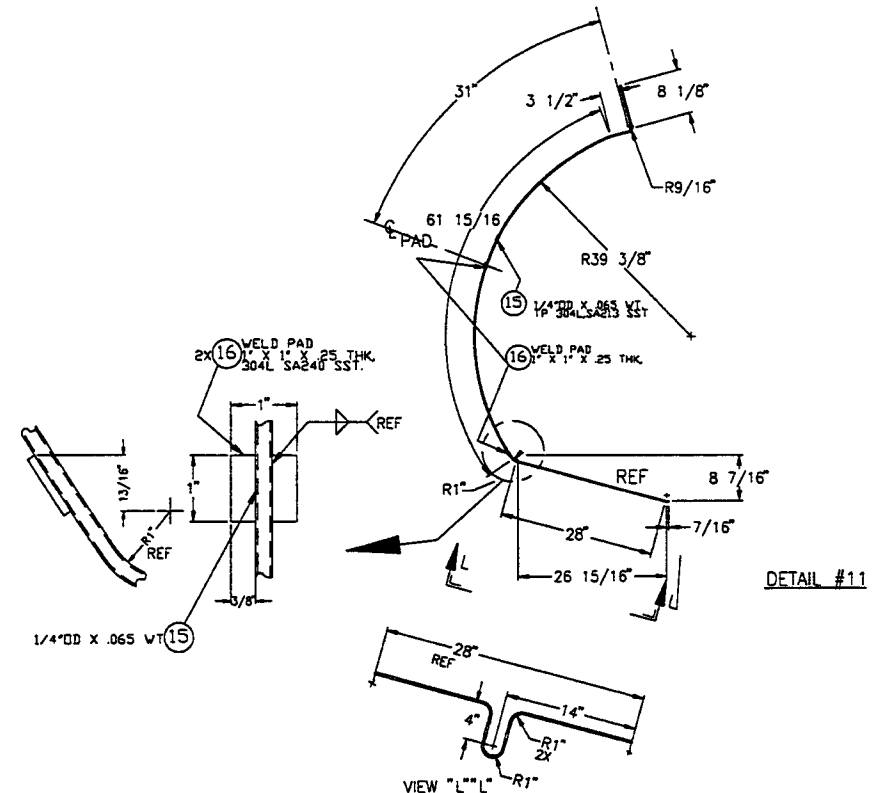
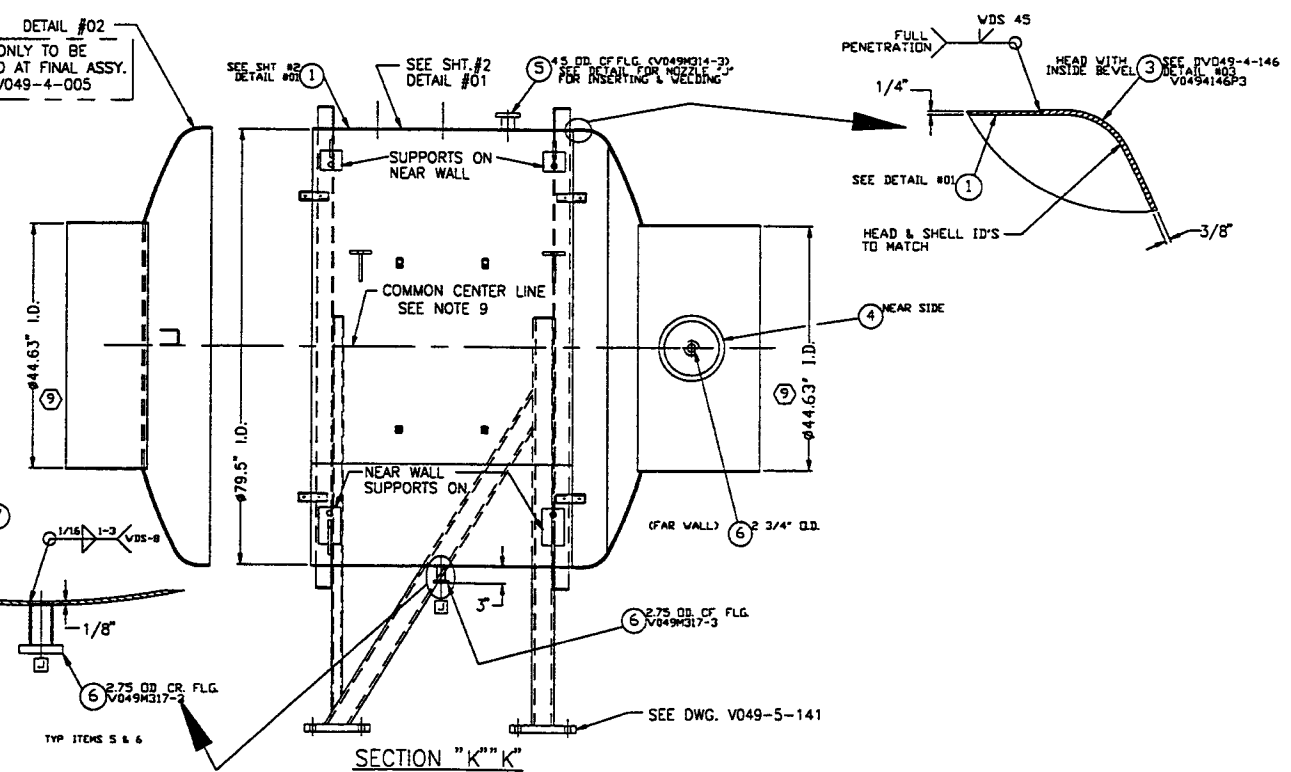
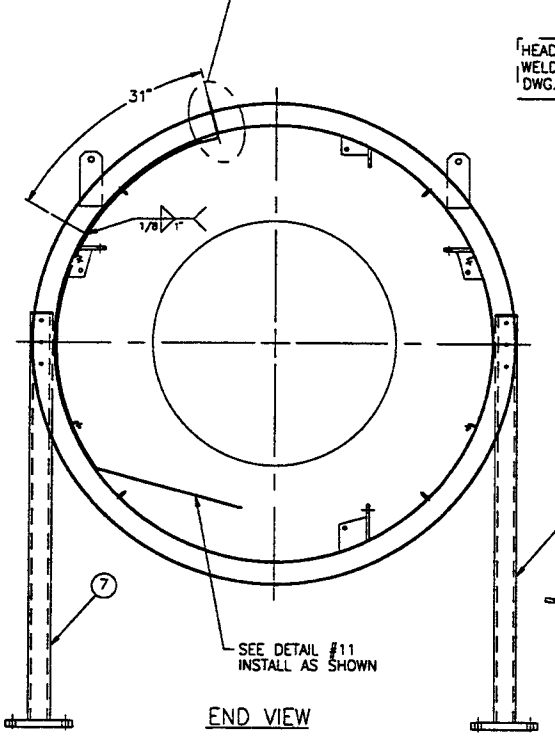
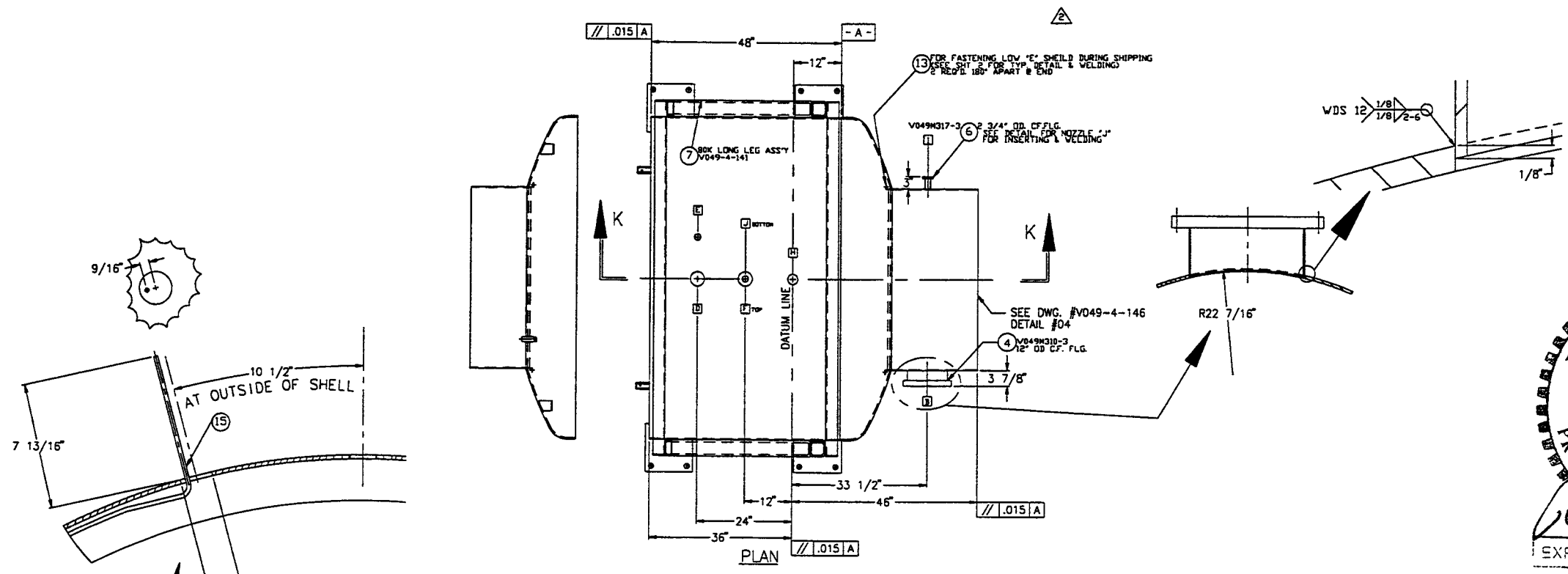
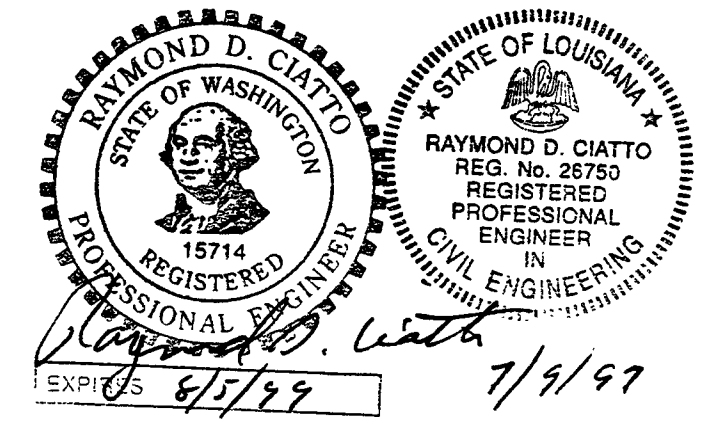


11. WDS NO'S. REFER TO WELD DATA SPEC. V049-2-084.
10. USE LEG ASSEMBLY FOR STIFFENER ALIGNMENT SPACING
9. I.D.'S ARE TO BE ALIGNED ALONG THEIR COMMON CENTER LINE TO WITHIN ±.06
8. LEAK TEST & METHOD PER PSI SPEC. V049-2-014, BY PSI.
7. CERTIFIED MANUFACTURER'S MATERIAL TEST REPORTS REQUIRED, AS NOTED.
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 1/8" 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.



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SYMBOL	CHARACTERISTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
□	FLATNESS	FRACTIONAL ± .1
○	CYLINDRICITY	ANGULAR BOUND 10°-30° BEND 1/2°
∥	PARALLELISM	TWO PLACE DECIMAL ± .01
⊥	PERPENDICULARITY	THREE PLACE DECIMAL ± .015
∠	ANGULARITY	FINISHED SURFACE, RMS 63
⊕	TRUE POSITION	BREAK CORNERS IN
⊙	CONCENTRICITY	REMOVE ALL BURRS

REV	DESCRIPTION	ISSUE DESCRIPTION
3	REISSUED FOR FABRICATION AS NOTED	GS PEF DMW RDC REC PV 1/3/97 0399
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

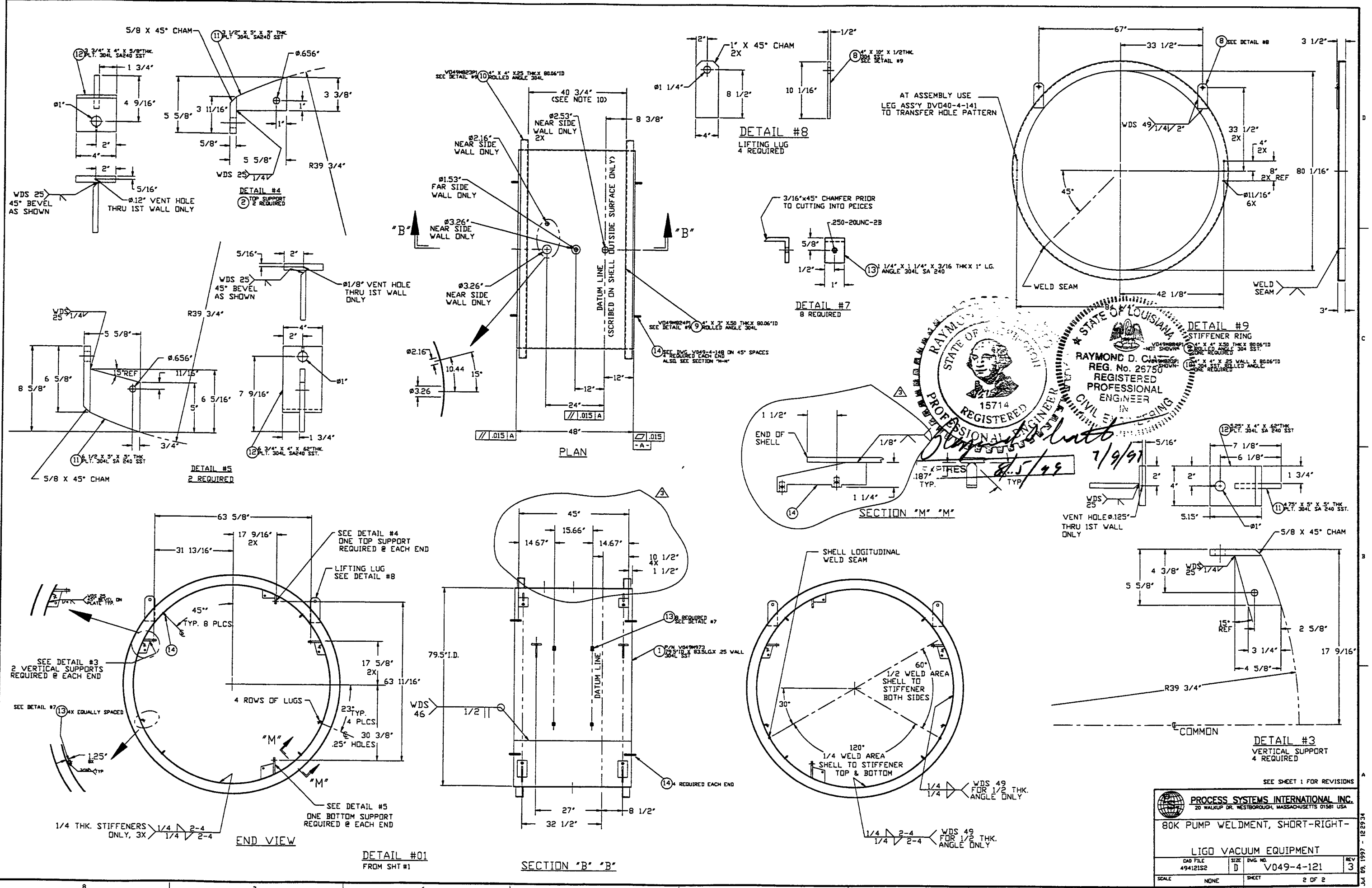
**PROCESS SYSTEMS INTERNATIONAL, INC.**  
20 WALKUP DR., WESTBOROUGH, MASSACHUSETTS 01581 USA

80K PUMP WELDMENT-SHORT-RIGHT

LIGO VACUUM EQUIPMENT

CAD FILE: 494121S1 SIZE: D DWG. NO: V049-4-121 REV: 3

SCALE: NONE SHEET: 1 OF 2



PROCESS SYSTEMS INTERNATIONAL INC. 20 WALKUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
80K PUMP WELDMENT, SHORT-RIGHT-			
LIGD VACUUM EQUIPMENT			
CAD FILE 49412152	SIZE D	DWG. NO. V049-4-121	REV. 3
SCALE NONE	SHEET 2	OF 2	