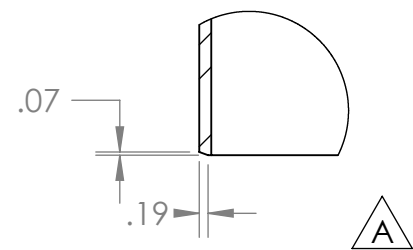
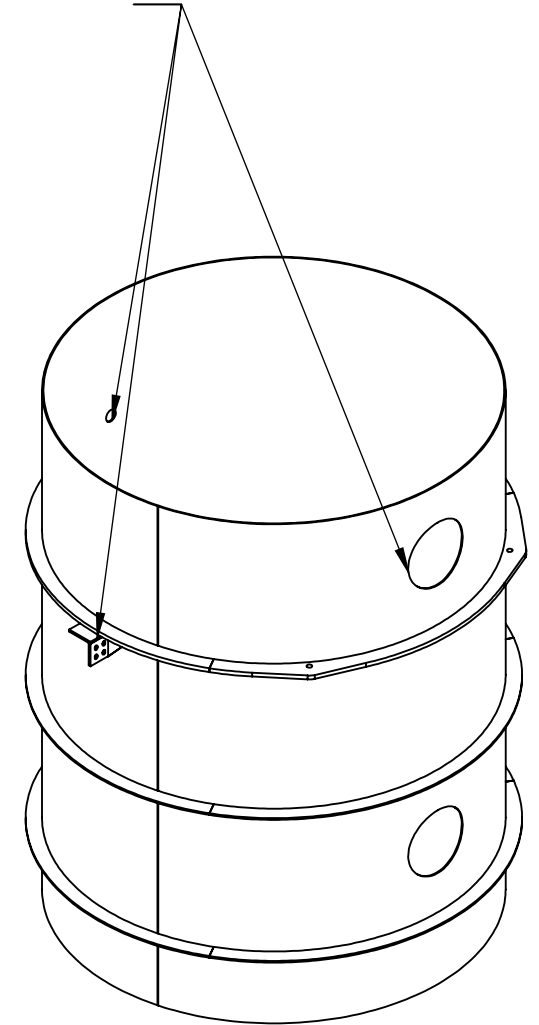
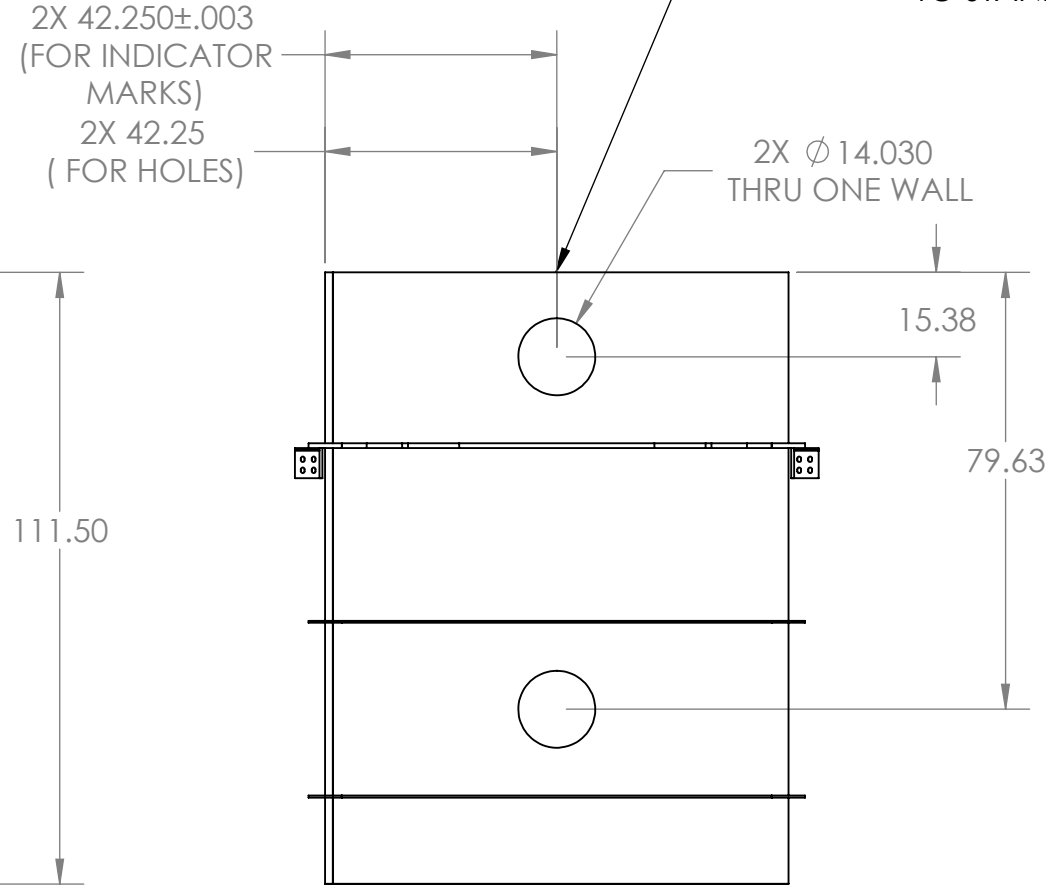
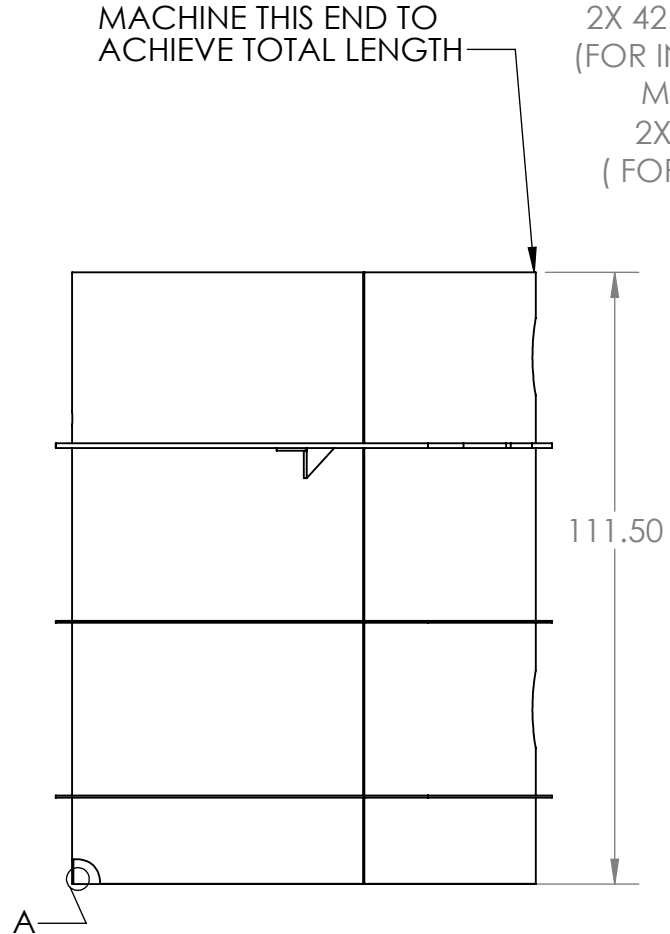
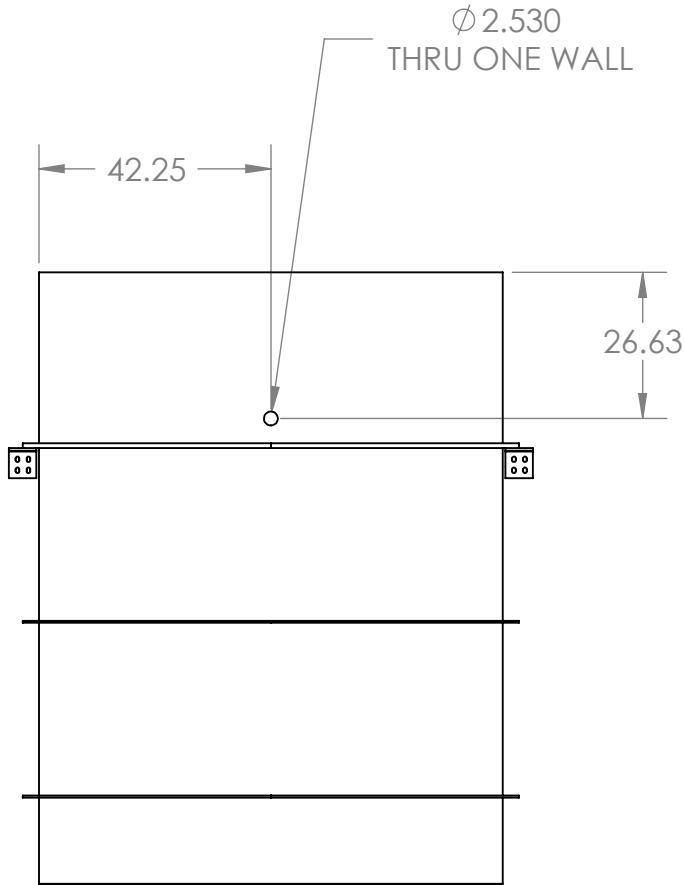


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD PREP	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2

MACHINE AN INDICATOR MARK HERE
 WIDTH: .02 ± .005
 DEPTH: .02 ± .005
 LENGTH: .50

MAKE CAREFUL NOTE OF
 ORIENTATION OF HOLES RELATIVE
 TO STAND BRACKETS!



DETAIL A
 SCALE 1 : 4

MACHINE AN INDICATOR MARK HERE
 WIDTH: .02 ± .005
 DEPTH: .02 ± .005
 LENGTH: .50

- 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.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114211-00WS	WELDMENT, TUBE, RIGHT, MCB TUBE	1

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

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

//, □, ⊥ WITHIN .03

THIRD ANGLE PROJECTION



WEIGHT: 2518.80#

APPROVALS	DATE
DRAFTER MKM2	7/9/10
CHECKER RW	7/22/10
ENGINEER MKM2	7/9/10

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 www.gnbvalves.com

TITLE: TUBE, RIGHT, MCB TUBE FINAL MACHINING OP		DWG. NO. B 114210-00S	REV B
DO NOT SCALE DRAWING		SCALE: 1:35	SHEET 1 OF 1