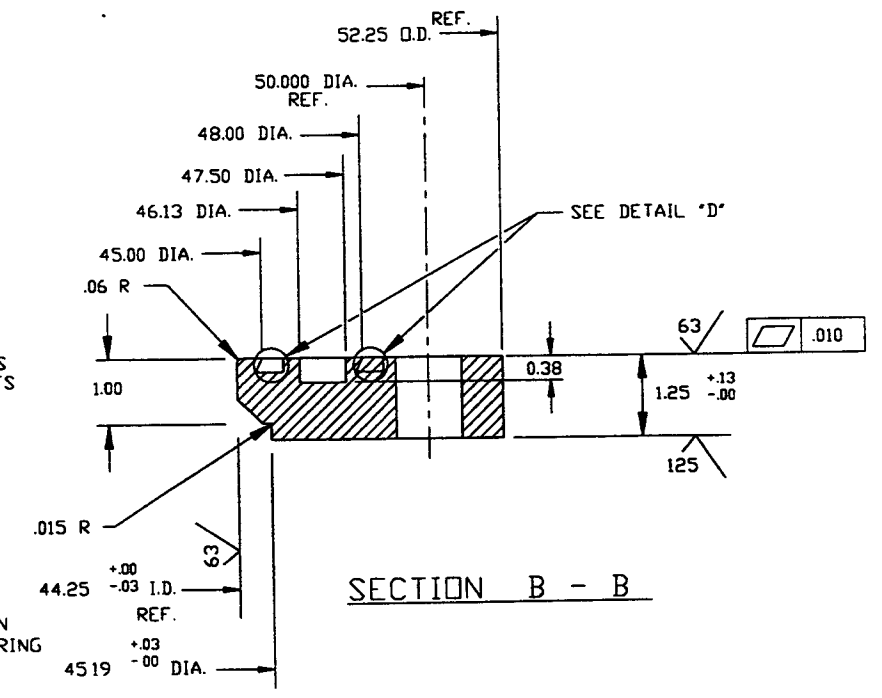


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
  - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
  - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN 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 O.D. ALL FORGING MANUFACT. NOS. TO BE LEFT INTACT



THIS FLANGE TO BE MADE FROM P/N V049M244-1  
WEIGHT: 215#

INNER O-RING .275 DIA. STOCK x 140 3/4" LG. VULCANIZED - BAKED VITON E-60C  
OUTER O-RING .275 DIA. STOCK x 150" LG. VULCANIZED - BAKED VITON E-60C

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DWG. NO.	DESCRIPTION	USED ON:	NEXT ASS'Y:
	REFERENCE DRAWINGS		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES:  
FRACTIONAL ± 1/16  
ANGULAR APPROX ± 30' BEH ± 2"  
TWO PLACE DECIMAL ± .010  
THREE PLACE DECIMAL ± .005  
FINISHED SURFACE RMS 32  
BREAK CHORDS .040 DIA. OUT .005 REMOVE ALL BURRS  
DO NOT SCALE THIS DWG.

REV.	DESCRIPTION	CHKD	DRAWN	DATE	DEC
3	REISSUED FOR FABRICATION / FDR UPDATE				
2	REISSUED FOR FABRICATION	GS	PEF	DMV	RDC REC
1	RELEASED FOR FAB	GS	PEF	DMV	RDC REC
0	ISSUED FOR FDR				
P3	PRELIMINARY				
P2	PRELIMINARY				

CAD FILE	SIZE	DWG. NO.	REV.
V0494017	C	V049-4-017	3

SCALE 1 1/2"=1'-0" SHEET 1 OF 1