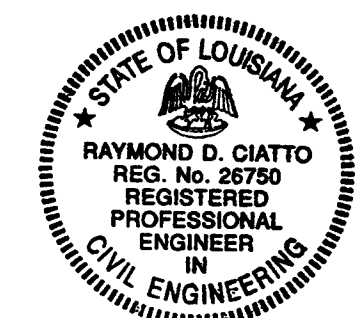


- NOTE:**
- 1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
 - 2: ALL MATERIAL TO BE 304L STAINLESS STEEL
 - 3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN 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 0°.
- 11: DO NOT MACHINE FLANGE O.D. ALL FORGING MANUFACT. NOS TO BE LEFT INTACT.
- 12: SEE DWG. V049-4-101 FOR FLANGE MOUNTING LOCATIONS AND ORIENTATIONS.
G1 PORT ORIENTATION TO BE USED AT 'C' NOZZLES
G2 PORT ORIENTATION TO BE USED AT 'B' NOZZLES.

THIS FLANGE TO BE MADE FROM P/N V049M135-1
WEIGHT: 318#

INNER O-RING .275 DIA. STOCK x 191 1/4' LG. VULCANIZED - BAKED VITON E-60C
OUTER O-RING .275 DIA. STOCK x 200 5/8' LG. VULCANIZED - BAKED VITON E-60C



PROPRIETARY AND CONFIDENTIAL
THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION BELONGING TO PROCESS SYSTEMS INTERNATIONAL, INC. OR ITS AFFILIATED COMPANIES AND SHALL BE USED ONLY FOR THE PURPOSE FOR WHICH IT WAS SUPPLIED. IT SHALL NOT BE COPIED, REPRODUCED OR OTHERWISE USED, NOR SHALL SUCH INFORMATION BE FURNISHED IN WHOLE OR IN PART TO OTHERS EXCEPT IN ACCORDANCE WITH THE TERMS OF ANY AGREEMENT UNDER WHICH IT WAS SUPPLIED OR WITH THE PRIOR WRITTEN CONSENT OF PROCESS SYSTEMS INTERNATIONAL, INC. AND SHALL BE RETURNED UPON REQUEST.

DWG NO	DESCRIPTION	USED ON	REV.	DESCRIPTION	ISSUE DESCRIPTION	CHKD	DRAWN	DATE	DEC			
D V049-4-101	BSC OVERALL ASSEMBLY		4	REISSUED FOR FABRICATION PER RFC V049-033	PEF RDC	PFH/DHW	REB/RC	RDC	REC	PV	1/27/97	0421
D V049-4-003	BSC SHELL WELDMENT/MACHINING		3	REISSUED FOR FABRICATION	PEF RDC	PFH	REB	REC	REC	PV	10/8/96	0294
			2	AS NOTED/FABRICATION	PEF RDC	PFH	REB	REC	REC	PV	8-21-96	0203
			1	DELETED ONE PORT, RELOCATED ONE PORT	PEF RDC		REB	REC	REC	PV	6-12-96	
			0	ISSUED FOR FDR		RDC	DHW	REC		PV	4-20-96	0150

CAD FILE	SIZE	DWG. NO	REV.
V0494019	C	V049-4-019	4

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

EXPIRES 8/5/97

LIGO-D961102-04-V