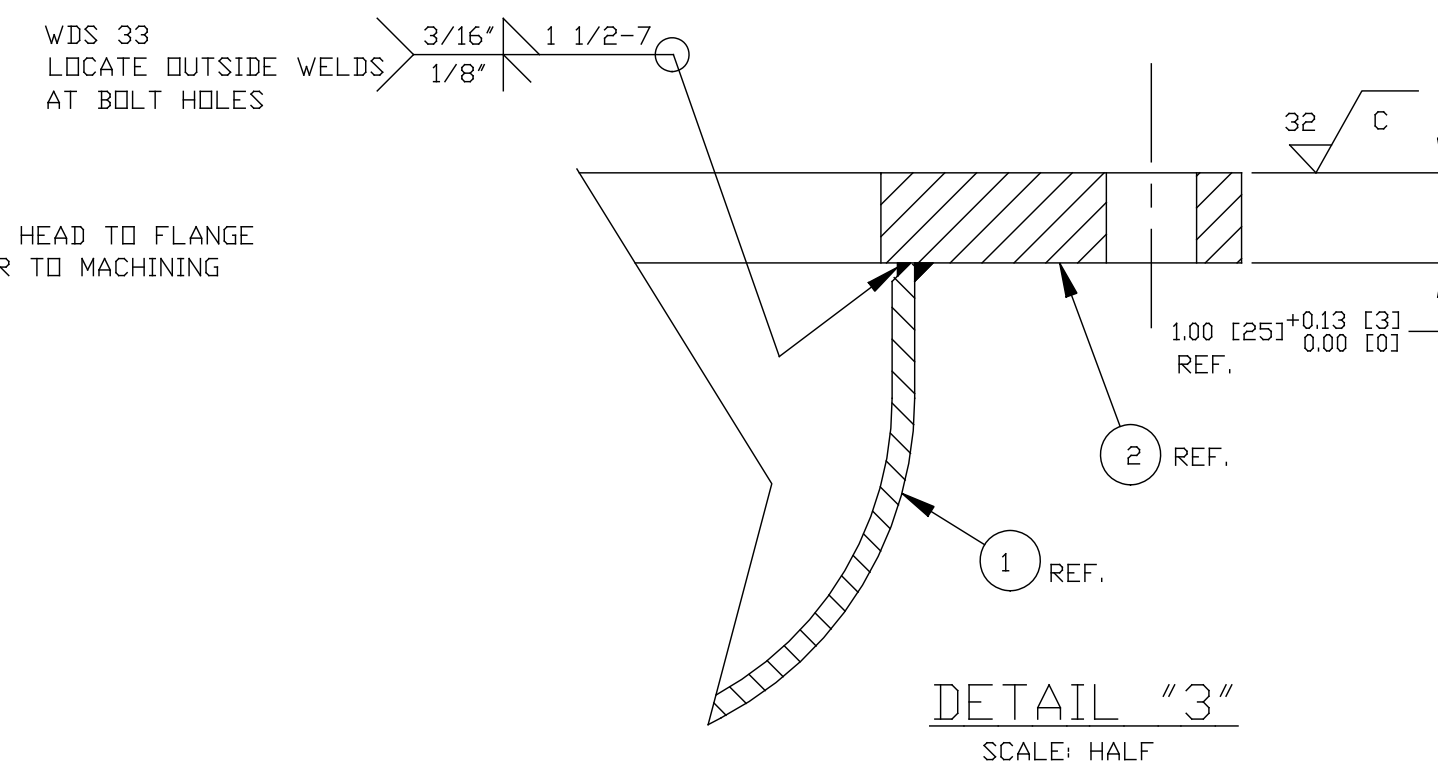
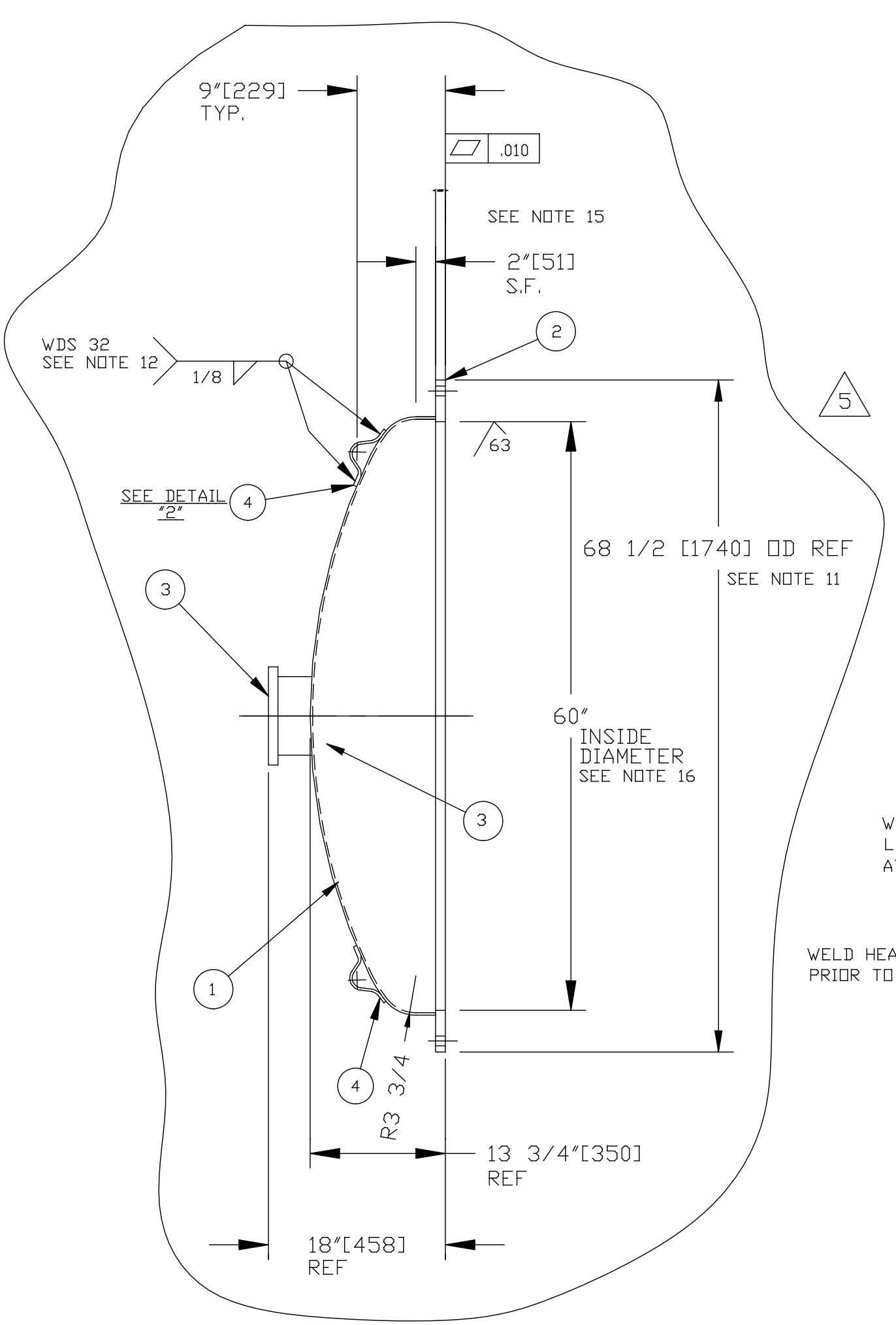
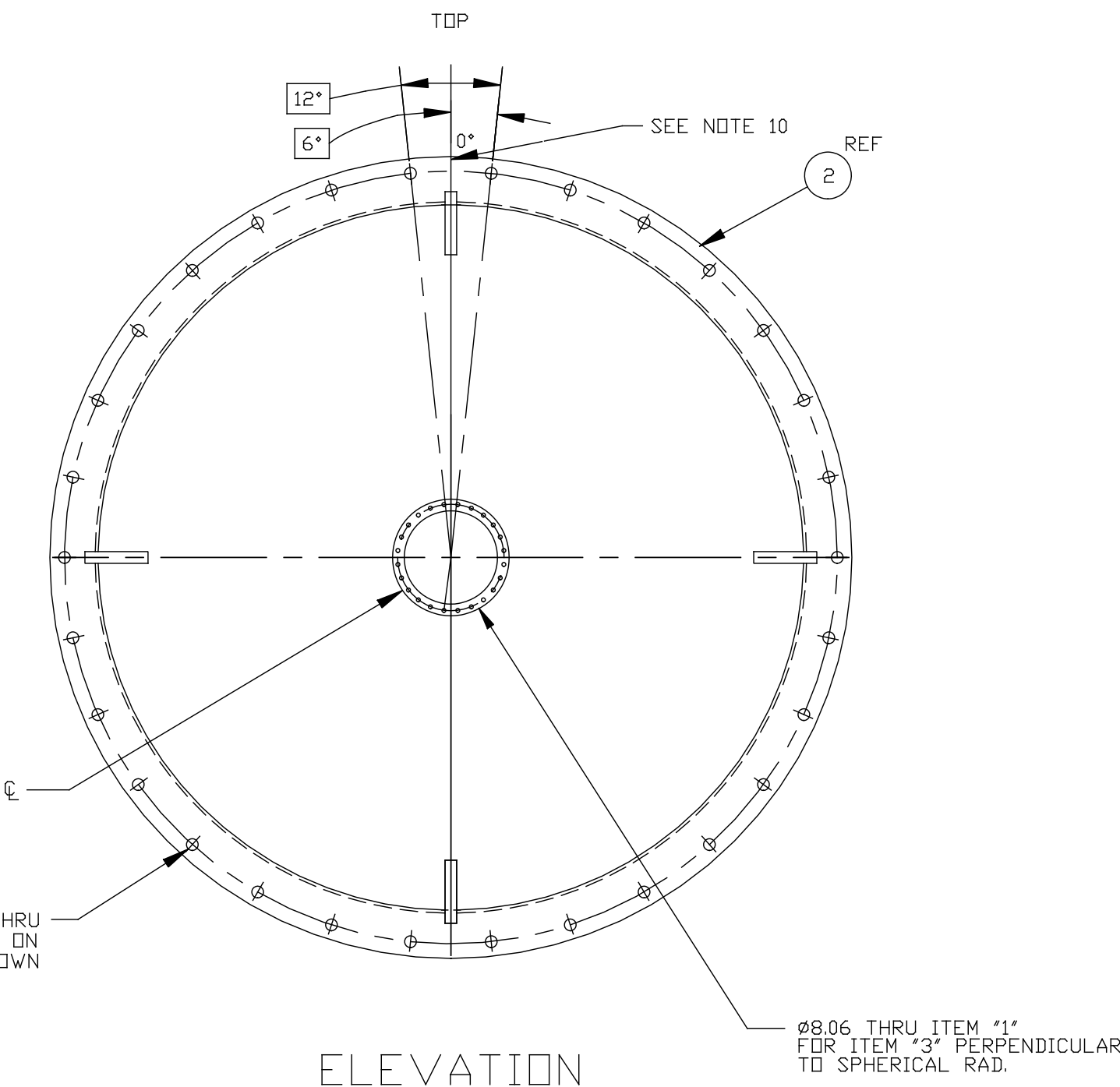


DETAIL "2"
SCALE: HALF
LIFTING LUG
QTY: FOUR (4) REQ'D
P/N: V0494014P4-3
MAT'L: 304 SST, 3/4" WIDE X 1/4" THK FLAT BAR, ASTM A479



DETAIL "3"
SCALE: HALF

- NOTES**
- DO NOT FINISH MACHINE I.D. OF FLANGE FORGING.
 - 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" CLEAR OF EXISTING WELD LEG. IF A STEP OCCURS, FINISH WITH 1/8" RADIUS.
 - EACH FINISHED COVER IS TO BE MARKED WITH A UNIQUE SEQUENTIAL PSI SERIAL NUMBER. THE NUMBER IS TO BE MADE FROM THE DRAWING NO. PLUS THE SEQUENTIAL NO. V0494A11-01-02 ETC.
 - CONFLAT FLANGES ARE TO HAVE PROTECTIVE COVERS AT ALL TIMES DURING AND AFTER MANUFACTURING, PER PSI SPEC V049-2-123.
 - IF FIT UP GAPS OCCUR, INCREASE SIZE OF WELD TO MAINTAIN FULL WELD.
 - DO NOT MACHINE FLANGE O.D. ALL FORGING MANUFACTURERS NUMBERS TO BE LEFT INTACT.
 - MACHINING VENDOR TO USE PSI'S CENTER PUNCH MARK LOCATED AT 0° ON EACH HEAD AS THE STARTING POINT FOR THE NATURAL CENTERLINE BOLT PATTERN. BOLT HOLES TO STRADDLE THE VERTICAL CENTERLINE AS SHOWN IN THE ELEVATION.
 - CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
 - FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL, UNLESS NOTED.
 - CLEAN PER SPEC: V049-2-015.
 - MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH ± 8 RMS.
 - GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL OR ALUMINUM MATERIAL.
 - FABRICATION TO BE IN ACCORDANCE WITH SPEC. V049-2-117.
 - HEADS ARE ASME F&D.
 - PORT LOCATIONS, DIMENSIONS TAKEN FROM OUTER SPHERICAL RADII ITEM '1'.
 - HELIUM LEAK TEST PER SPEC V049-2-014 BY PSI.

MAKE FLANGE FROM P/N V049M137-1

WEIGHT ASSEMBLED: 560#

PROPRIETARY AND CONFIDENTIAL				SYMBOL CHARACTERISTIC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		5 REVISED AS NOTED/I.D. PER RFC V049-051		PV 4/11/97 0464		PROCESS SYSTEMS INTERNATIONAL, INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA BSC END COVER, TYPE A11 BEAM SPLITTER CHAMBER LIGO VACUUM EQUIPMENT	0116
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.				▱ FLATNESS ○ CYLINDRICITY // PARALLELISM ⊥ PERPENDICULARITY ∠ ANGULARITY ⊕ TRUE POSITION ⊙ CONCENTRICITY		FRACTIONAL: ± 1 ANGULAR: ± 0°-30' BEND ± 2° TWO PLACE DECIMAL ± 0.30 THREE PLACE DECIMAL ± 0.015 FINISHED SURFACE RMS BREAK CORNERS IN DUTY REMOVE ALL BURRS 63		4 REVISED PER RFC V049-018 / ISSUED FOR FABRICATION		0366			
V049-2-040 SPEC. FOR ST.ST. FLANGE FORGINGS.				DO NOT SCALE THIS DRAWING		USED ON:		3 REISSUED FOR FABRICATION		0299		CAD FILE: V0494A11 SIZE: D DWG. NO.: V049-4-A11 REV: 5 SCALE: AS NOTED SHEET: 1 OF 1	Nov 23, 1996 - 13:00:37
V049-2-039 SPEC. FOR VESSEL HEADS.				NEXT ASSY:		ISSUED FOR FABRICATION		2 ISSUED FOR FABRICATION		0194			
DWG. NO. DESCRIPTION REFERENCE DRAWINGS DWG. NO. DESCRIPTION				REV		DESCRIPTION DESCRIPTION		1 AS NOTED		0194			
				REV		DESCRIPTION DESCRIPTION		0 ISSUED FOR F&D		0194			
				REV		DESCRIPTION DESCRIPTION		0 ISSUED FOR F&D		0194			