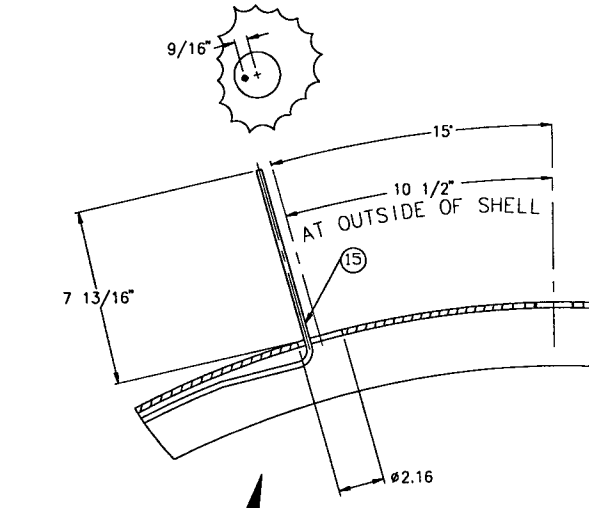
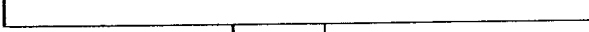
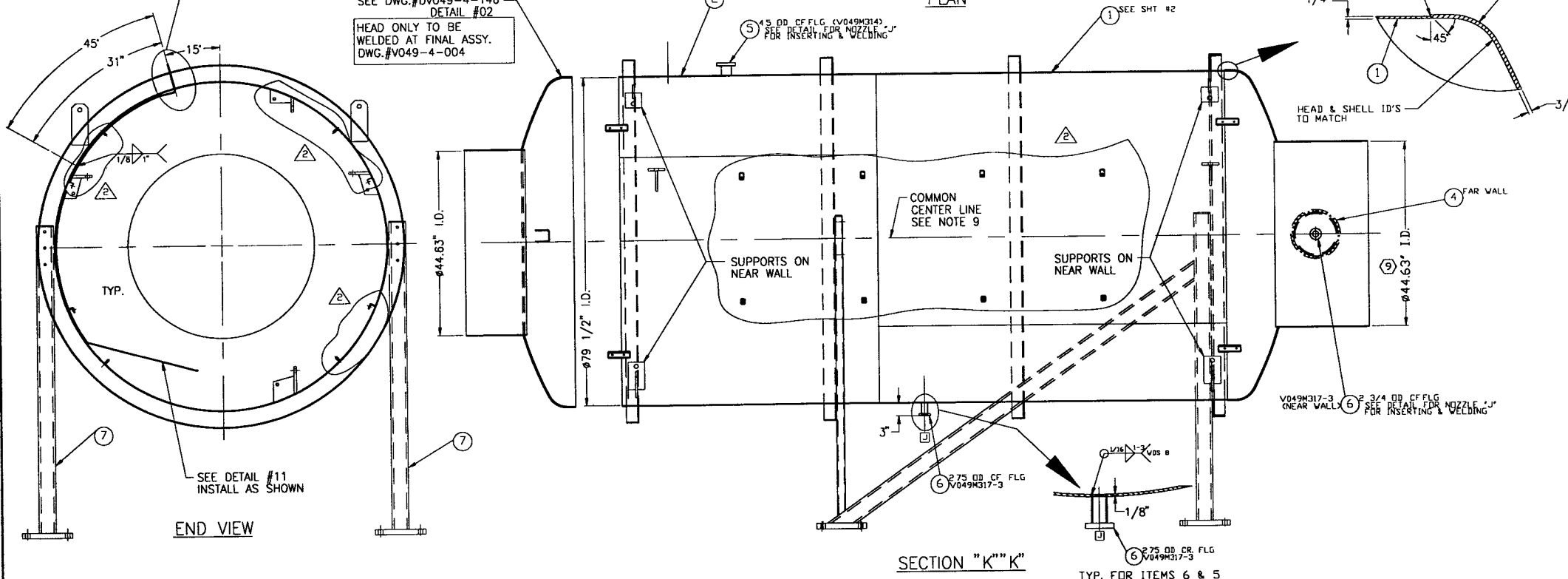
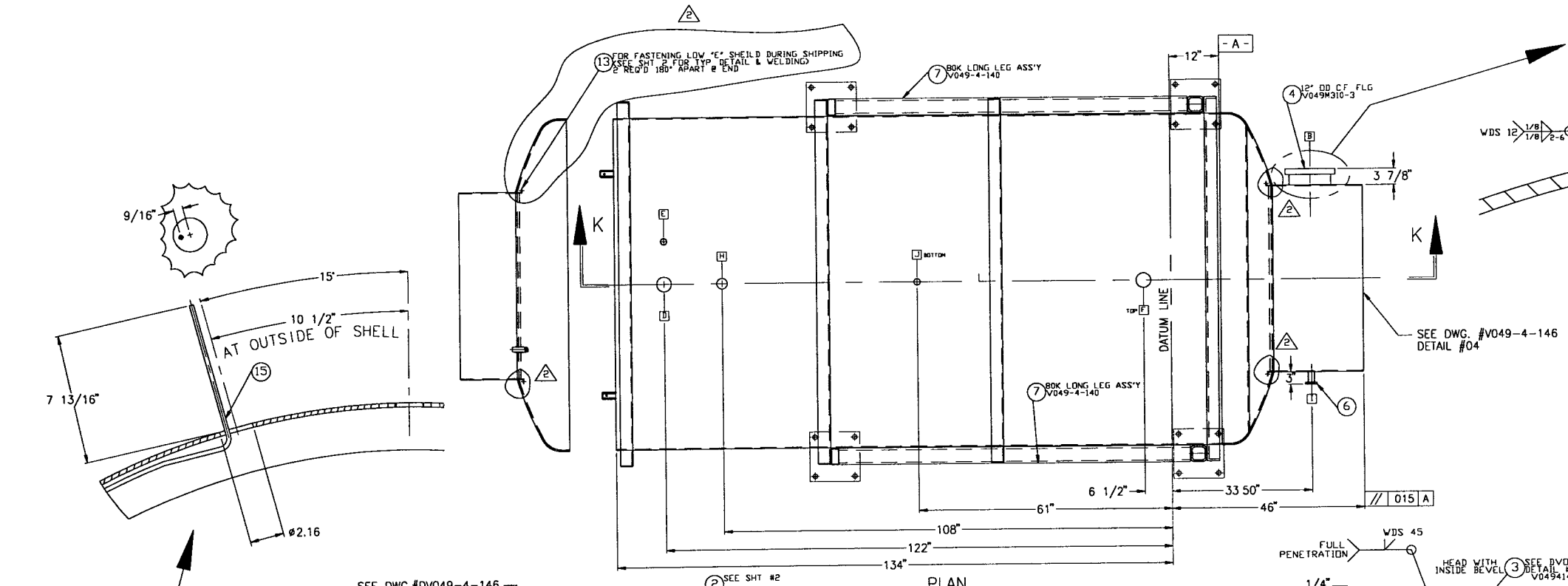
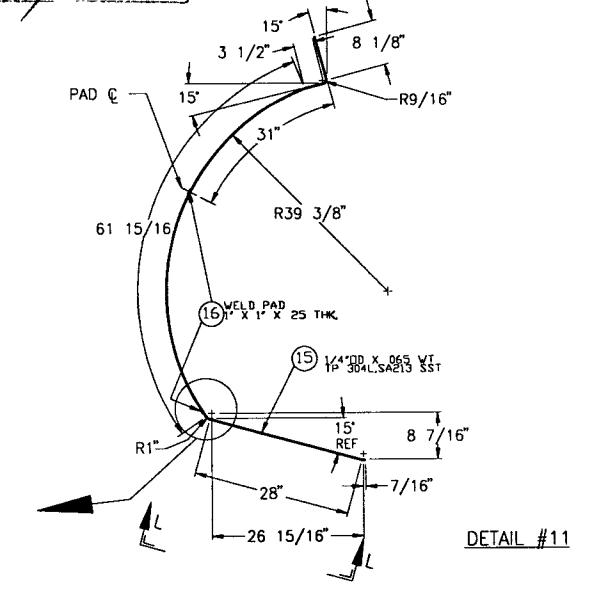
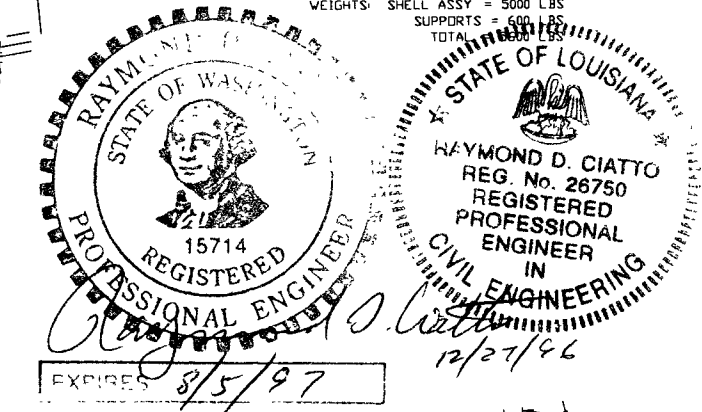


- 11 WDS NO'S REFER TO WELD DATA SPEC V049-2-084
- 10 USE LEG ASSEMBLY FOR STIFFENER ALIGNMENT SPACING
- 9 ID'S ARE TO BE ALIGNED ALONG THEIR COMMON CENTER LINE TO WITHIN ±0.6
- 8 LEAK TEST & METHOD PER PSI SPEC V049-2-014, BY PSI
- 7 CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED, AS NOTED
- 6 FLANGE BOLT HOLES TO STRADDLE NATURAL CENTERLINES OF VESSEL UNLESS NOTED CONFLAT VENT SLOTS TO BE LOCATED TOP & BOTTOM
- 5 CLEAN PER SPEC V049-2-015
- 4 NOZZLES "B" TO BE CONTOURED TO INSIDE DIAMETER OF SHELL OR TO CURVATURE OF HEAD, UNLESS OTHERWISE NOTED
- 3 DO NOT USE CARBON STEEL BRUSHES OR BRUSHES CONTAMINATED WITH CARBON STEEL ON STAINLESS OR ALUMINUM MATERIAL GRINDING TO INTERNAL VACUUM BOUNDARY SURFACES IS NOT ALLOWED
- 2 HEADS ARE ASME F&D
- 1 CHAMBER FABRICATION TO BE IN ACCORDANCE WITH SPEC V049-2-095

WEIGHTS: SHELL ASSY = 5000 LBS
SUPPORTS = 600 LBS
TOTAL = 5600 LBS

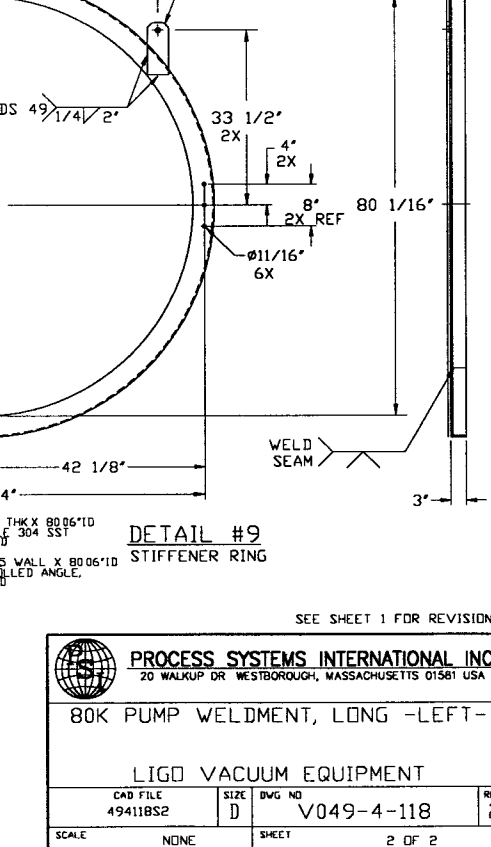
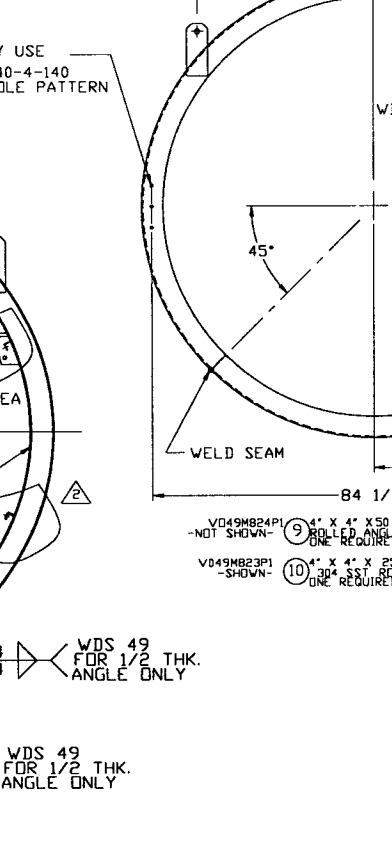
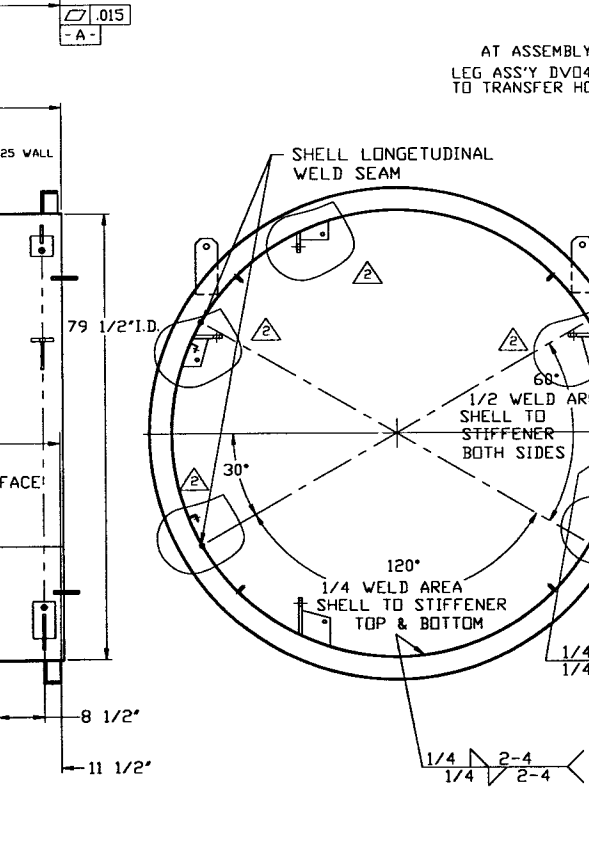
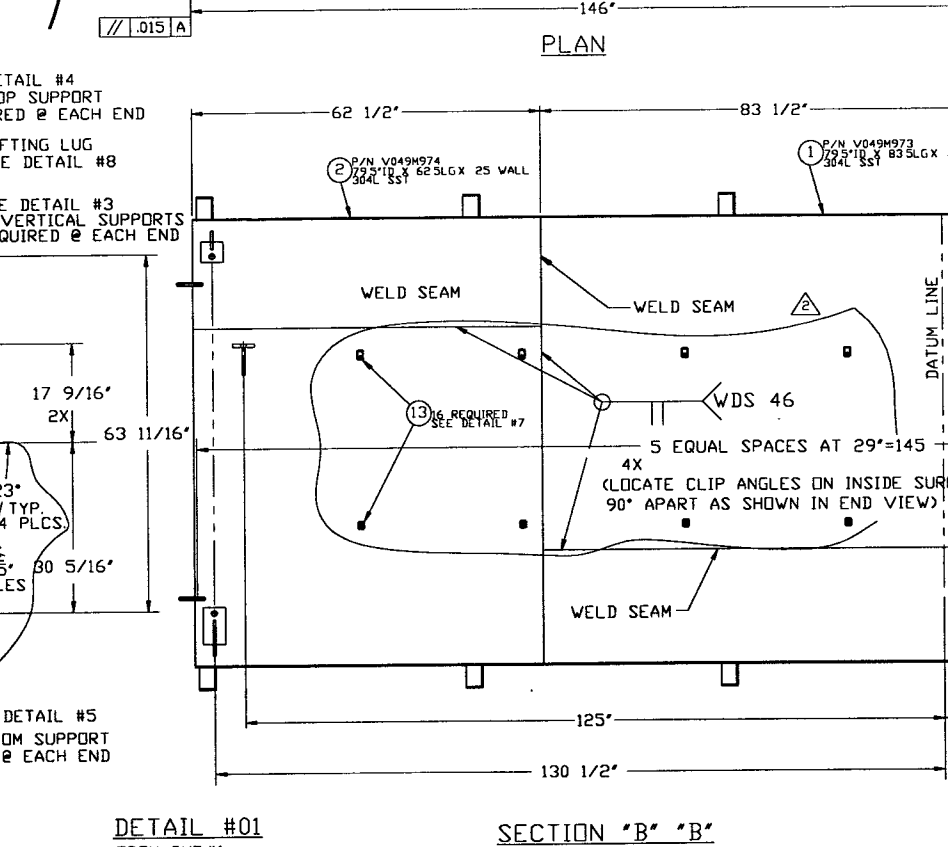
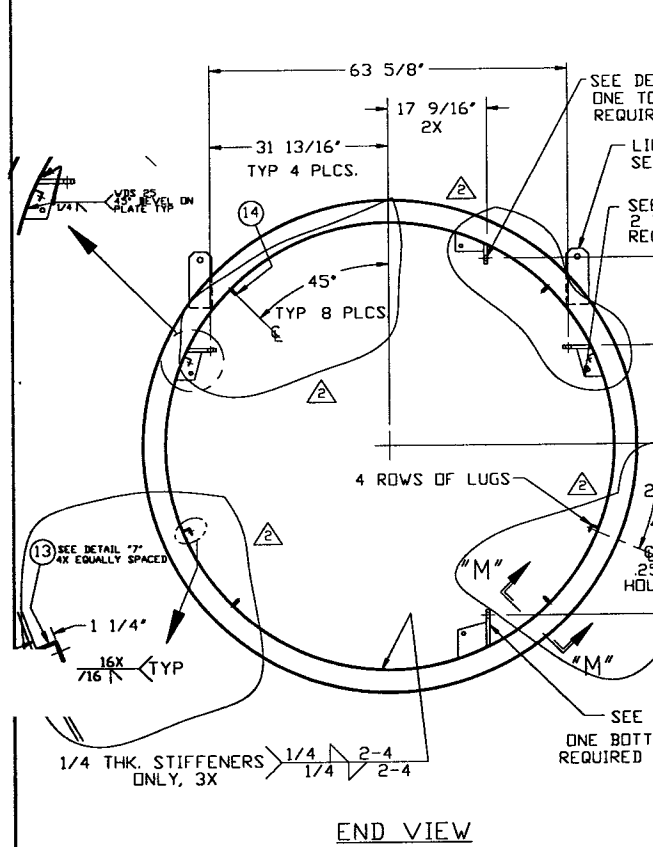
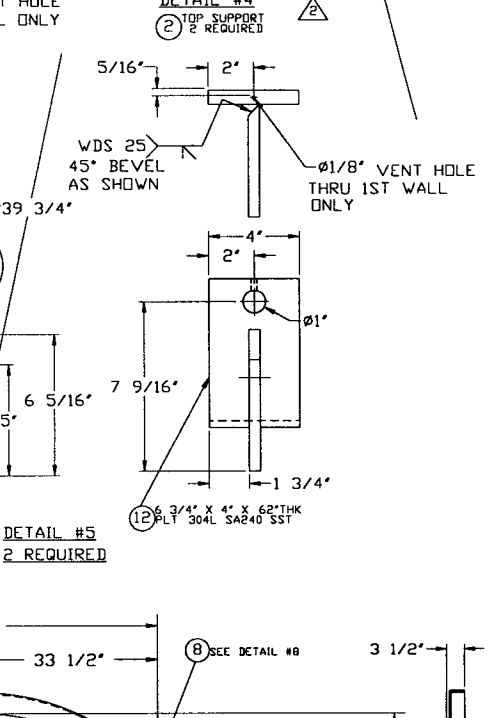
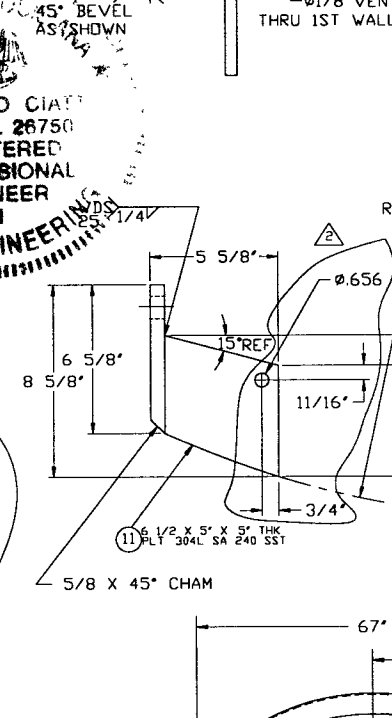
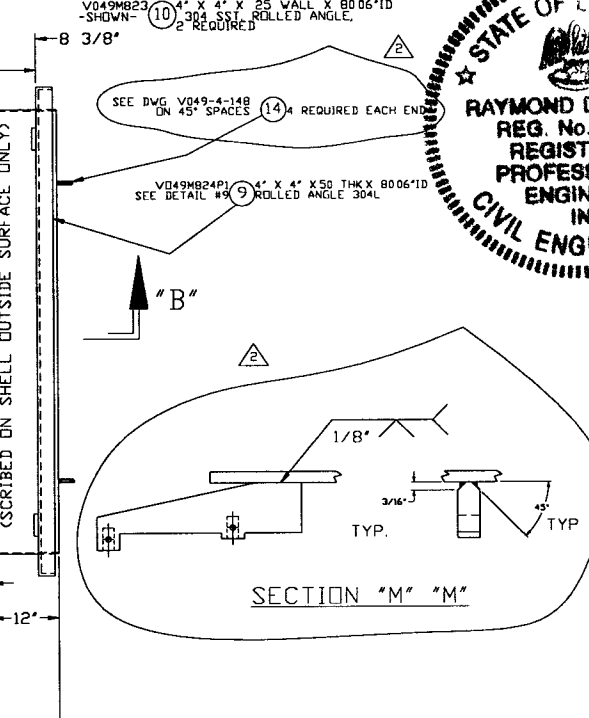
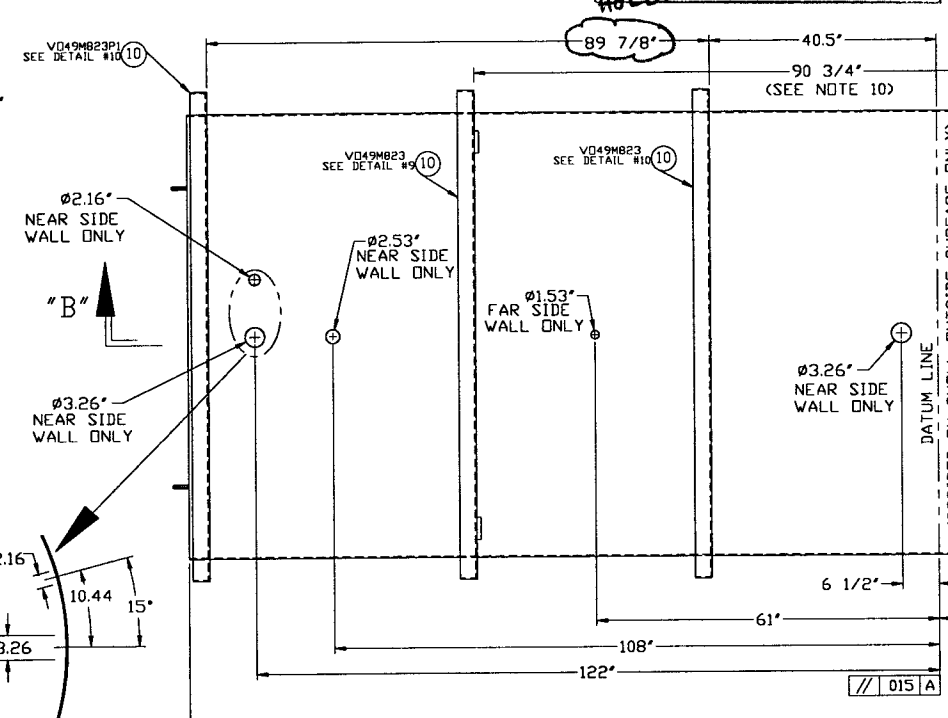
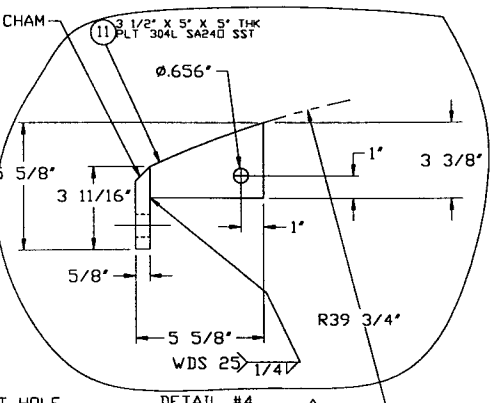
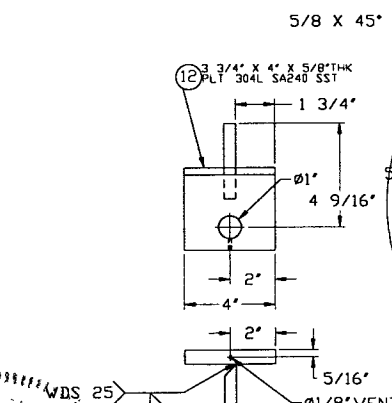
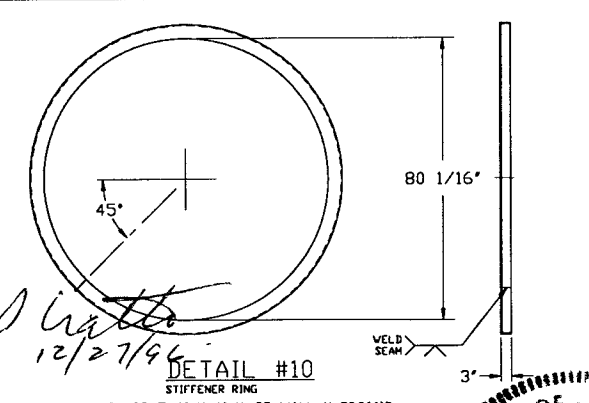
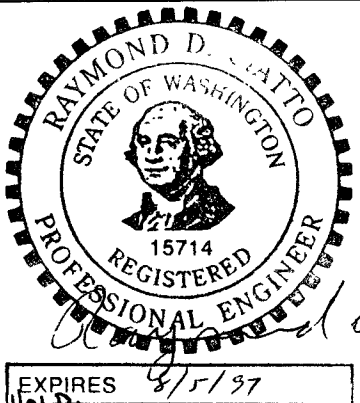
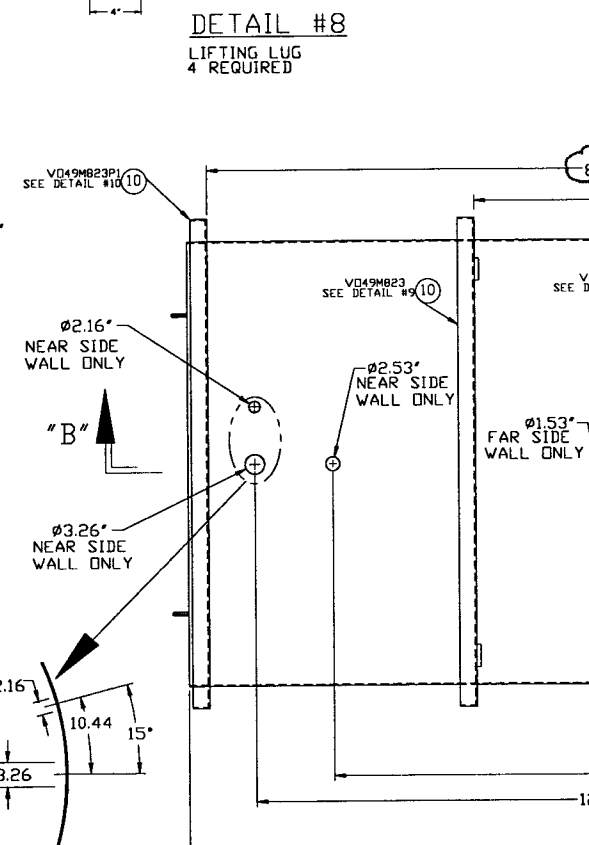
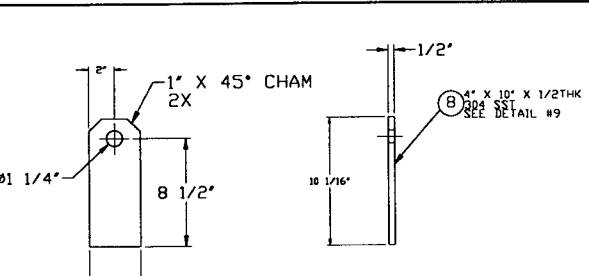
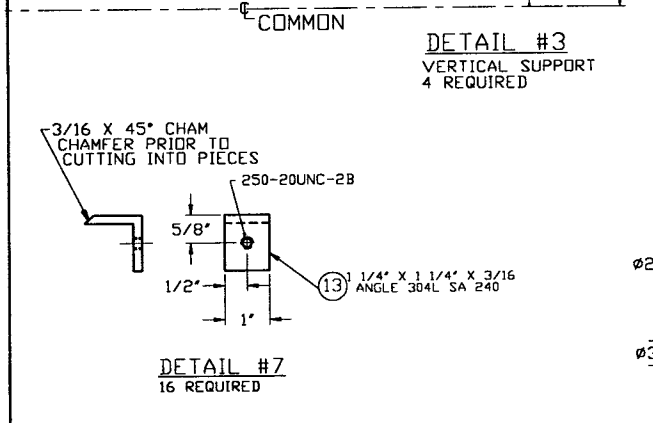
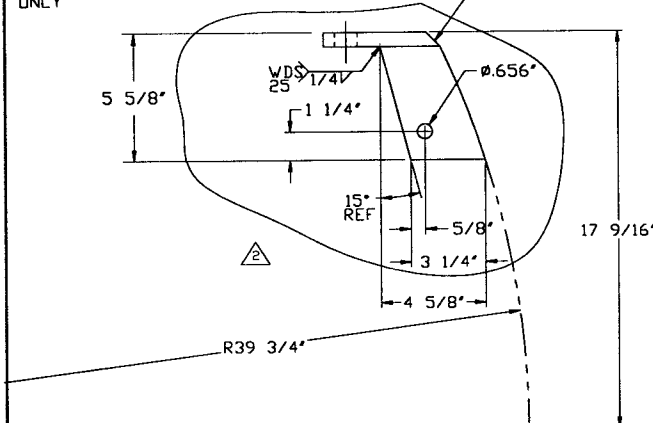
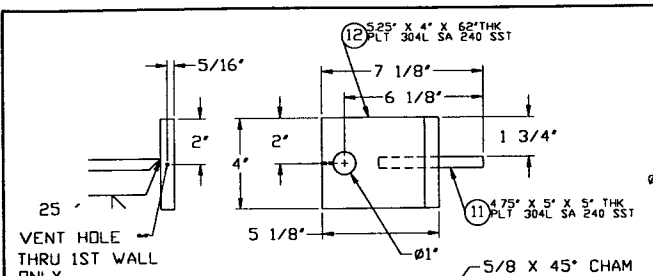


DWG NO	DESCRIPTION	DWG NO	DESCRIPTION
7		6	
8		5	
9		4	
10		3	
11		2	
12		1	

SYMBOL	CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	REV	DESCRIPTION	CHKD	DRWN	DATE	DESN
□	FLATNESS	TOLERANCES: FRACTIONAL: ± 1 ANGULAR/ARCH: ± 30°-30" BEND ± 2° TWO PLACE DECIMAL: ± 0.03 THREE PLACE DECIMAL: ± 0.015 FINISHED SURFACE RMS 6.3 BREAK CORNERS IN DWG REMOVE ALL BURRS	2	REISSUED FOR FABRICATION	GS	PEF	DMW	RDC
○	CYLINDRICITY		1	REISSUED FOR FABRICATION	REB	GS	PEF	DMW
	PARALLELISM		0	ISSUED FOR FABRICATION	REB	GS	PEF	DMW
⊥	PERPENDICULARITY							
∠	ANGULARITY							
⊕	TRUE POSITION							
⊙	CONCENTRICITY							

0970420-02-V	
PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA	
80K PUMP WELDMENT, LONG -LEFT-	
LIGD VACUUM EQUIPMENT	
CAD FILE 494118S1	SIZE D
DWG NO V049-4-118	REV 2
SCALE NONE	SHEET 1 OF 2

DEC 27, 1996 - 08:13:33



PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA			
80K PUMP WELDMENT, LONG -LEFT-			
LIGO VACUUM EQUIPMENT			
CAD FILE 49411BS2	SIZE D	DWG NO V049-4-118	REV 2
SCALE NONE	SHEET 2 OF 2		