

STATE OF LOUISIANA
 RAYMOND D. CIATTO
 REG. No. 29750
 REGISTERED PROFESSIONAL ENGINEER
 IN CIVIL ENGINEERING

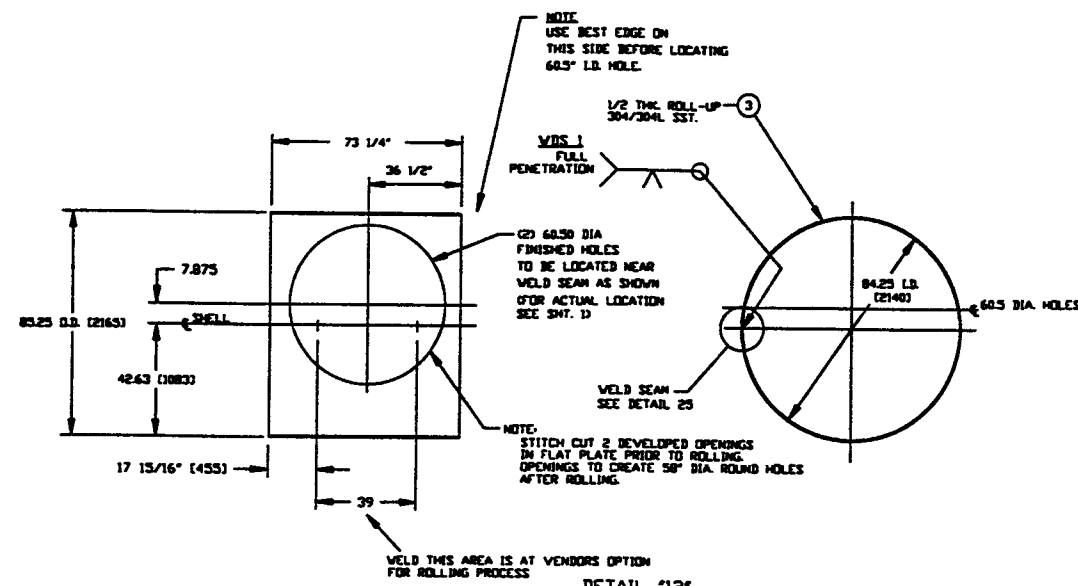
STATE OF WASHINGTON
 RAYMOND D. CIATTO
 16714
 REGISTERED PROFESSIONAL ENGINEER

8/2/97

DWG. NO.	DESCRIPTION	DATE	BY	CHECKED
V049-4-002	HAM ASSY.			

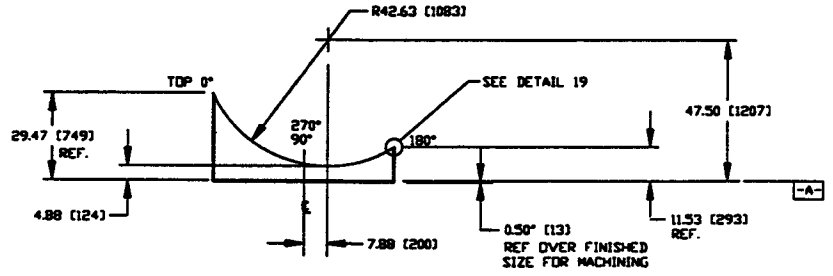
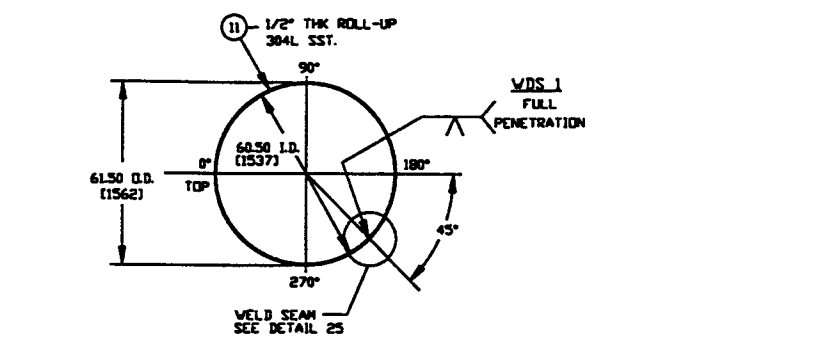
REV	DESCRIPTION	DATE	BY	CHECKED
3	REISSUED FOR FABRICATION AS NOTED			
2	REISSUED FOR FABRICATION			
1	ISSUED FOR FABRICATION			

PROCESS SYSTEMS INTERNATIONAL, INC. 20 BALDWIN DR. WESTBOROUGH, MASSACHUSETTS 01581 USA	
HAM SHELL WELDMENT LIGO VACUUM EQUIPMENT	
DWG. NO. V049-4-128	REV. 3
DATE 7/26/96	BY DA
DATE 10/21/96	BY PV
DATE 9/27/96	BY PV
DATE 10/7/96	BY PV
DATE 10/21/96	BY PV

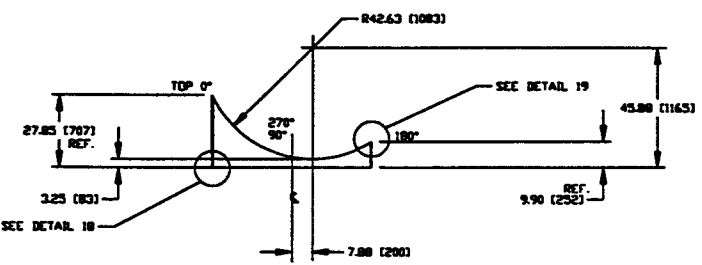
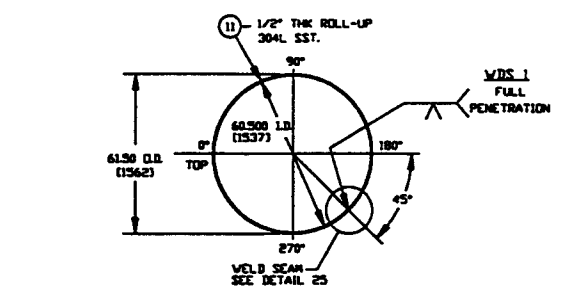
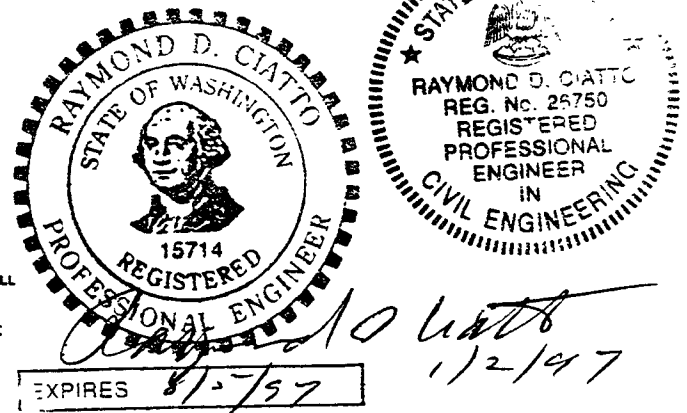
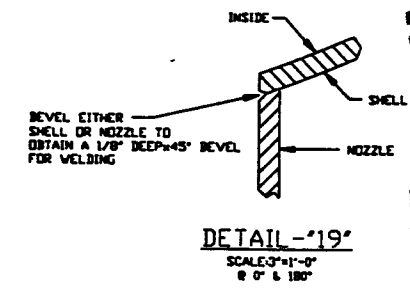
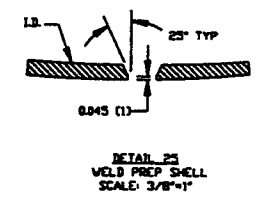
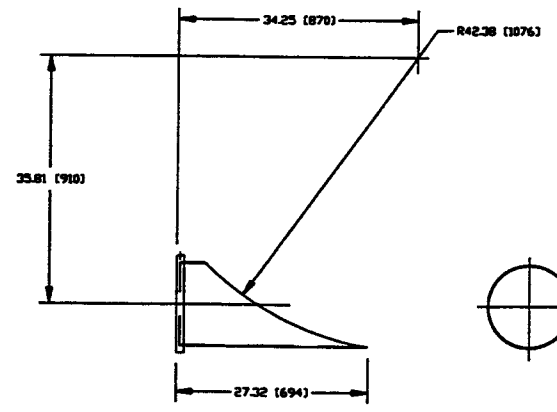
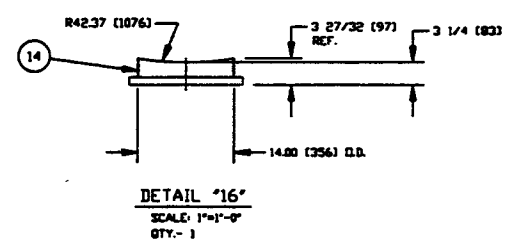
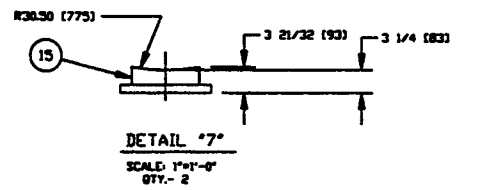


DETAIL "12"
 SHELL ROLL-UP
 SCALE: 3/8"=1'-0"
 QTY. - 1
 SHELL P/N V0494128P3-14

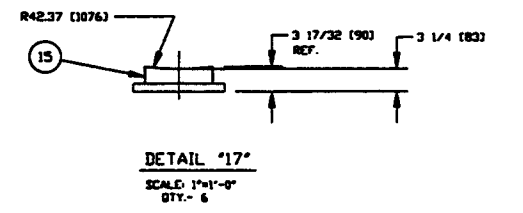
NOTE: PLATE PRIOR TO ROLLING MUST HAVE DIAGONAL CORNER TO CORNER DIMENSIONS WITHIN 1/16" OF EACH OTHER.



DETAIL "14"
 SCALE: 3/8"=1'-0"
 MAKE FROM P/N V0494128P1-14
 QTY. - 1

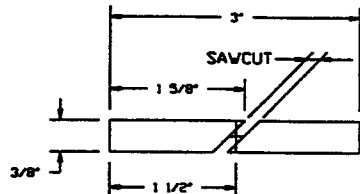
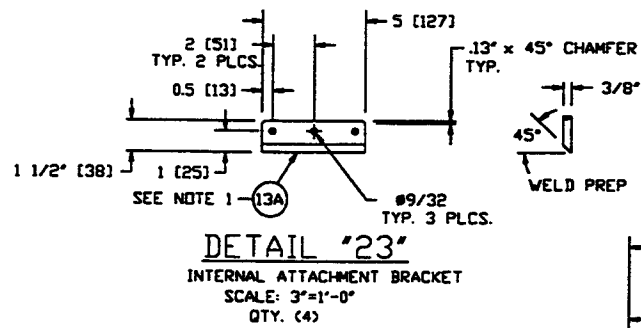
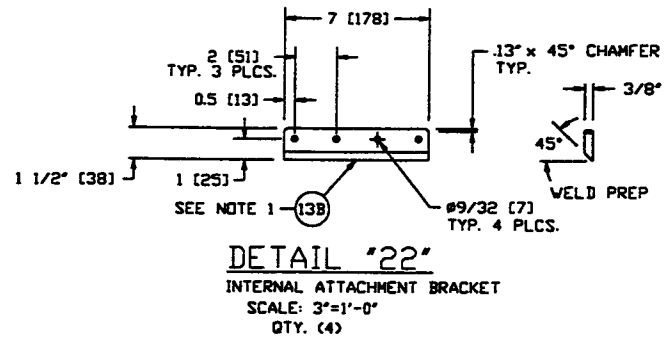
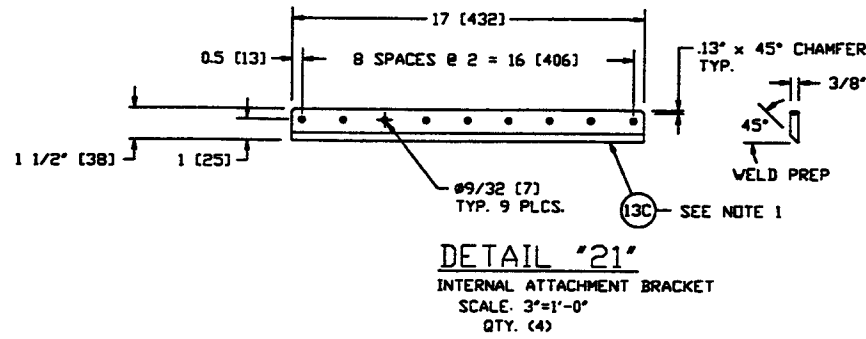
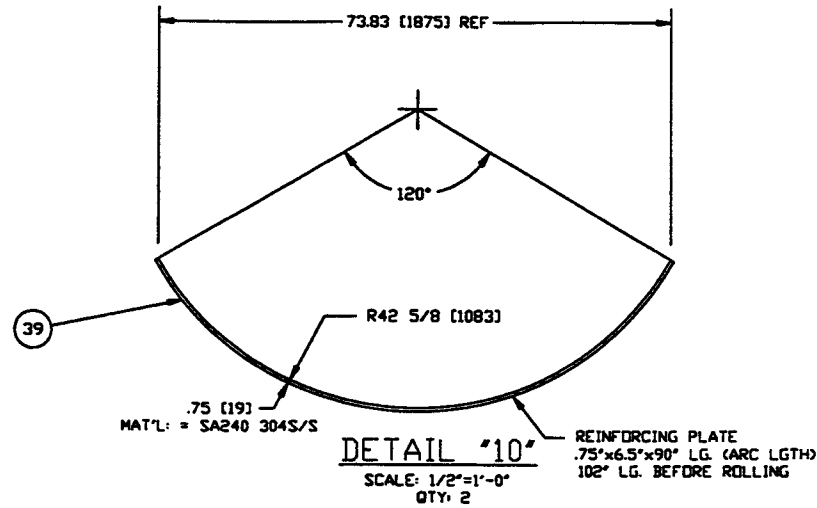
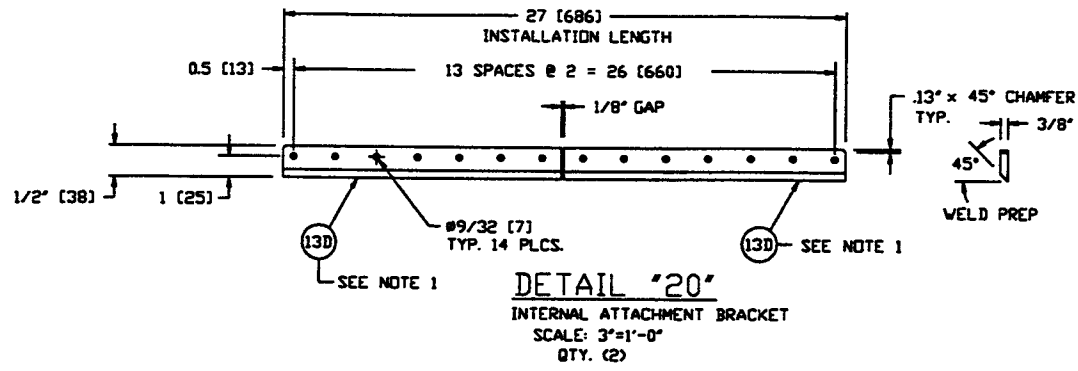


DETAIL "15"
 SCALE: 3/8"=1'-0"
 MAKE FROM P/N V0494128P1-14
 QTY. - 1

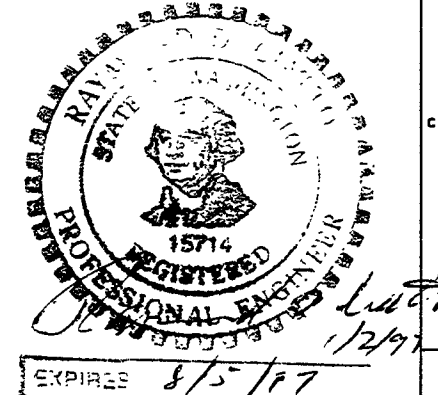
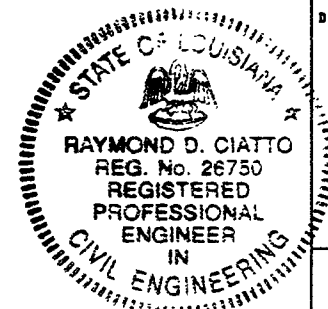
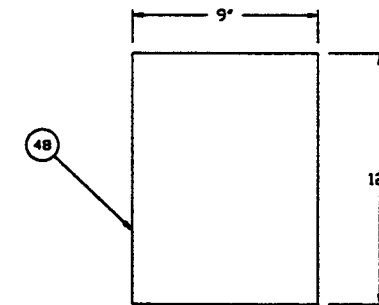
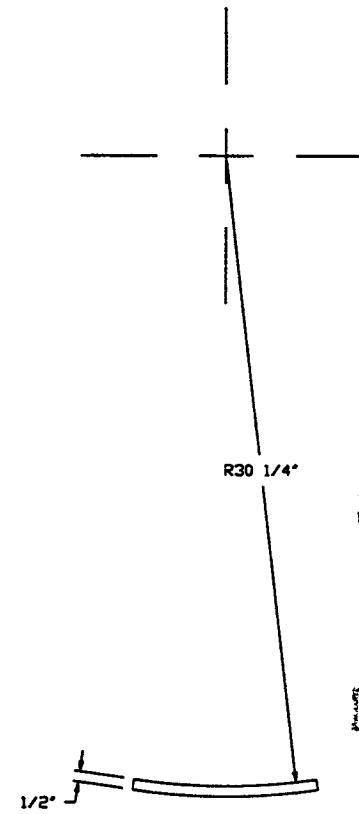
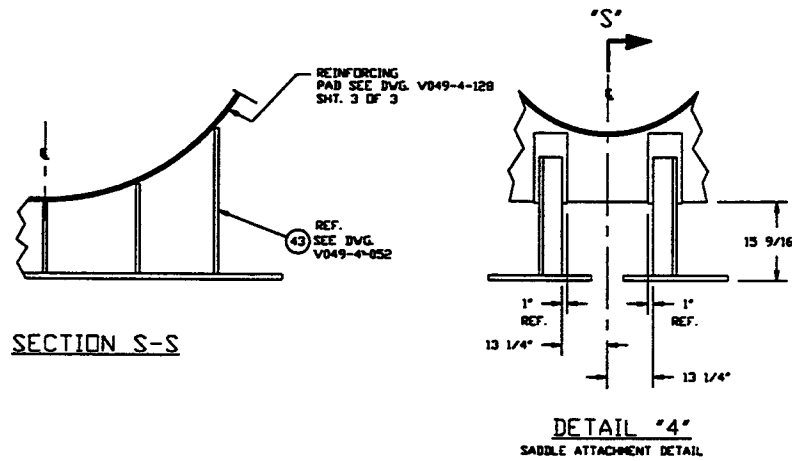


NOTE: THE BEVEL ANGLE ON THE VESSEL END OF THE 60.5" I.D. NOZZLES IS TO VARY UNIFORMLY FROM 0° AT THE TOP (0°) & BOTTOM (180°) TO 45° AT THE SIDES (90° & 270°). THIS IS TO MAINTAIN A UNIFORM 45° x 1/8" DEEP WELD PREP WITH A LAND, AROUND THE CIRCUMFERENCE OF THE 61.5" O.D. NOZZLE. (SEE NOTE 12 SHT. 1)

PROCESS SYSTEMS INTERNATIONAL INC. 30 WALCUP DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
HORIZONTAL ACCESS MODULE (HAM) ROLL-UP DETAILS LIGO VACUUM EQUIPMENT			
DWG FILE	SIZE	DWG. NO.	REV.
V0494128/412832	D	V049-4-128	3
SCALE	NOTED	SHEET	2 OF 3



NOTE:
1.) SAW CUT BEVEL THE LENGTH OF EACH PART.
CUT FROM 3" WIDE BAR LENGTH WISE ON 45° ANGLE.



PROCESS SYSTEMS INTERNATIONAL, INC. 20 WALKER DR. WESTBOROUGH, MASSACHUSETTS 01581 USA			
HORIZONTAL ACCESS MODULE (HAM)			
LIGD VACUUM EQUIPMENT			
DWG FILE V049128/412853	SIZE D	ENG. NO. V049-4-128	REV. 3
SCALE 3/8"=1'-0" & NOTED		SHEET 3 OF 3	

Oct 28, 1996 - 095607