



DETAIL "2"
P/N: V0494014P1
SCALE: HALF

DETAIL "3"
SCALE: HALF

- 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

NOT FOR CONSTRUCTION

Raymond D. Watts, PE
5/6/96 LIG-0961100-00-V

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

COVER, TYPE I
BEAM SPLITTER CHAMBER
LIGD VACUUM EQUIPMENT

REV	DATE	BY	CHKD	DRWN	DESCRIPTION
0	4-25-96	PV			ISSUED FOR FDR
	4-22-96	PV			REVISED
	4-6-96	MA			REVISED DIM. TOL'S AS NOTED
	3-18-96	DA			RE-RELEASE FOR PROTOTYPE FABRICATION
	2-6-96	KAR			FDR PROTOTYPE FABRICATION
	11-19-95	KAR			RELEASE FOR QUOTE

SCALE	AS NOTED
SHEET	1 OF 1

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± .01
ANGULAR ± .01° BEND ± .2°
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RING
BREAK CORNERS IN OUT
REMOVE ALL BURRS 63

DO NOT SCALE THIS DRAWING
USED ON:
NEXT ASS'Y:

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