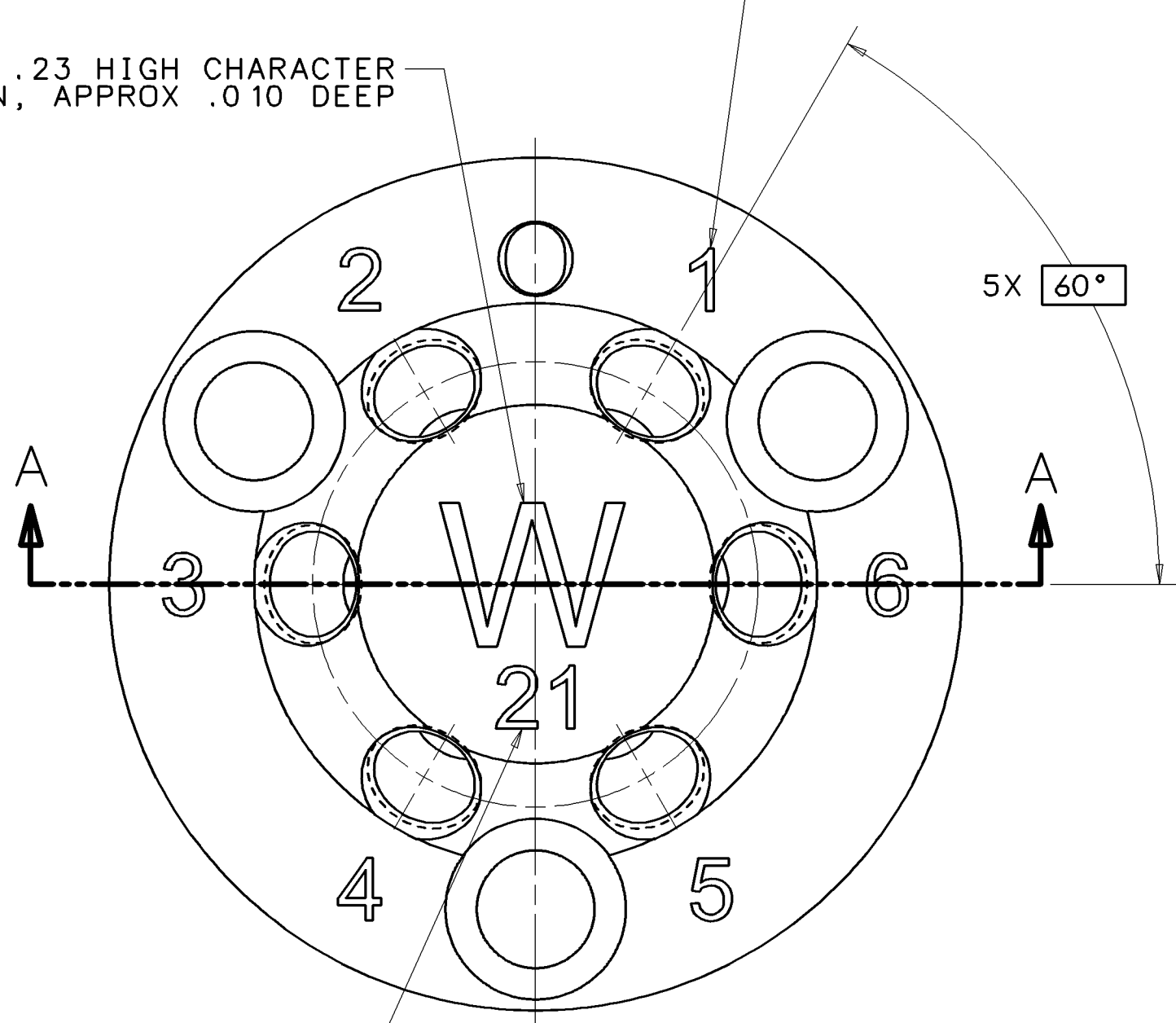
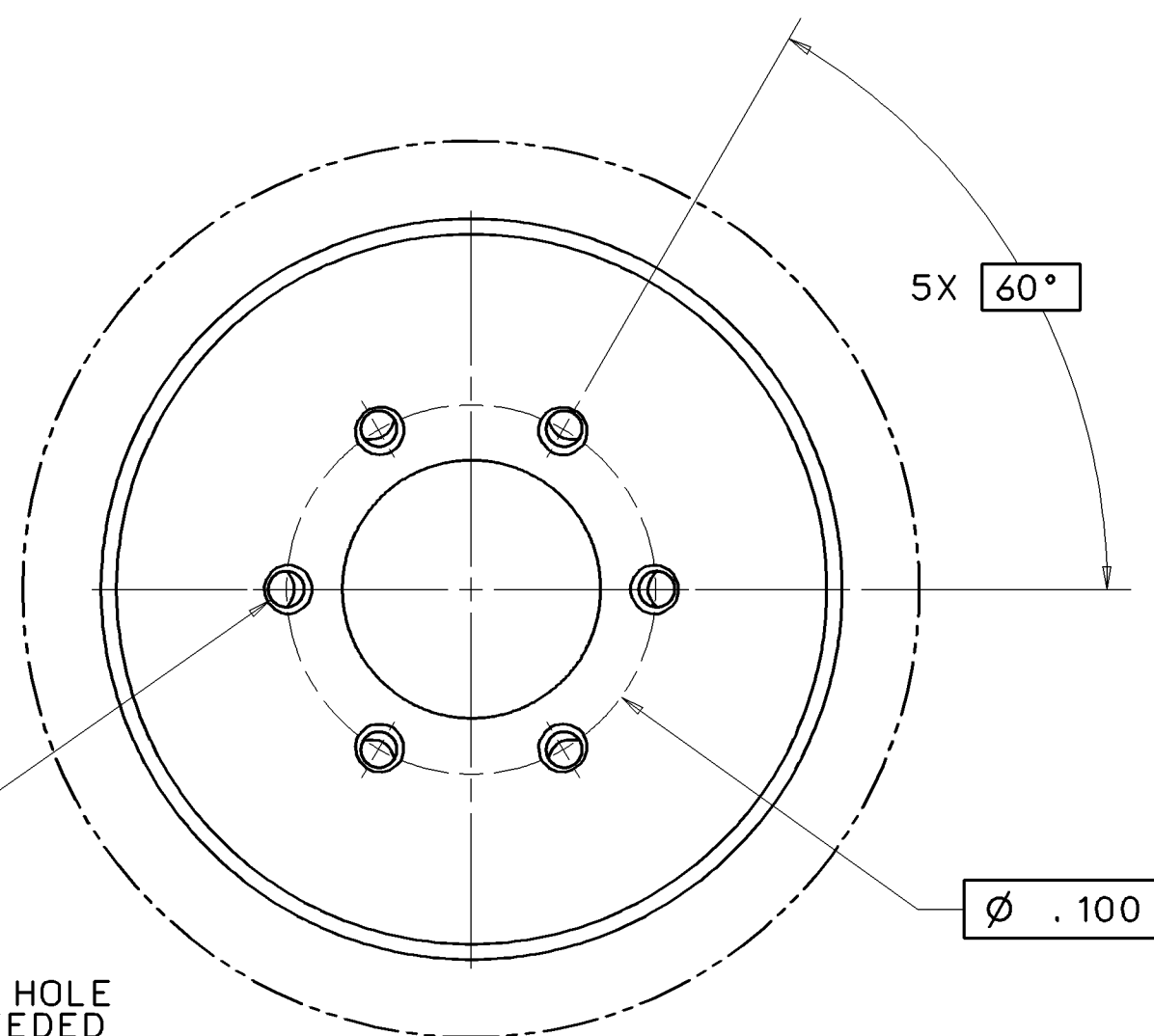
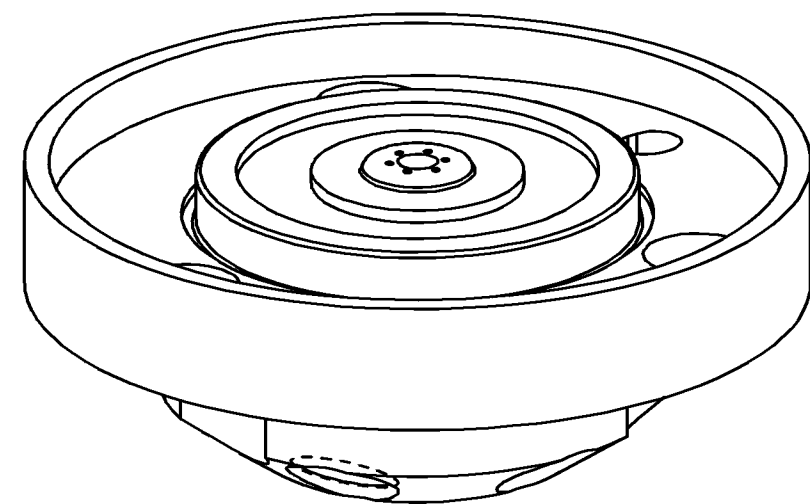
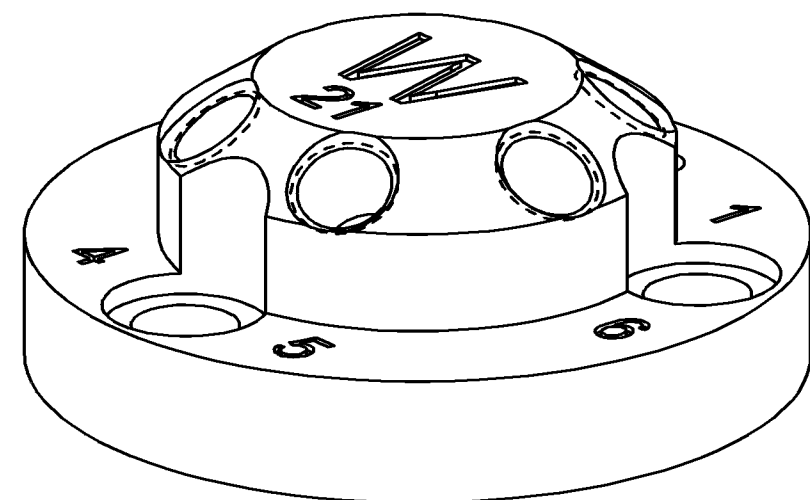
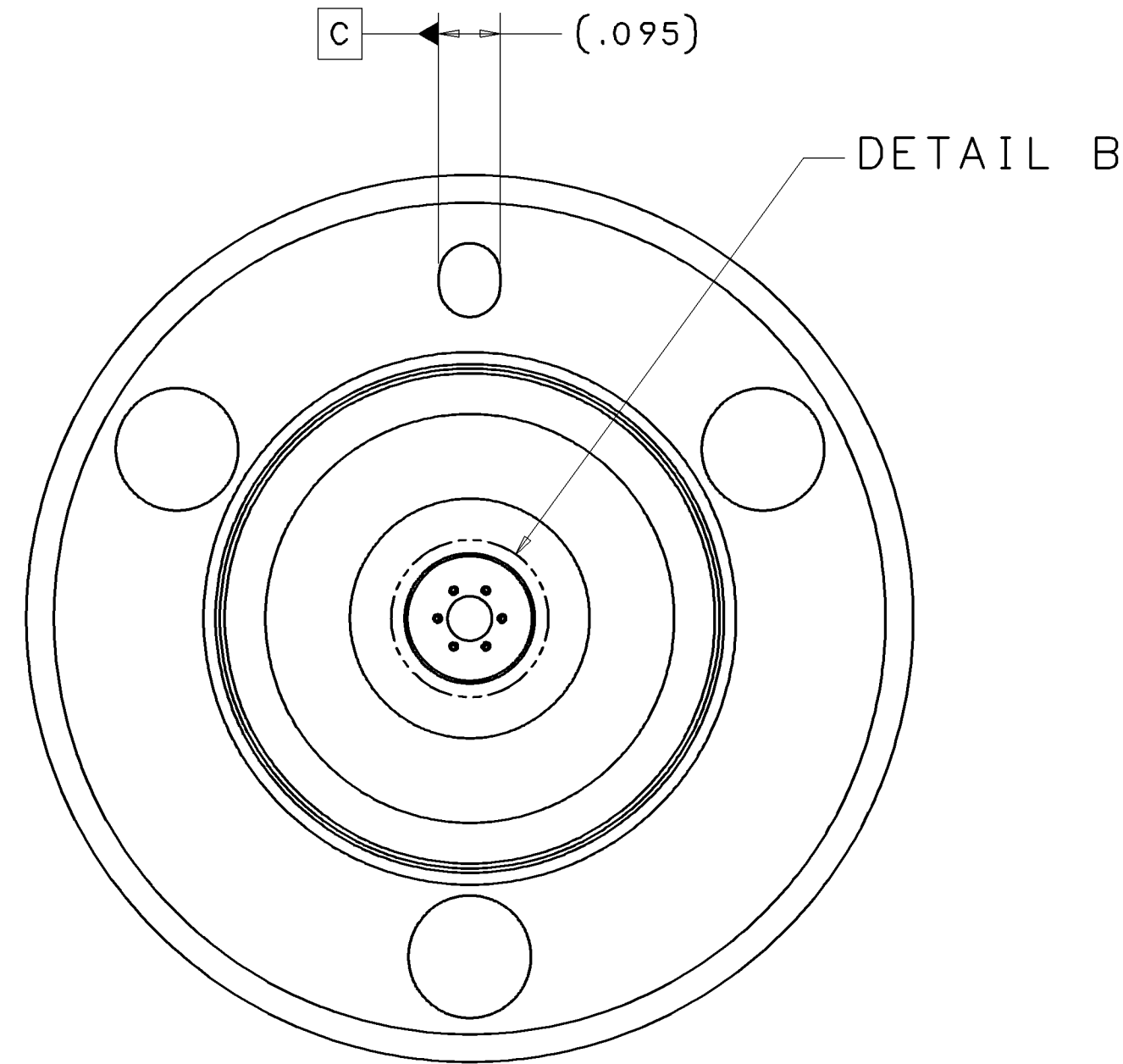
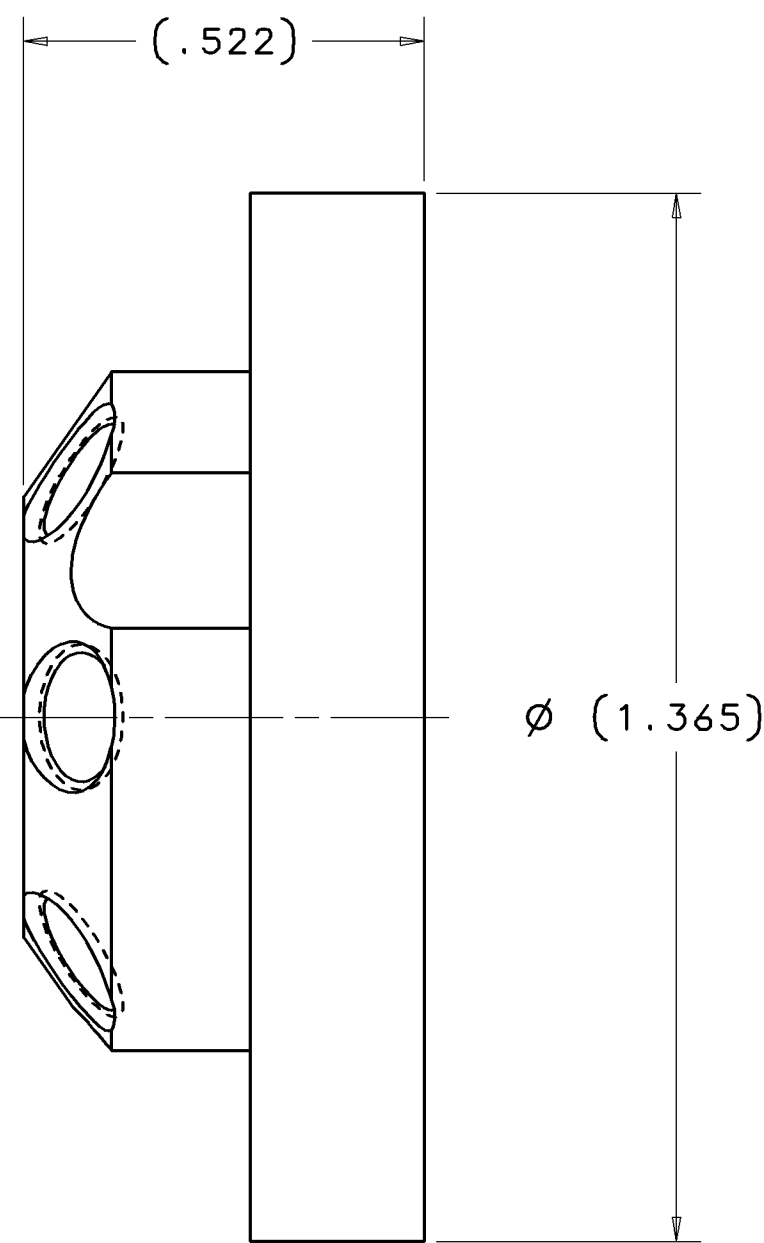


INSCRIBE .23 HIGH CHARACTER  
APPROX AS SHOWN, APPROX .010 DEEP

6X INSCRIBE .10 HIGH CHARACTERS  
APPROX AS SHOWN, APPROX .010 DEEP



INSCRIBE .10 HIGH CHARACTERS  
APPROX AS SHOWN, APPROX .010 DEEP



6X Ø .010 ±.001  
TO INTERSECTION OF Ø.011 HOLE  
ADDITIONAL DEPTH MAY BE NEEDED  
TO REMOVE "SHELF" IN DETAIL K.  
DRILL POINT PERMITTED

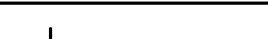
NOTE 1.1 FOR DATUM REFERENCES

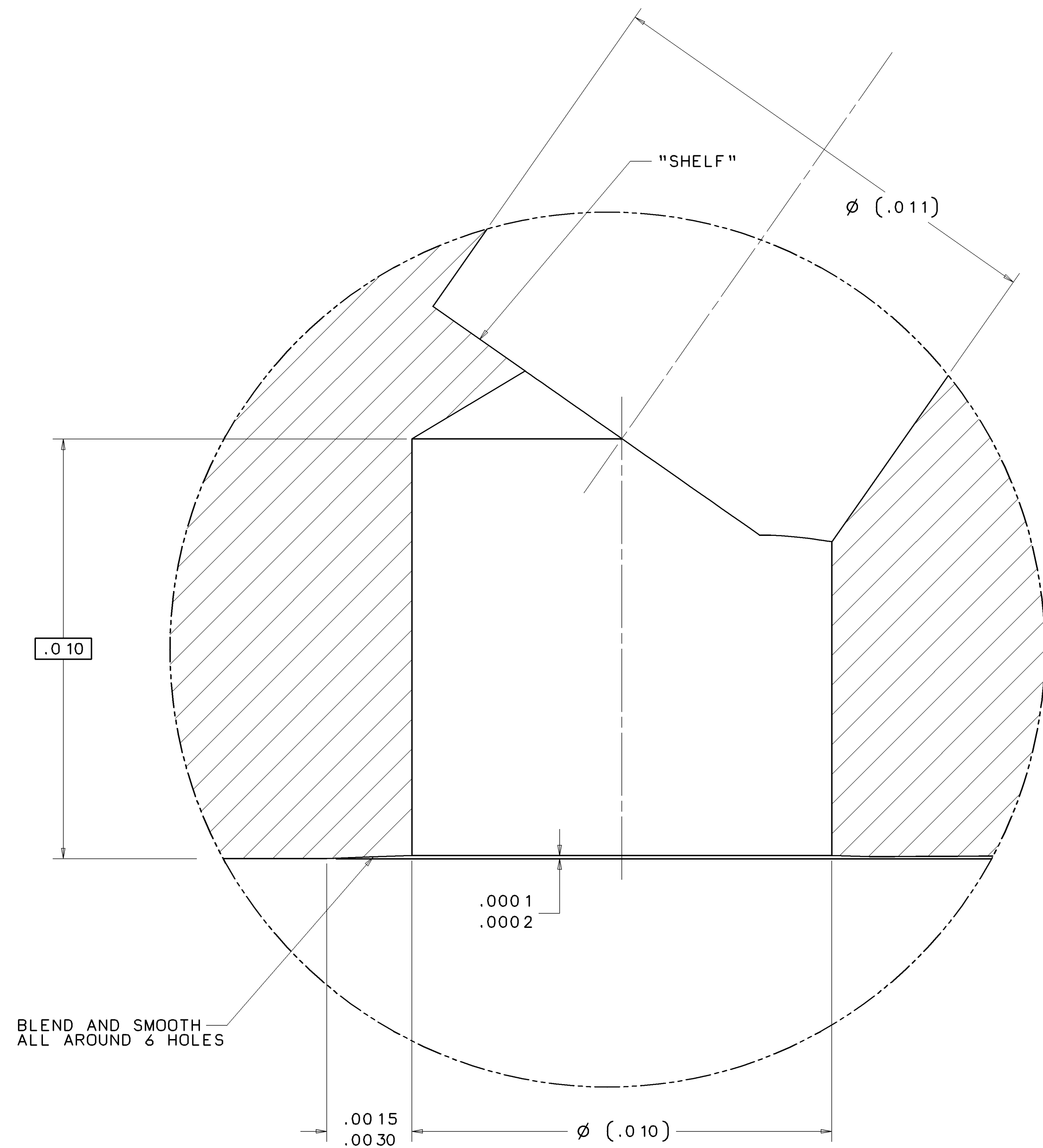
DETAIL B  
SCALE 20:1

WATERS CRITICAL CLEAN™ PART, SEE NOTES

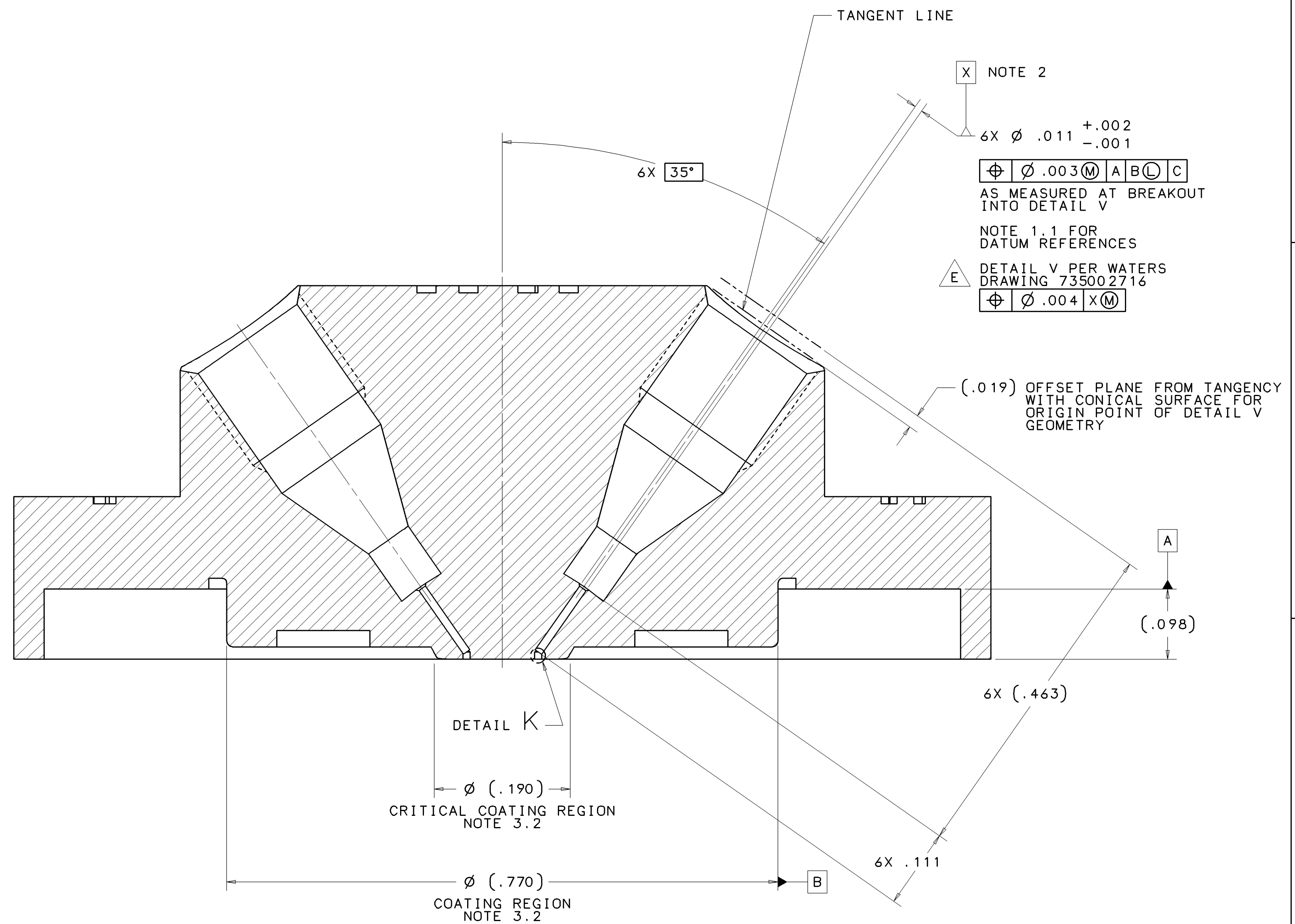
#### NOTES:

- 1.0 MATERIAL: 316 SST ANNEALED, HARDNESS: BHN 135-185 AT Ø.190 REGION  
APPROVED VENDOR: CARPENTER TECHNOLOGY
- 1.1 SEE WATERS DRAWING 735002264 FOR FABRICATION DETAIL
- 2.0 DATUM X REPRESENTS INDIVIDUAL PORTS FOR DETAIL "V" LOCATION
- 3.0 FINISH
  - 3.1 PASSIVATE BEFORE COATING PROCESS PER WATERS SPEC WAT022306
  - 3.2 COATING VENDOR: NANOFILM TECHNOLOGIES INTERNATIONAL
  - 3.2.1 SPECIFICATIONS PER WATERS SPEC 735002319
- 4.0 CLEANLINESS REQUIREMENTS: THIS PART IS TO BE FREE OF CONTAMINATION AS DEFINED IN WATERS CRITICAL CLEAN™ PARTS AND ASSEMBLIES SPECIFICATION, 735001035. SUPPLIERS WITHOUT A QUALIFIED WATERS CRITICAL CLEAN™ PROCESS SHALL WORK WITH WATERS TO BECOME QUALIFIED, OR USE A QUALIFIED CLEANING SUPPLIER. QUALIFIED SUPPLIERS ARE LISTED IN 735001035, APPENDIX A.
- 5.0 PACKAGING REQUIREMENTS: THIS PART IS TO BE INDIVIDUALLY PACKAGED PER WATERS SPECIFICATION FOR CRITICAL CLEAN™ PARTS, 735001035.

|                                                                                                                                                                    |                                                                                       |                                                                                                              |           |                       |                                                                              |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------|-----------|-----------------------|------------------------------------------------------------------------------|--------------|
| FOR DIMENSIONING AND TOLERANCING<br>USE ASME Y14.5M 1994                                                                                                           |  | UNLESS OTHERWISE SPECIFIED                                                                                   | DESIGN    | C. HUDSON<br>18NOV10  | <b>Waters</b><br>34 Maple Street<br>Milford, Massachusetts 01757-3696 U.S.A. |              |
|                                                                                                                                                                    |                                                                                       | All dimensions are in inches. Dimensions in brackets [ ] are metric. Remove all burrs and break sharp edges. | DRAWN     | C. HUDSON<br>18NOV10  |                                                                              |              |
| THIRD ANGLE PROJECTION                                                                                                                                             |                                                                                       | Tolerances:<br>Decimals                                                                                      | CHECKED   | N/A                   | TITLE<br>STATOR, VALVE,<br>VENT, DOGLEG,<br>18 KPSI                          |              |
| NEXT ASSY: 289006541                                                                                                                                               |                                                                                       | .XXX = ± .01<br>.XXX = ± .005<br>Angles = ± 1°                                                               | ENGR      | M. MOELLER<br>18NOV10 |                                                                              |              |
| THIS DRAWING AND ALL INFORMATION HEREON IS THE PROPERTY OF WATERS CORPORATION. ANY COPYING, REPRODUCTION OR UNAUTHORIZED USE IS FORBIDDEN WITHOUT WRITTEN CONSENT. |                                                                                       | SURFACE ROUGHNESS 63/                                                                                        | ENGR      | N/A                   | SIZE DWG NO<br>D 40 50 12 4 6 1                                              |              |
|                                                                                                                                                                    |                                                                                       | DO NOT SCALE PRINT                                                                                           | APPD      | N/A                   |                                                                              | REV E        |
|                                                                                                                                                                    |                                                                                       |                                                                                                              | SCALE 4:1 |                       | VERSION 04                                                                   | SHEET 1 of 2 |



DETAIL K  
SCALE 500 : 1



SECTION A-A  
SH 1

|                |                       |              |
|----------------|-----------------------|--------------|
| SIZE<br>D      | DWG NO<br>40 50 12461 | REV<br>E     |
| SCALE<br>1 : 1 | VERSION<br>04         | SHEET 2 OF 2 |