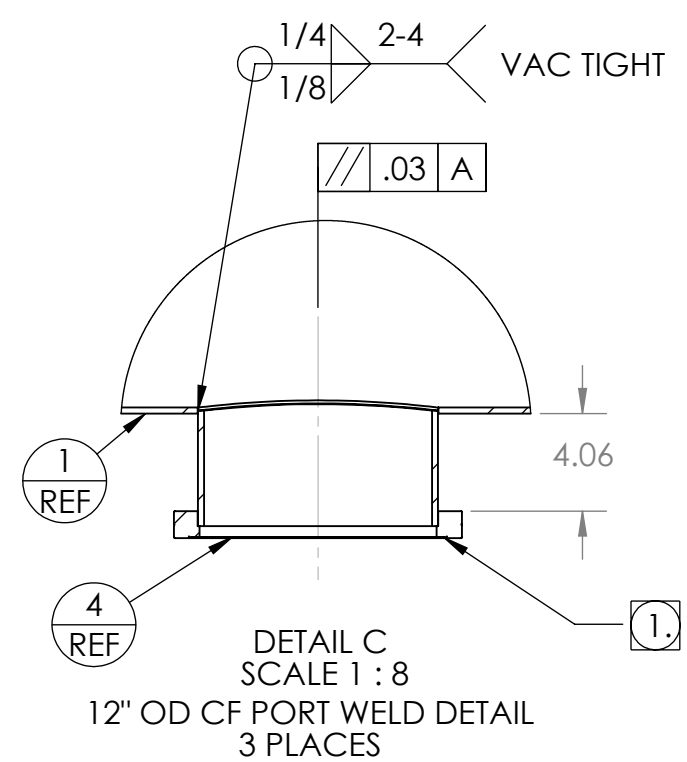
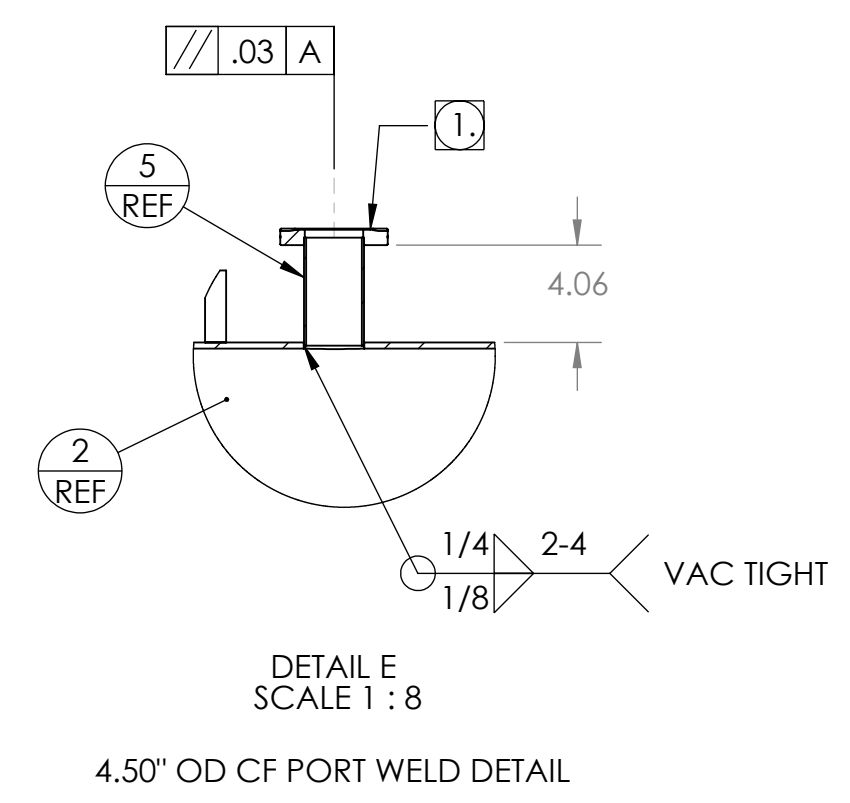
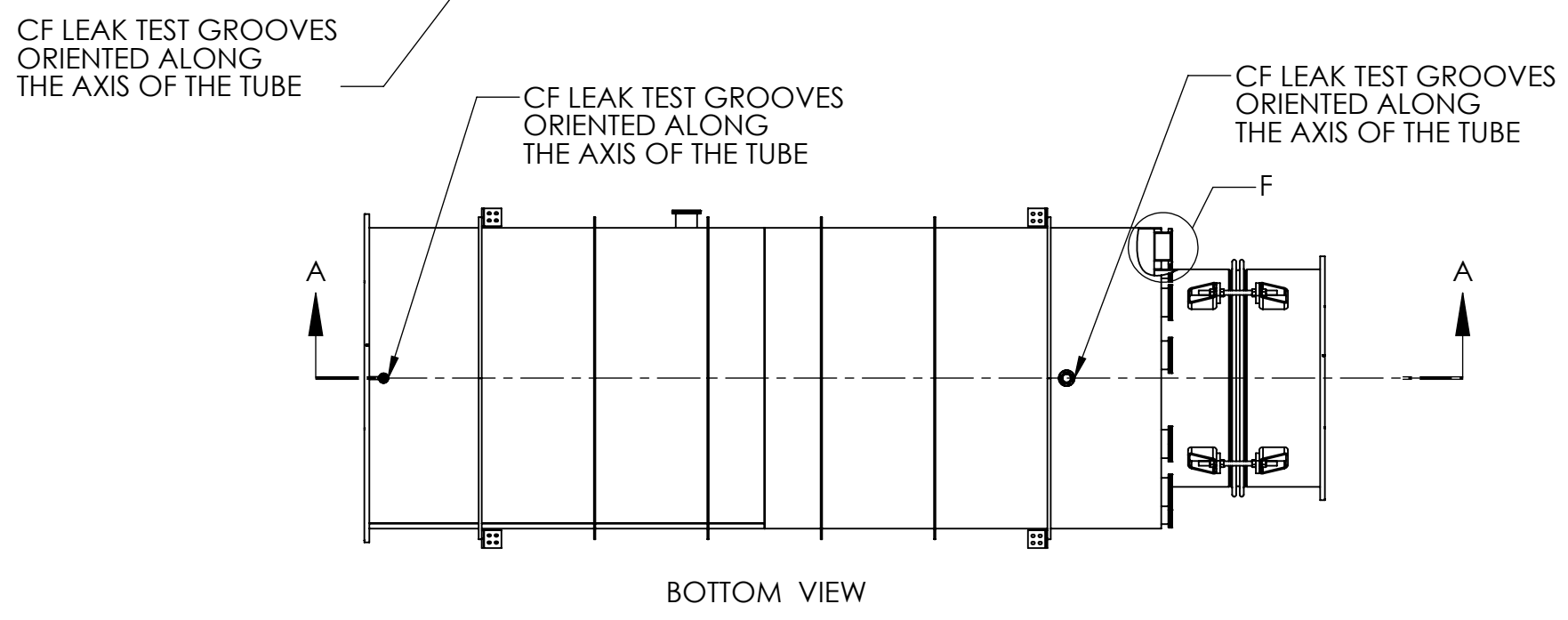
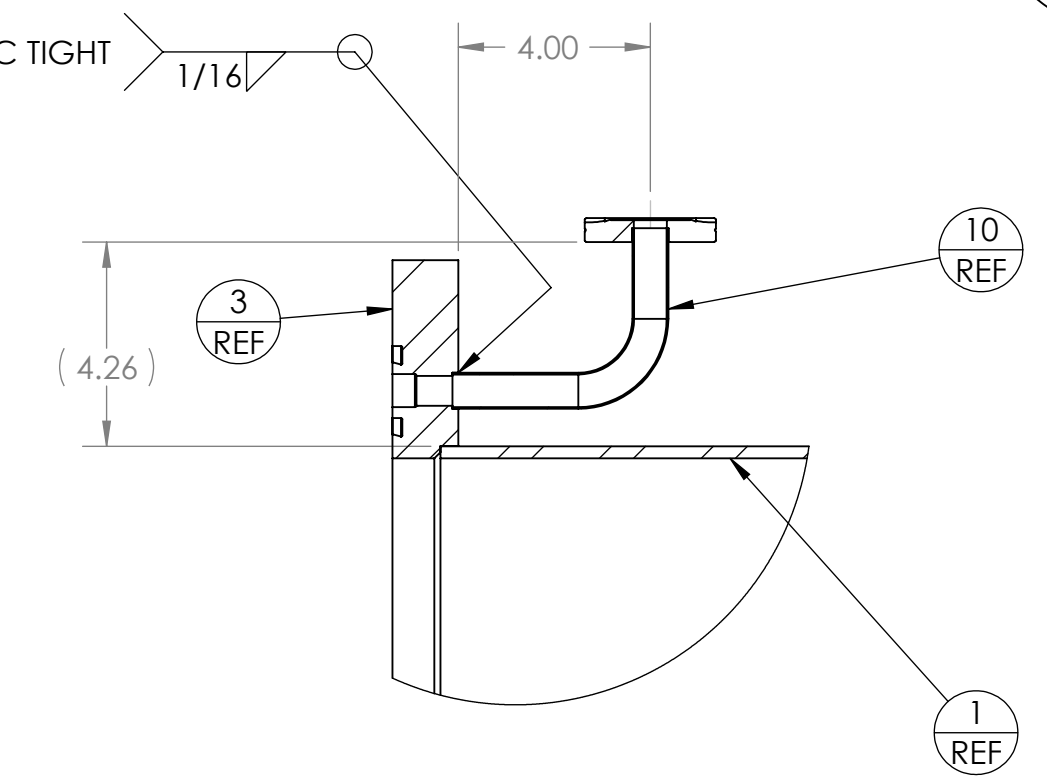
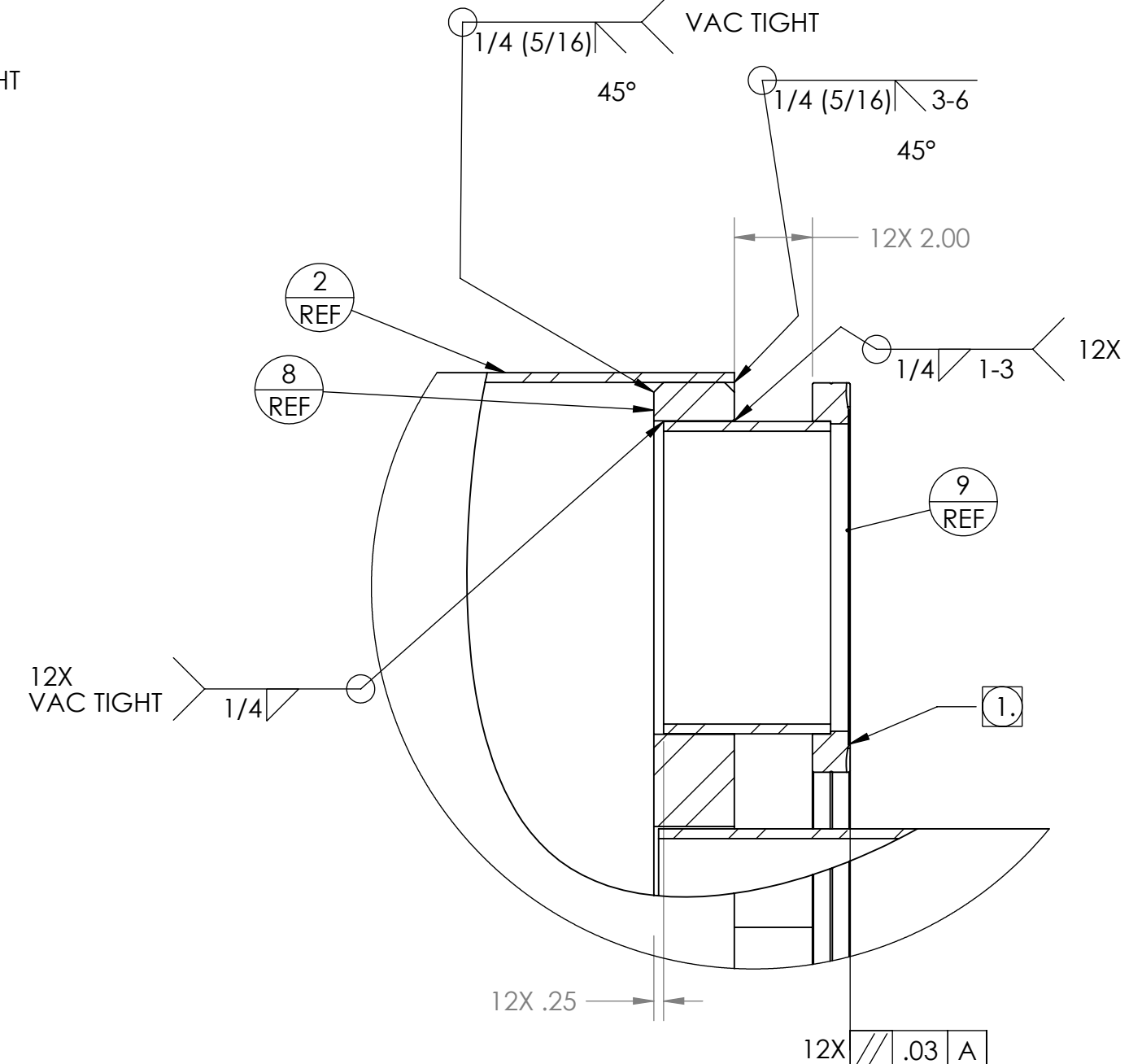
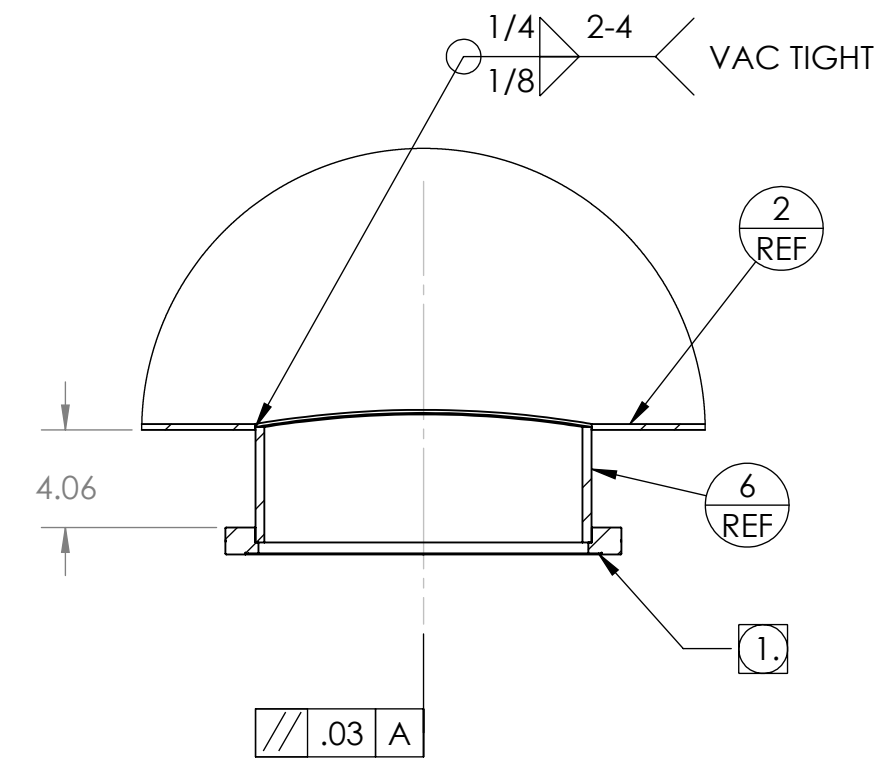
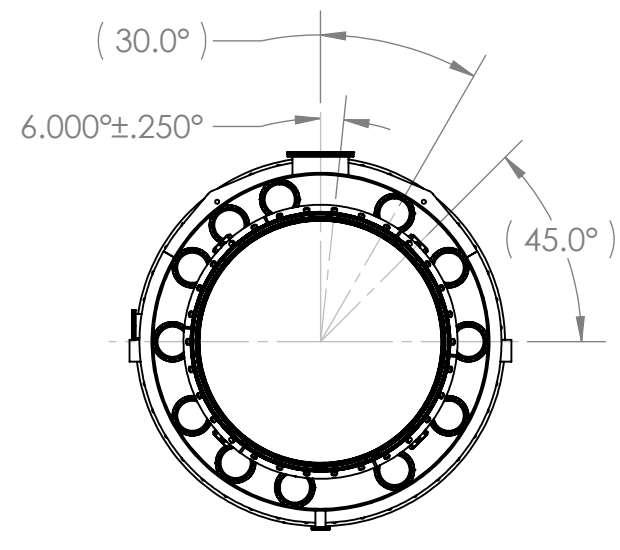
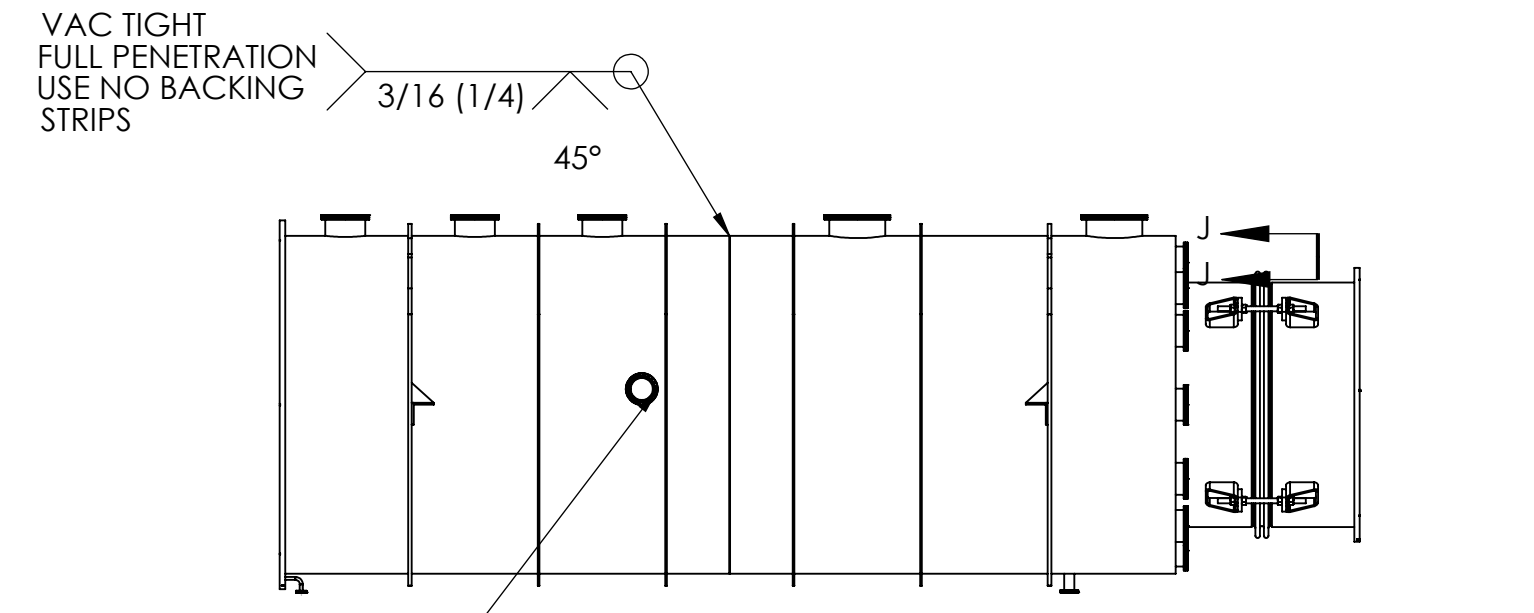
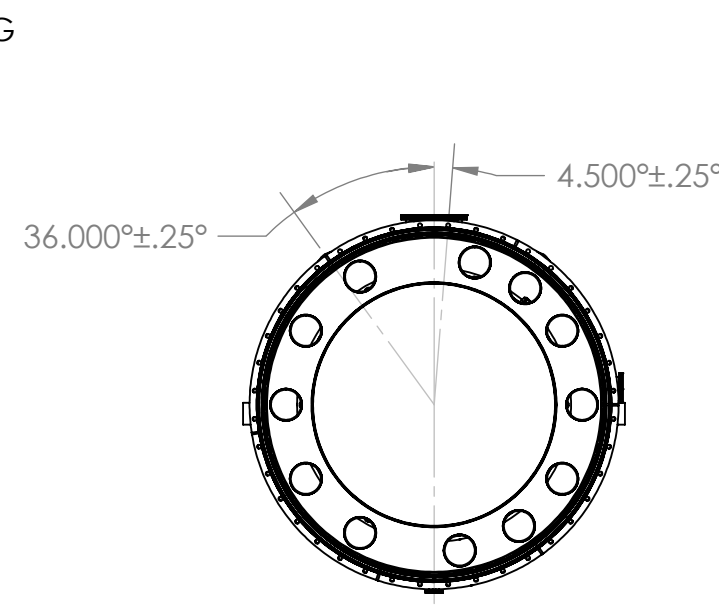
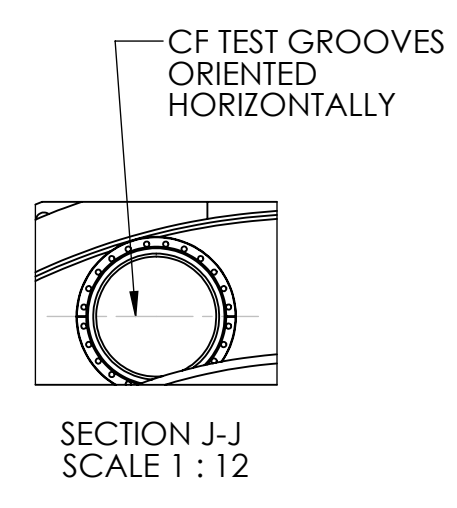
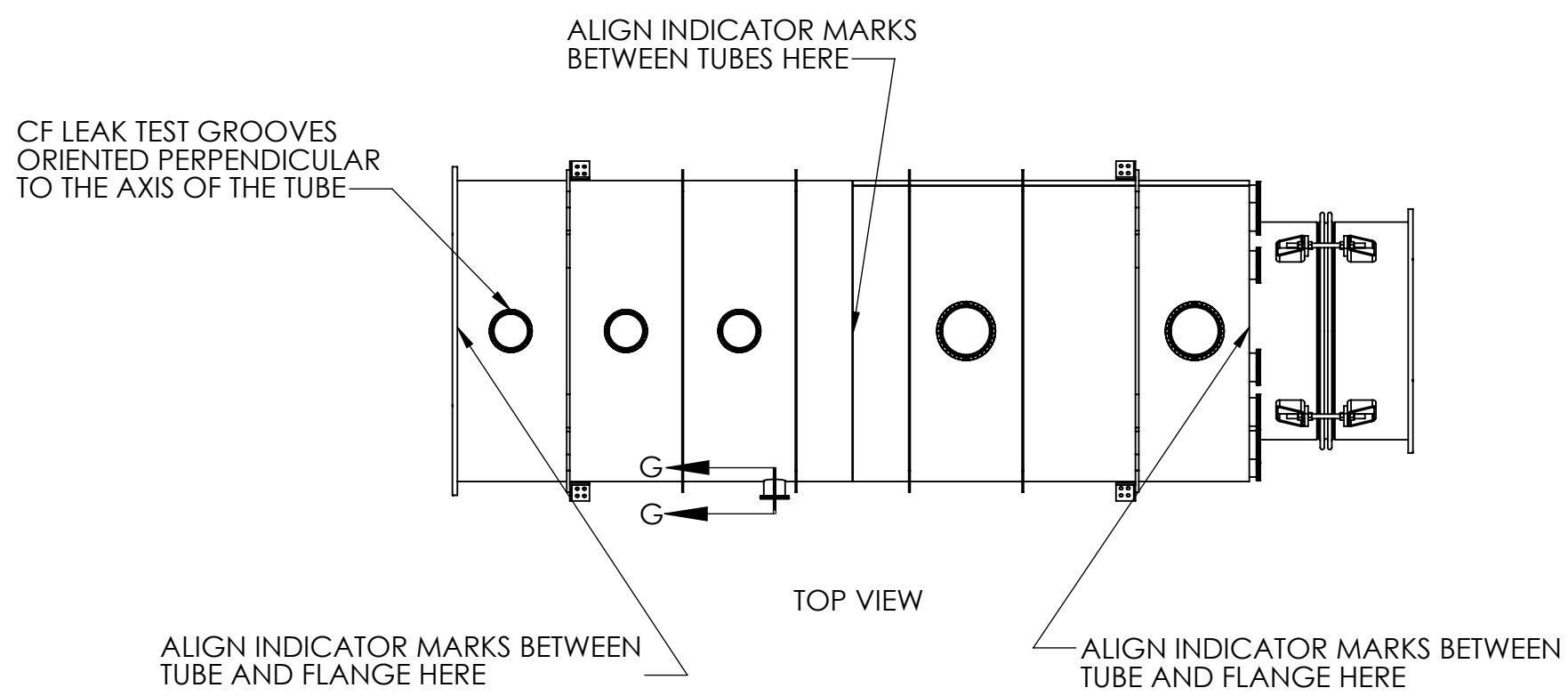
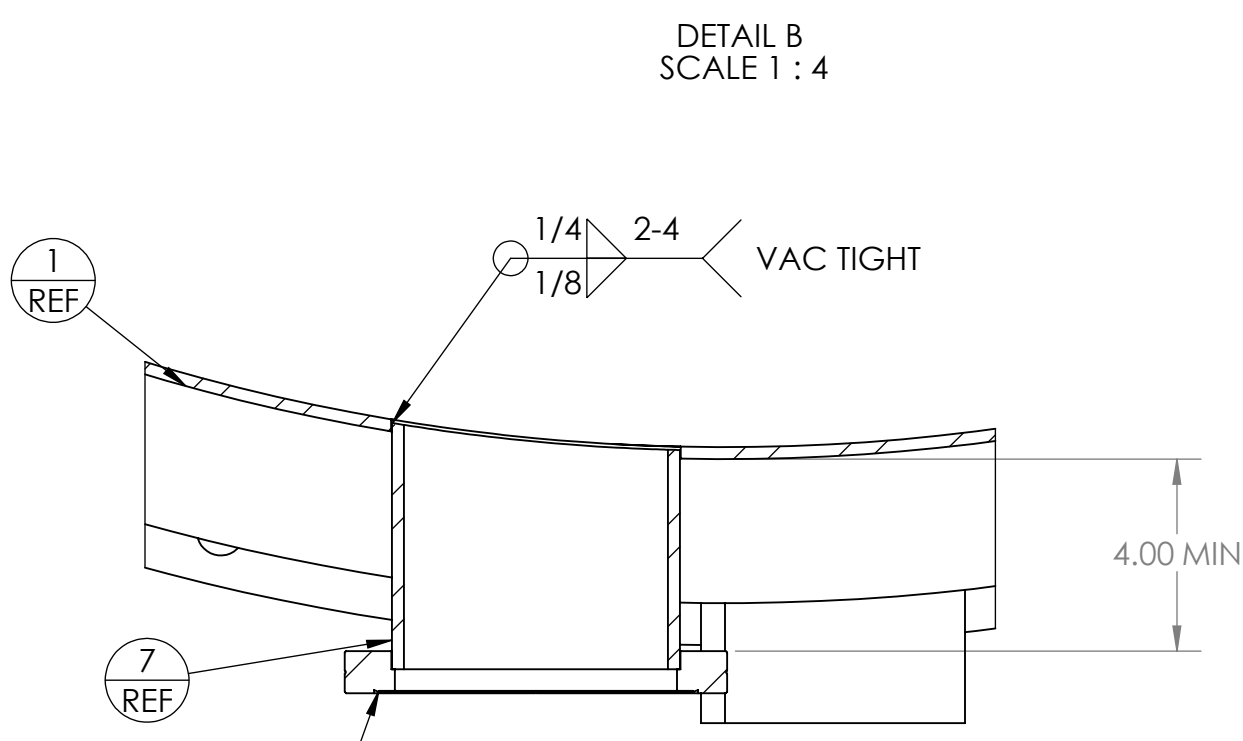
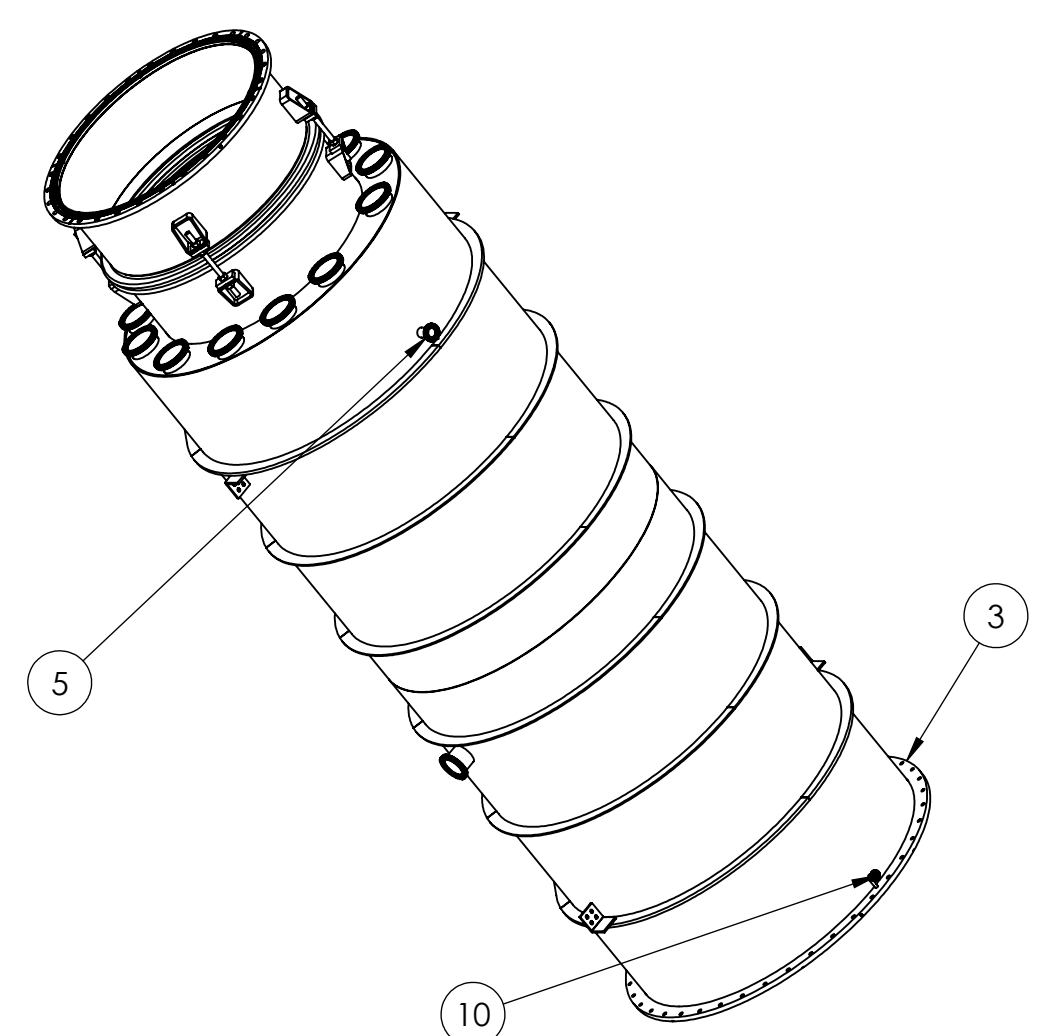
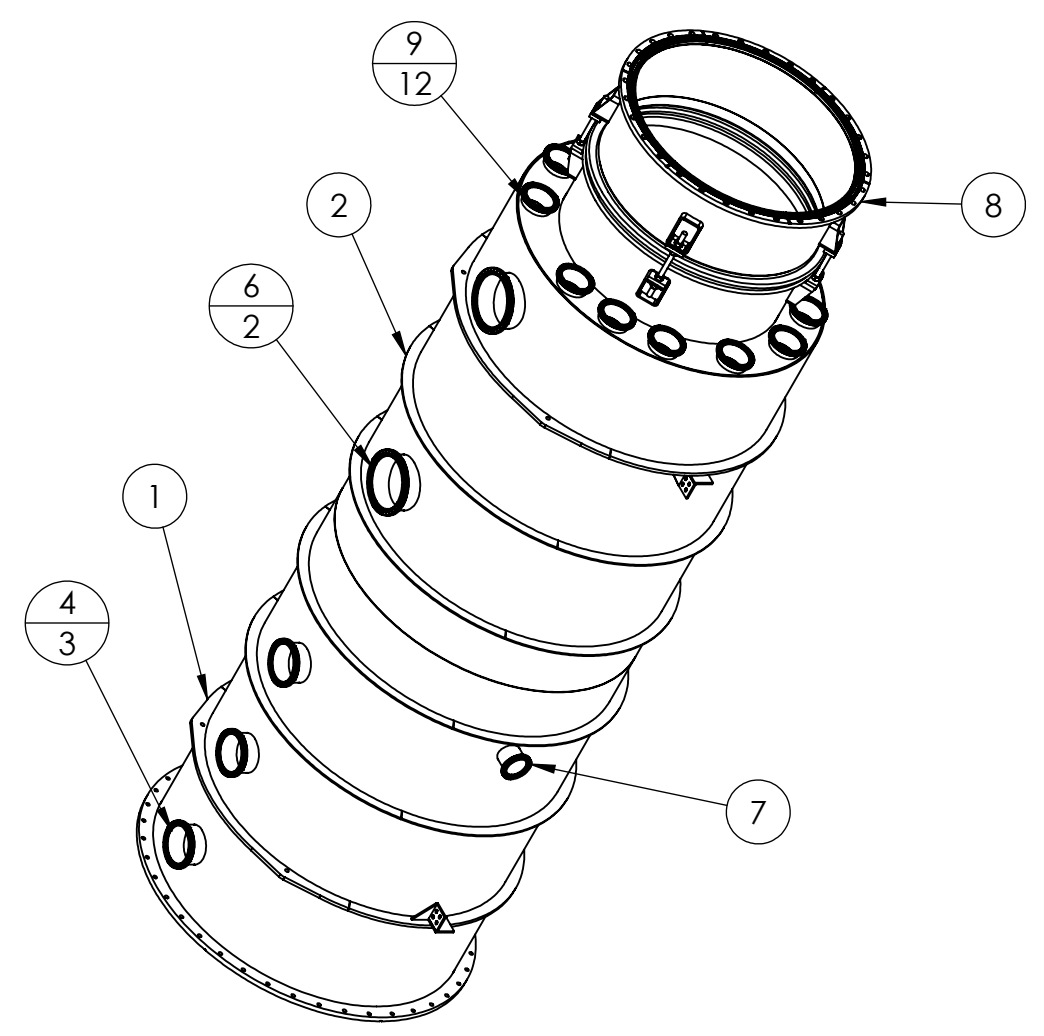
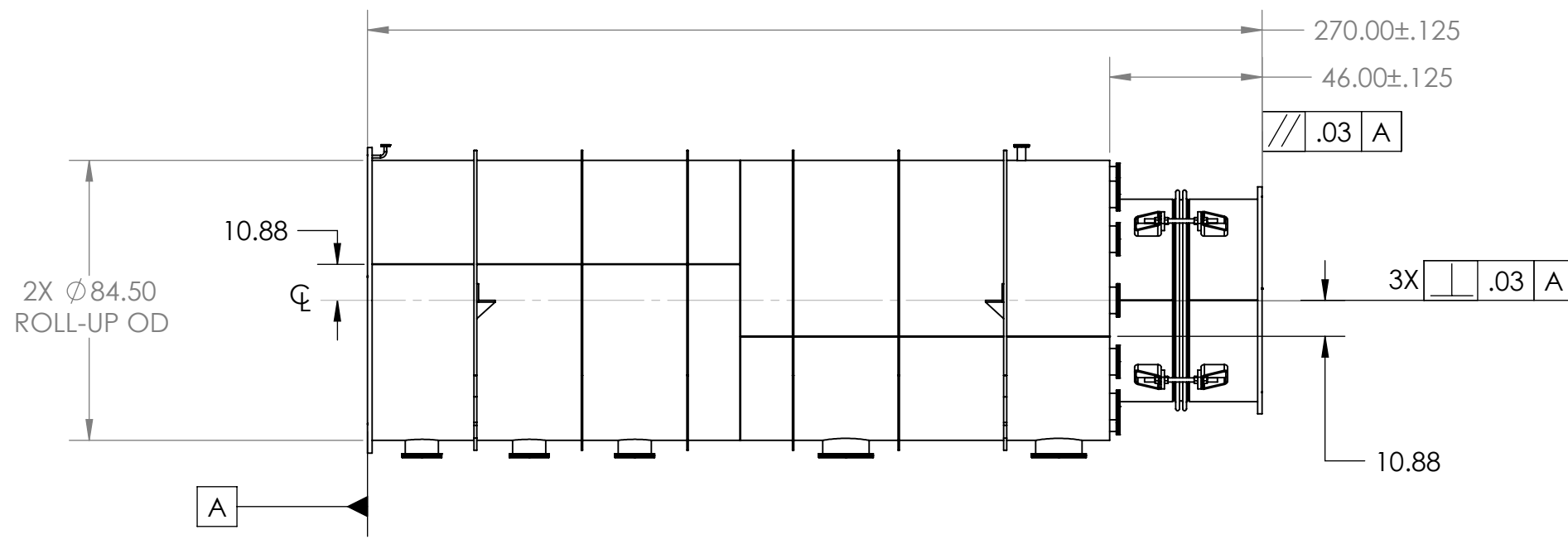
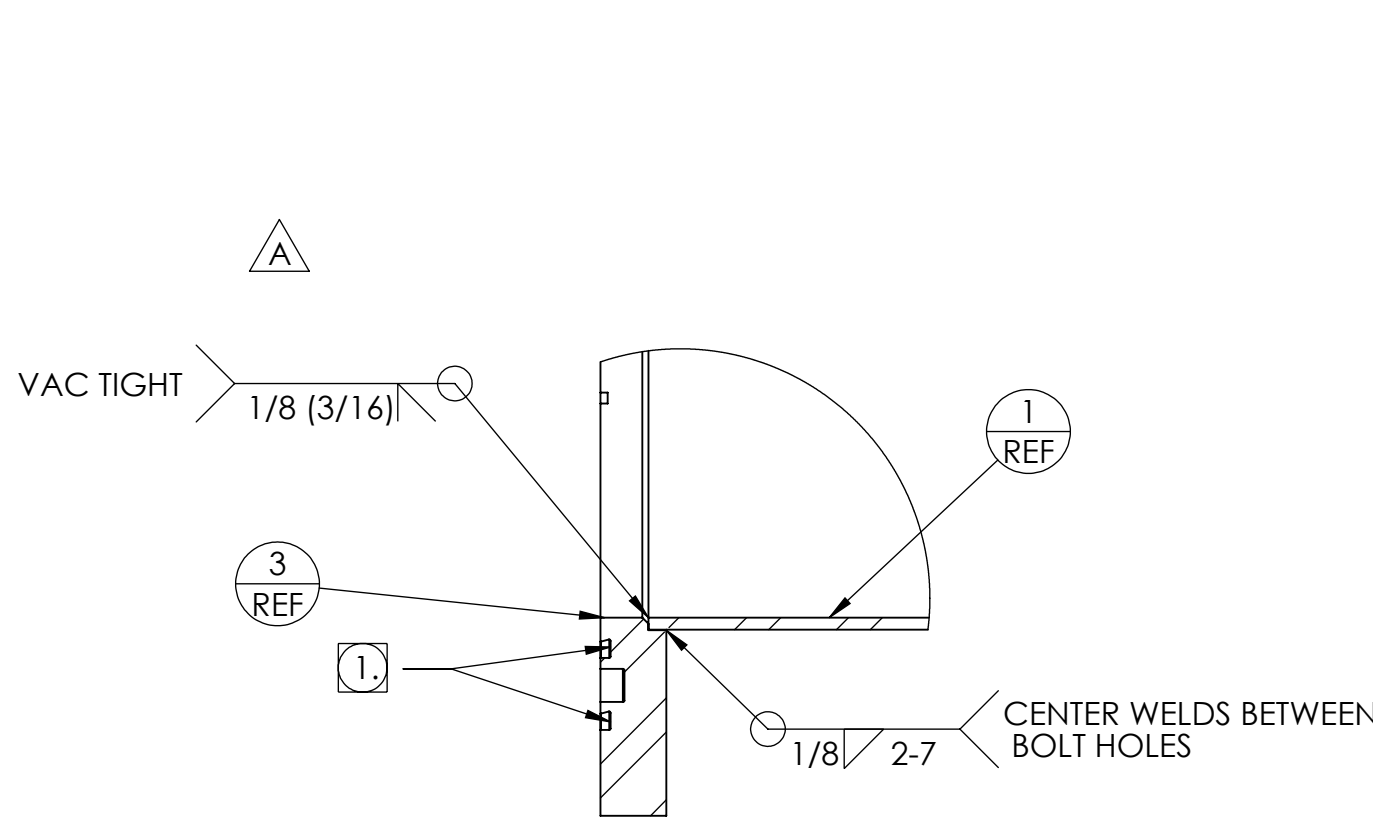


ZONE		REV.	DESCRIPTION	DATE	APPROVED
A			REVISED WELD CALLOUTS	8/11/2010	MKM2
B			RELEASED TO PRODUCTION	8/25/2010	MKM2



- 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"ID, DOUBLE GROOVED	1
4	114214-00WS	PORT, 12" OD CONFLAT, NR. THRU HOLES	3
5	114219-00WS	PORT, 4.5" OD CF, NR. THRU HOLES	1
6	114216-00WS	PORT, CF, 16.50" OD, THICK WALLED	2
7	114340-00WS	PORT, 8" CF, 5.5 LG	1
8	114221-02WS	WELDMENT, NIPPLE, BELLOWS, MC TUBE	1
9	114260-00WS	WELDMENT, PORT, 10" CF	12
10	114235-00WS	PORT, PUMPOUT, 2.75" CF	1

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

TOLERANCES:
 ANGULAR: ±10°/30'
 FINISH: XX±.03
 UNFINISHED RADII: R.015
 BREAK EDGES: .010x45°
 REMOVE ALL BURRS

APPROVALS: DATE: 7/9/10

DRAWER: MKM2
 CHECKER: RW
 ENGINEER: MKM2

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, MCB TUBE WAMCB#3

DO NOT SCALE DRAWING

DWG. NO. 114200-02WS
 SCALE: 1:48 SHEET 1 OF 1

REV B