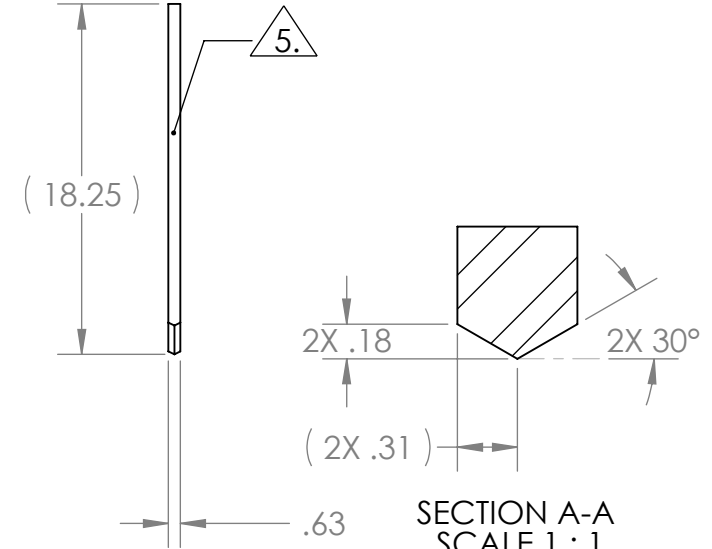
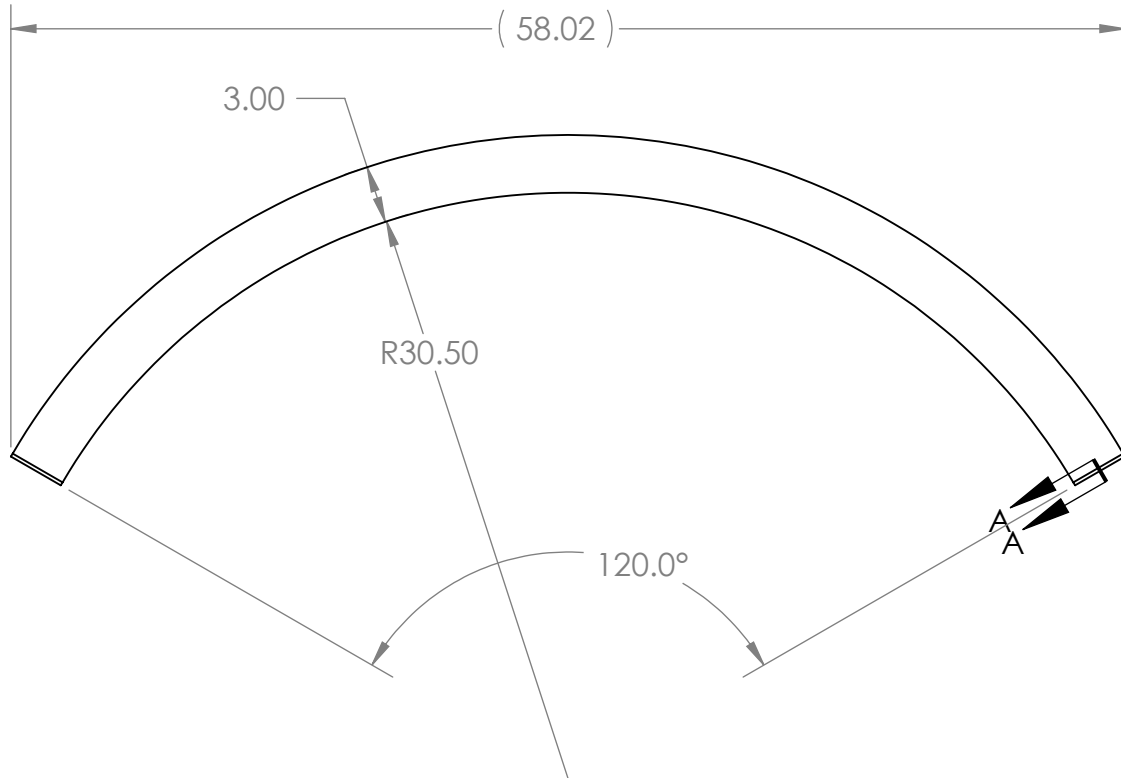


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REMOVED WELD PREP, RELEASED TO PRODUCTION	8/23/2010	MKM2
	B	ADDED REVISED WELD PREP	8/25/2010	MKM2



SECTION A-A  
 SCALE 1 : 1  
 WELD PREP DETAIL  
 TWO PLACES



NOTES:

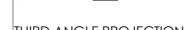
- THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
- NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
  - WATER LEACHABLE CHLORIDES: 100PPM
  - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
  - TOTAL SULFUR: 1000PPM
- DO NOT ALLOW PART 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

DESCRIPTION: PLT, .63 THK, 18.25 WD, 58.03 LG  
 MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240

UNLESS OTHERWISE SPECIFIED:  
 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

THIRD ANGLE PROJECTION



WEIGHT: 36.22 #

APPROVALS

	NAME	DATE
DRAFTER	MKM2	6/14/10
CHECKER	RW	6/14/10
ENGINEER	MKM2	6/14/10

DO NOT SCALE DRAWING

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 916-395-3003 FAX: 916-395-3363  
 WWW.GNBVALVES.COM

TITLE:  
 STIFFENER, BASE,  
 MIDSTATION SPOOL

DWG. NO.  
**A** 114266-00S

SCALE: 1:10 SHEET 1 OF 1

REV  
 B