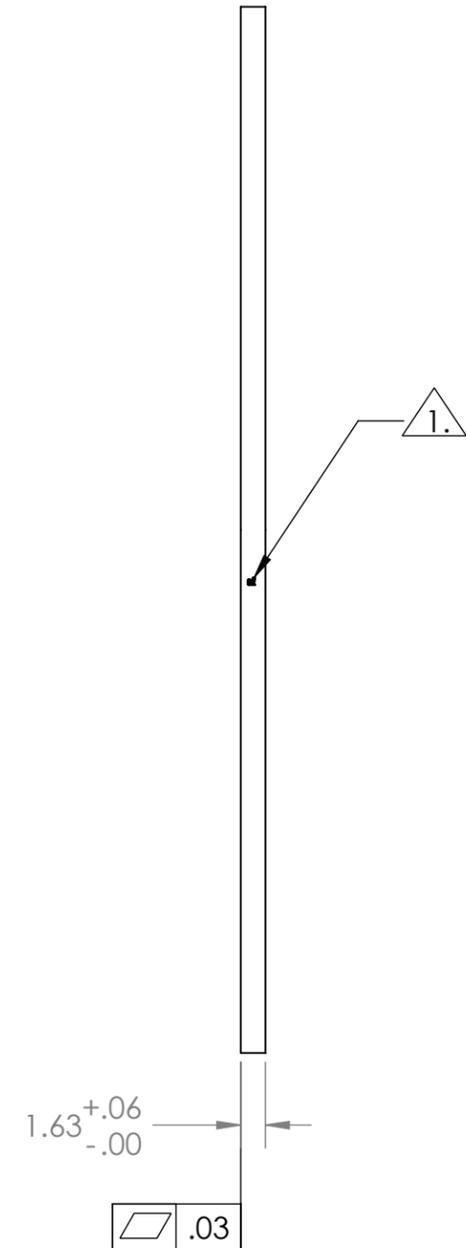
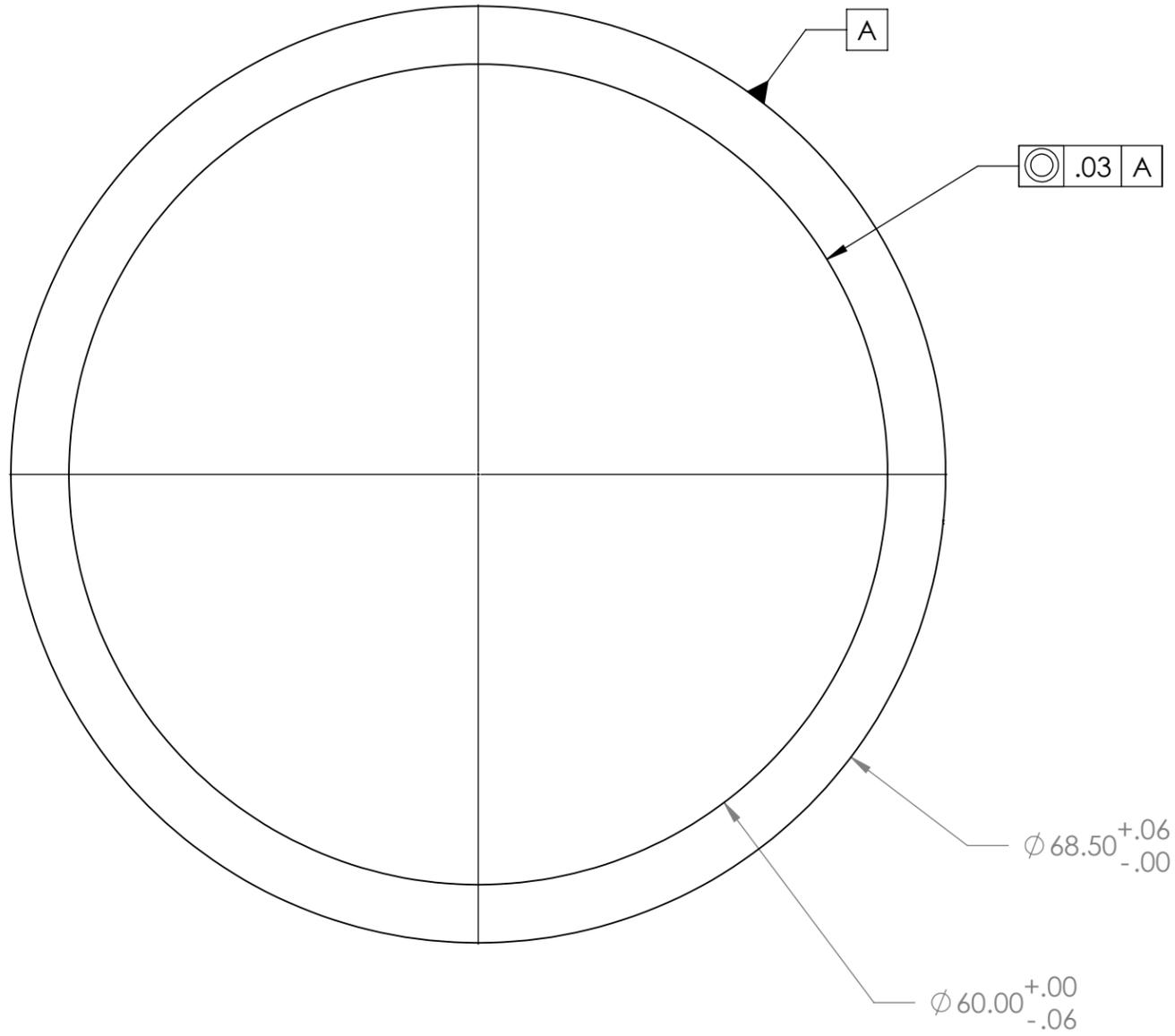


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ZONE		REV.	DESCRIPTION	DATE	APPROVED
		A	RELEASED TO PRODUCTION	8/20/2010	MKM2



- NOTES:
1. TURN OUTER DIAMETER TO WITHIN TOLERANCE, THEN ENGRAVE THE FOLLOWING USING A VIBRATORY TOOL WITH A TIP WITH A MINIMUM RADIUS OF .005":
 - a. HEAT NUMBER
 - b. LOT NUMBER
 - c. PART NUMBER
 2. PROVIDE A COUPON, SIZED 2" X 2", FROM THE SAME HEAT NUMBER, LOT, AND THICKNESS OF THE MATERIAL.
 3. NO WELD SPLICES OR REPAIR WELDING ALLOWED
 4. MATERIAL IDENTIFICATION TO BE MAINTAINED AT ALL TIMES. IF IDENTIFICATION IS LOST, TESTING REQUIRED FOR THE MATERIAL MUST BE REPEATED.
 5. NO GRINDING ALLOWED
 6. FORGING MUST BE PROTECTED FROM CONTAMINATION FROM CARBON STEEL OR HYDROCARBONS. KEEP FORGINGS PROTECTED AT ALL TIMES.
 7. PACKAGE FORGINGS PER ASTM A-700.

DESCRIPTION FORGING, 1.63 THK, 60.00 ID, 68.50 OD
 MATERIAL: AISI 304L PER ASME SA-182 GRADE F, MAX SULFUR CONTENT .006%

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 250/500
 ANGULAR: ± 0°30'
 .XX ± .06
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS

WEIGHT: 402.89#

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

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 www.gnbvalves.com

TITLE: **FORGING, FLANGE, MIDSTATION**
 60.0 ID, 68.50 OD

DO NOT SCALE DRAWING
 SCALE: 1:12
 SHEET 1 OF 1

DWG. NO. **B** 114269-00S
 REV **A**