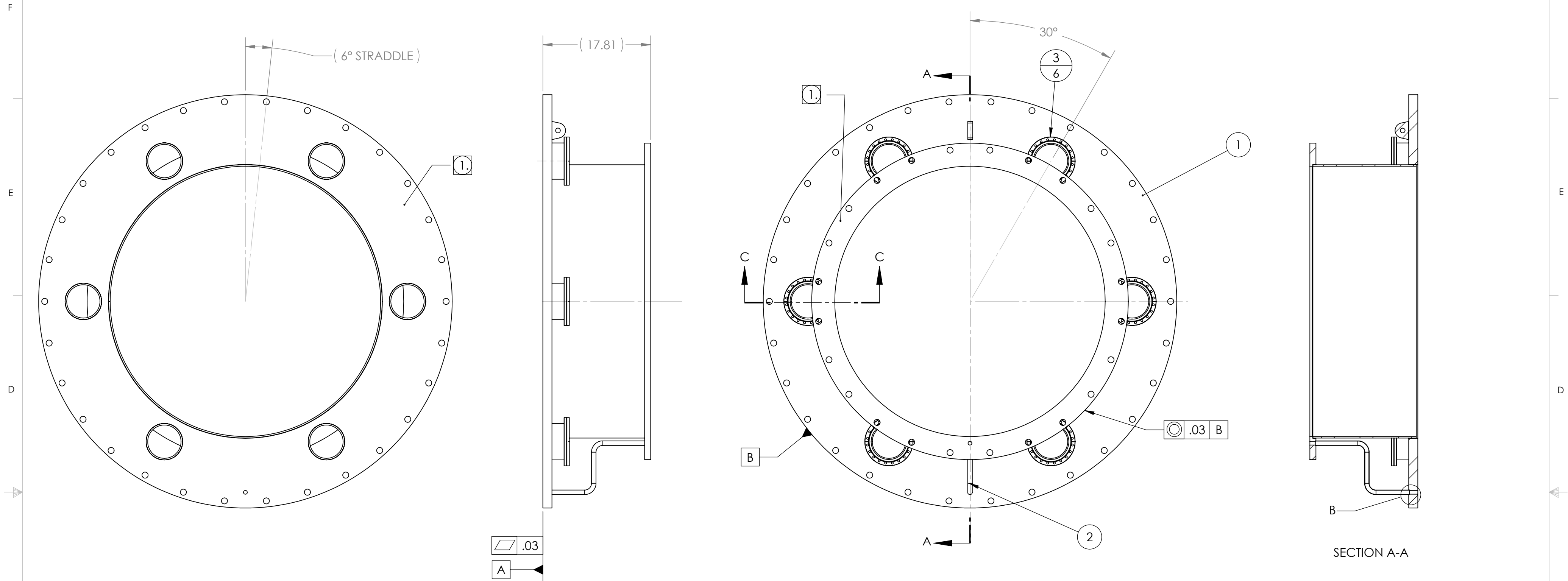


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED GD&T, ANGLE TOLERANCES	7/1/2010	MKM2
	B	REVISED NOTE; THIS IS NO LONGER THE TOP LEVEL PRINT	8/19/2010	MKM2
	C	RELEASED TO PRODUCTION	8/23/2010	MKM2



$\square$  .03  
 A

$\square$  .03 B

$\square$  .03 A

2.00 MIN

(.25)

VAC TIGHT  $\sphericalangle$  1/8

SECTION C-C  
 SCALE 1 : 3  
 8" CF PORT WELD DETAIL  
 SIX PLACES

2X  
 VAC TIGHT  $\sphericalangle$  1/16

DETAIL B  
 SCALE 1 : 1.5

- NOTES:
- $\square$  VACUUM SEALING SURFACE
  - ALL WELDS TO BE SMOOTH BUT NO GRINDING IS ALLOWED.
  - ALL WELDS TO BE GTAW.
  - ALL WELD PREPARATION TO BE DONE BY TUNGSTON CARBIDE TOOLING IF NEEDED.
  - CLEAN ALL WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING.
  - ALL WELDING TO BE IN ACCORDANCE WITH QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE.
  - COMPONENT TO BE FREE FROM CONTAMINATION PER QP1730-10, CONTAMINATION CONTROL PLAN

$\triangle$  B

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114285-00S	MACHINING, ADAPTER 1-16	1
2	114293-00S	PIPE, PUMP OUT PLUMBING	1
3	114295-00WS	PORT, 8" CF, WELDMENT	6

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240  
 WEIGHT: 1195.61#

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: $\pm 0^{\circ}30'$ .XX $\pm .01$ .XXX $\pm .005$ UNSPECIFIED FILLETS: R.015 BREAK EDGES .010x45° REMOVE ALL BURRS	FINISH 125
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APPROVALS: DRAFTER MKM2 6/11/10, CHECKER RW 6/15/10, ENGINEER MKM2 6/11/10

GNB CORPORATION  
 SCIENTIFIC AND INDUSTRIAL EQUIPMENT  
 3200 DWIGHT RD. SUITE 100  
 ELK GROVE, CA 95758  
 916-395-3003 FAX: 916-395-3363  
 www.gnbvalves.com

TITLE: FINAL WELDMENT, ADAPTER A-16

DO NOT SCALE DRAWING

SCALE: 1:12 SHEET 1 OF 1

$\triangle$  A

THIRD ANGLE PROJECTION

DWG. NO. 114284-00WS  
 REV C