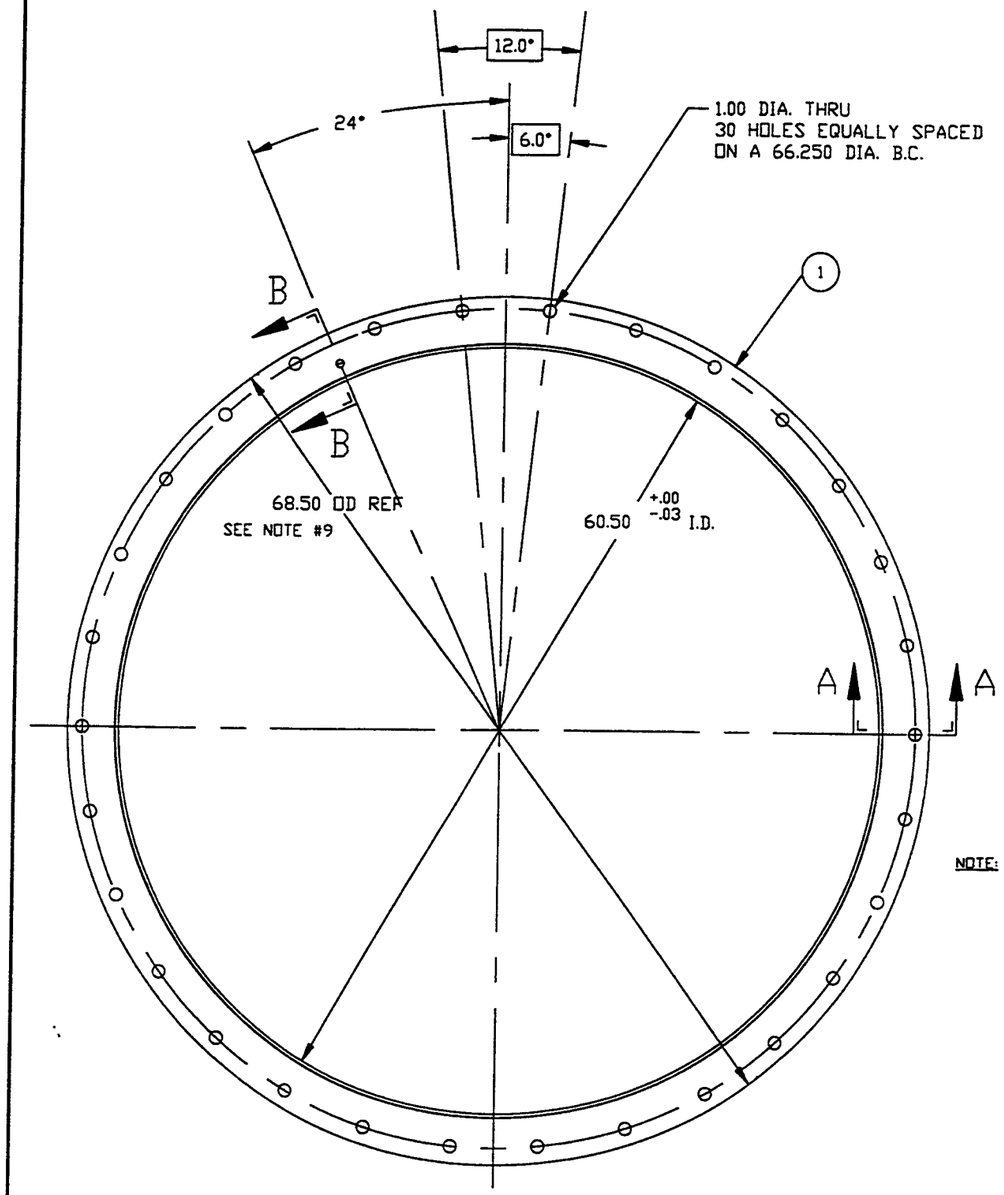
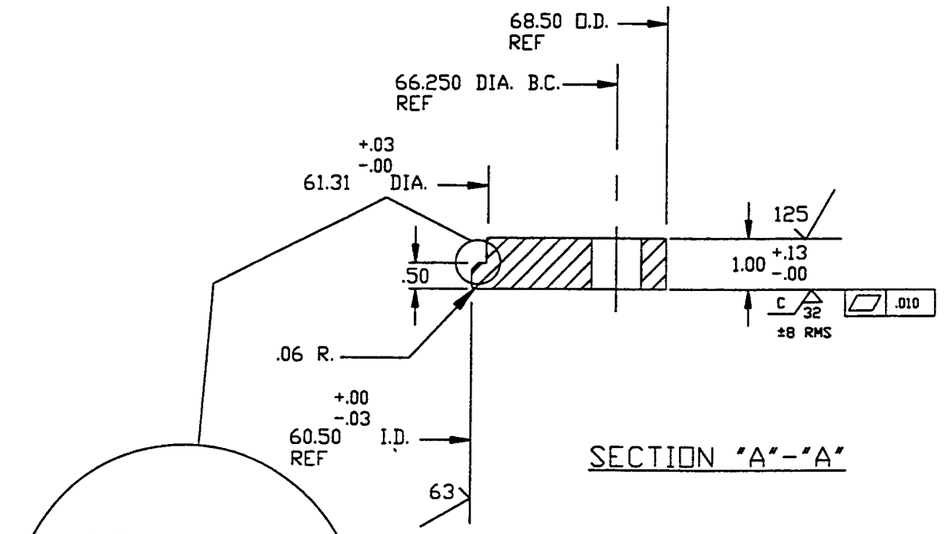
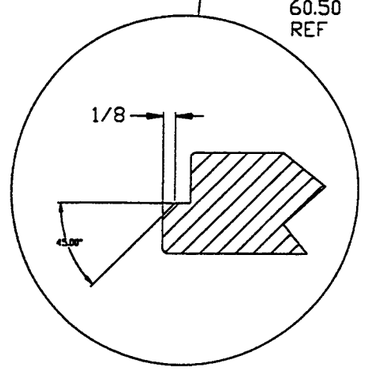
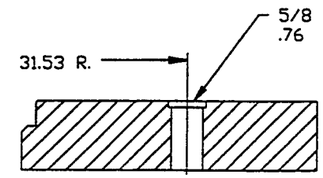




SECTION "A"-"A"





SECTION "B"-"B"

NOTE:

1: FLANGES WILL BE USED IN ULTRA HIGH VACUUM SERVICE
SEE SPECIFICATION V049-2-040 FOR MATERIAL REQUIREMENTS
SEE SPECIFICATION V049-2-136 FOR MACHINING REQUIREMENTS
2: ALL MATERIAL TO BE 304L STAINLESS STEEL
3: FLANGES MUST BE PACKAGED, HANDLED, AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.
4: MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH
5: NO ABRASIVE STONES, CLOTHS OR GRINDING WHEELS MAY BE USED.
6: NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS TO BE USED.
7: NO CARBON STEEL OR OTHER SOURCE OF IRON CONTAMINATION ARE TO COME IN CONTACT WITH FLANGES DURING MANUFACTURING OR HANDLING.
8: STEAM CLEAN & WRAP IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.
9. DO NOT MACHINE FLANGE OD.
ALL FORGING MANUFACT. NOS. TO BE LEFT INTACT.

THIS FLANGE TO BE MADE FROM P/N V049M243-1

WEIGHT: 230#

RAYMOND D. CIOTTI
REG. No. 28750
REGISTERED
PROFESSIONAL
ENGINEER
IN
CIVIL ENGINEERING
STATE OF WASHINGTON
16714
REGISTERED
PROFESSIONAL ENGINEER

EXPIRES 6/5/97

PROPRIETARY AND CONFIDENTIAL

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DWG. NO.	DESCRIPTION
	REFERENCE DRAWINGS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR MACH ± 30' BEND ± 2°
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
FINISH: ALL SURFACE RMS 63
BREAK CORNERS SHARP OUTSIDE
REMOVE ALL BURRS

DO NOT SCALE THIS DWG.

USED ON

NEXT ASS'Y

REV.	DESCRIPTION	CHKD	DRAWN	DATE	DCO
0	ISSUED FOR FABRICATION	SPIDER		9/20/96	0218

ISSUE DESCRIPTION

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

60.5" I.D. X 68.25" O.D. FLANGE
DETAIL (BE-3A) (FLAT FACED)
LIGO VACUUM EQUIPMENT

CAD FILE	SIZE	DWG. NO.	REV.
V0494144	C	V049-4-144	0

SCALE 1 1/2"=1'-0" SHEET 1 OF 1

Sept 20, 1996 - 16:14:03

LIGO-D970440-00-V