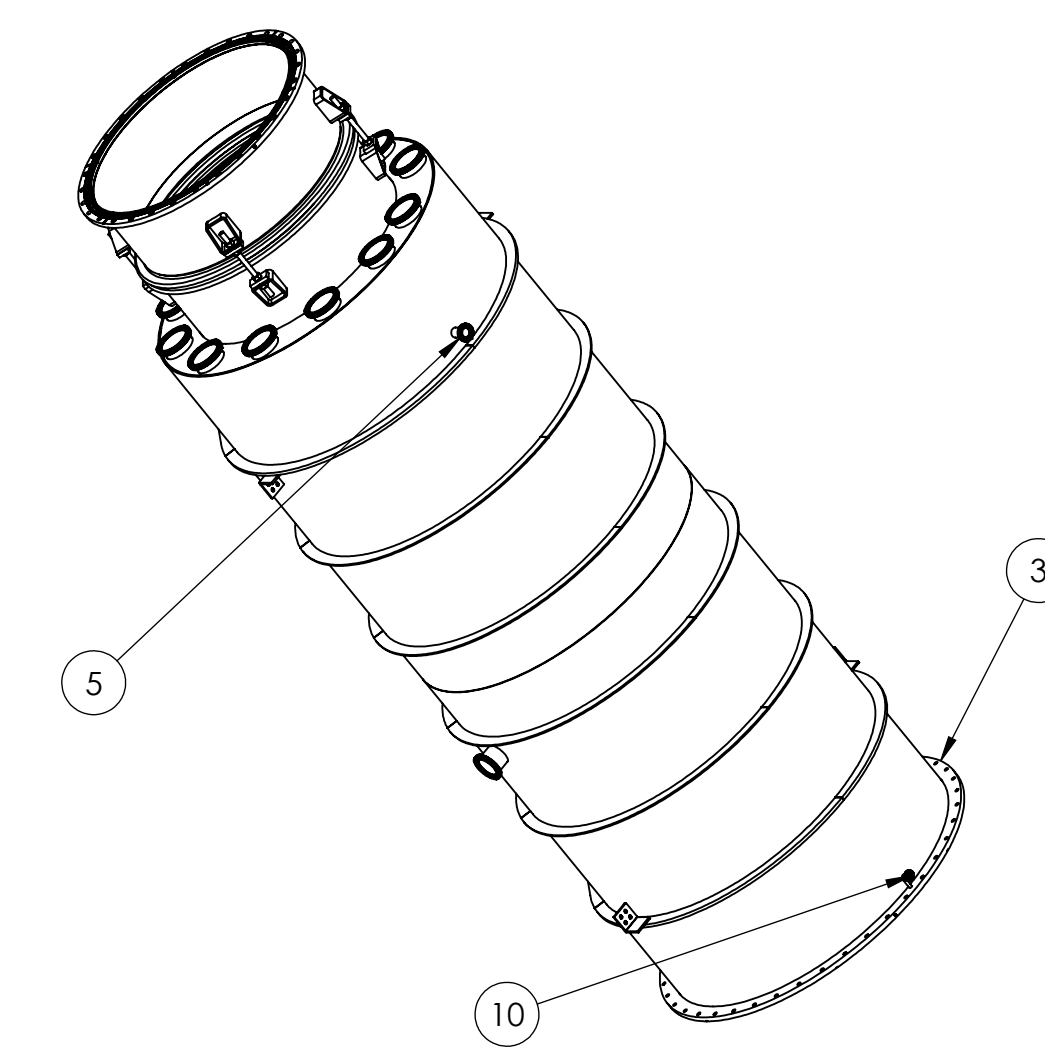
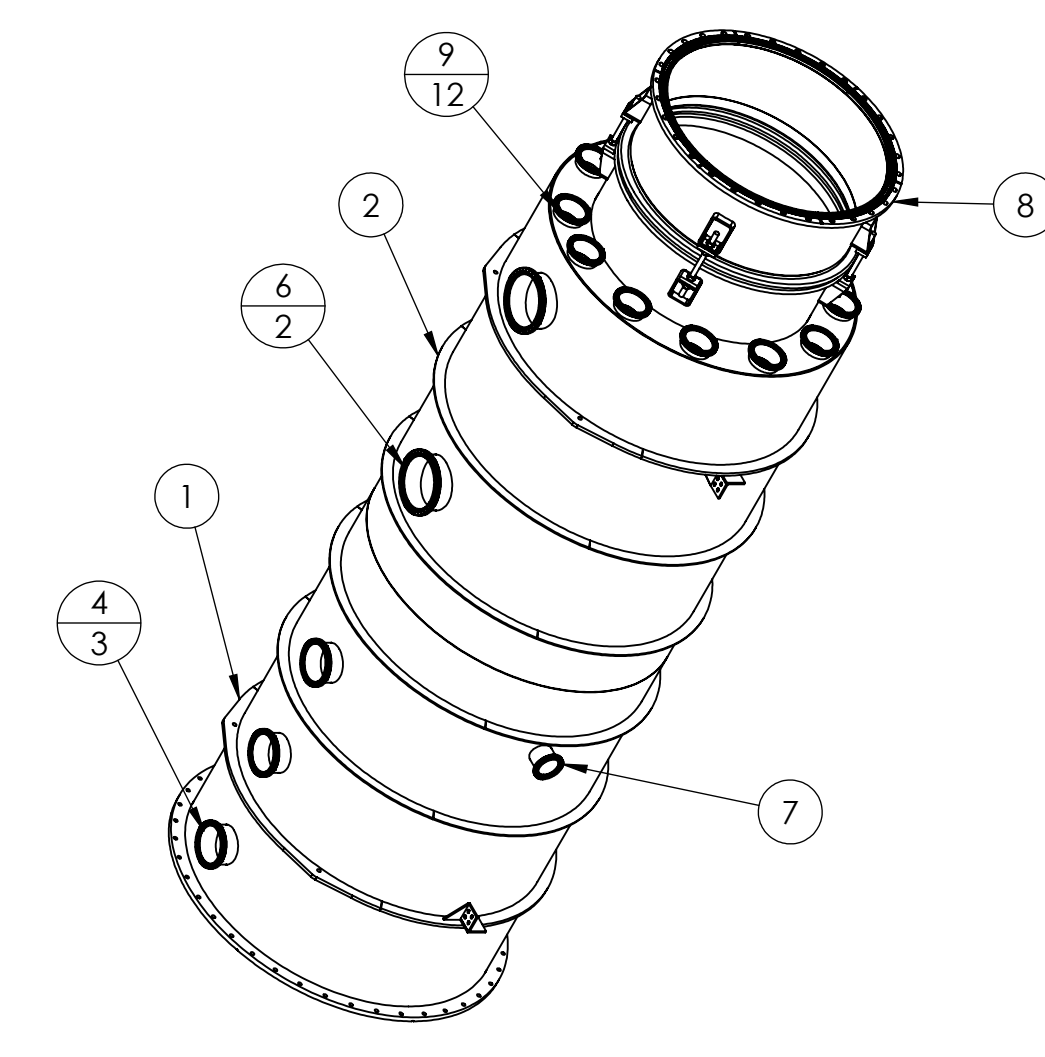
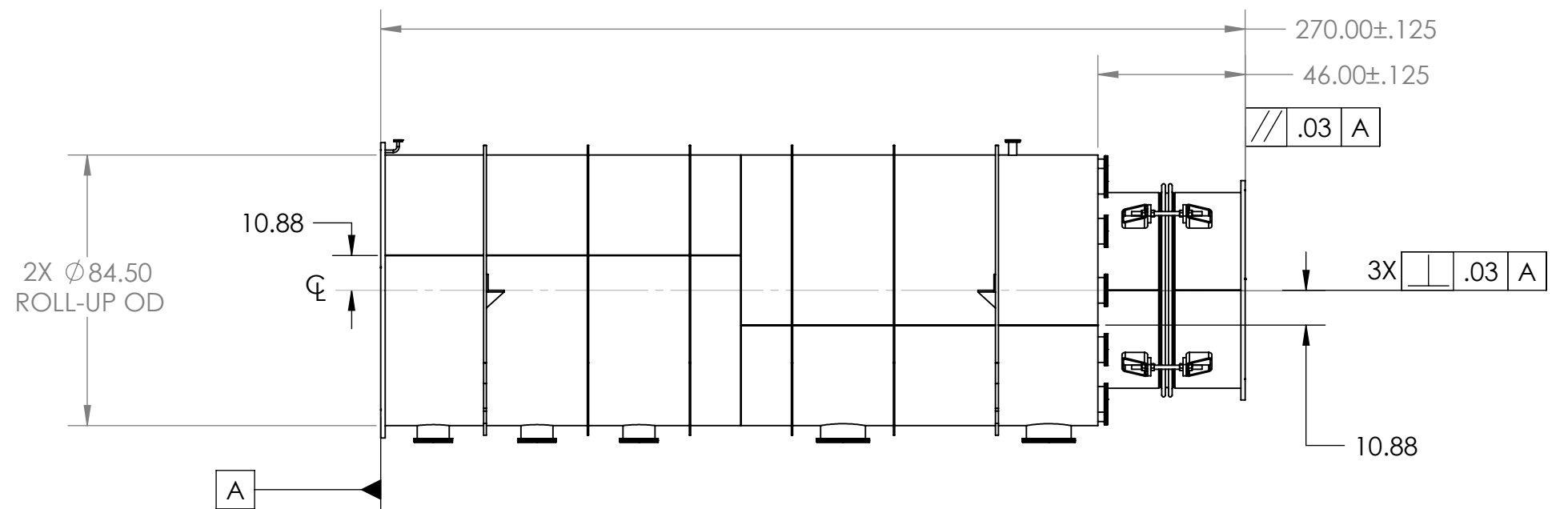
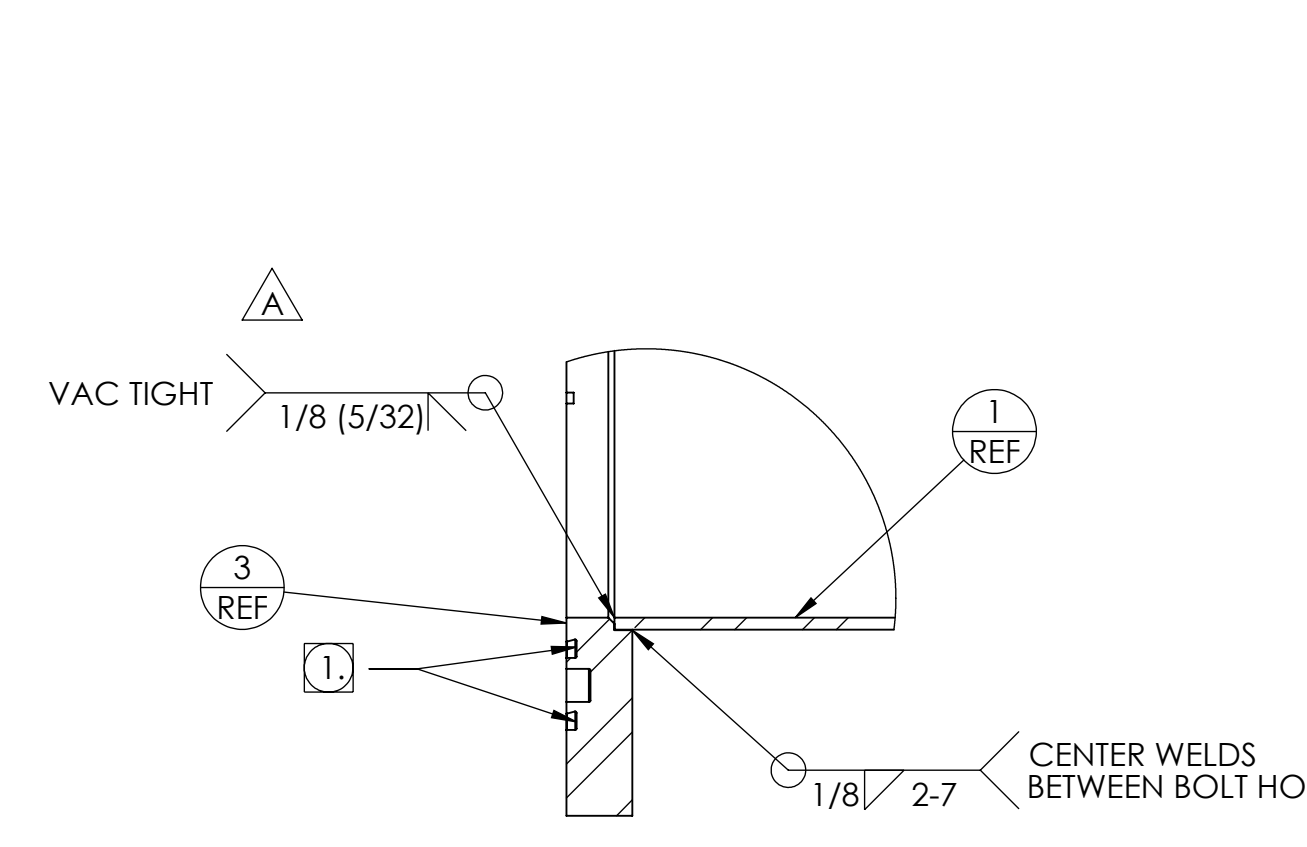
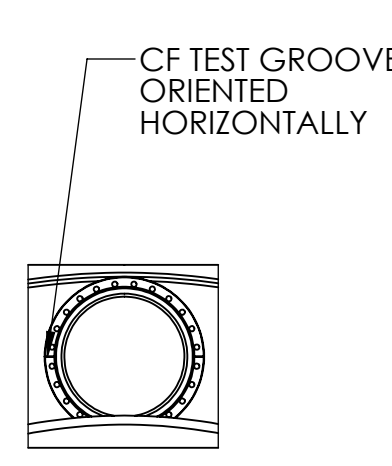
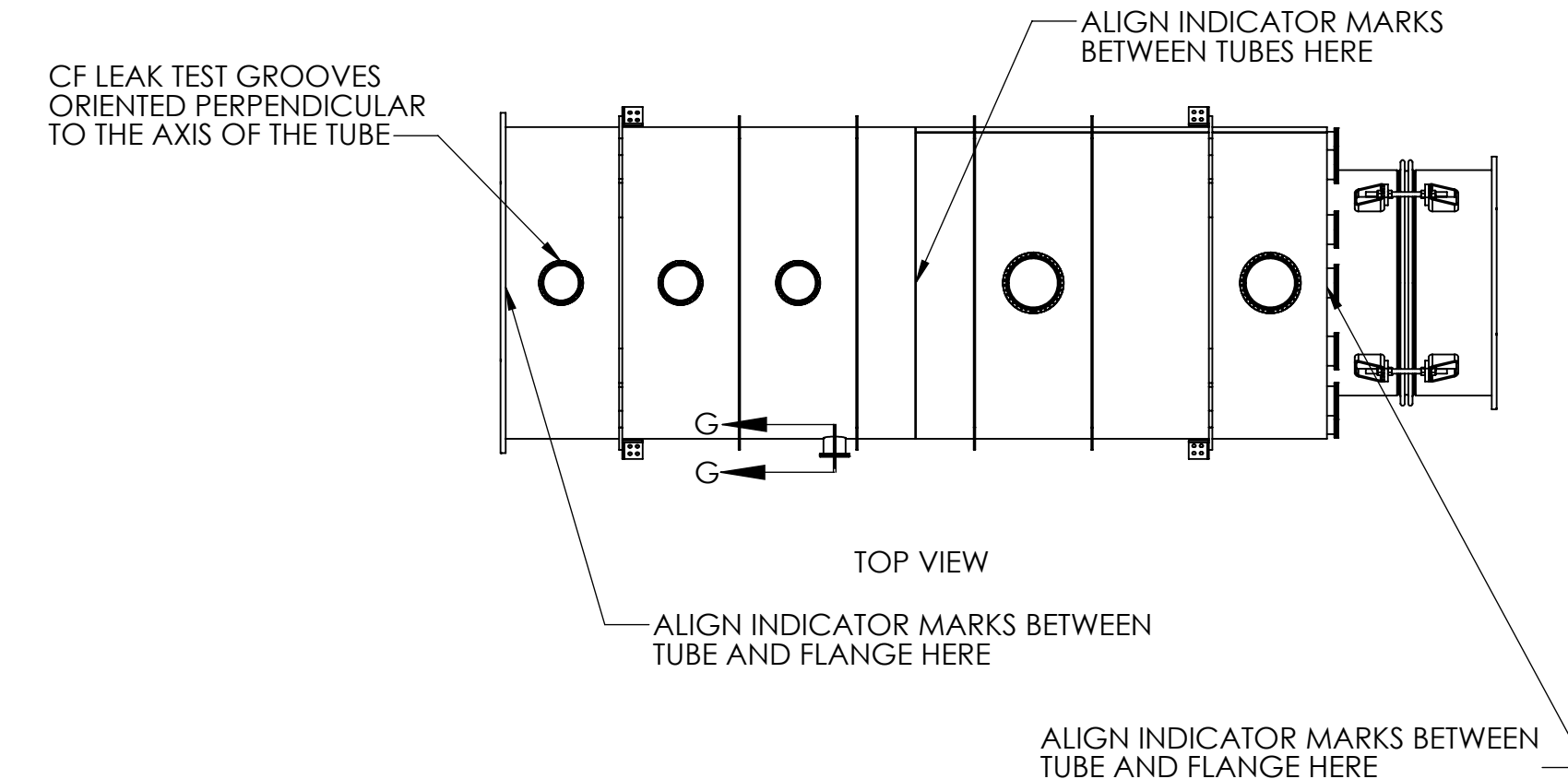


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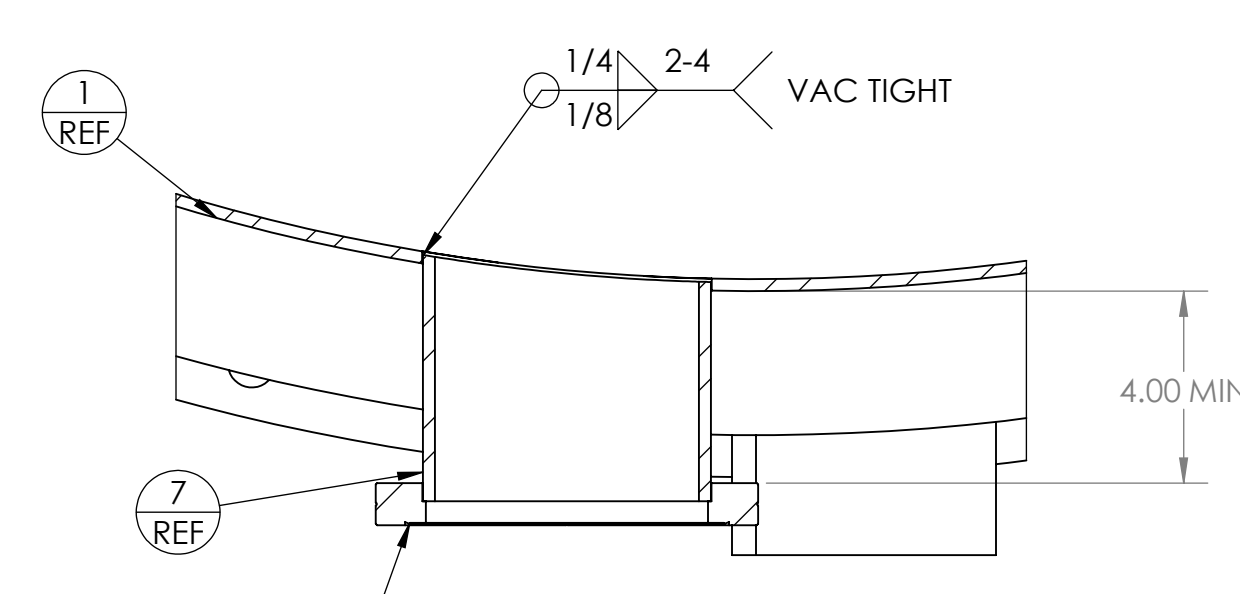
ZONE		REV.	DESCRIPTION	DATE	APPROVED
		A	REVISED WELD SIGNS	8/11/2010	MKM2
		B	RELEASED TO PRODUCTION	8/25/2010	MKM2



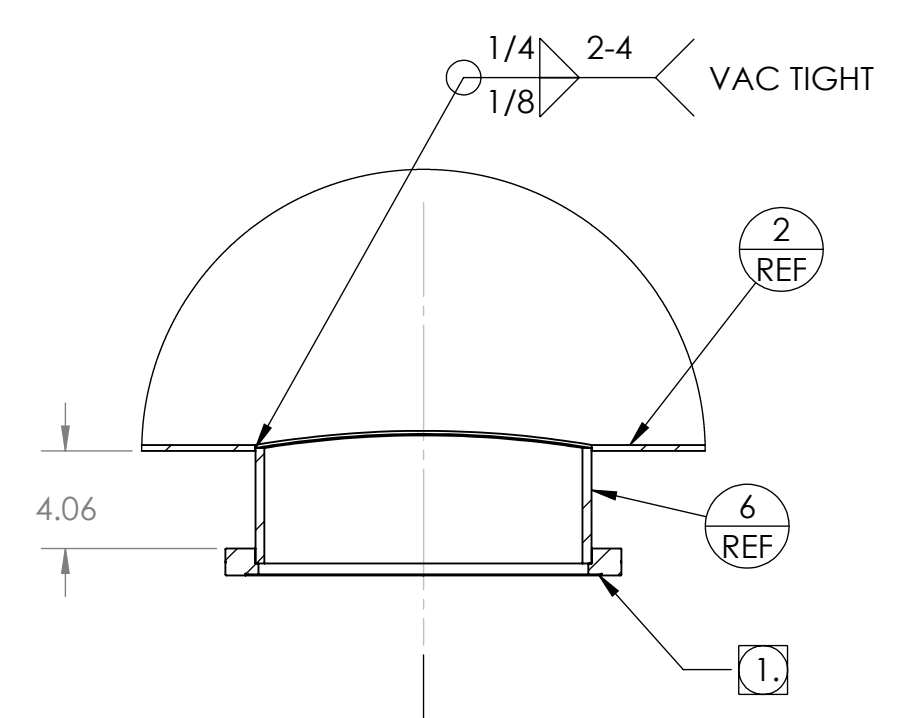
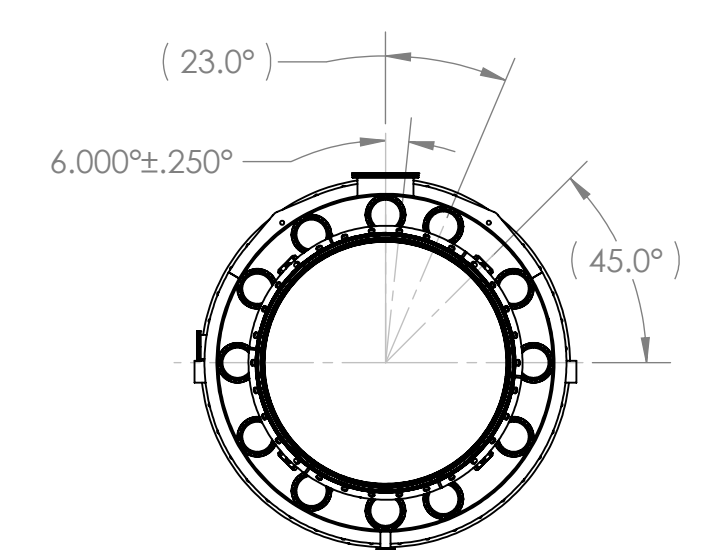
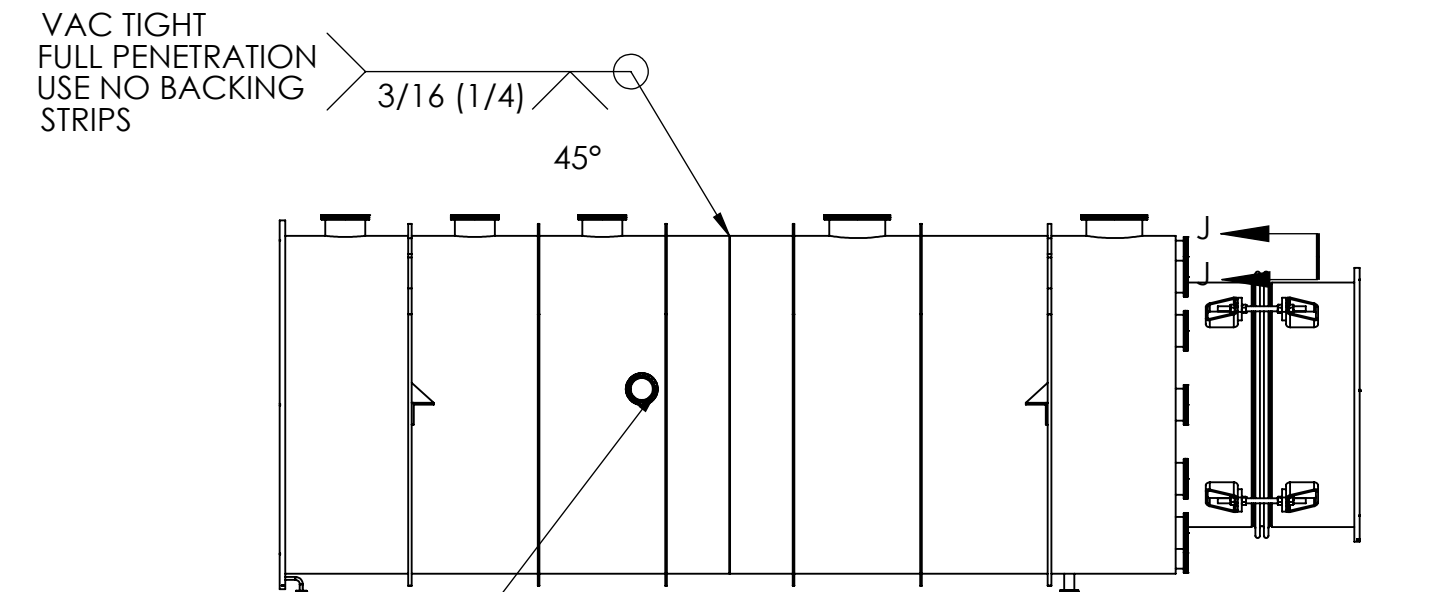
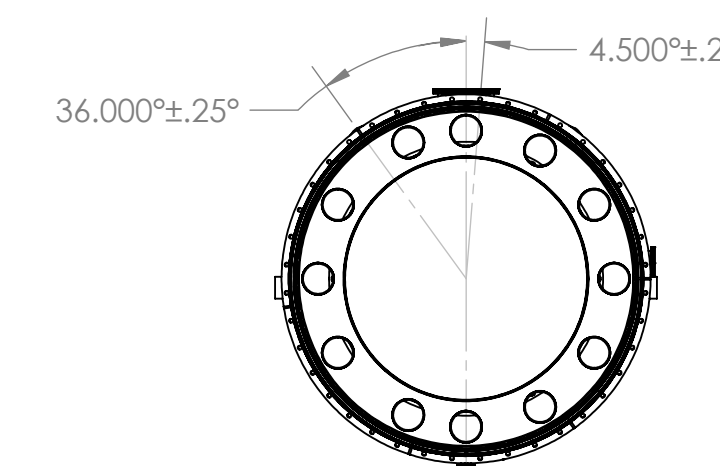
DETAIL B
SCALE 1 : 4



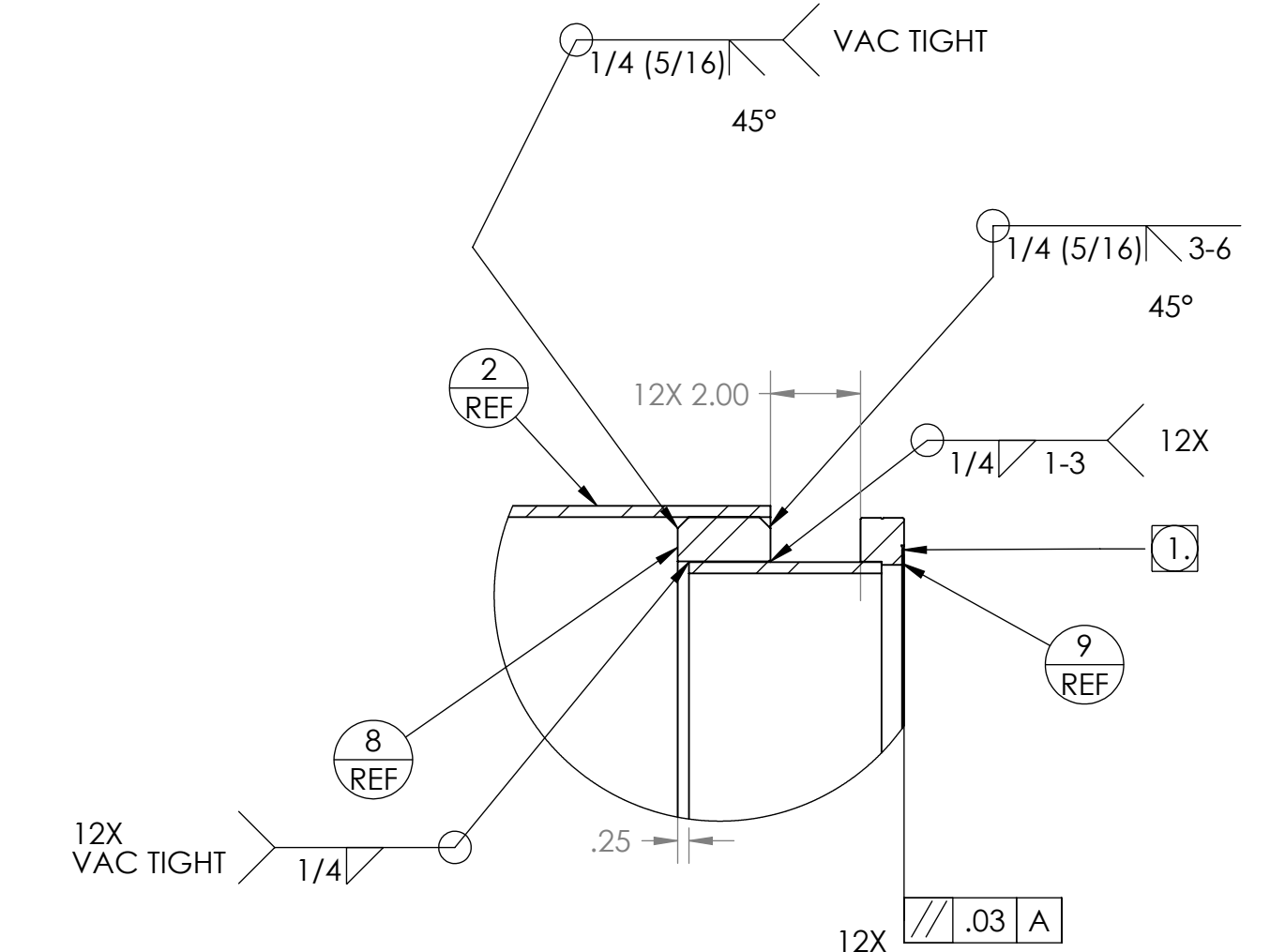
SECTION J-J
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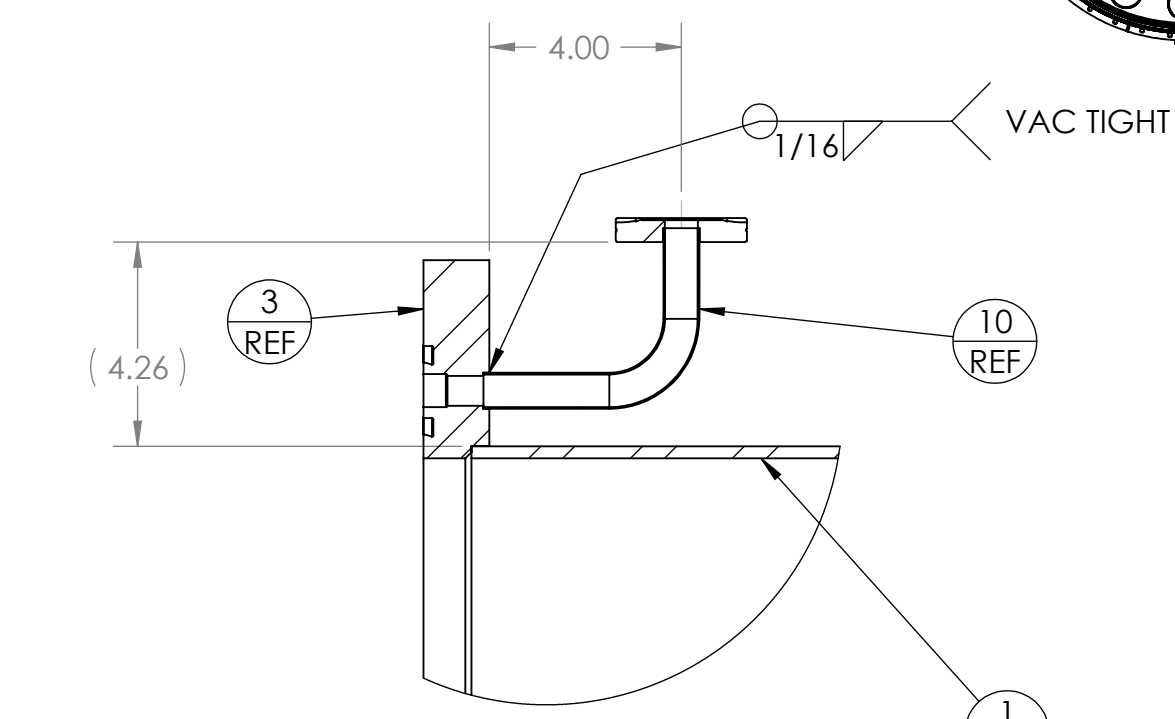
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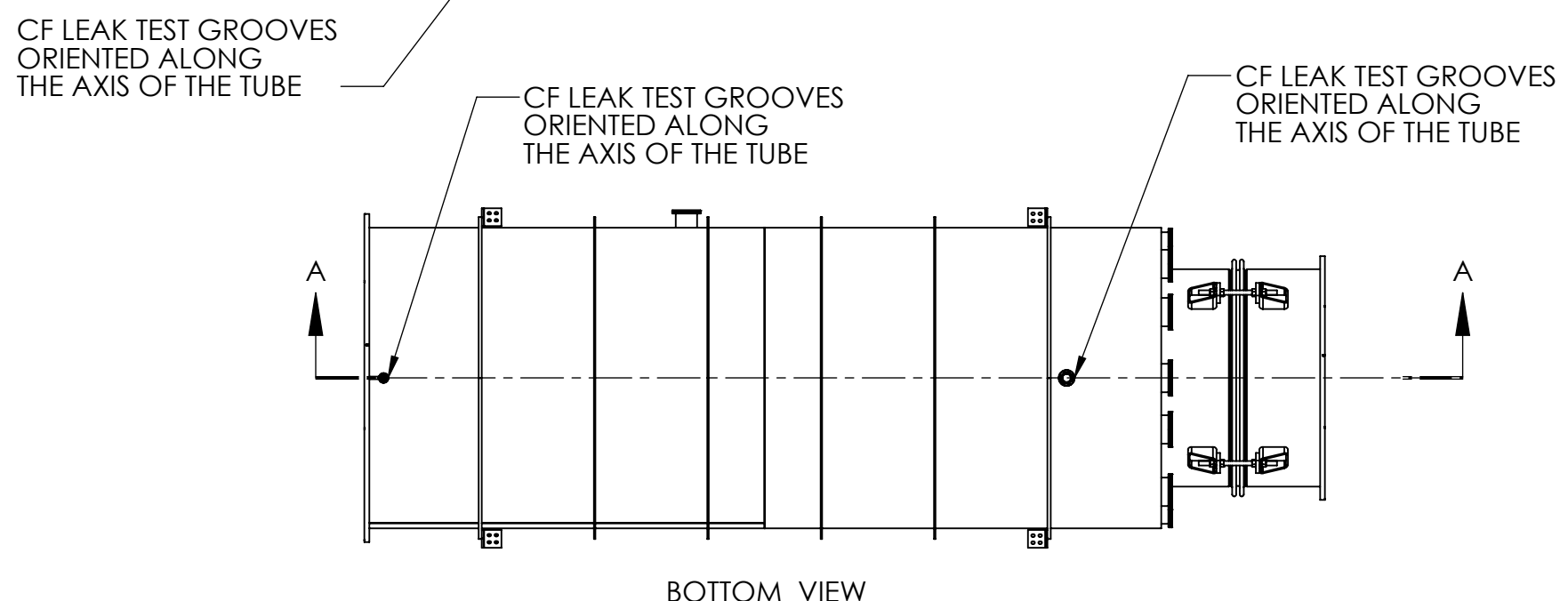
DETAIL D
SCALE 1 : 8
16.50\"/>



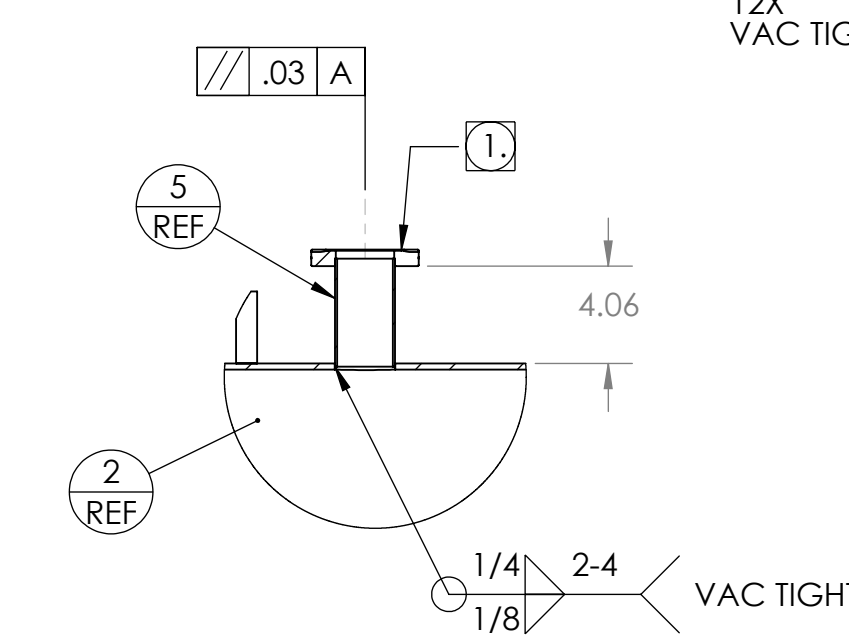
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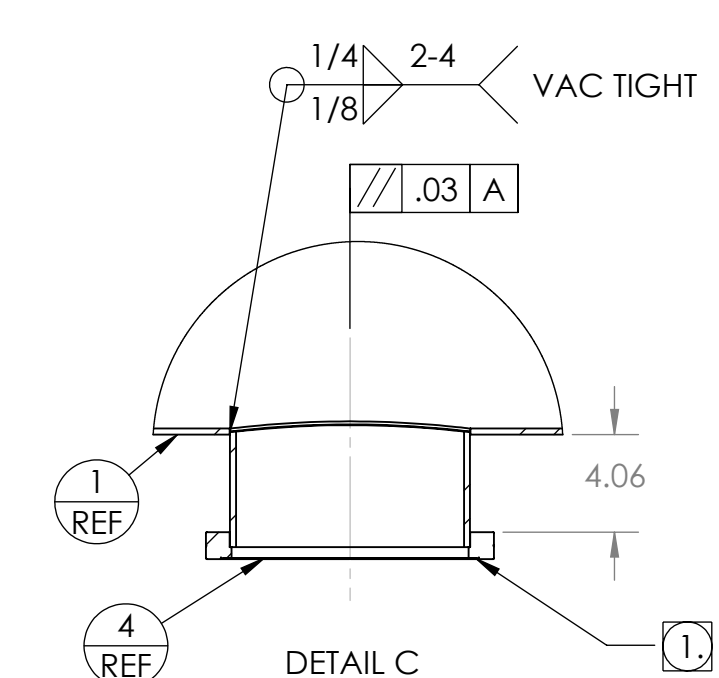
DETAIL H
SCALE 1 : 4



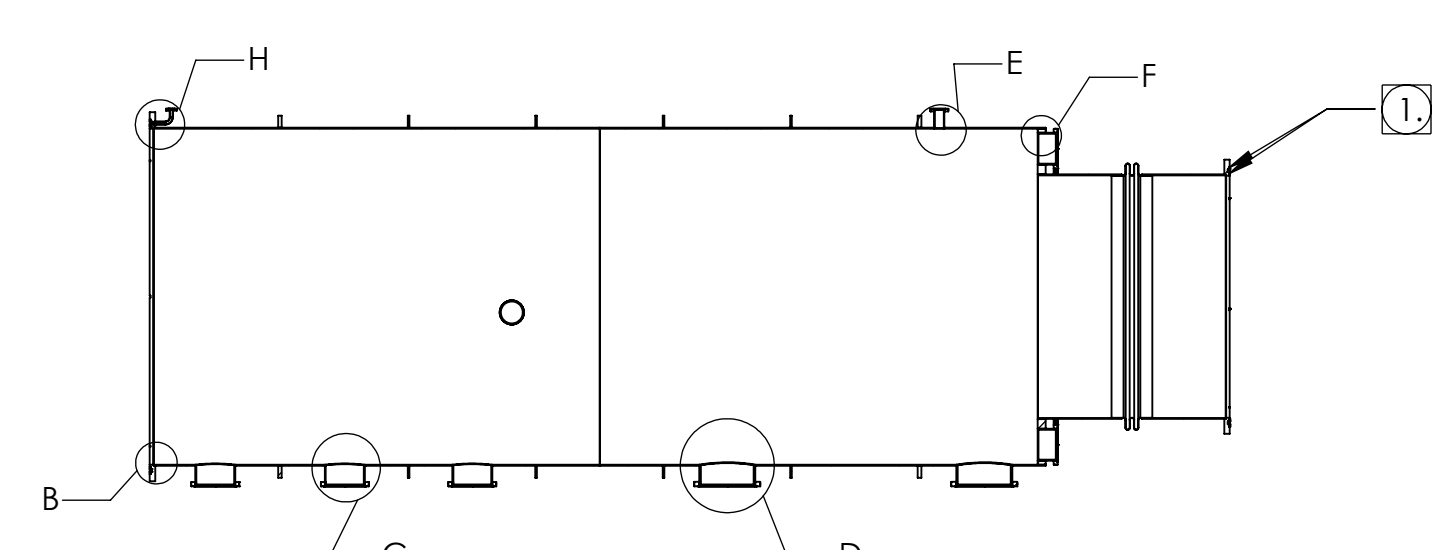
BOTTOM VIEW



DETAIL E
SCALE 1 : 8
4.50\"/>



DETAIL C
SCALE 1 : 8
12\"/>



SECTION A-A

- NOTES:
- VACUUM SEALING SURFACE
 - CLEAN ALL WELD WIRE AND SURFACES WITH CO2 SCRUBBING PRIOR TO WELDING.
 - 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.
 - ALL WELDING TO BE IN ACCORDANCE WITH QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE.
 - AFTER WELDING, COMPLETE COMPONENT TO BE CLEANED PER QP1730-10.
 - COMPONENT TO BE FREE FROM CONTAMINATION PER QP1730-10, CONTAMINATION CONTROL PLAN.
 - COMPONENT CLEANLINESS TO BE TESTED PER QP1750-A3, LIGO CLEANLINESS TESTING.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114201-00S	TUBE, LEFT, MCB TUBE	1
2	114210-00S	TUBE, RIGHT, MCB TUBE	1
3	114212-00S	FLANGE, 84\"/>	
4	114214-00WS	PORT, 12\"/>	
5	114219-00WS	PORT, 4.5\"/>	
6	114216-00WS	PORT, CF, 16.50\"/>	
7	114340-00WS	PORT, 8\"/>	
8	114221-01WS	WELDMENT, NIPPLE, BELLOW, MC TUBE	1
9	114260-00WS	WELDMENT, PORT, 10\"/>	
10	114235-00WS	PORT, PUMPOUT, 2.75\"/>	

MATERIAL: AISI 304/ AISI 304L DUAL CERT PER SA240
 UNLESS OTHERWISE SPECIFIED: WEIGHT: 8016.43 #
 DIMENSIONS ARE IN INCHES

FINISH: XXX ± .005
 ANGULAR: ±10°/30°
 UNFINISHED RADII: R.015
 BREAK EDGES: .010x45°
 REMOVE ALL BURRS

APPROVALS: DATE: 7/9/10
 DRAFTER: MKM2
 CHECKER: RW 7/22/10
 ENGINEER: MKM2 7/9/10

GNB CORPORATION
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 ELK GROVE, CA 95758
 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: FINAL WELDMENT, MCB TUBE
 WAMCB#2, LAMCB#2

DO NOT SCALE DRAWING
 DWG. NO. 114200-01WS
 SCALE: 1:48 SHEET 1 OF 1

REV B