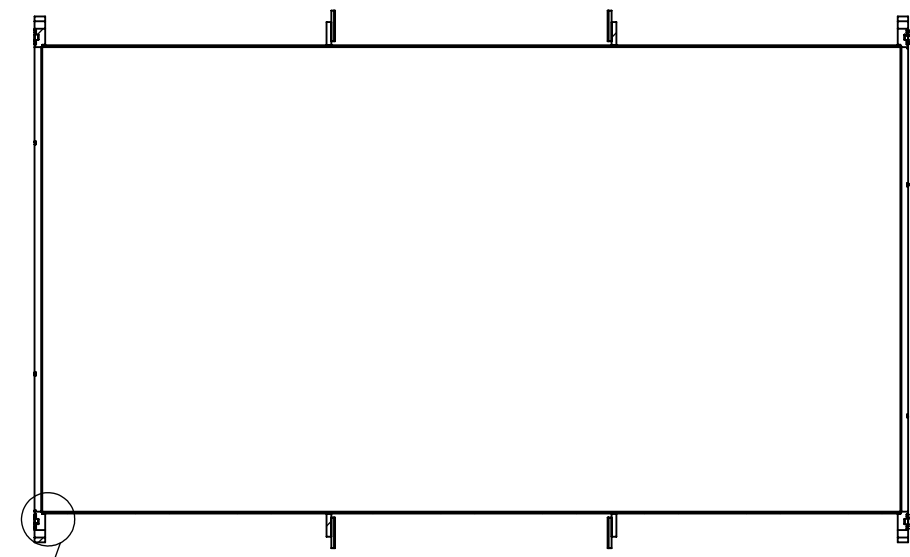
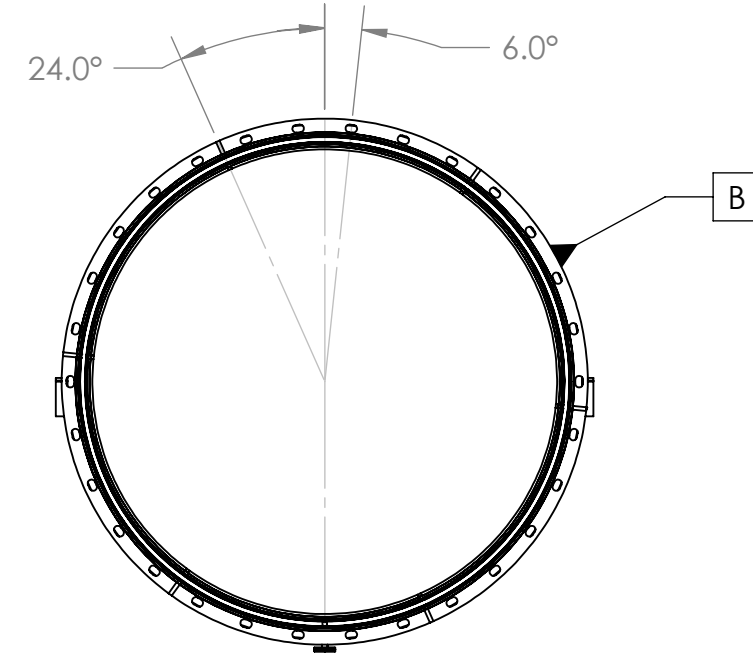
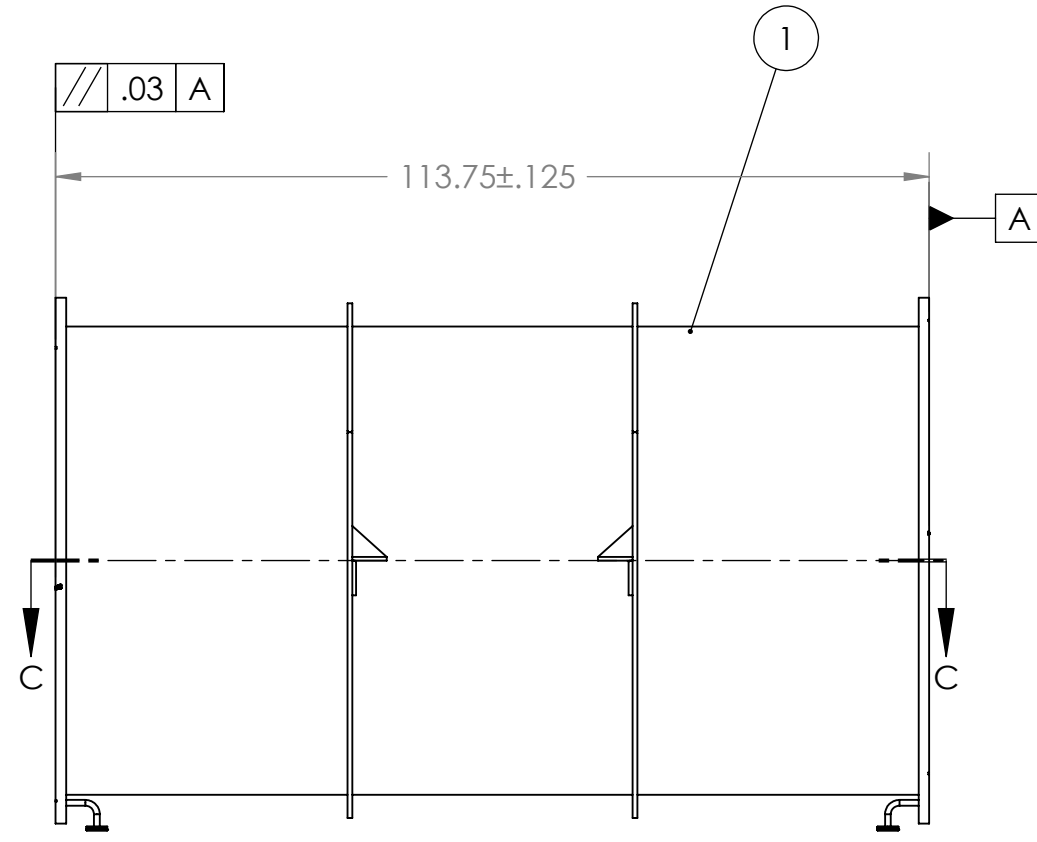
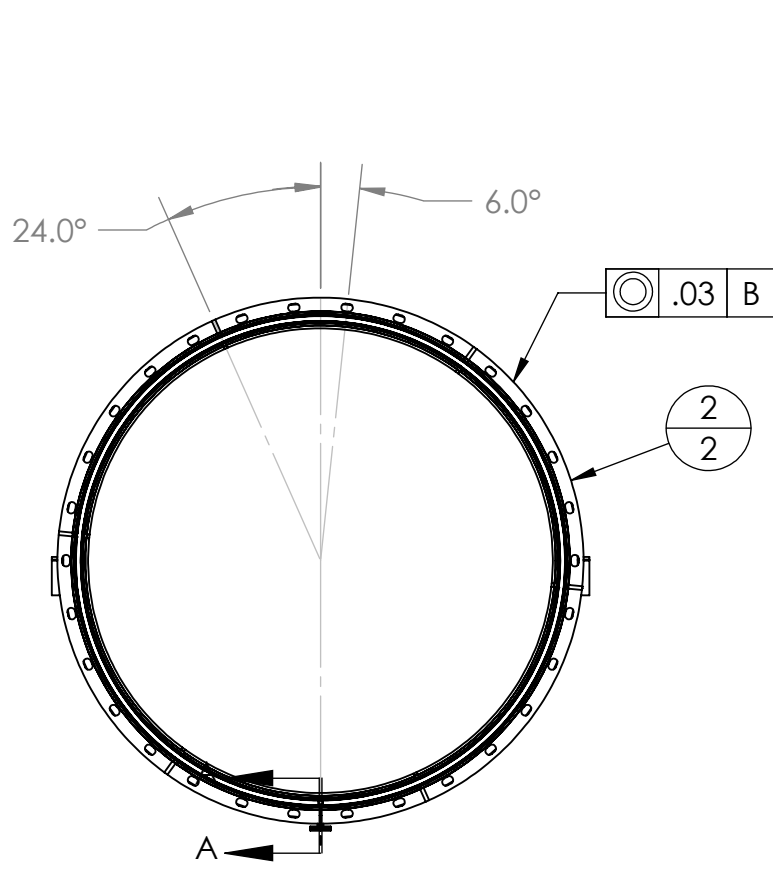
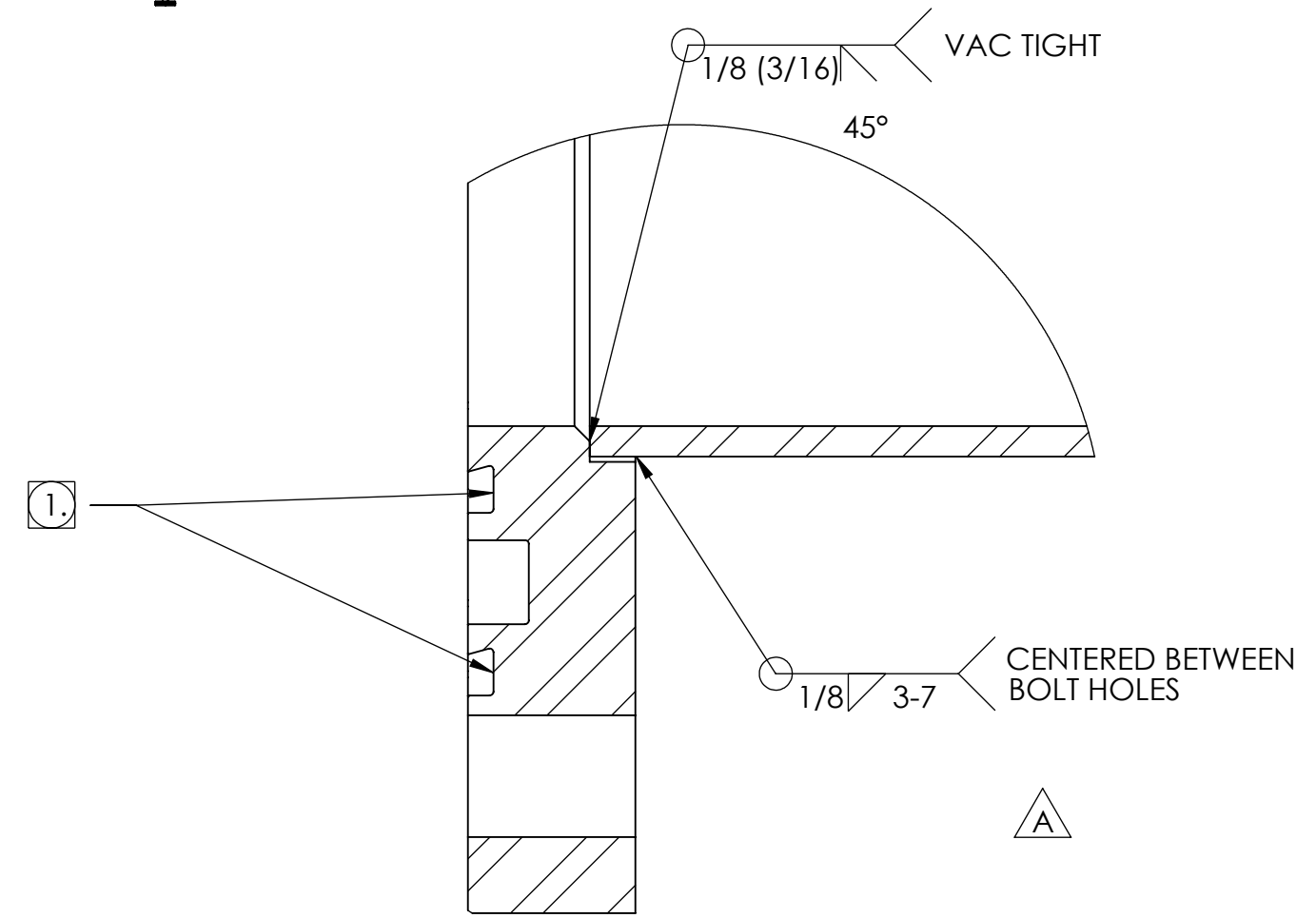


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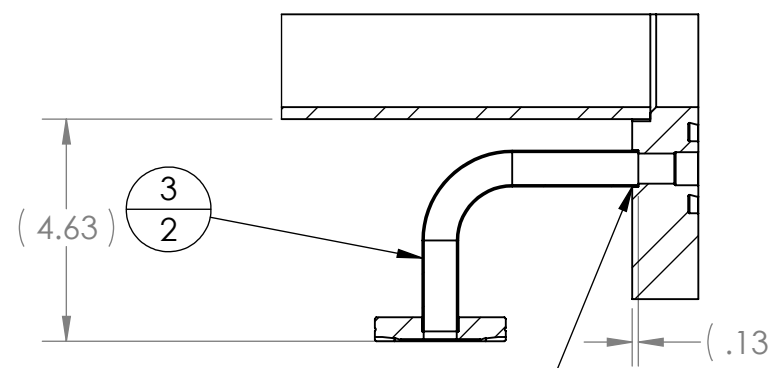
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALL-OUT	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/23/2010	MKM2



SECTION C-C



DETAIL D
 SCALE 1 : 1.5
 FLANGE WELD DETAIL
 TWO PLACES



SECTION A-A
 SCALE 1 : 4
 PUMP OUT PORT
 2 PLACES

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

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114270-00S	WELD PREP, TUBE,	1
2	114268-00S	FLANGE, MIDSTATION SPOOL	2
3	114235-00WS	PORT, PUMPOUT, 2.75" CF	2

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

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 125
 ANGULAR: ± 0°30'
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS
 // .1 WITHIN .03

APPROVALS	DATE
DRAFTER MKM2	7/2/10
CHECKER RW	7/9/10
ENGINEER MKM2	7/2/10

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 www.gnbvalves.com

TITLE: WELDMENT, FINAL, MIDSTATION SPOOL

THIRD ANGLE PROJECTION

DO NOT SCALE DRAWING	DWG. NO. 114263-00WS	REV B
SCALE: 1:25	SHEET 1 OF 1	