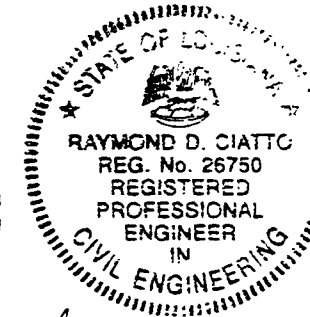
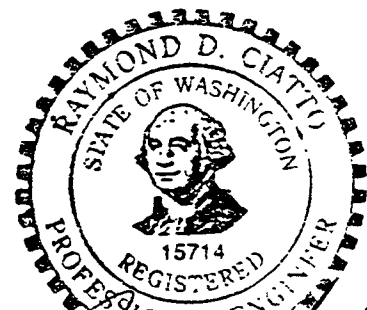
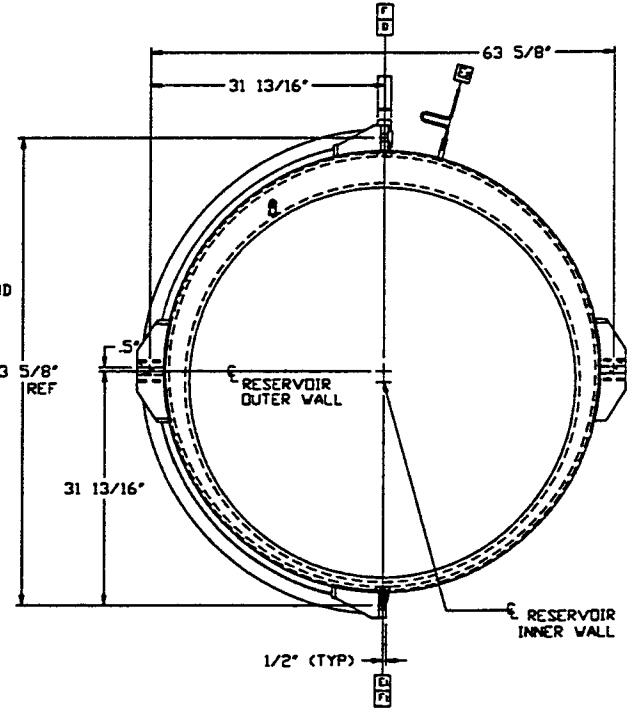
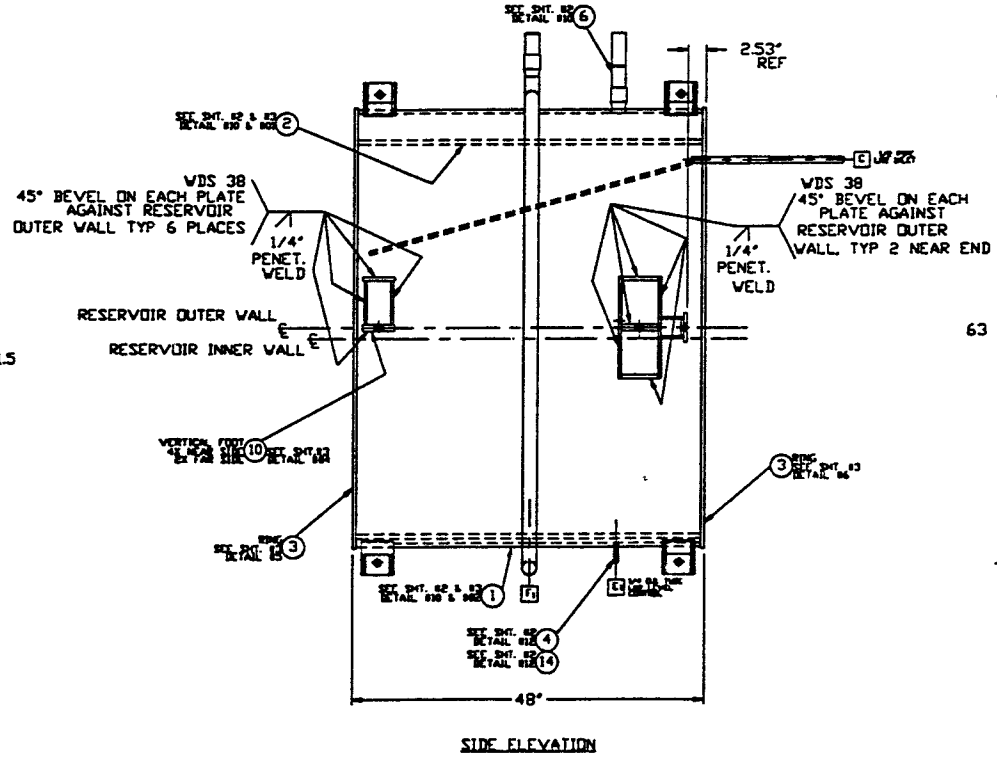
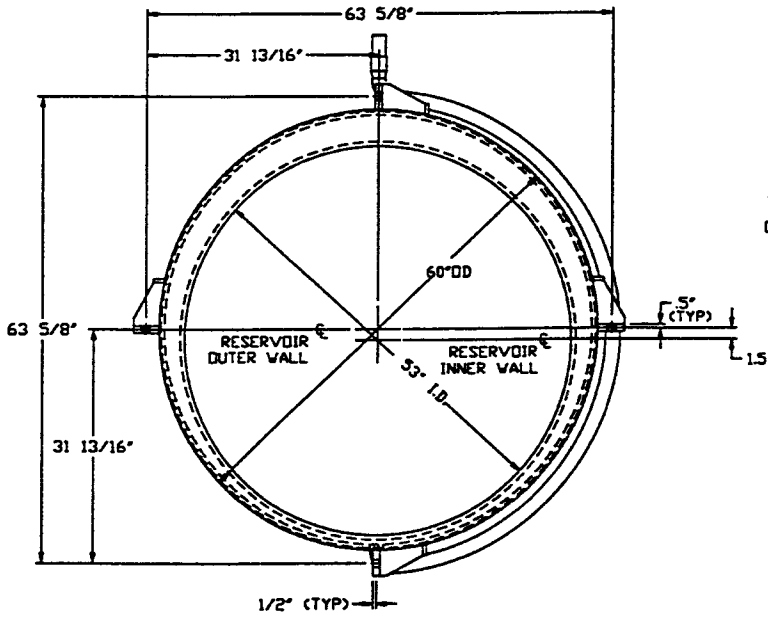
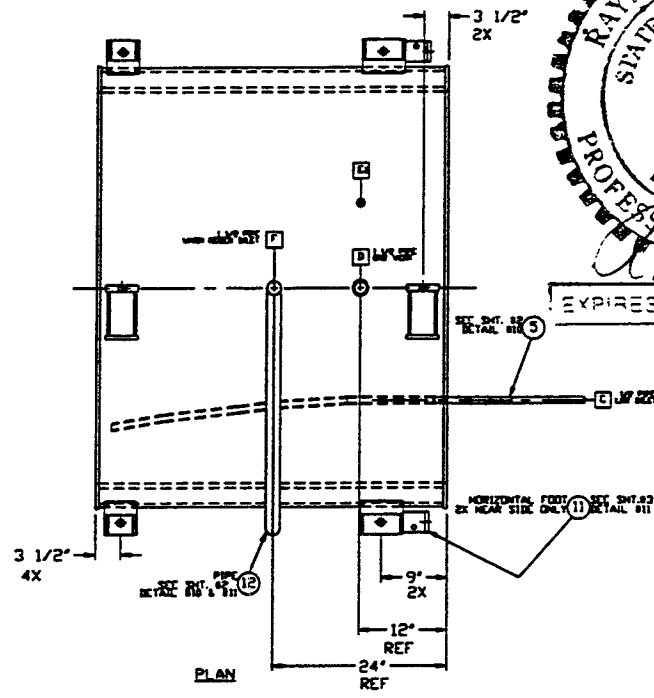


- NOTES
12. WDS NO'S REFER TO WELD DATA SPEC. V049-2-084
 11. BOK PUMP FABRICATION PLAN SPEC. V049-2-082
 10. BOK PUMP QUALITY PLAN SPEC. V049-2-098
 9. HANDLING TO BE ACCORDANCE WITH SPEC V049-2-120
 8. ROLLING & MACHINING TO BE IN ACCORDANCE WITH SPEC V049-2-136
 7. EACH FINISHED WELDMENT IS TO BE MARKED WITH A UNIQUE SEQUENTIAL SERIAL NUMBER DEVELOPED FROM THE DRAWING NUMBER PLUS -01 ETC. NUMBER TO BE LOCATED AT OUTSIDE END PLATE
 6. PRESSURE TEST: PNEUMATIC 38 PSIG AT 70" PER PSI PROCEDURE
 5. LEAK TEST & METHOD PER PSI SPEC V049-2-014, BY PSI.
 4. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED.
 3. CLEAN INSIDE & OUTSIDE SURFACES PER SPEC. V049-2-015
INSIDE SURFACES TO BE CLEANED PRIOR TO WELD UP.
 2. DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL.
GRINDING ON INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED.
 1. BOK PUMP FABRICATION PLAN SPEC. V049-2-096.



DESIGN DATA	
MAX. OPER. PRESS	15 PSIG
CORROSION ALLOWANCE	0
POSTWELD HEAT TREATMENT	NONE
FIBREPROOFING	N/A
RADIOGRAPHING	NONE
MATERIALS	
SHELL	AL 5B209 6061-T6
PIPE NEDS (SEE DETAILS)	
SUPPORT LUGS	AL 5B209 6061-T6
WEIGHTS EMPTY 12000	



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SYMBOL	CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
	FLATNESS	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	CYLINDRICITY	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	PARALLELISM	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	PERPENDICULARITY	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	ANGULARITY	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	TRUE POSITION	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED
	CONCENTRICITY	FUNCTIONAL SURFACES TO BE FINISHED TO 32 RMS FINISH UNLESS OTHERWISE SPECIFIED

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30 HULLIP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA

BOK PUMP RESERVOIR-SHORT-LEFT

LIGD VACUUM EQUIPMENT

DATE FILE: 4/94/09151
SCALE: NONE

REV 0

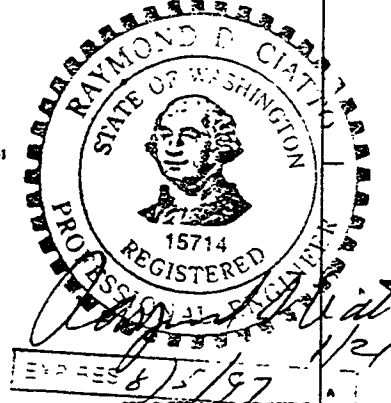
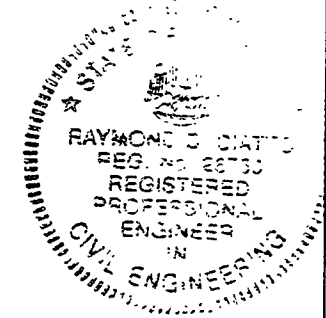
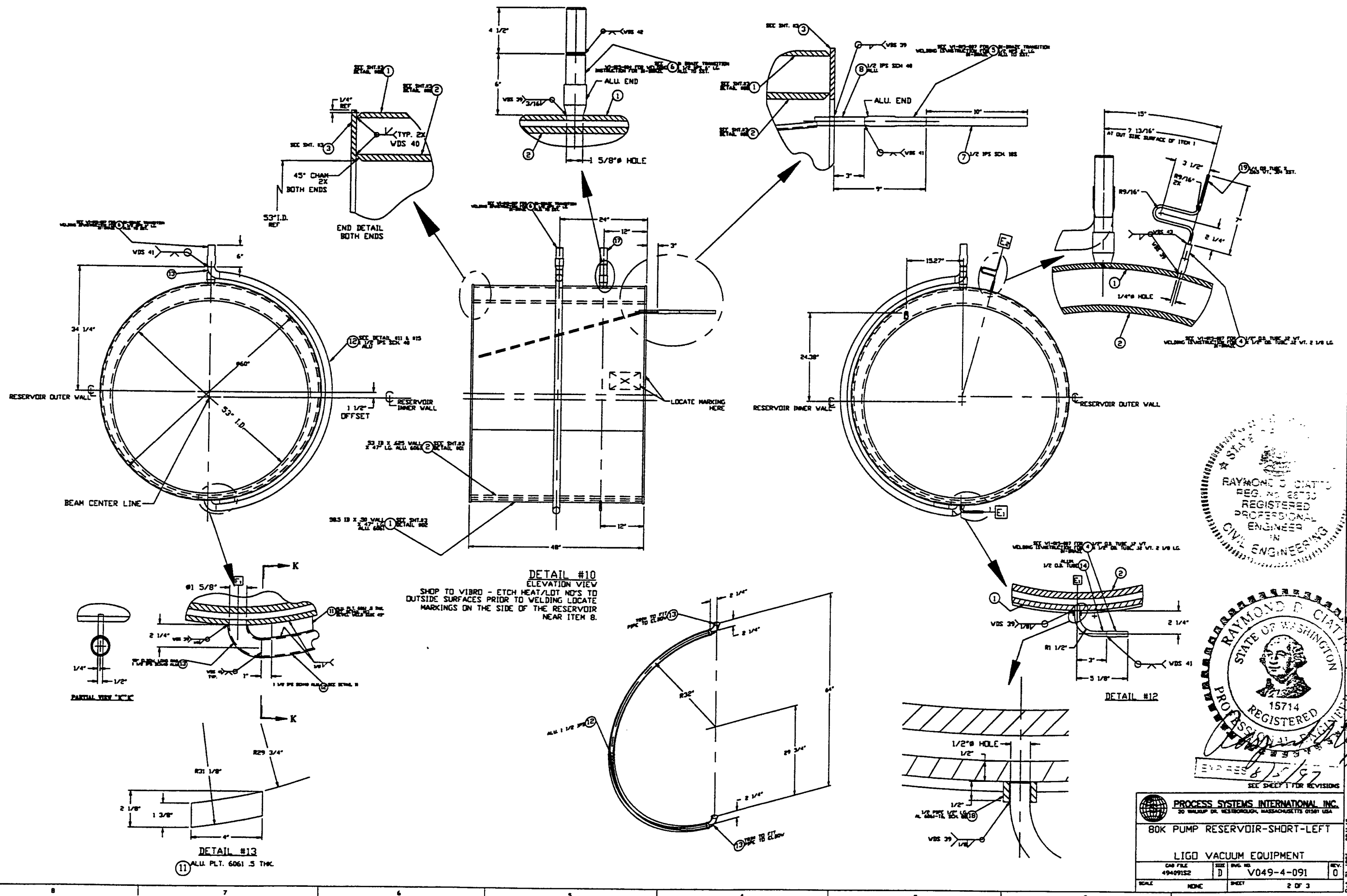
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65 RDC REC TDV 10/22/96 0312

CHKD DRWN DATE DEC 9

SHEET 1 OF 3

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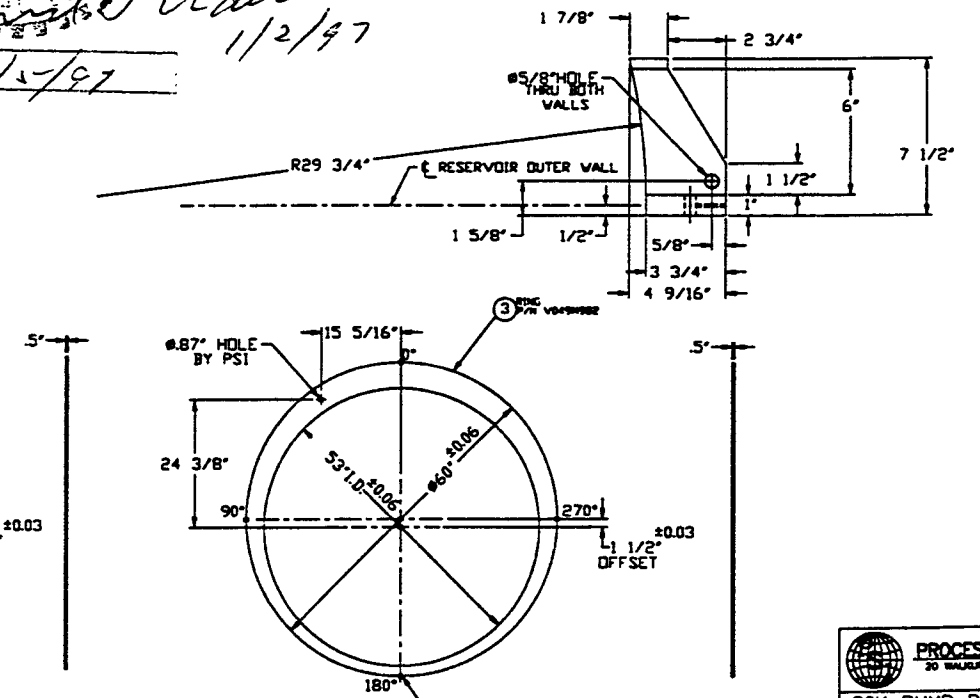
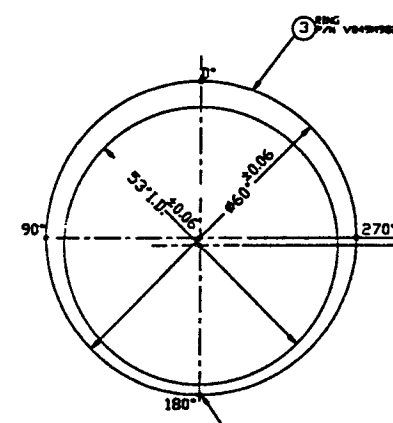
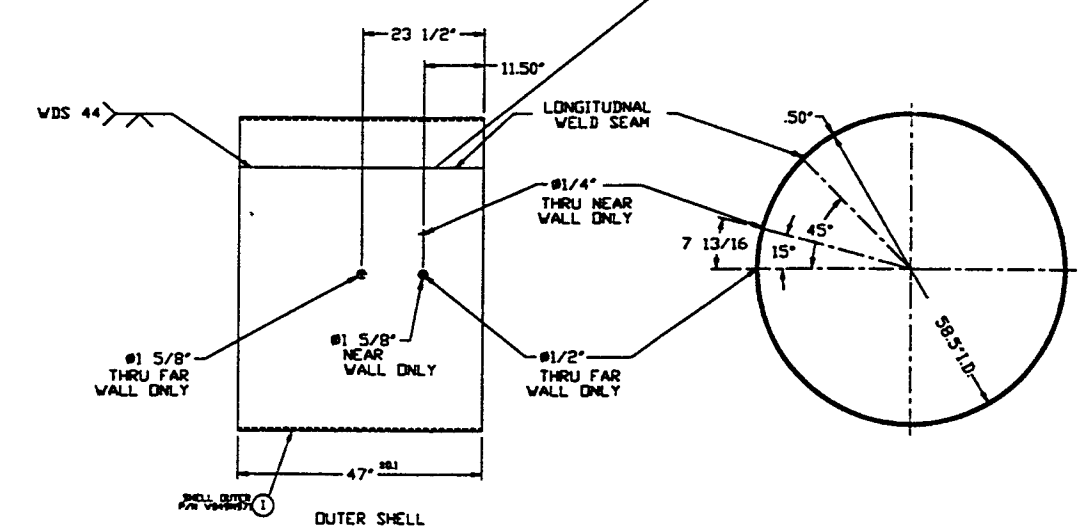
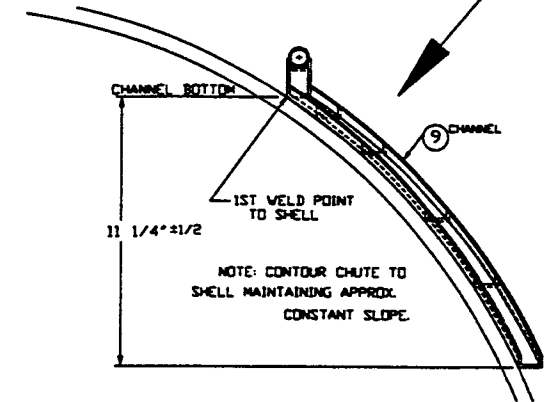
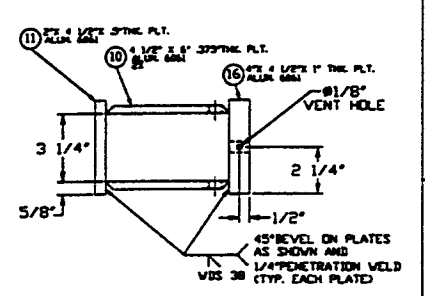
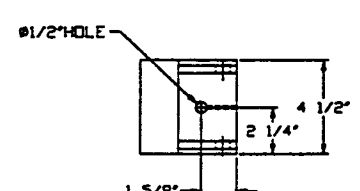
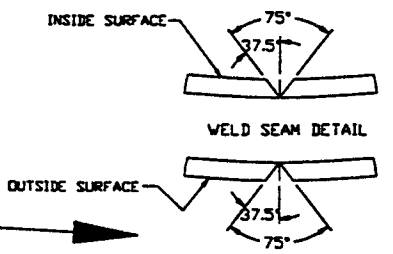
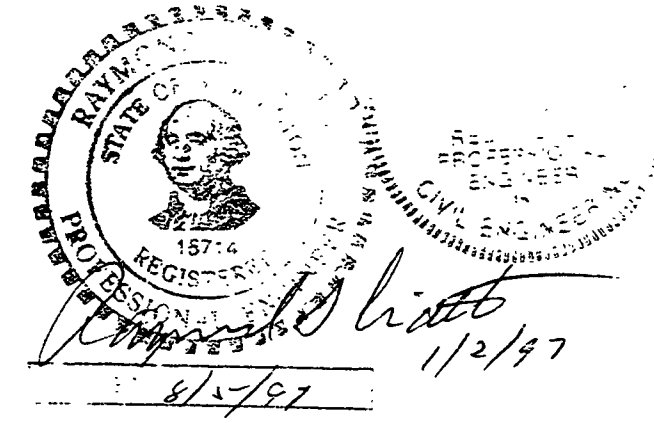
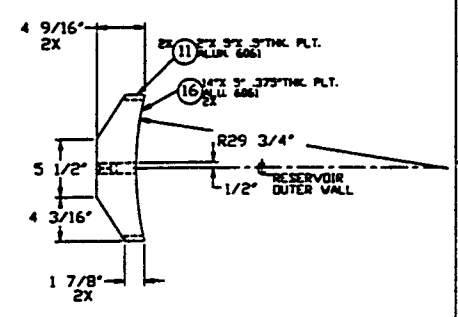
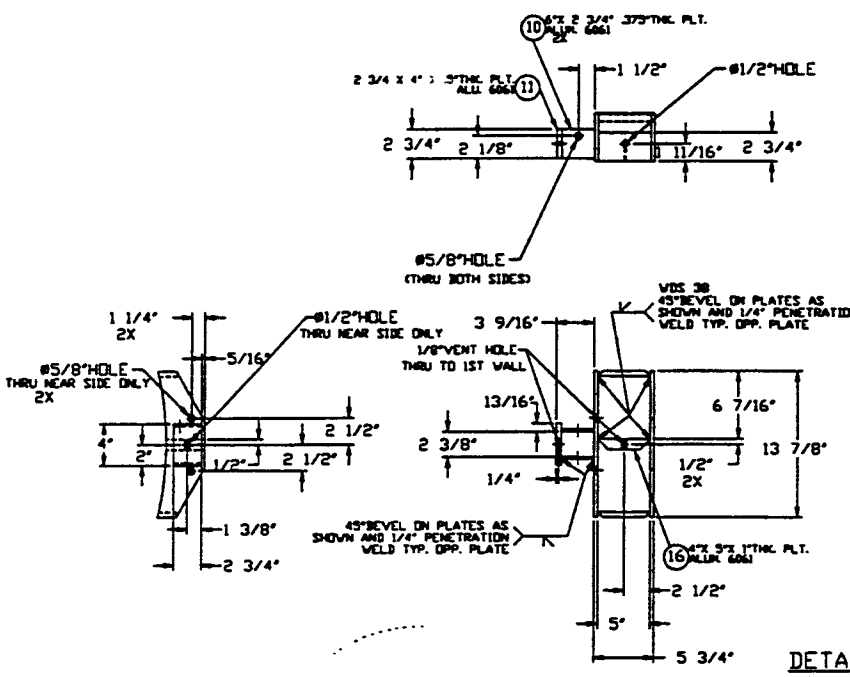
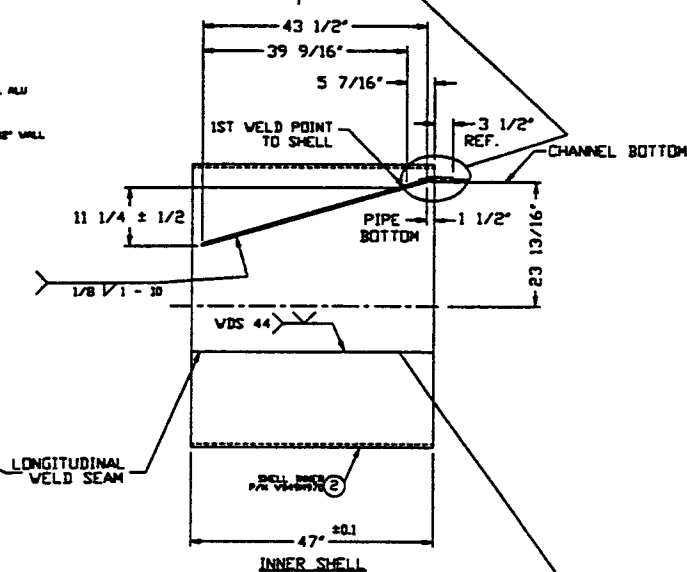
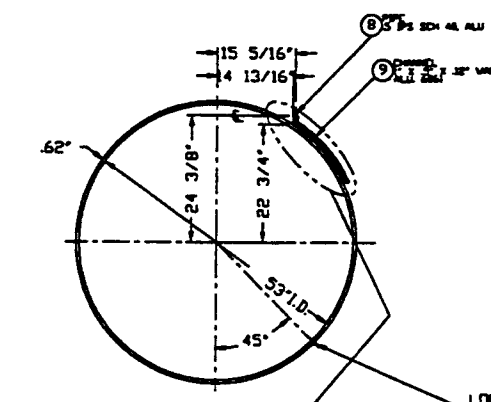
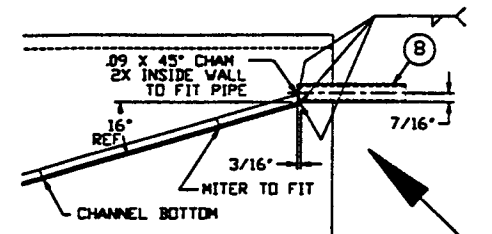


DETAIL #10
 ELEVATION VIEW
 SHOP TO VIBRO - ETCH HEAT/LOT NO'S TO
 OUTSIDE SURFACES PRIOR TO WELDING LOCATE
 MARKINGS ON THE SIDE OF THE RESERVOIR
 NEAR ITEM 8.

DETAIL #13
 ALL P.L.T. 6061.5 THK.

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80K PUMP RESERVOIR-SHORT-LEFT			
LIGD VACUUM EQUIPMENT			
<small>CAD FILE</small> 494091S2	<small>SIZE</small> D	<small>ENG. NO.</small> V049-4-091	<small>REV.</small> 0
<small>SCALE</small> NONE	<small>SHEET</small> 2 OF 3	<small>DATE</small> 11/2/97	

011160 - 0611 1E 130



DETAIL #04
FROM SHT #1
VERTICAL FOOT
6 REQUIRED

DETAIL #02
FROM SHT. #1

DETAIL #05
STAMP P/N, HEAT/LOT NO. ON ONE SIDE

DETAIL #06
STAMP P/N, HEAT/LOT NO. ON ONE SIDE

PLATE PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITH IN 1/16 OF EACH OTHER

SEE SHEET 1 FOR REVISIONS

PROCESS SYSTEMS INTERNATIONAL, INC.			
30 WALSH DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
80K PUMP RESERVOIR SHORT -LEFT-			
LIGO VACUUM EQUIPMENT			
DWG FILE 49499153	SIZE D	REV. NO. V049-4-091	REV. 0
SCALE NONE	SHEET 3	OF 3	