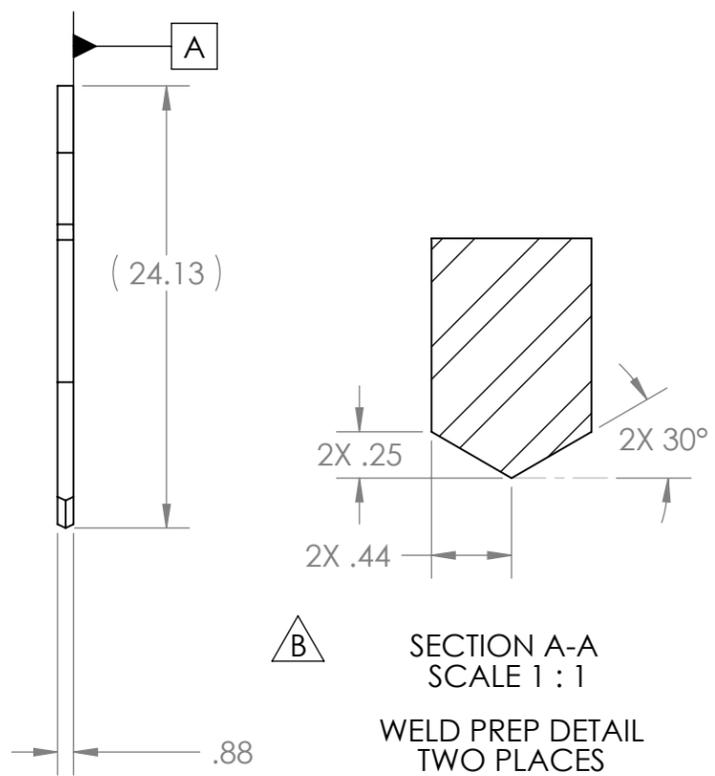
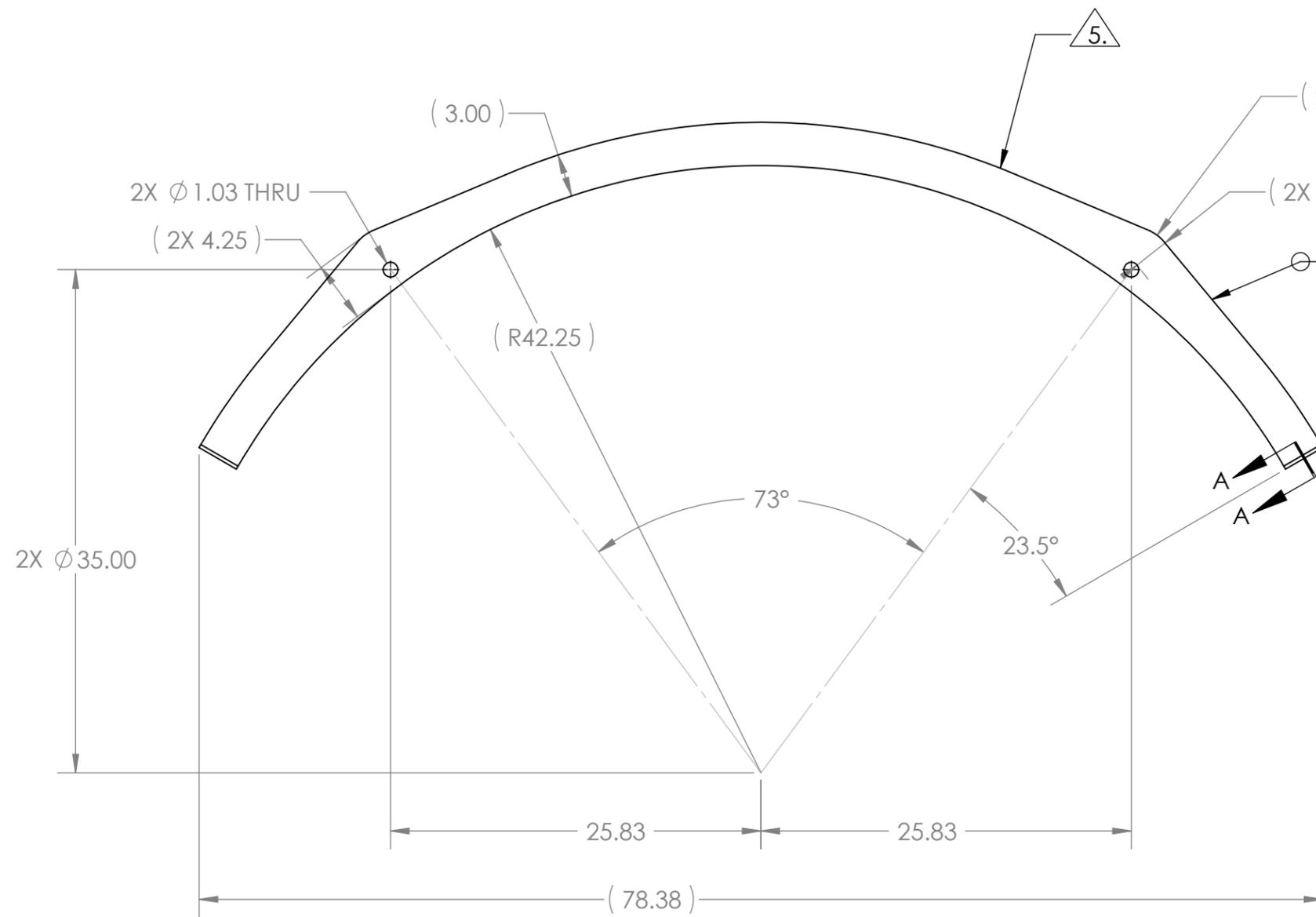


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REMOVED CHAMFERS; RELEASED TO PRODUCTION	8/24/2010	MKM2
	B	REVISED WELD PREP	8/25/2010	MKM2



- 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.

5. USING A VIBRATORY TOOL WITH A TIP WITH A MINIMUM RADIUS OF .005", ENGRAVE THE FOLLOWING ON THE INDICATED SURFACE:

- HEAT NUMBER
- LOT NUMBER
- PART NUMBER

6. BASIC DIMENSIONS TO BE DERIVED FROM CAD FILE.

DESCRIPTION PLT, .88 THK, 25.13 WD, 78.38 LG
 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

FINISH 125
 //, /, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 73.77#

APPROVALS	DATE
DRAFTER MKM2	6/14/10
CHECKER ER	6/14/10
ENGINEER MKM2	6/14/10

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TITLE: **STIFFENER, LIFTING, MC TUBES**

DO NOT SCALE DRAWING	B DWG. NO. 114205-00S	REV B
SCALE: 1:10	SHEET 1 OF 1	