



- DETAIL #2**
SCALE: HALF
LIFTING LUG
QTY: FOUR (4) REQ'D
P/N: V0494014P4-3
MAT'L: 304 SST, 3/4\"/>

NOTES:

 - 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-078 SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
 - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL (EXCEPT AS NOTED)
 - 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 ± 8 RMS
 - 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.
 - 9: HEADS ARE ASME F&D
 10. PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII ITEM #1.
 11. DO NOT MACHINE FLANGE O.D. ALL FORGING MFG NOS. TO BE LEFT INTACT.
 12. HELIUM LEAK TEST PER SPEC. V049-2-014, BY PSI.
 13. IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
 14. EACH FINISHED COVER IS TO BE MARKED WITH A UNIQUE SEQUENTIAL PSI SERIAL NUMBER. THE NUMBER IS TO BE MADE FROM THE DRAWING NO. PLUS THE SEQUENTIAL NO. V0494127-01, -02 ETC.
 15. CONFLAT FLANGES ARE TO BE PROTECTED WITH COVERS AT ALL TIMES DURING AND AFTER MACHINING PER PSI SPEC V049-2-123.
 16. MACHINING VENDOR TO USE PSI'S CENTER PUNCH MARK LOCATED AT 0° ON EACH HEAD AS THE STARTING POINT FOR THE NATURAL CENTERLINE BOLT PATTERN. BOLT HOLES TO STRADDLE THE VERTICAL CENTERLINE AS SHOWN IN THE ELEVATION.
 17. DO NOT MACHINE THE BACKSIDE TO THE FINISHED THICKNESS. LEAVE THE ±200 RMS FINISH AS SUPPLIED BY THE FLANGE FORGING VENDOR, UNLESS THE BACK SURFACE PARALLELISM EXCEEDS 0.030 AS MEASURED FROM THE FINISHED SEALING SURFACE. IF MACHINING IS REQUIRED, THEN CLEAN OFF MINIMUM MATERIAL COMPLETELY ACROSS THE BACKSIDE AND STOP 1/2\"/>
 - 18. DO NOT FINISH MACHINE I.D. OF FLANGE FORGING.

MAKE FLANGE FROM P/N V049M136-1
WEIGHT ASSEMBLED: 802#

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<p>DWG. NO. DESCRIPTION DWG. NO. DESCRIPTION</p>				<p>USED ON: REV DESCRIPTION</p>				<p>SCALE 1=10 SHEET 1 OF 1</p>				<p>CAD FILE V0494127 SIZE D DWG. NO. V049-4-127 REV 4</p>							
<p>REFERENCE DRAWINGS</p>				<p>NEXT ASS'Y:</p>				<p>ISSUE DESCRIPTION</p>				<p>SCALE 1=10 SHEET 1 OF 1</p>							

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