



- NOTES
10. SCRIBE OUTER EDGE OF FLANGE WITH SCRIBE LINE & METAL STAMP 0°.
 9. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
 8. FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL, UNLESS NOTED.
 7. CLEAN PER SPEC: V049-2-015.
 6. ALL NOZZLES TO BE CONTOURED TO OUTSIDE DIAMETER OF SHELL OR TO CURVATURE OF HEAD, UNLESS OTHERWISE NOTED.
 5. GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
 4. FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-044.
 3. HEADS ARE ASME F&D.
 2. PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII ITEM "2"
 1. HELIUM LEAK TEST PER SPEC V049-2-014 BY PSI.

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DWG. NO.	DESCRIPTION	DWG. NO.	DESCRIPTION
		V049-2-040	SPEC. FOR ST.ST. FLANGE FORGINGS.
		V049-2-039	SPEC. FOR VESSEL HEADS.
REFERENCE DRAWINGS			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± .1
ANGULAR/ARCH 30°-30' BEND ±2°
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS
BREAK CORNERS IN
REMOVE ALL BURRS 63

DO NOT SCALE THIS DRAWING

USED ON:

NEXT ASS'Y:

REV	DESCRIPTION	DESCRIPTION	CHKD	DRWN	DATE	DESH
0	ISSUED FOR FDR/FAB					
P5	REVISED					
P4	REVISED DIM. TOL'S AS NOTED					
P3	RE-RELEASE FOR PROTOTYPE FABRICATION					
P2	FOR PROTOTYPE FABRICATION					
P1	RELEASE FOR QUOTE					

APR 30 1996

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PROCESS SYSTEMS INTERNATIONAL, INC.
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**COVER, TYPE I
BEAM SPLITTER CHAMBER
LIGO VACUUM EQUIPMENT**

CAD FILE	SIZE	DWG. NO.	REV.
V0494014/4014S2	D	V049-4-014	0
SCALE AS NOTED	SHEET	1 OF 1	

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