

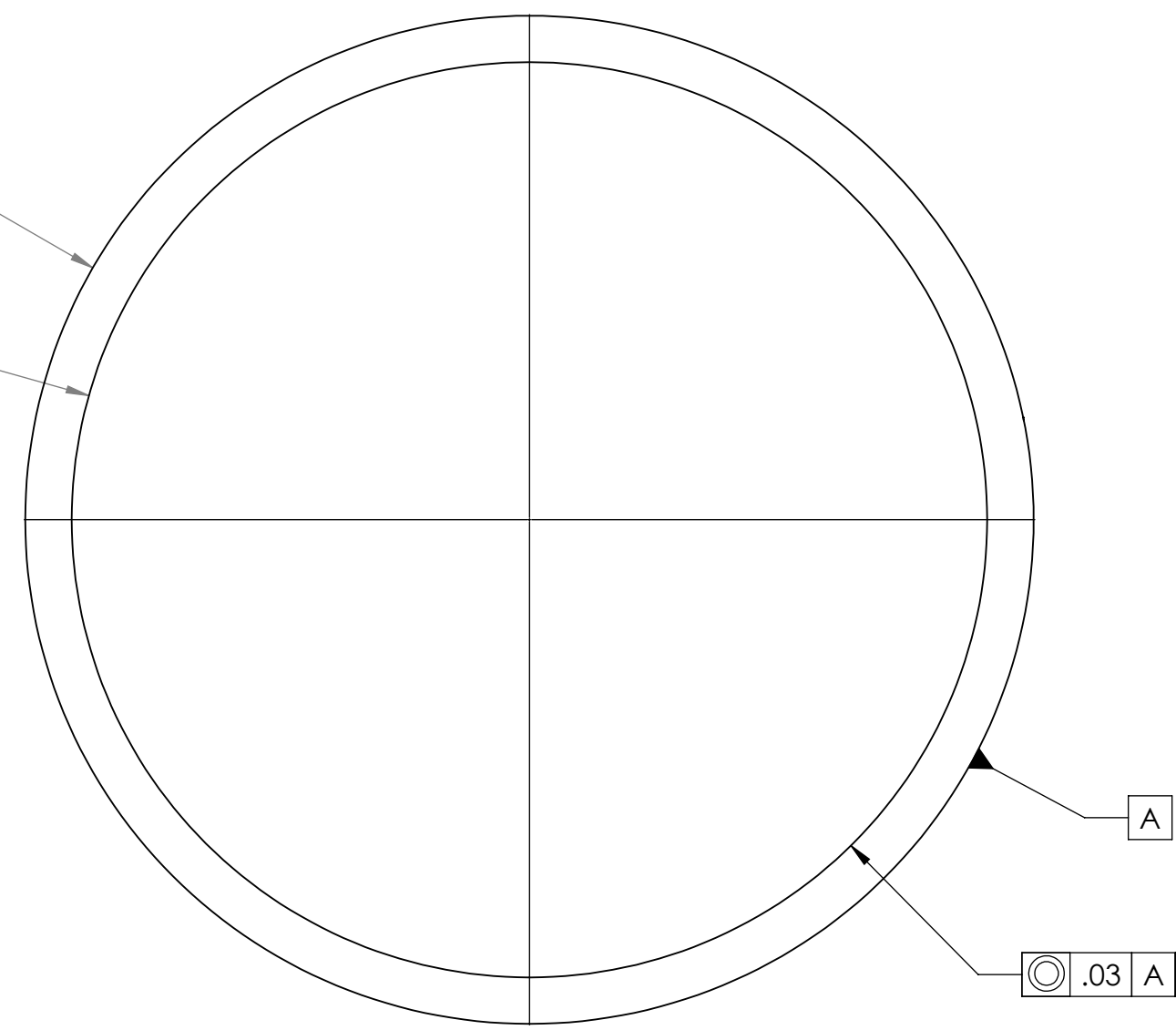
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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	83.75 WAS 84.00	8/4/2010	MKM2
	B	RELEASED TO PRODUCTION	8/20/2010	MKM2

$\phi 92.25^{+.06}_{-.00}$

$\phi 83.75^{+.00}_{-.06}$

**A**




$1.63^{+.06}_{-.00}$

**.03**

**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, 84.00 ID, 92.25 OD		WEIGHT: 553.52#	
MATERIAL: AISI 304L PER ASME SPEC SA-182 GRADE F; MAX SULFUR CONTENT: .006%			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: $\pm 0^{\circ}30'$ .XX $\pm .06$ .XXX $\pm .005$ UNSPECIFIED FILLETS: R.015 BREAK EDGES .010x45° REMOVE ALL BURRS		 SCIENTIFIC AND INDUSTRIAL EQUIPMENT 3200 DWIGHT RD. SUITE 100 ELK GROVE, CA, 95758 916-395-3003 FAX: 916-395-3363 www.gnbvalves.com	
APPROVALS		DATE	
DRAFTER	MKM2	6/14/10	
CHECKER	RW	6/15/10	
ENGINEER	MKM2	6/14/10	
TITLE: <b>FORGING, FLANGE, 84" ID, 92.25 OD</b>			
DO NOT SCALE DRAWING		DWG. NO. 114213-00S	
SCALE: 1:16		SHEET 1 OF 1	
			REV B