



RAYMOND D. CIATTO
 STATE OF LOUISIANA
 REGISTERED PROFESSIONAL ENGINEER
 REG. No. 26750
 CIVIL ENGINEERING
 IN

EXPIRES 1/2/97

- 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: STEAM CLEAN & WRAP IN POLYETHELENE TO PREVENT CONTAMINATION DURING SHIPPING.

THIS FLANGE TO BE MADE FROM P/N V09M259-1
 WEIGHT: 895#

Raymond D. Ciatto PE-WA.

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DWG. NO.	DESCRIPTION	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16" ANGULAR APPROX 10'-30" BEND ± 2° TWO PLACE DECIMAL ± .010 THREE PLACE DECIMAL ± .005 FINISHED SURFACE RUGS 63 BREAK CORNERS: RADIUS OUT-JOBS REMOVE ALL BURRS	DO NOT SCALE THIS DWG.	REV.	DESCRIPTION	CHKD	DRAWN	DATE	DED	
			0		RELEASED FOR FABRICATION					
						GS	RAL	D.M.	7/31/96	0218

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

48.81" I.D. x 80" O.D. FLG DETAIL
 W/ OBS PORTS (FLAT FACED)
 LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG NO	REV
V0494071	C	V049-4-071	0

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