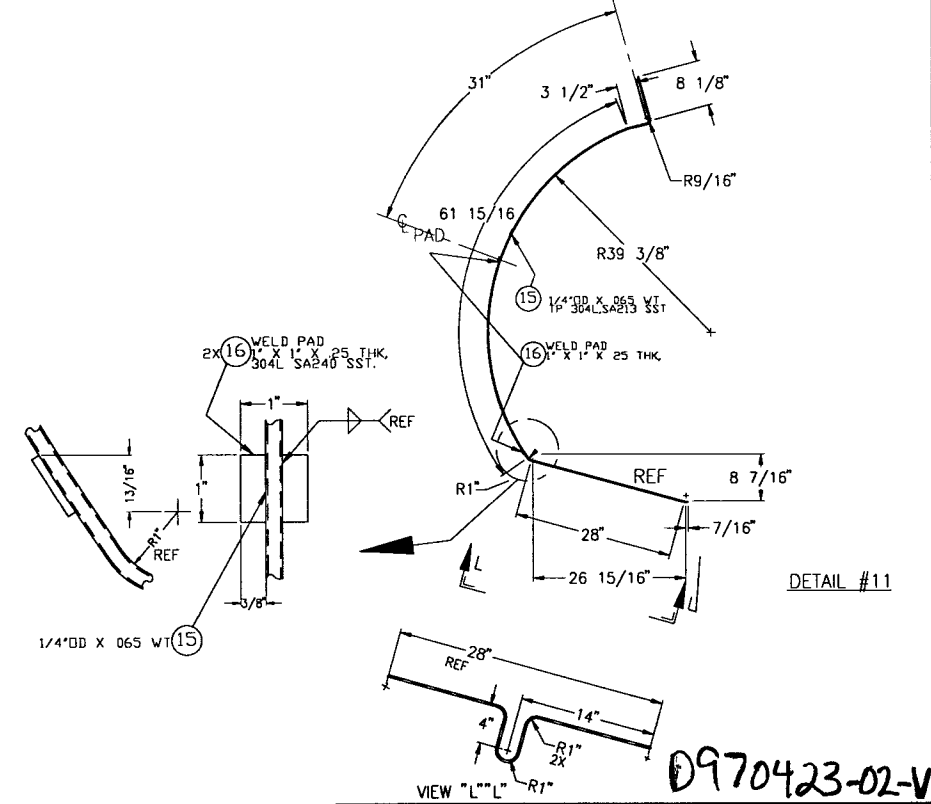
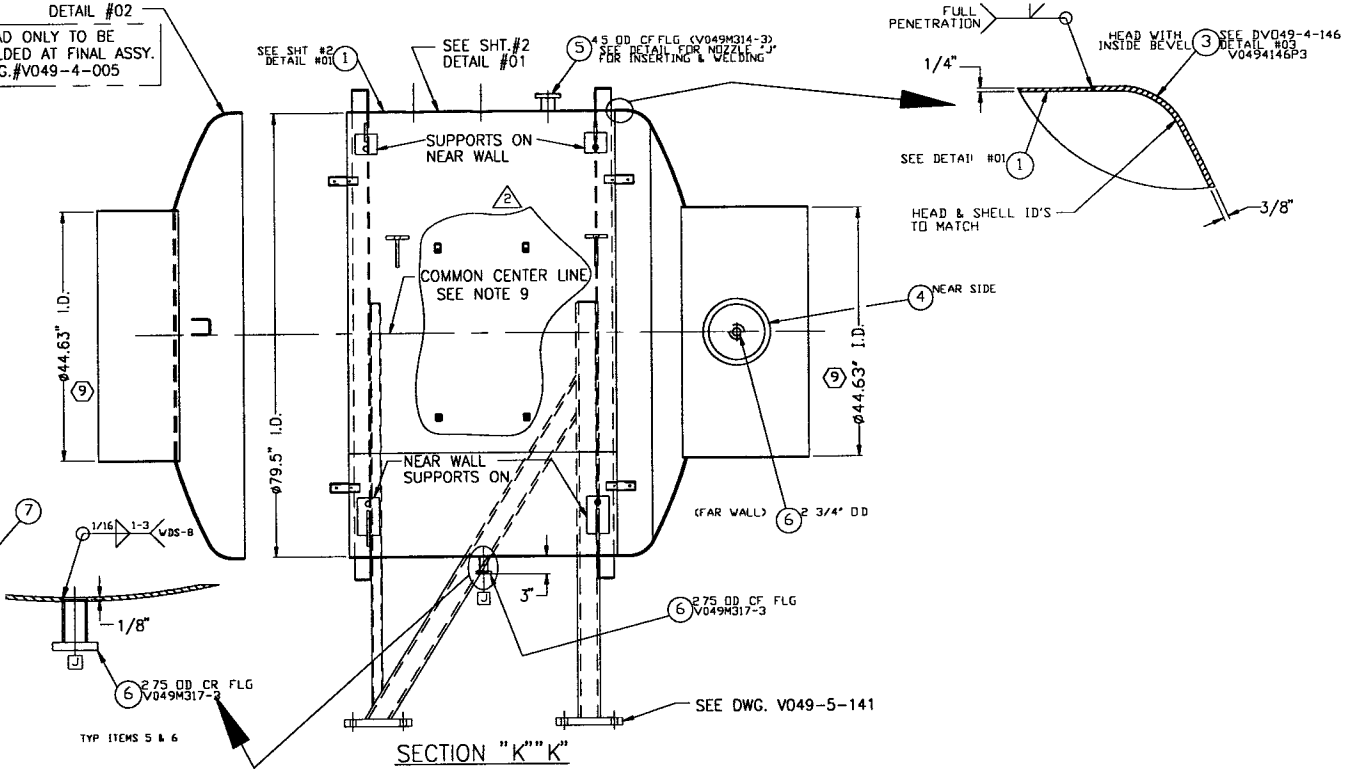
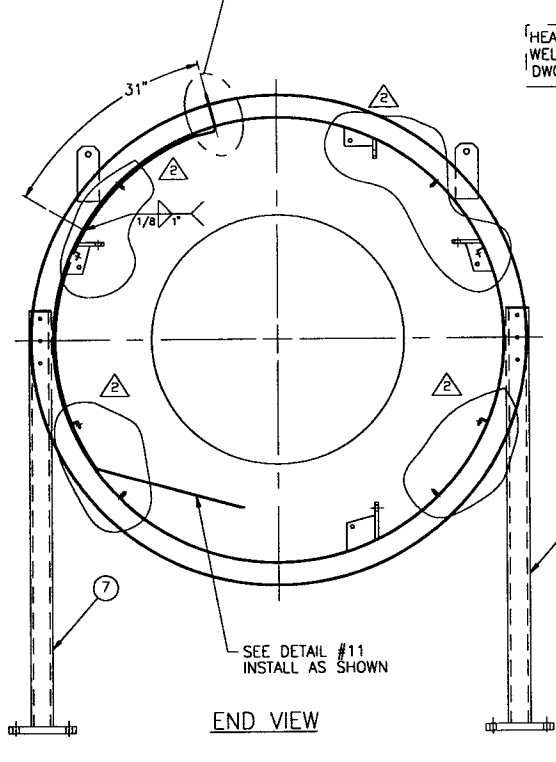
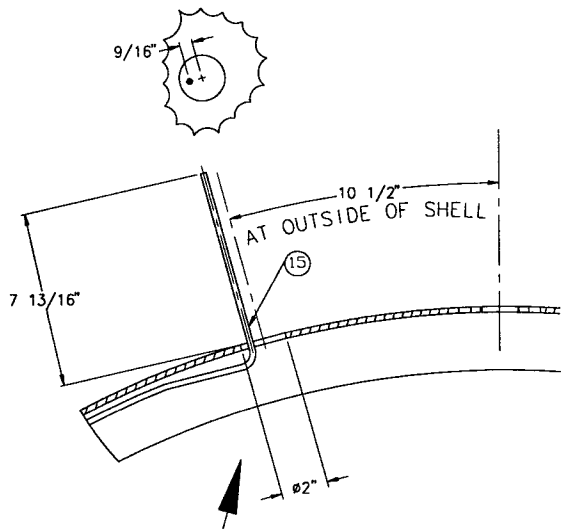
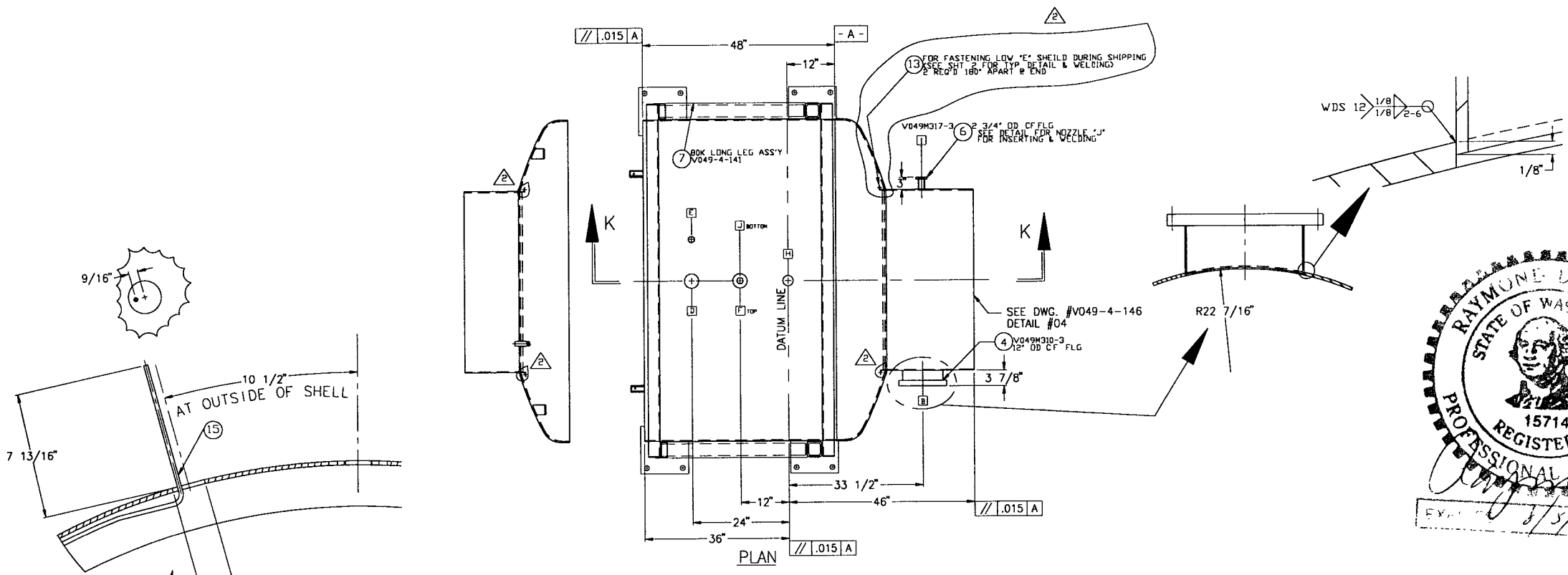
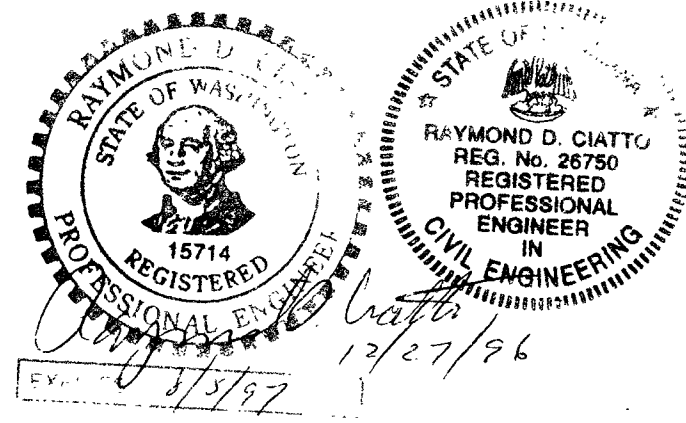


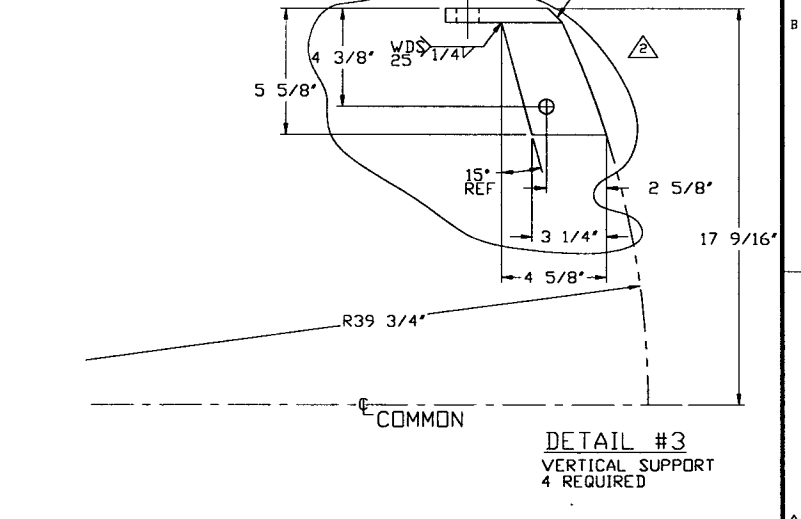
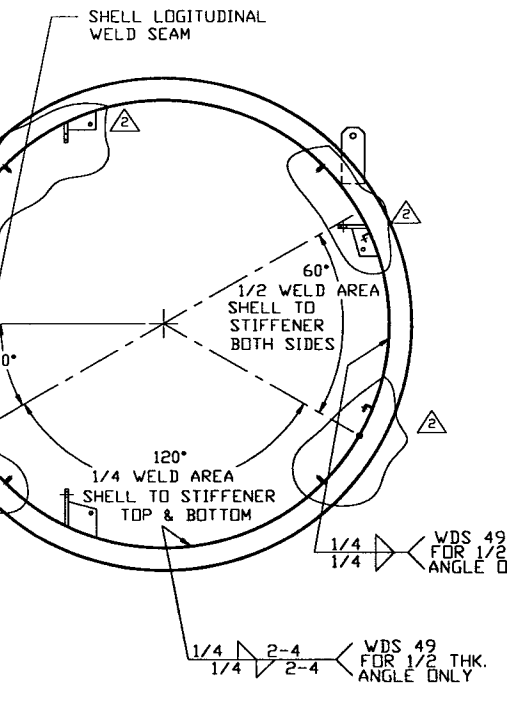
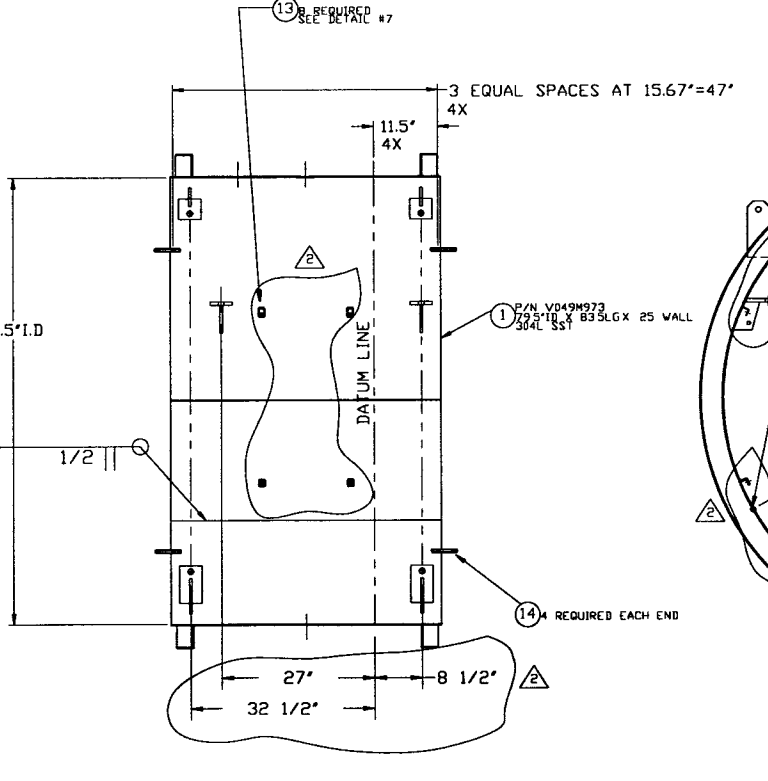
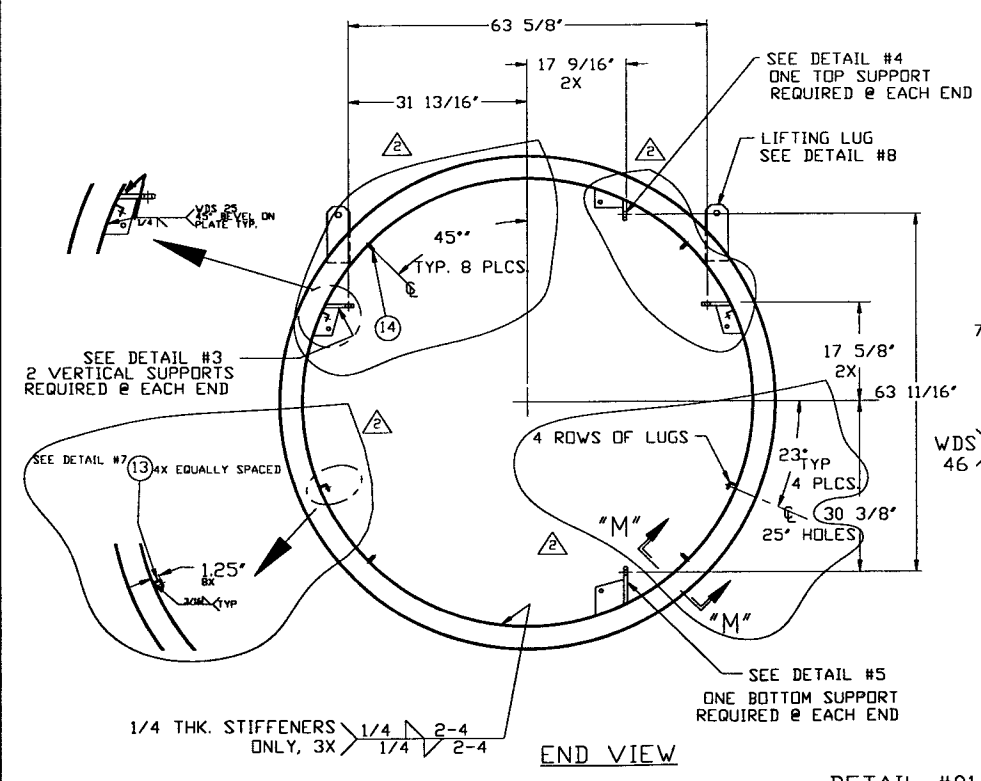
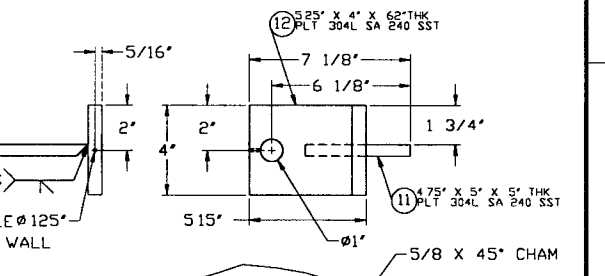
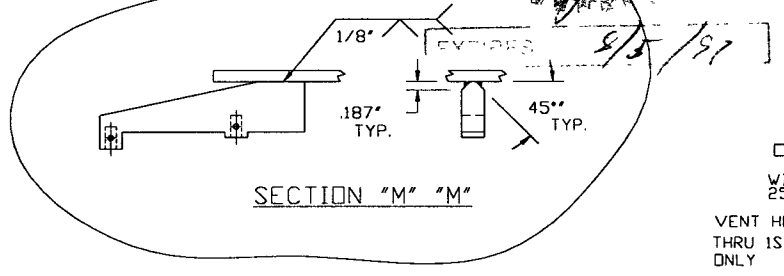
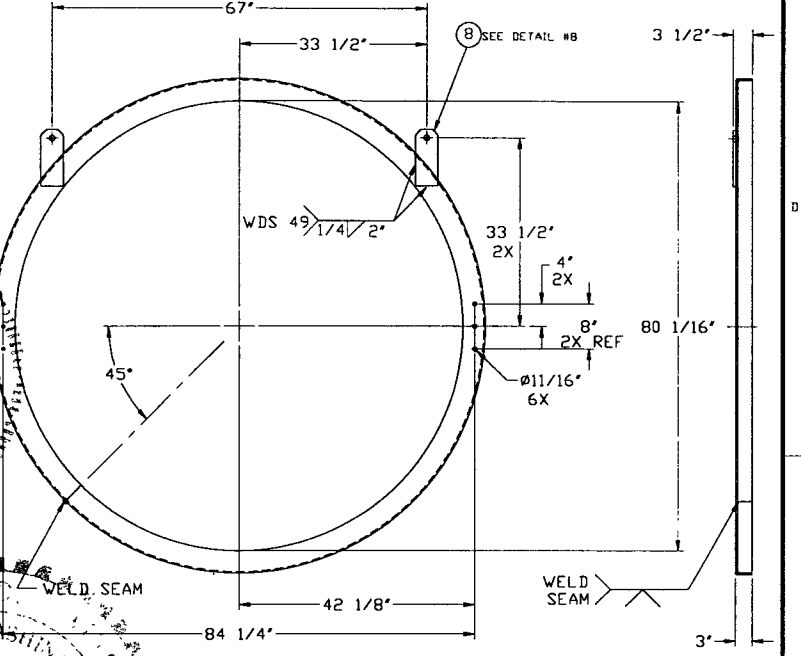
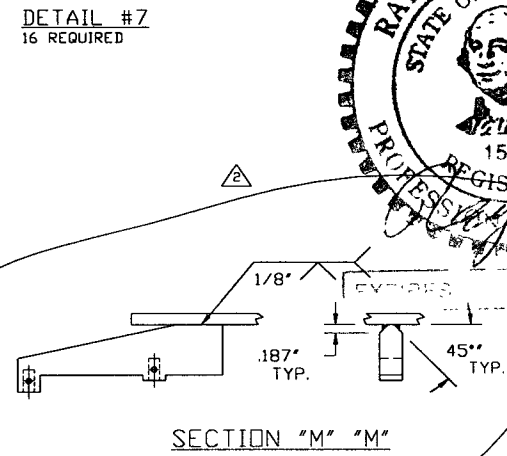
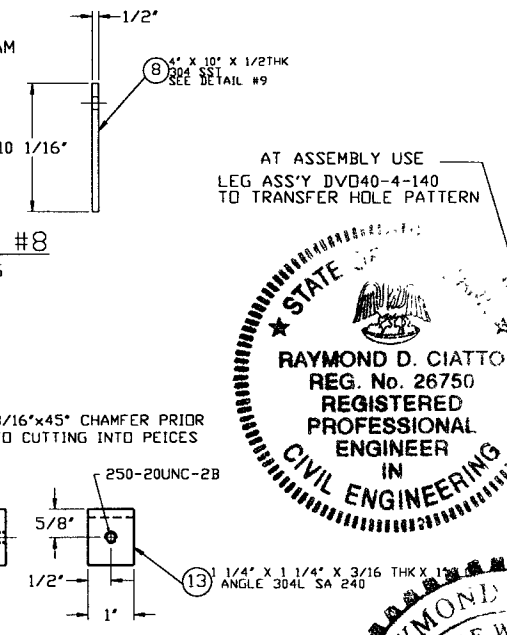
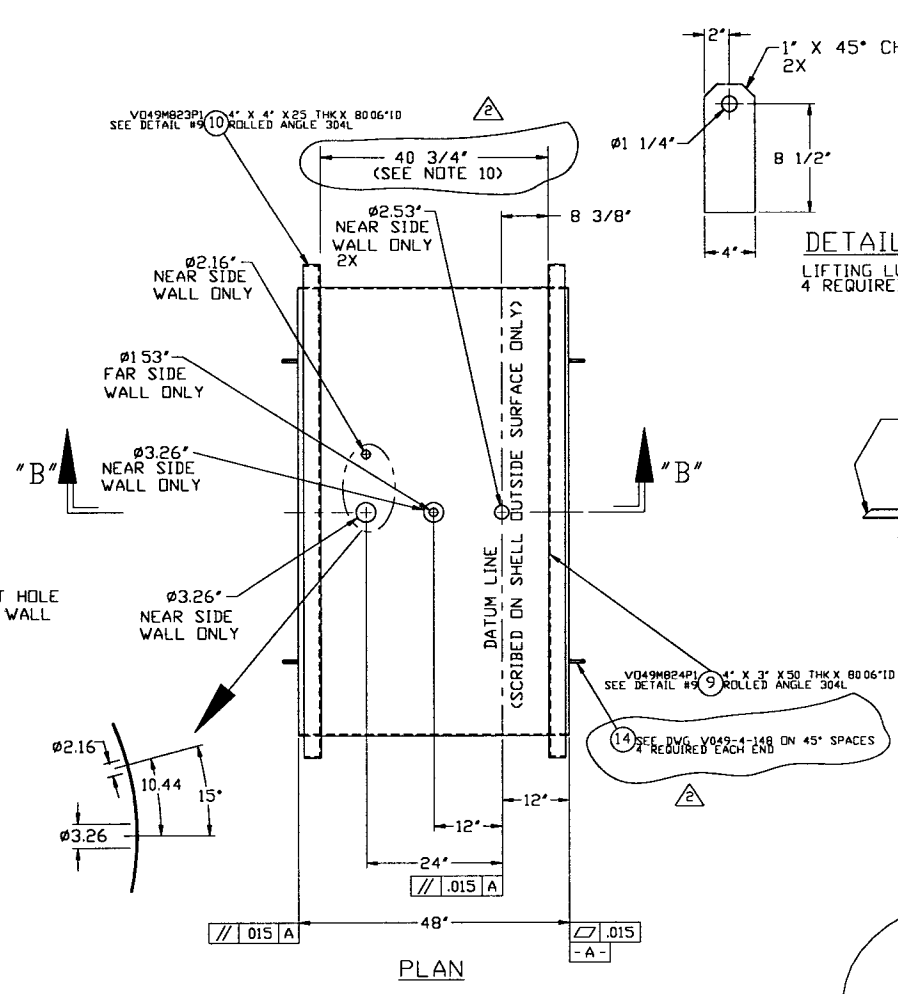
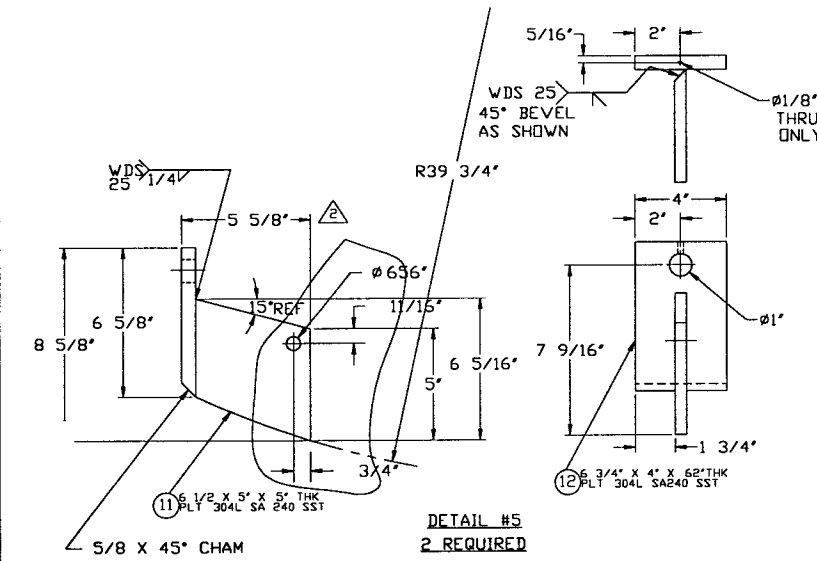
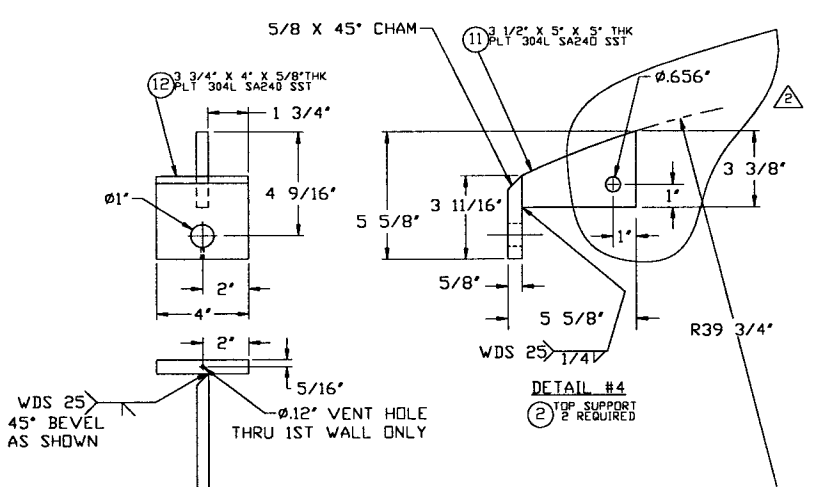
- 11 WDS NO'S REFER TO WELD DATA SPEC V049-2-084
- 10 USE LEG ASSEMBLY FOR STIFFENER ALIGNMENT SPACING
- 9 ID'S ARE TO BE ALIGNED ALONG THEIR COMMON CENTER LINE TO WITHIN ±0.6
- 8 LEAK TEST & METHOD PER PSI SPEC V049-2-014, BY PSI
- 7 CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED, AS NOTED
- 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 V049-2-096

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



SYMBOL			CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES									PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR WESTBOROUGH, MASSACHUSETTS 01581 USA						
□			FLATNESS	TOLERANCES:									80K PUMP WELDMENT-SHORT-RIGHT						
○			CYLINDRICITY	FRACTIONAL ± 1									LIGO VACUUM EQUIPMENT						
∥			PARALLELISM	ANGULAR ± 30° BEND ± 2°									CAD FILE 494121S1						
⊥			PERPENDICULARITY	TWO PLACE DECIMAL ± .03									SIZE D						
∠			ANGULARITY	THREE PLACE DECIMAL ± .015									DWG NO V049-4-121						
⊕			TRUE POSITION	FINISHED SURFACE RMS 6.3									REV 2						
⊙			CONCENTRICITY	BREAK CORNERS IN OUT REMOVE ALL BURRS									SCALE NONE						
DO NOT SCALE THIS DRAWING					USED ON: DWG. V049-4-005					ISSUE DESCRIPTION					SHEET 1 OF 2				
NEXT ASSY: DWG. V049-4-005					REV DESCRIPTION					CHKD DRWN DATE DEC									
					2 REISSUED FOR FABRICATION					GS PEF DMW RDC REC PV 12/9/96 0379									
					1 REISSUED FOR FABRICATION					REB GS PEF DMW RDC REC PV 11/15/96 0352									
					0 ISSUED FOR FABRICATION					REB GS PEF DMW RDC REC JT 11/4/96 0329									

0970423-02-V



AT ASSEMBLY USE  
LEG ASS'Y DVD40-4-140  
TO TRANSFER HOLE PATTERN

STATE OF WASHINGTON  
RAYMOND D. CIATTO  
REG. No. 26750  
REGISTERED  
PROFESSIONAL  
CIVIL ENGINEER  
15714

RAYMOND D. CIATTO 12/27/96

DETAIL #01  
FROM SHT.#1

SECTION "B" "B"

<b>PROCESS SYSTEMS INTERNATIONAL INC.</b> 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
80K PUMP WELDMENT, SHORT-RIGHT-			
LIGD VACUUM EQUIPMENT			
CAD FILE 494121S2	SIZE D	DWG NO V049-4-121	REV 2
SCALE NONE	SHEET 2 OF 2		