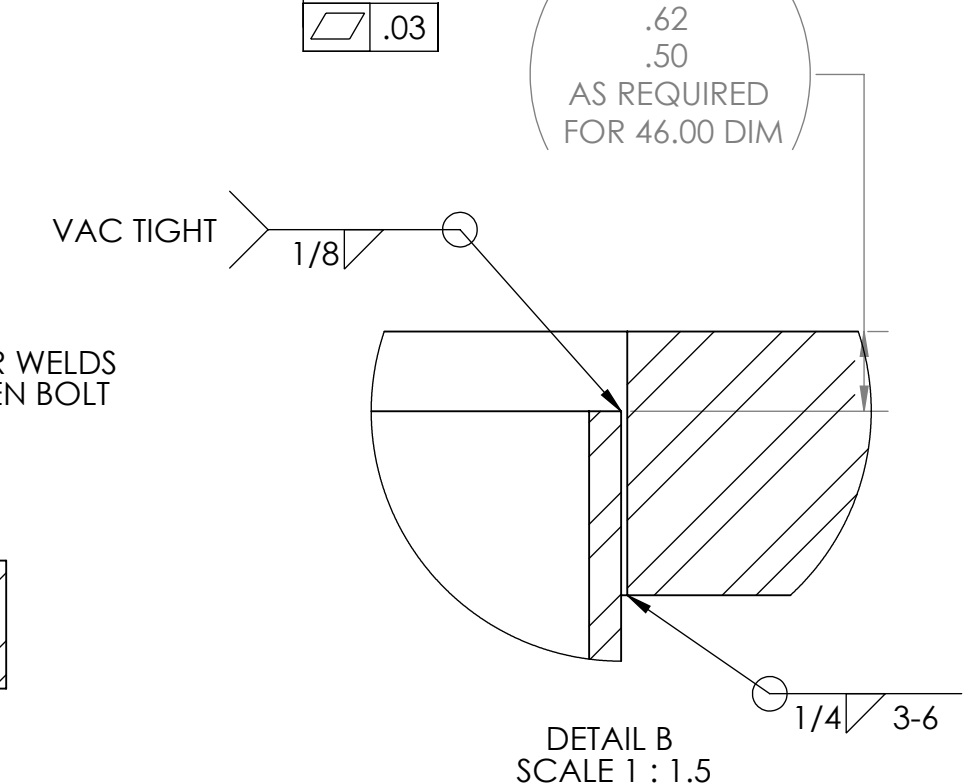
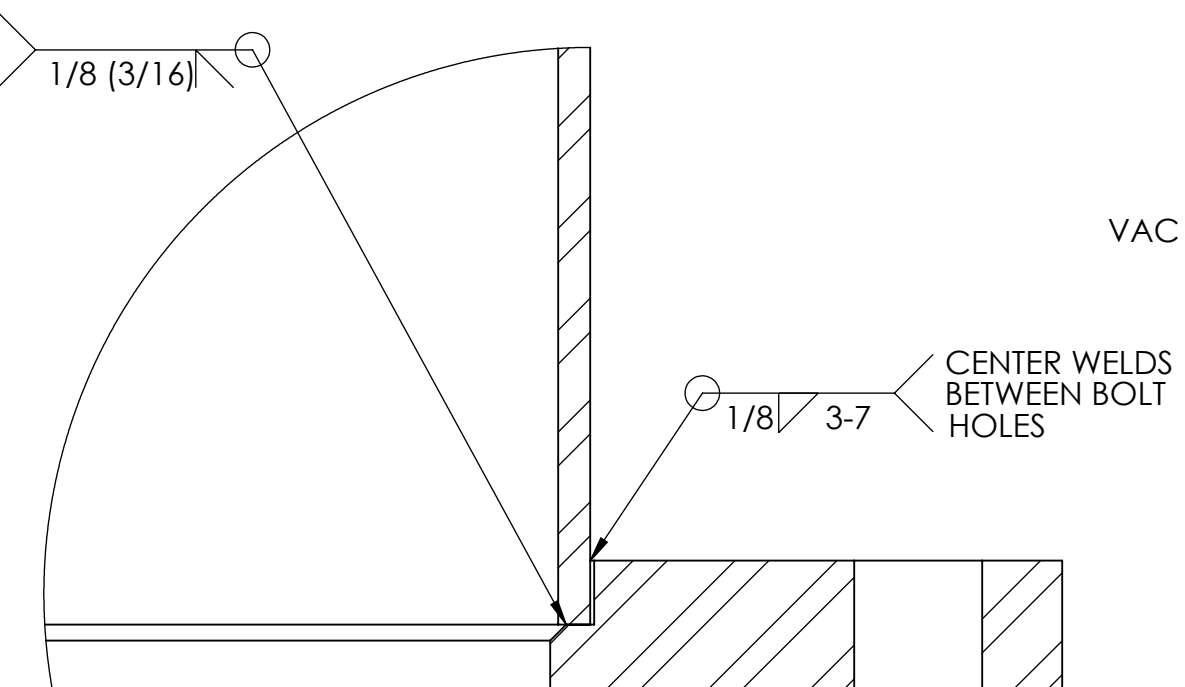
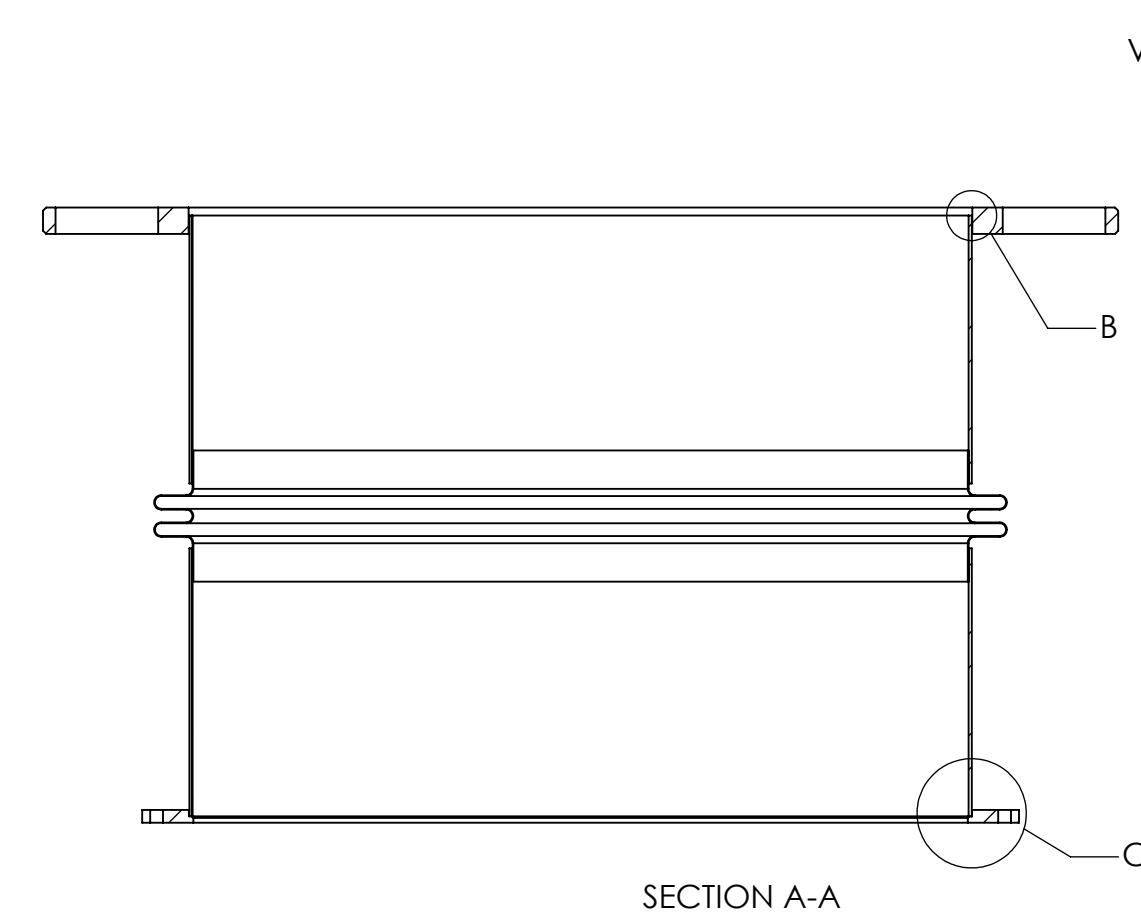
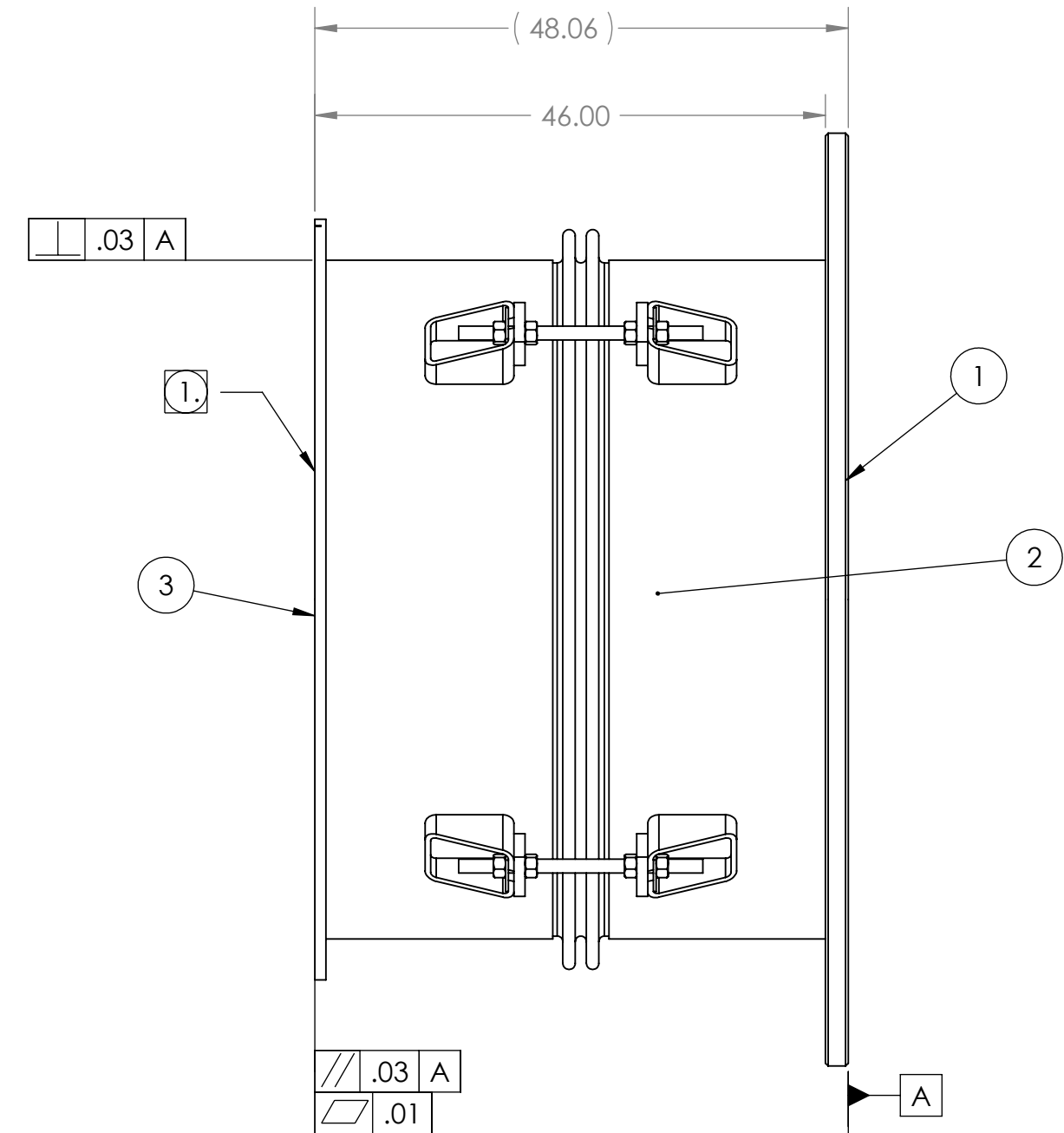
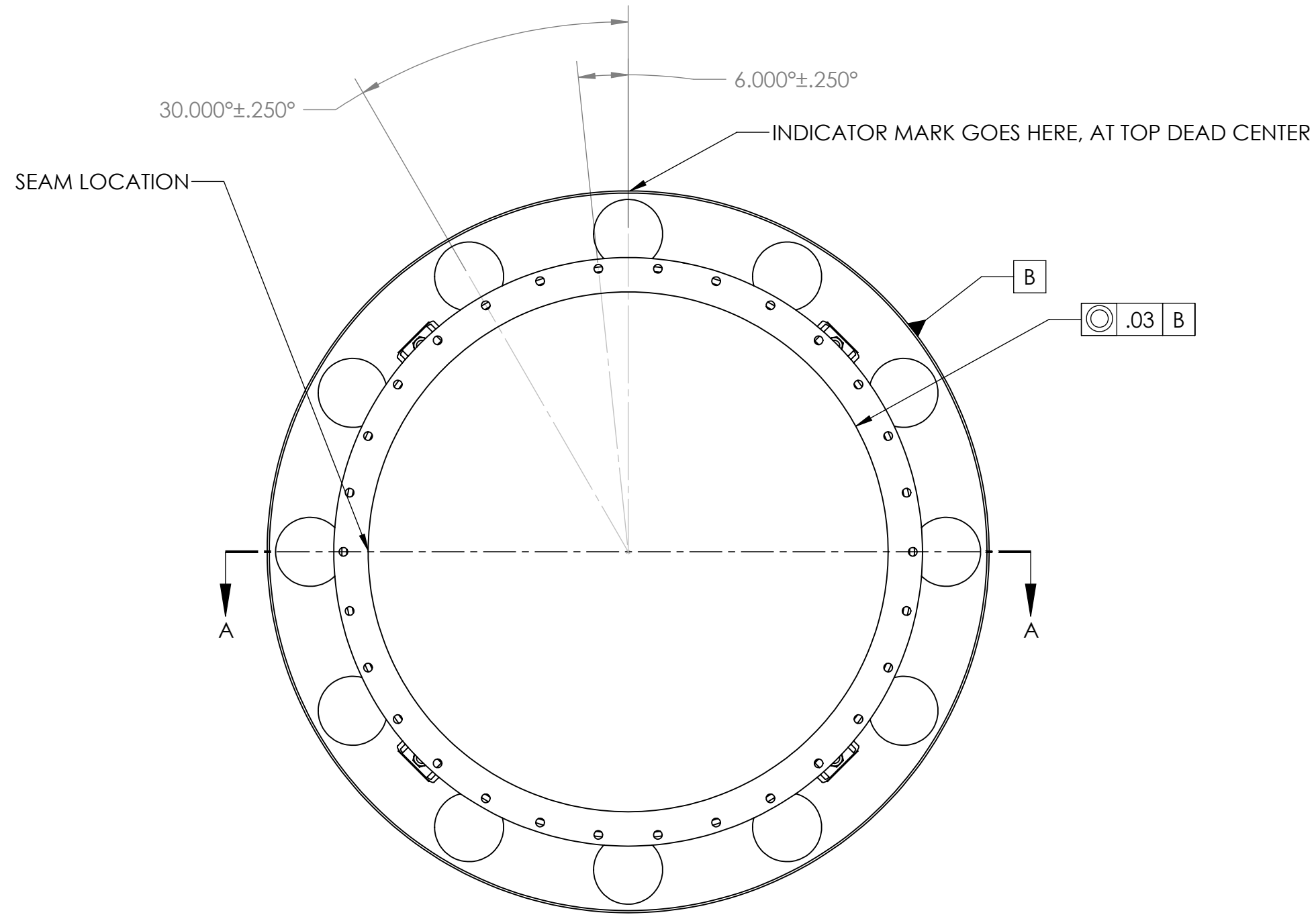


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ADDED INDICATOR NOTE, TIGHTENED ANGULAR TOLERANCES; RELEASED TO PRODUCTION	8/24/2010	MKM2



NOTES:

- VACUUM SEALING SURFACE
- ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
- WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
- CLEAN WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
- INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
- ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
- ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
- NO POST WELD HEAT TREATMENT IS REQUIRED
- FLANGE CANNOT BE TURNED AFTER THIS OPERATION; TAKE EXTREME CARE NOT TO DAMAGE THE FLANGE DURING HANDLING

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114223-04S	PLATE, REDUCER, MC-A	1
2	114222-00WS	WELDMENT, BELLOWS SUBASSEMBLY	1
3	114258-00S	FLANGE, 60.50 ID, SMOOTH	1

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

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

APPROVALS	DATE
DRAFTER MKM2	7/13/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/13/10

GNB CORPORATION
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THIRD ANGLE PROJECTION

TITLE: WELDMENT, NIPPLE, BELLOWS, MCA TUBE

DO NOT SCALE DRAWING	C DWG. NO. 114255-00WS	REV A
SCALE: 1:15	SHEET 1 OF 1	