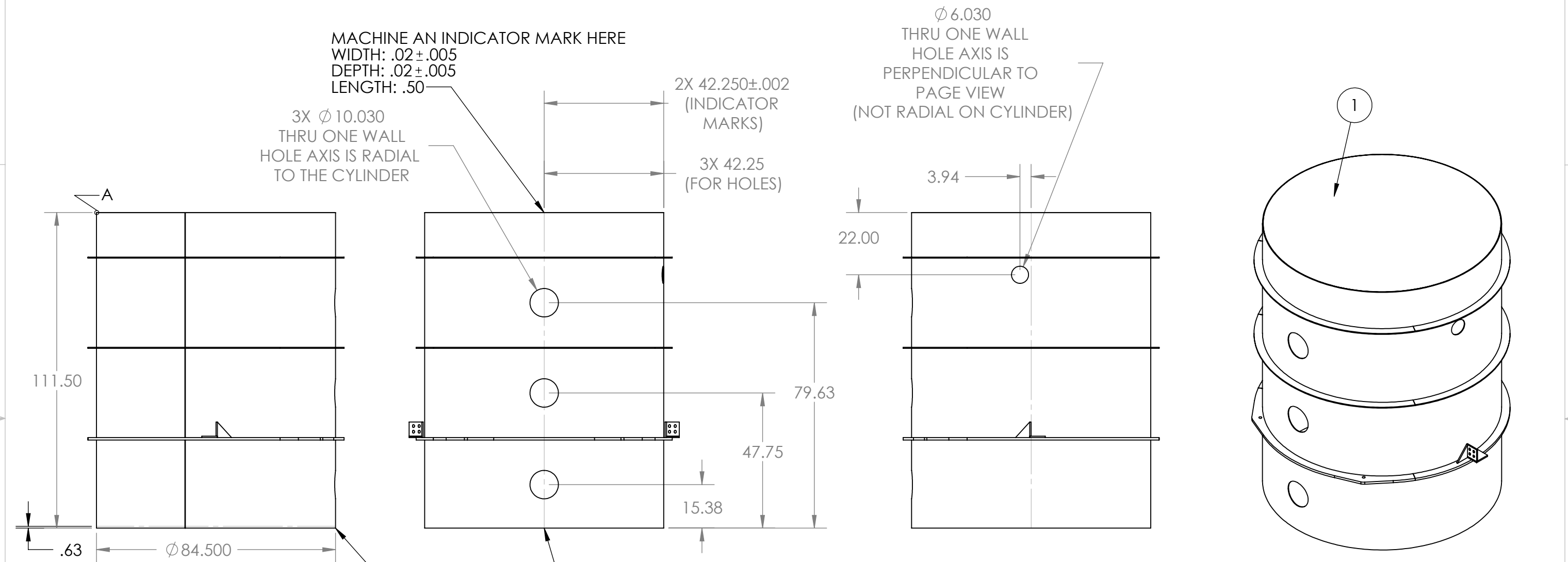


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD PREP	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2



MACHINE AN INDICATOR MARK HERE
 WIDTH: .02 ± .005
 DEPTH: .02 ± .005
 LENGTH: .50

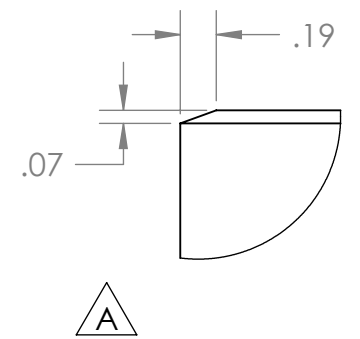
3X Ø 10.030
 THRU ONE WALL
 HOLE AXIS IS RADIAL
 TO THE CYLINDER

2X 42.250 ± .002
 (INDICATOR
 MARKS)
 3X 42.25
 (FOR HOLES)

Ø 6.030
 THRU ONE WALL
 HOLE AXIS IS
 PERPENDICULAR TO
 PAGE VIEW
 (NOT RADIAL ON CYLINDER)

MACHINE THIS
 END FOR TOTAL LENGTH
 AND THIS AREA TO THE
 TIGHTER DIAMETER TOLERANCE

MACHINE AN INDICATOR MARK HERE
 WIDTH: .02 ± .005
 DEPTH: .02 ± .005
 LENGTH: .50



DETAIL A
 SCALE 1 : 1

- NOTES:
- THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
 - NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - WATER LEACHABLE CHLORIDES: 100PPM
 - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - TOTAL SULFUR: 1000PPM
 - DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
 - MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114202-00WS	WELDMENT, TUBE, LEFT, MCB	1

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

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 ANGULAR: ± 0°30'
 .XX ± .01
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

//, □, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 2522.34#	
APPROVALS	DATE
DRAFTER MKM2	7/9/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/9/10

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

TITLE: TUBE, LEFT, MCB TUBE FINAL MACHINING	
DO NOT SCALE DRAWING	DWG. NO. 114201-00S SCALE: 1:35
REV B	SHEET 1 OF 1