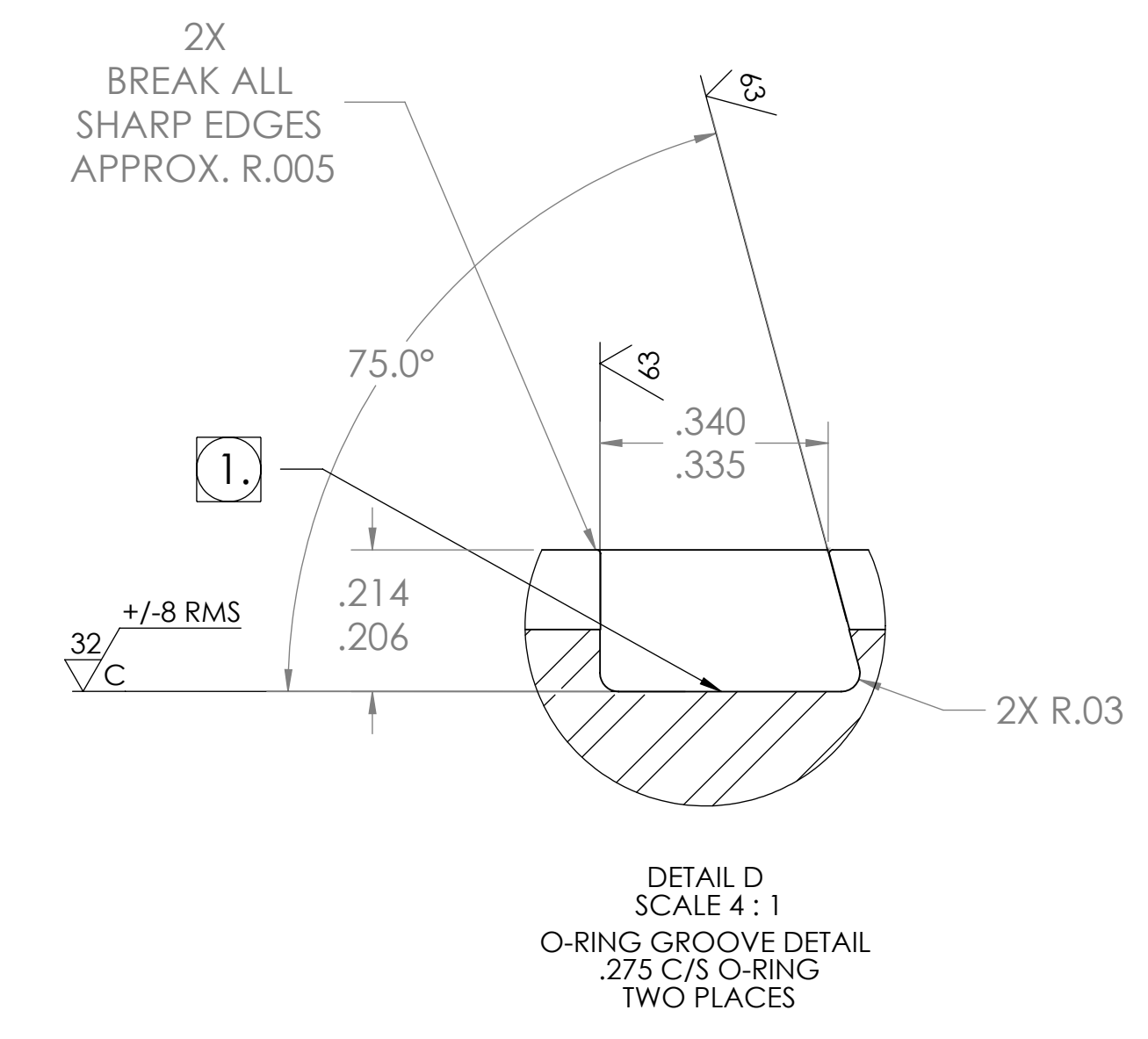
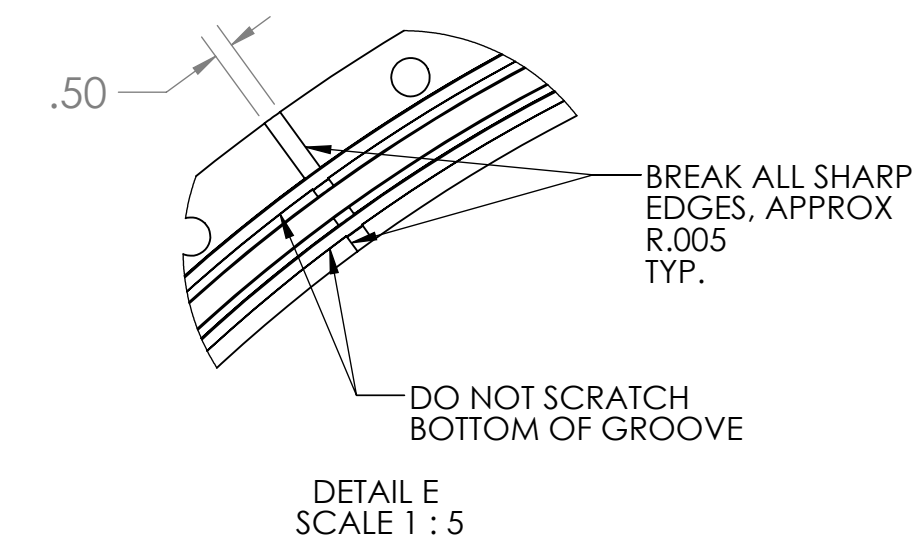
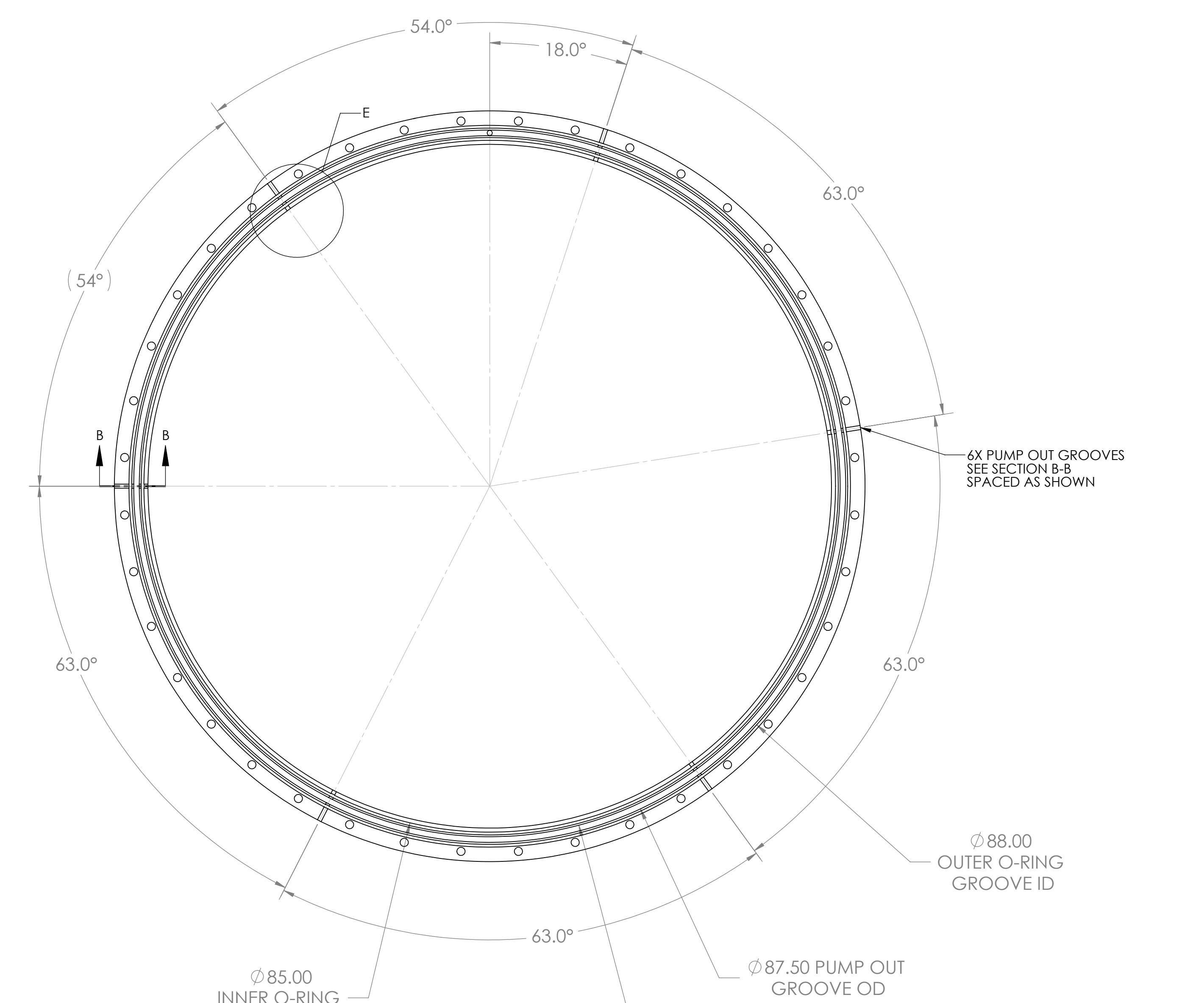
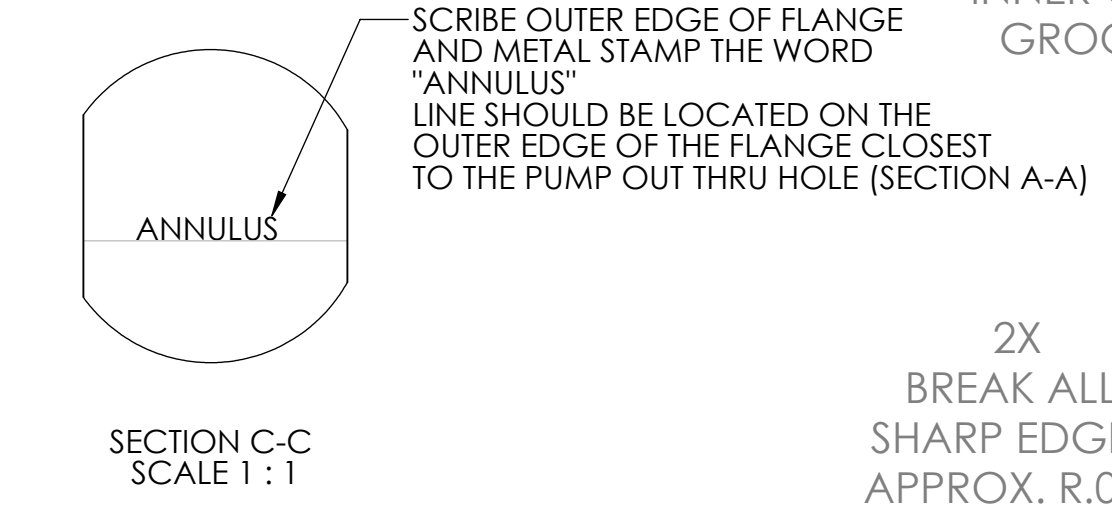
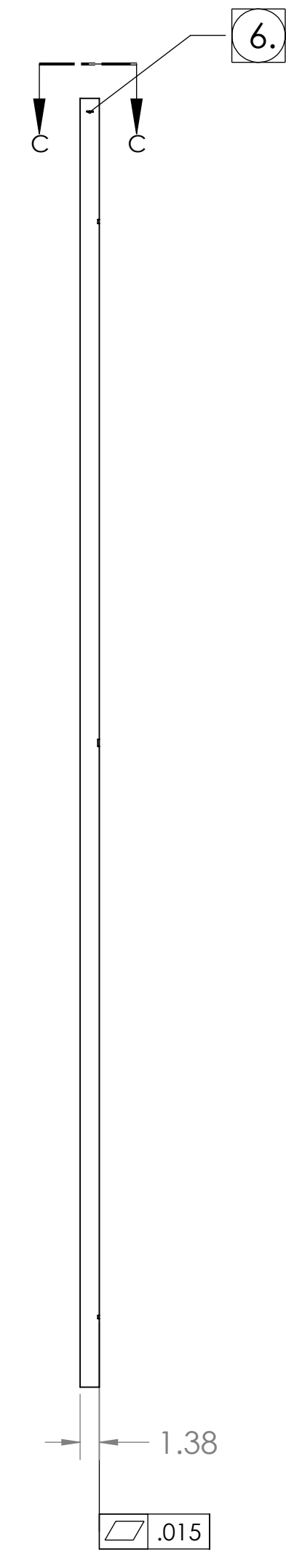
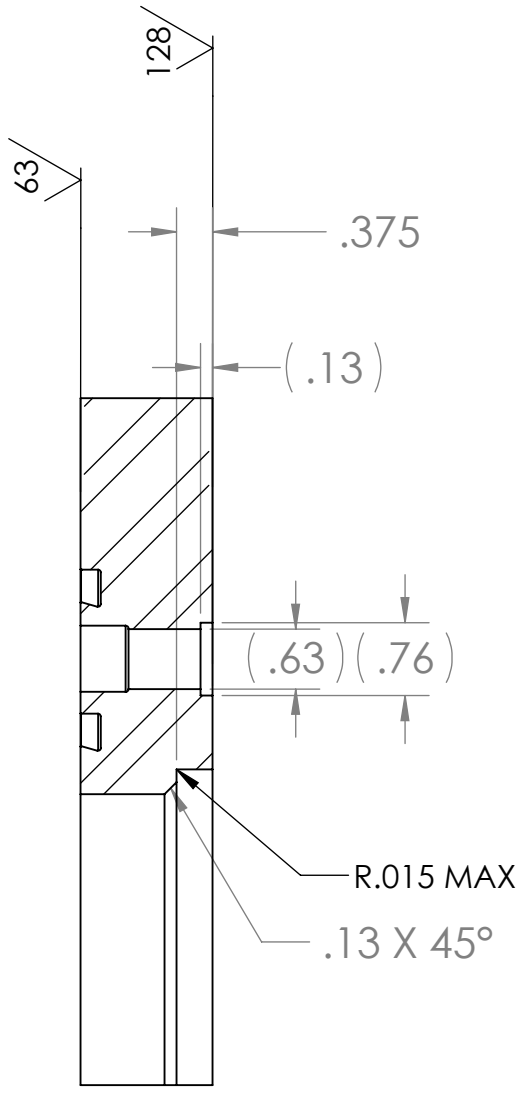
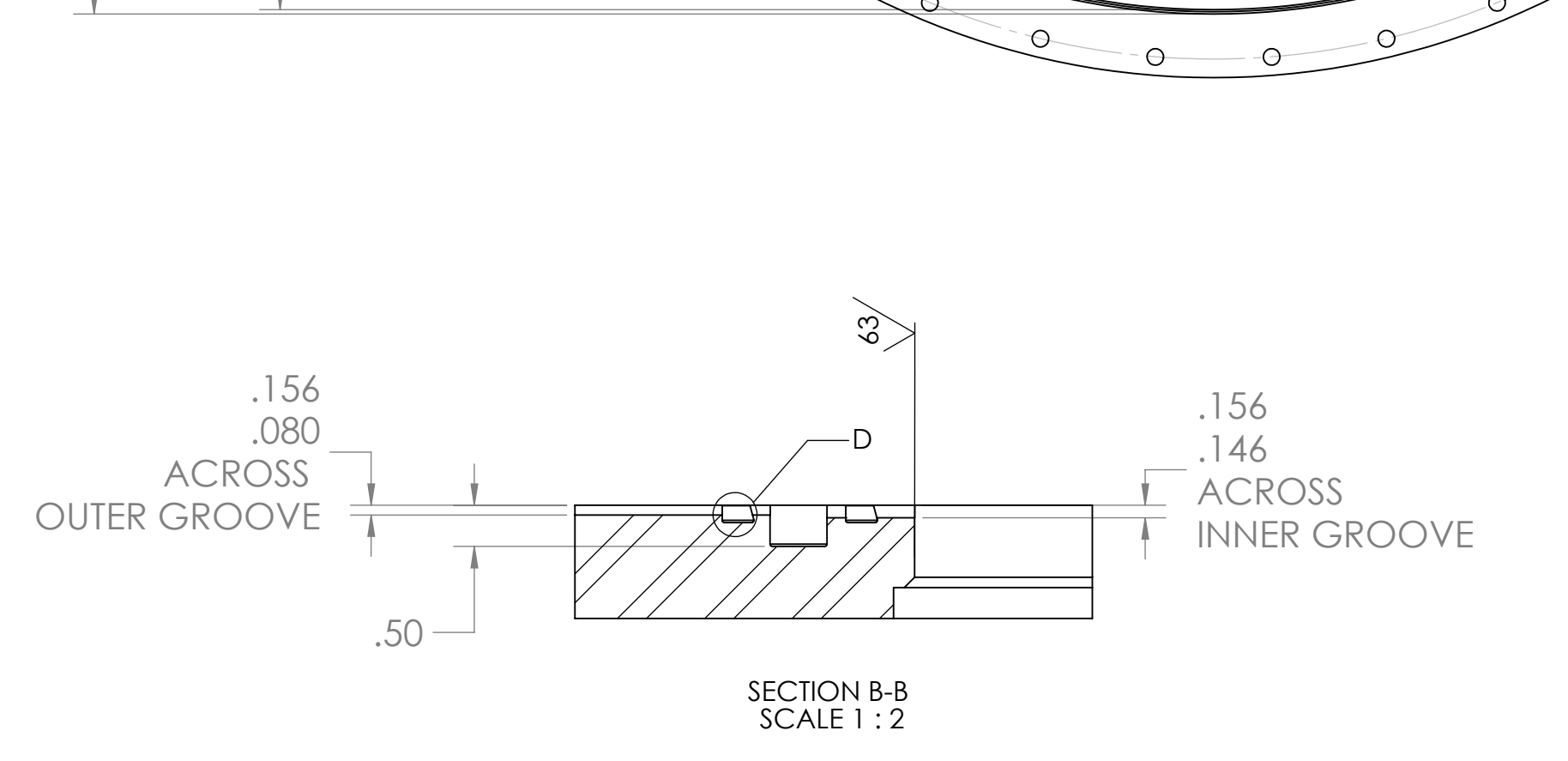
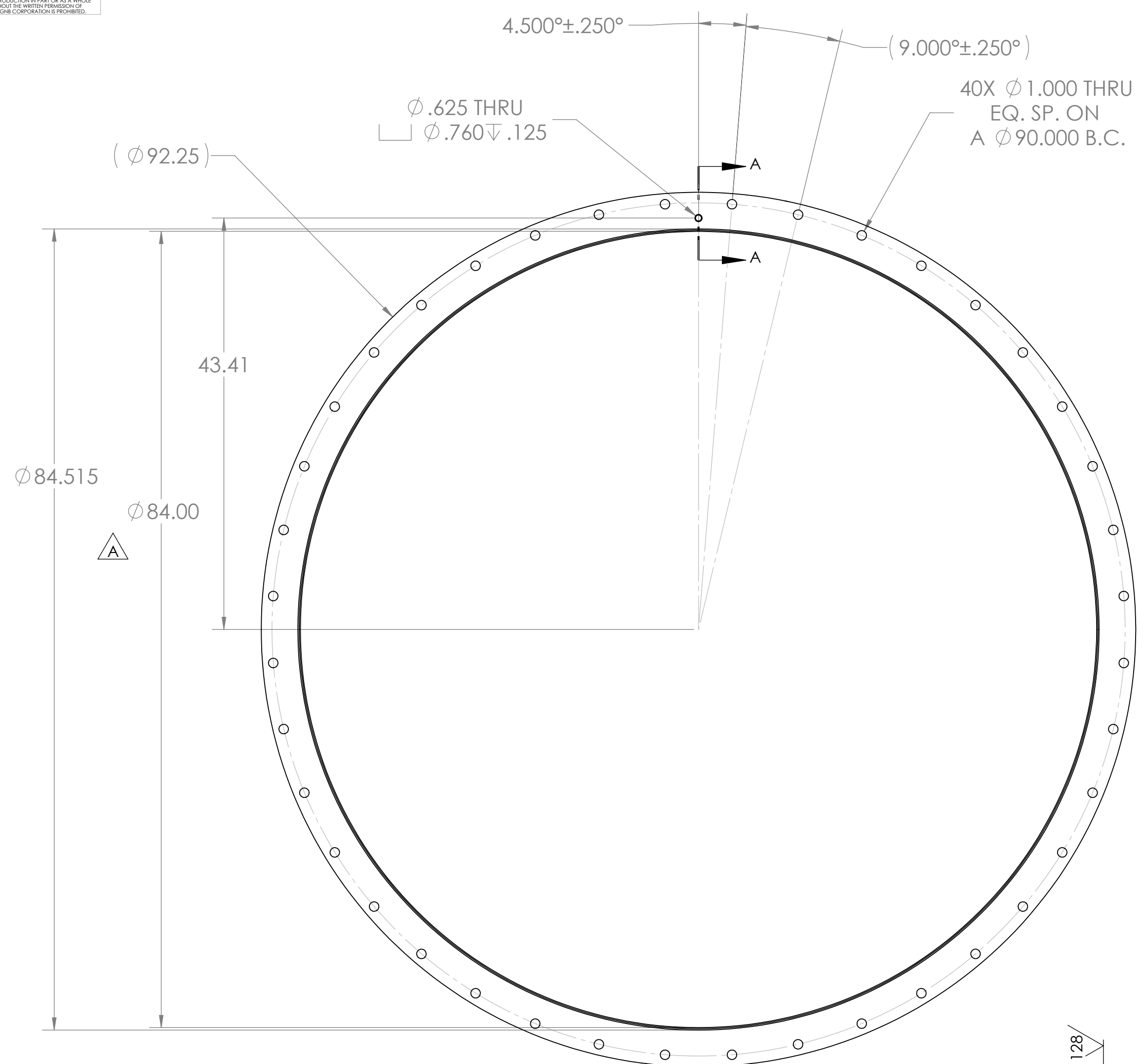


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	84.00 WAS 83.75	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2



- NOTES:**
- VACUUM SEALING SURFACE
 - 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.
 - DO NOT MACHINE OD OF FORGING; FORGING MANUFACTURER'S NUMBERS TO REMAIN INTACT
 - FLANGE FINAL FACE CUT TO BE COMPLETED ON THE SAME SET-UP AS THE O-RING GROOVES
 - MACHINE TOOL LAY TO BE CONCENTRIC ON ALL SURFACES THAT REQUIRE A 32 RMS FINISH
 - IF NECESSARY TO SHIP FLANGE ALONE, STEAM CLEAN AND WRAP IT IN POLYETHYLENE TO PREVENT CONTAMINATION DURING SHIPPING.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114213-00S	FORGING, FLANGE, 84" ID, 92.25 OD	1

MATERIAL: AISI 304L PER ASME SPEC 182 GRADE F; MAX SULFUR CONTENT .006%

UNLESS OTHERWISE SPECIFIED: WEIGHT: 393.79 #

DIMENSIONS ARE IN INCHES FINISH: .125

ANGULAR: 10'30"

XXX ±.005

UNSPECIFIED RADII: R.015

BREAK EDGES: .010x45°

REMOVE ALL BURRS

APPROVALS: [Signature] DATE: 6/25/10

DRAWN: MKM2

CHECKED: RW

ENGINEER: MKM2

DATE: 6/25/10

3200 DWIGHT RD. SUITE #100
 ELK GROVE, CA 95758
 916-395-3003 FAX: 916-395-3363
 WWW.GNBOLIVES.COM

GNB CORPORATION
 SCIENTIFIC AND INDUSTRIAL EQUIPMENT

TITLE: **FLANGE, 84"ID, DOUBLE GROOVED**

DO NOT SCALE DRAWING

DWG. NO: 114212-00S

SCALE: 1:10 SHEET 1 OF 1

REV B