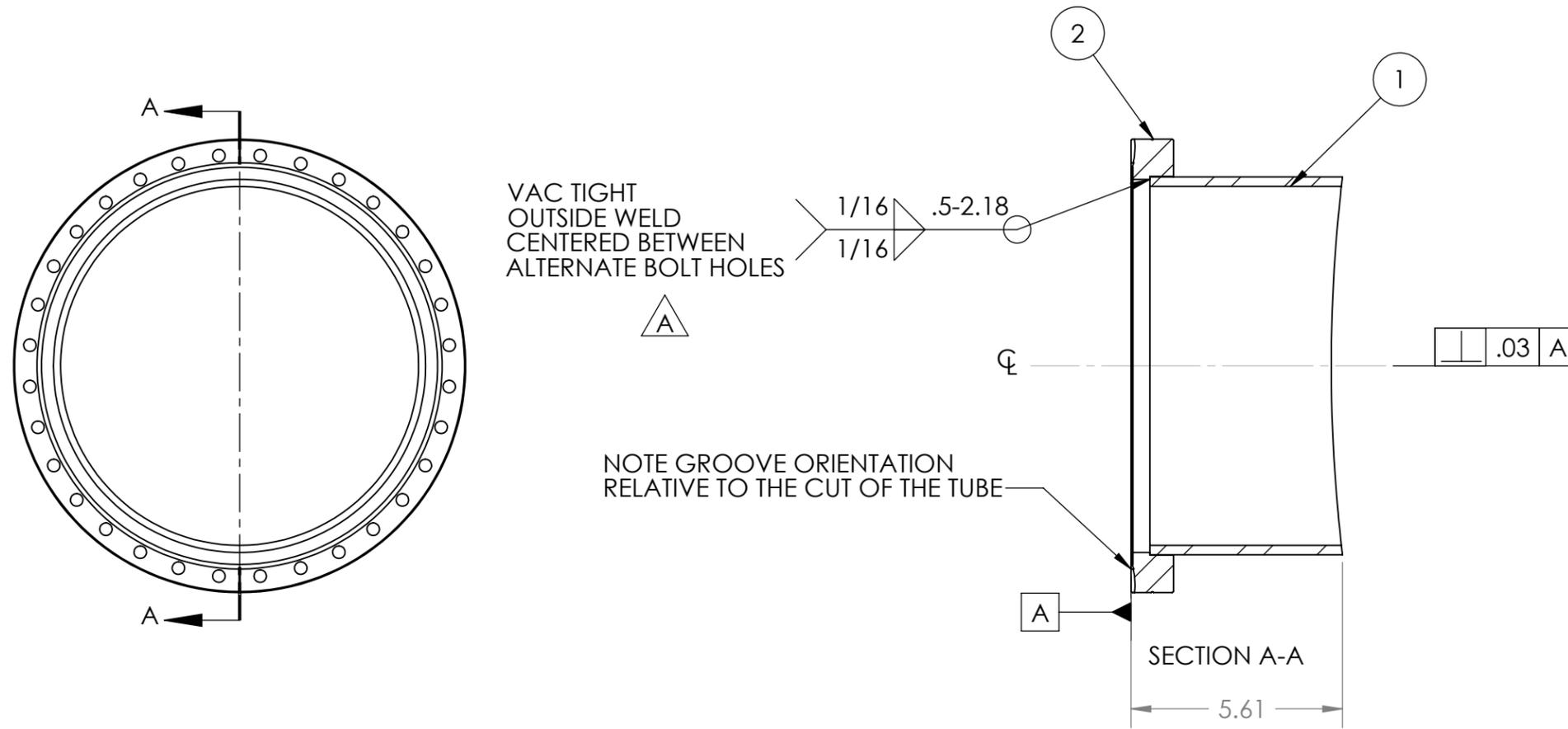


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALL-OUT	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/24/2010	MKM2



NOTES:

1. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
2. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
3. CLEAN WELD WIRE AND WELDED SURFACES WITH CO2 SCRUBBING
4. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
5. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
6. ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
7. NO POST WELD HEAT TREATMENT IS REQUIRED
8. NOTE ORIENTATION OF TEST SLOT IN FLANGE TO CUT OF TUBE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114215-00S	TUBE, PORT, 12" CF	1
2	1200-1000N	FLANGE, CONFLAT, 12" OD, NON-ROTATABLE, THRU HOLES	1

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 ANGULAR: ± 0°30'  
 .XX ± .03  
 .XXX ± .005  
 UNSPECIFIED FILLETS: R.015  
 BREAK EDGES .010x45°  
 REMOVE ALL BURRS

//, □, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 21.31 #

APPROVALS	DATE
DRAFTER MKM2	6/25/10
CHECKER RW	7/22/10
ENGINEER MKM2	6/25/10

**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: PORT, 12" OD CONFLAT, NR, THRU HOLES

DO NOT SCALE  
 DRAWING

DWG. NO. 114214-00WS  
 SCALE: 1:4 SHEET 1 OF 1

REV B