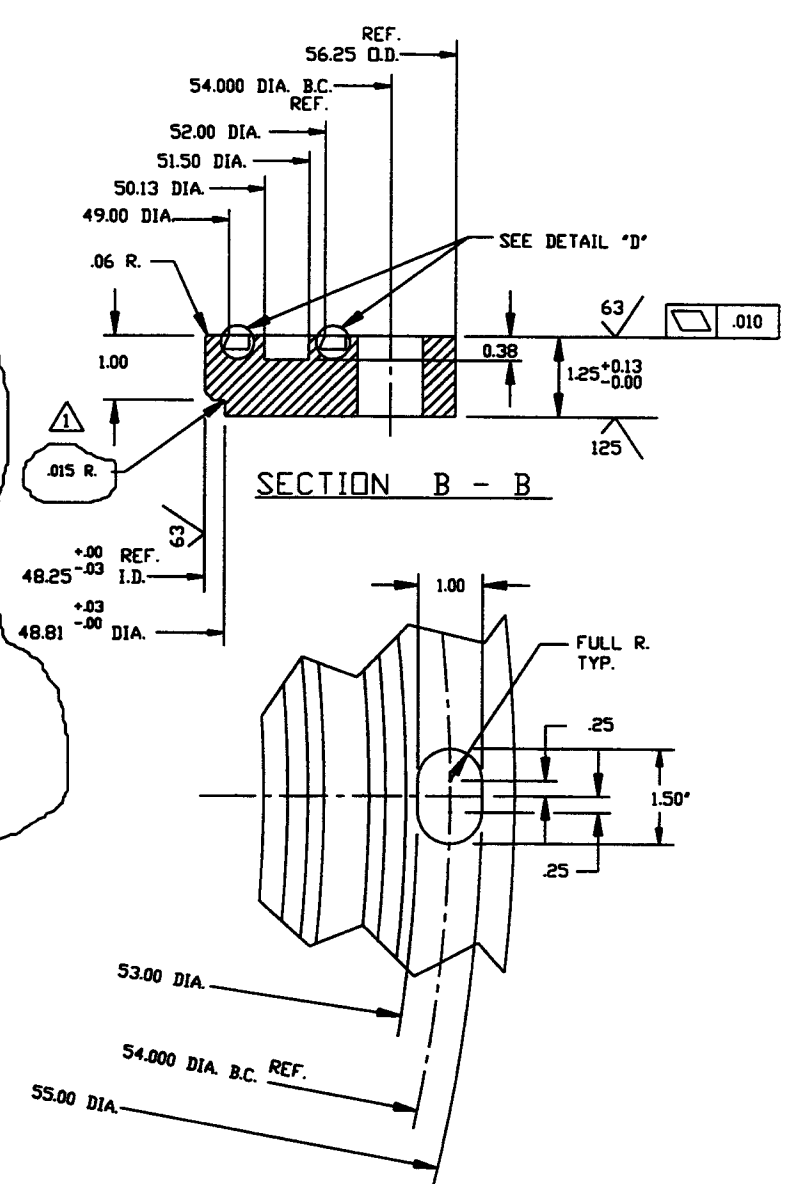
RAYMOND D. CHATFIELD
 REG. NO. 28750
 REGISTERED
 PROFESSIONAL
 ENGINEER
 IN
 CIVIL ENGINEERING
 STATE OF MASSACHUSETTS



INNER O-RING .275 DIA. STOCK x 153 1/8' LG. VULCANIZED - BAKED VITON E-60C
 OUTER O-RING .275 DIA. STOCK x 162 1/2' LG. VULCANIZED - BAKED VITON E-60C



- 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: 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 "ANNULUS"
- 11: DO NOT MACHINE FLANGE OD. ALL FORGING MANUFACT. NDS. TO BE LEFT INTACT.

THIS FLANGE TO BE MADE FROM P/N V049M242-1
 WEIGHT: 233#

PROPRIETARY AND CONFIDENTIAL
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DWG. NO.	DESCRIPTION	USED ON	REV.	DESCRIPTION	ISSUE DESCRIPTION
	REFERENCE DRAWINGS	NEXT ASSY.	1	REISSUED FOR FABRICATION	GS RALD
			0	ISSUED FOR FABRICATION	DA 10/8/96 0294

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

48 1/4" I.D. FLANGE DETAIL
 (GROOVED) W/SLOTS
 LIGO VACUUM EQUIPMENT

CAD FILE: V0494081
 SIZE: C
 DWG. NO.: V049-4-081
 SCALE: 1 1/2"=1'-0"