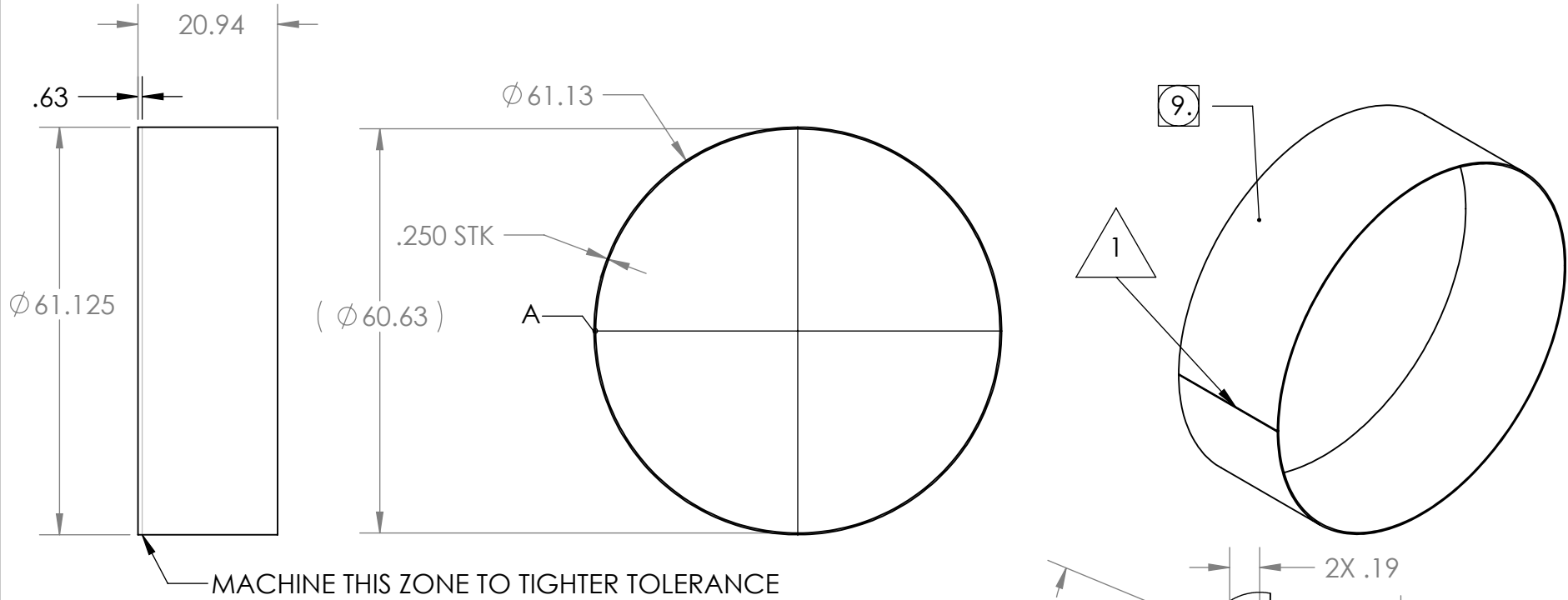


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ZONE REV.		DESCRIPTION	DATE	APPROVED
A		ADDED COUPON NOTE, TIGHTENED GD&T PER CUSTOMER REQUEST	7/8/2010	MKM2
B		REVISED WELD PREP	8/11/2010	MKM2
C		REVISED NOTES, ADDED MACHING NOTE	8/12/2010	MKM2
D		REVISED WELD PREP PER VENDOR CAPABILITY	8/13/2010	MKM2
E		RELEASED TO PRODUCTION	8/20/2010	MKM2



MACHINE THIS ZONE TO TIGHTER TOLERANCE

DETAIL A
 SCALE 1 : 1
 WELD PREP DETAIL

NOTES

1. SEAM TO ARRIVE WITH WELD PREPS IN PLACE.
2. TACK ROLL UP WITH CERTIFIED ROD ONLY (PROVIDED BY GNB).
3. CARBON STEEL ROLLERS SHALL BE COVERED WITH STAINLESS STEEL PRIOR TO ROLLING TO PREVENT CONTAMINATION.
4. SEAM EDGES SHALL BE PREWORKED TO ENSURE ROUNDNESS OF THE FINAL CYLINDER.
5. ROLL-UP PLATES MAY HAVE SHEARED EDGES ONLY IF THE SHEARED EDGES ARE THEN RE-CUT WITH A TUNGSTEN CARBIDE TOOL TO REMOVE CONTAMINATION BY THE ROLLING VENDOR. ACCEPTABLE CUTTING METHODS ARE PLASMA, LASER, WATER JET, OR CARBIDE CUTTING.
6. FINAL BEVELS TO BE MADE WITH TUNGSTEN CARBIDE TOOLS ONLY.
7. PLATES AND ROLL-UPS MUST REMAIN PROTECTED FROM CONTACT WITH CARBON STEEL OR OTHER SOURCES OF CONTAMINATION DURING MOVING, WORKING, AND STORAGE. COVER CARBON STEEL WITH SST OR HEAVY PAPER, AND KEEP PLATES AND ROLL-UPS WRAPPED OR COVERED AT ALL TIMES WHEN NOT BEING PROCESSED.
8. ALL MATERIAL TO BE MANUFACTURED IN THE UNITED STATES.
9. MACHINE THIS AREA TO THE SPECIFIED DIMENSIONS
10. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
11. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - a. WATER LEACHABLE CHLORIDES: 100PPM
 - b. TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - c. TOTAL SULFUR: 1000PPM
12. A 2"X12" COUPON OF MATERIAL FROM THE SAME LOT OF MATERIAL MUST BE PROVIDED TO GNB
13. ETCH HEAT LOT NUMBER AND PART NUMBER WITH A VIBRATORY TOOL WITH A MINIMUM TIP RADIUS OF .005"

DESCRIPTION: ROLL-UP, .25 WALL, 60.63 ID, 20.94 LG		 SCIENTIFIC AND INDUSTRIAL EQUIPMENT 3200 DWIGHT RD, SUITE 100 ELK GROVE, CA 95758 916-395-3003 FAX: 916-395-3363 WWW.GNBVALVES.COM															
MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA-240																	
UNLESS OTHERWISE SPECIFIED:	WEIGHT: 289.23 #	<table border="1"> <thead> <tr> <th colspan="3">APPROVALS</th> </tr> <tr> <th>NAME</th> <th>DATE</th> <th></th> </tr> </thead> <tbody> <tr> <td>DRAFTER MKM2</td> <td>6/14/10</td> <td></td> </tr> <tr> <td>CHECKER RW</td> <td>6/14/10</td> <td></td> </tr> <tr> <td>ENGINEER MKM2</td> <td>6/14/10</td> <td></td> </tr> </tbody> </table>	APPROVALS			NAME	DATE		DRAFTER MKM2	6/14/10		CHECKER RW	6/14/10		ENGINEER MKM2	6/14/10	
APPROVALS																	
NAME	DATE																
DRAFTER MKM2	6/14/10																
CHECKER RW	6/14/10																
ENGINEER MKM2	6/14/10																
DIMENSIONS ARE IN INCHES																	
TOLERANCES: FINISH																	
ANGULAR: ± 0°30'	125																
.XX ± .03																	
.XXX ± .005																	
UNSPECIFIED FILLETS: R.015																	
BREAK EDGES .010 x 45°																	
REMOVE ALL BURRS																	
// ◊ ⊥ WITHIN .03																	
THIRD ANGLE PROJECTION																	
DO NOT SCALE DRAWING		DWG. NO. A 114224-00S SCALE: 1:24															
		SHEET 1 OF 1 REV E															