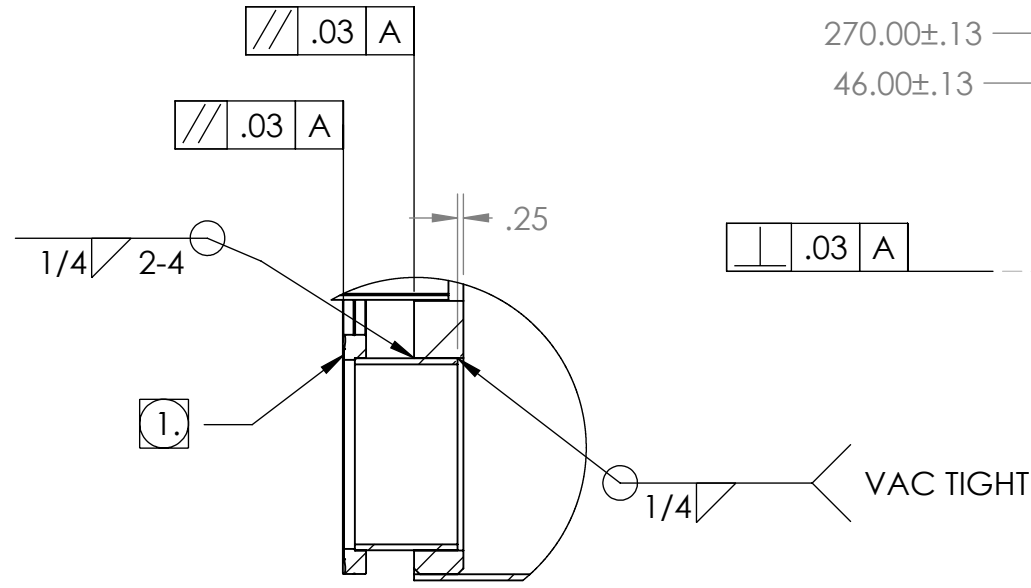
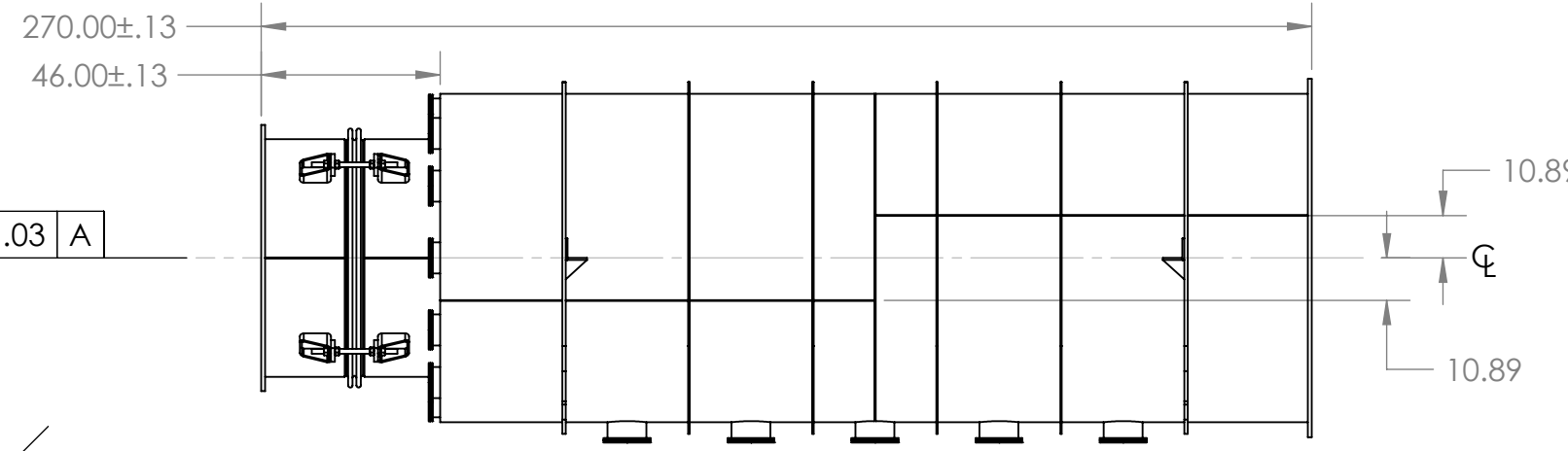
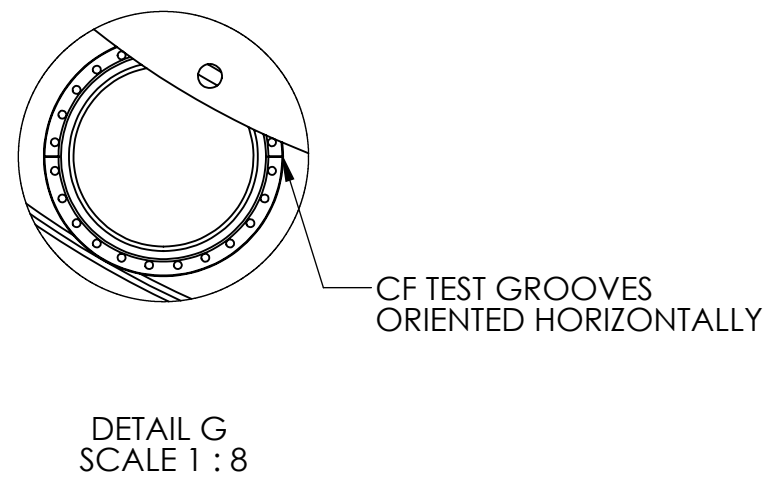
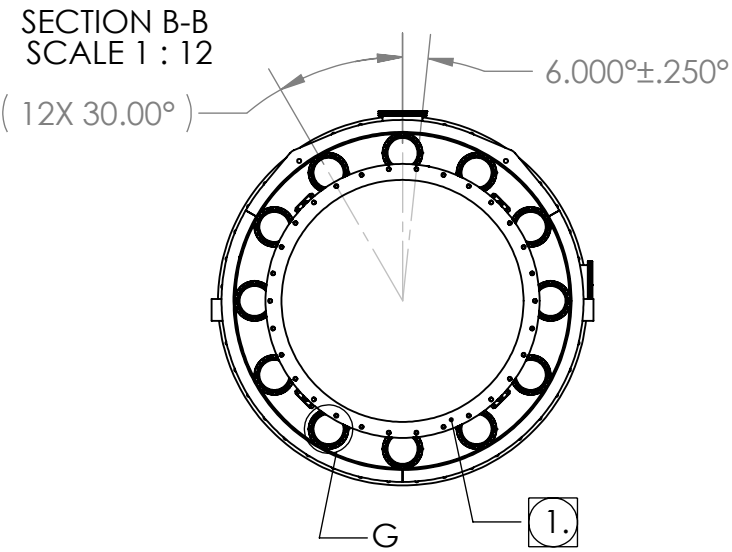
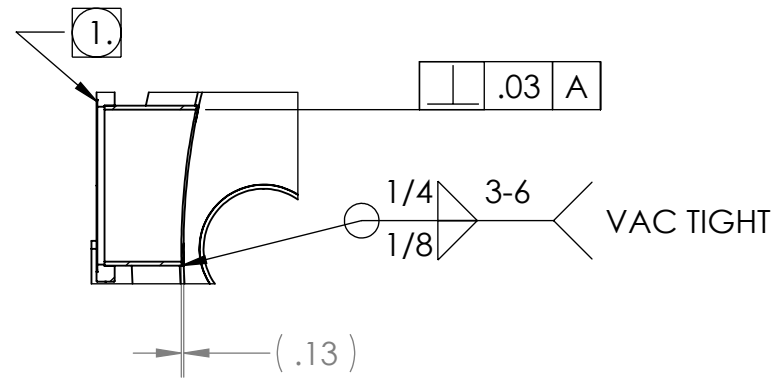


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALL-OUTS	8/11/2010	MKM2
	B	ADDED INDICATOR MARKS FOR ALIGNMENT, TIGHTENED ANGULAR TOLERANCES, RELEASED TO PRODUCTION	8/24/2010	MKM2



DETAIL C
 SCALE 1 : 8
 TUBE END
 10" CF PORTS WELD DETAIL
 12 PLACES



ALIGN INDICATOR MARKS BETWEEN FLANGE AND TUBE HERE

5X CF TEST GROOVES TO BE ORIENTED PERPENDICULAR TO THE AXIS OF THE TUBE.

ALIGN INDICATOR MARKS BETWEEN FLANGE AND TUBE HERE

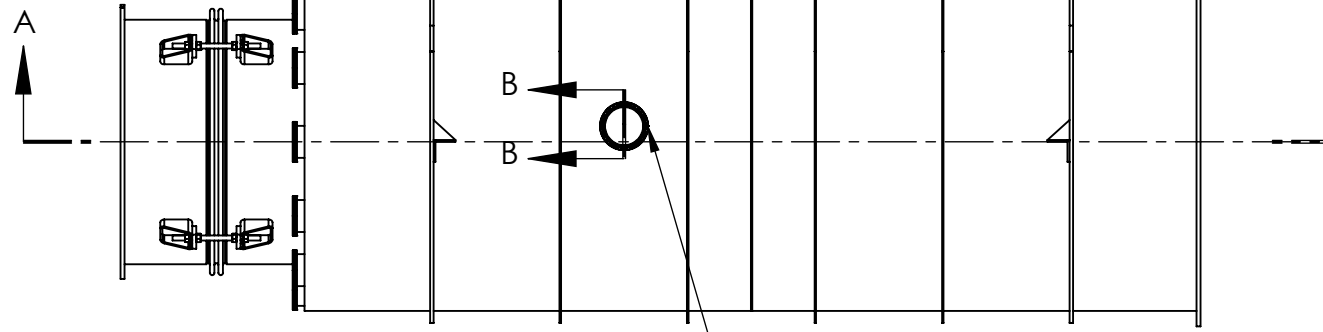
ALIGN TUBES BY USING CENTRAL PORT AS AN INDICATOR

VAC TIGHT USE NO BACKING STRIPS FULL PENETRATION

.03 A

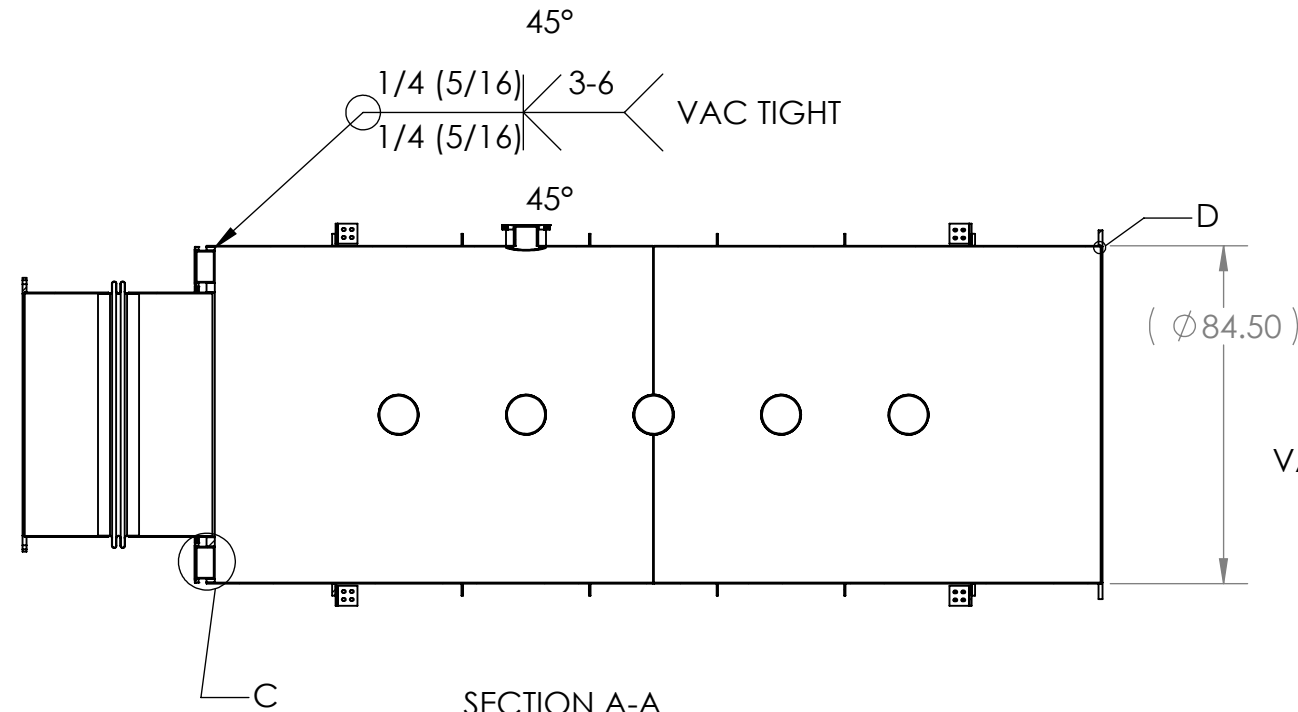
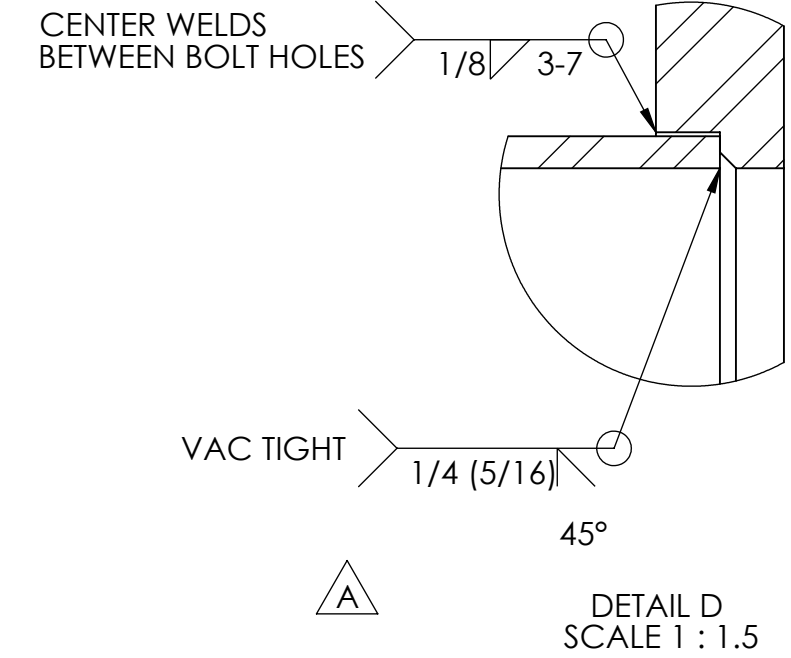
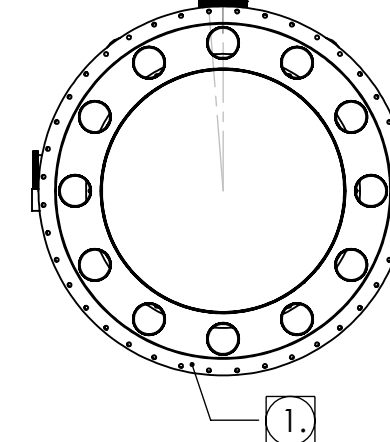
3/16 (1/4)

45°

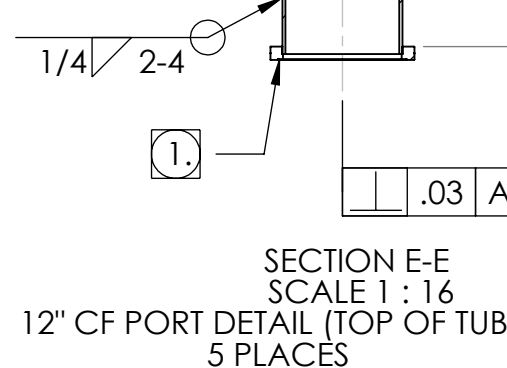


CF TEST GROOVES TO BE ORIENTED ALONG THE AXIS OF THE TUBE.

4.500 ± .250°



VAC TIGHT 1/8



SECTION E-E
 SCALE 1 : 16
 12" CF PORT DETAIL (TOP OF TUBE)
 5 PLACES

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114249-00S	TUBE, LEFT, MC TUBE	1
2	114251-00S	TUBE, RIGHT, MCA TUBE	1
3	114214-00WS	PORT, 12" OD CONFLAT, NR, THRU HOLES	5
4	114255-00WS	WELDMENT, NIPPLE, BELLOWS, MCA TUBE	1
5	114260-00WS	WELDMENT, PORT, 10" CF	12
6	114253-00S	FLANGE, 84.00 ID, MCA TUBE	1
7	114214-01WS	PORT, 12" OD CONFLAT, NR, THRU HOLES	1

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240
 WEIGHT: 7893.81#

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: ± 0°30' 125
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS
 // .1 WITHIN .03

APPROVALS: DATE: 7/13/10
 DRAFTER: MKM2
 CHECKER: RW 7/22/10
 ENGINEER: MKM2 7/13/10

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 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: WELDMENT, MC-A TUBE
 WAMCA#1/LAMCA#1

DO NOT SCALE DRAWING
 C DWG. NO. 114248-00WS
 SCALE: 1:48 SHEET 1 OF 1
 REV B

NOTES:

- VACUUM SEALING SURFACE
- ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
- WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
- CLEAN WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
- INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
- ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
- ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
- NO POST WELD HEAT TREATMENT IS REQUIRED