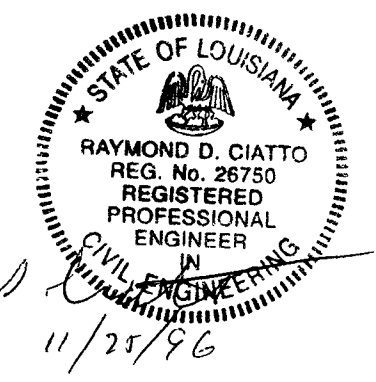
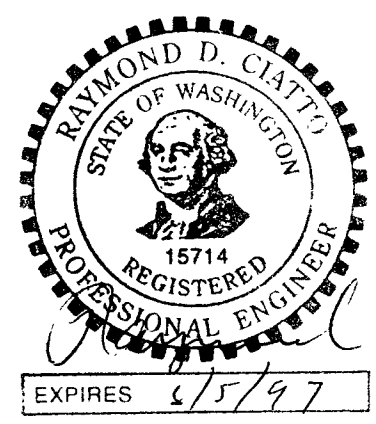


DETAIL '1'  
TYP. (5) PLCS  
SCALE: HALF

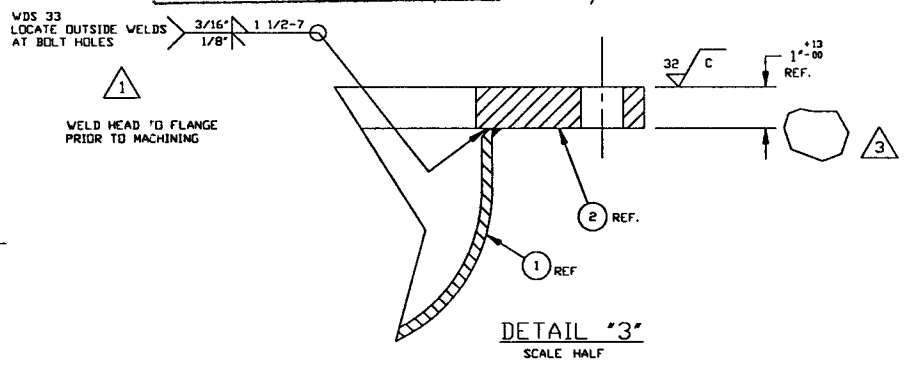
DETAIL '2'  
SCALE: HALF

LIFTING LUG  
QTY. (4) REQ'D  
P/N: V0494014P4-3  
MAT'L 304 SST. 3/4\"/>



NOTES

- 15 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\"/>
- 14. EACH FINISHED COVER IS TO BE MARKED WITH A UNIQUE SEQUENTIAL PSI NUMBER. THE NUMBER IS TO BE MADE FROM THE DRAWING NO PLUS THE SEQUENTIAL NO V049412B-01, -02 ETC.
- 13. CONFLAT FLANGES ARE TO HAVE PROTECTIVE COVERS AT ALL TIMES DURING AND AFTER MANUFACTURING PER PSI SPEC V049-2-123.
- 12. IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
- 11. DO NOT MACHINE FLANGE OD ALL FORGING MFG NOS TO BE LEFT INTACT.
- 10. MACHINING VENDOR TO USE PSI'S CENTER PUNCH MARK LOCATED AT 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. MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH \* B RMS.
- 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 V049-2-117, & 136.
- 3. HEADS ARE ASME F&D.
- 2. PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII ITEM '1'.
- 1. HELIUM LEAK TEST PER SPEC V049-2-014 BY PSI.



DETAIL '3'  
SCALE: HALF

MAKE FLANGE FROM P/N V049M243-1

WEIGHT ASSEMBLED: 585#

D961100-03-V

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

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
TOLERANCES:  
FRACTIONAL & J  
HOLE/SHAFT .00-.01 BOND .02  
TWO PLACE DECIMAL & .030  
THREE PLACE DECIMAL & .015  
FROGGER SURFACE .010  
BREAK CORNERS IN OUT  
REMOVE ALL BURRS & D

DO NOT SCALE THIS DRAWING

USED ON:

NEXT ASS'Y:

REV.	DESCRIPTION	DESCRIPTION	CHKD	DRWN	DATE	DESN
3	REVISED PER RFC V049-018 / ISSUED FOR FABRICATION	FDR/DMS	PEF	RDC	REC	PV
2	REISSUED FOR FABRICATION					
1	ISSUED FOR FABRICATION					
0	ISSUED FOR FDR					

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

COVER, TYPE I  
BEAM SPLITTER CHAMBER  
LIGO VACUUM EQUIPMENT

CAD FILE: V0494014/4014S2  
SIZE: D  
DWG. NO.: V049-4-014  
REV: 3

SCALE: AS NOTED  
SHEET: 1 OF 1