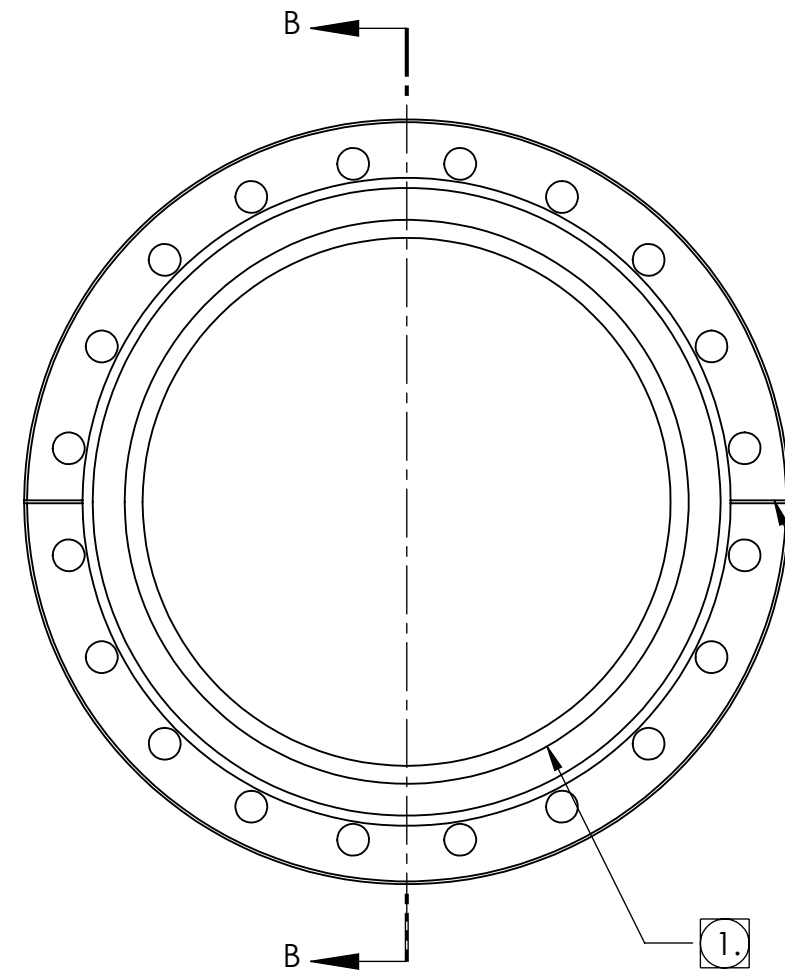
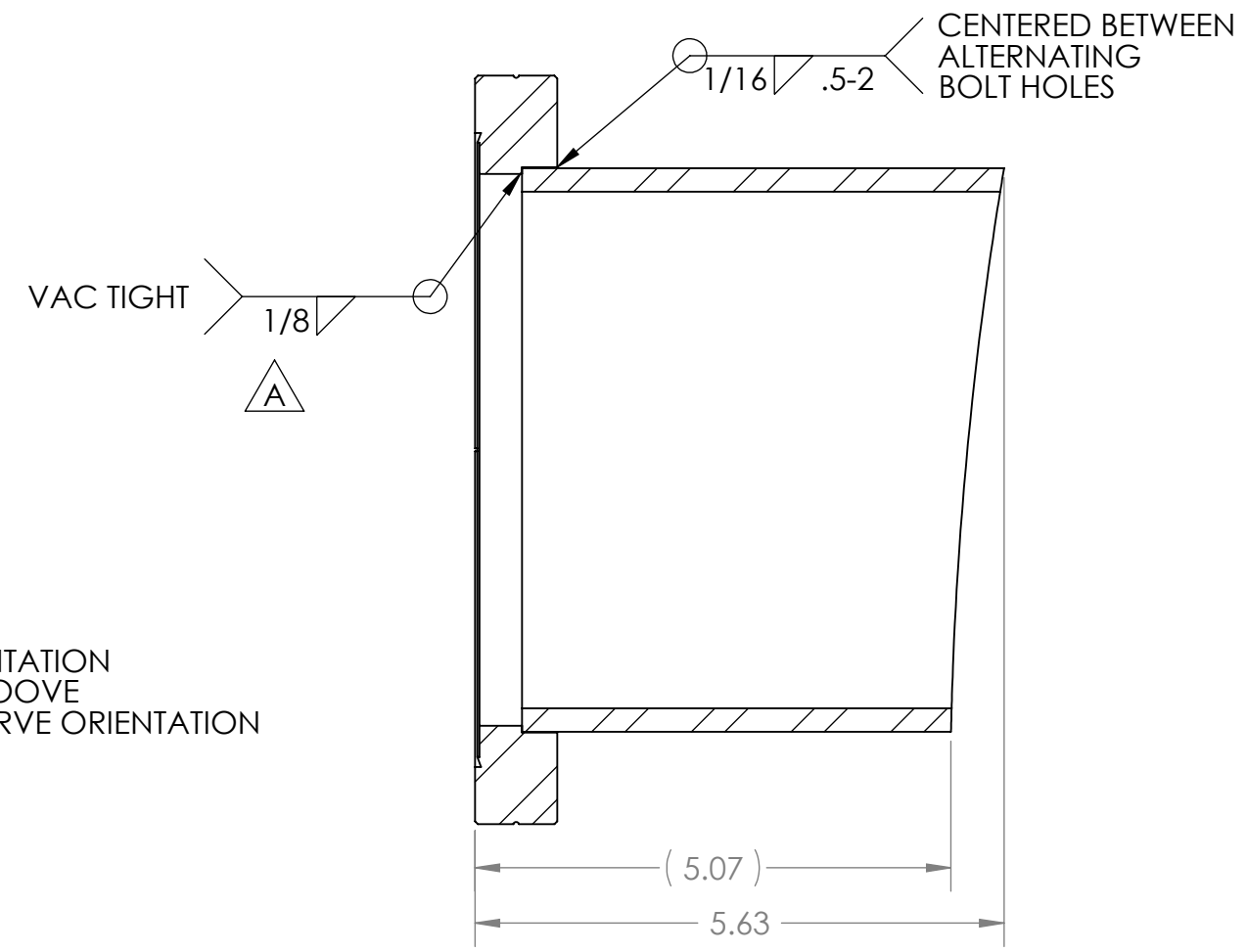


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REDUCED WELD SIZE	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2



NOTE ORIENTATION
 OF TEST GROOVE
 TO TUBE CURVE ORIENTATION



SECTION B-B

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	800-600N	(NORCAL) FLANGE, CF, 8" OD, THRU HOLE, NR	1
2	114432-00S	TUBE, 8" CF PORT, MCB TUBE	1

NOTES:

- 1. VACUUM SEALING SURFACE
- 2. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
- 3. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
- 4. CLEAN WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
- 5. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
- 6. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
- 7. ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
- 8. NO POST WELD HEAT TREATMENT IS REQUIRED

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 125
 ANGULAR: ± 1°
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

WEIGHT: 11.29#

APPROVALS	DATE
DRAFTER MKM2	7/23/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/23/10

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING

SCALE: 1:2

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 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: PORT, 8" CF, 5.5 LG

DWG. NO. 114340-00WS
 SHEET 1 OF 1

REV B