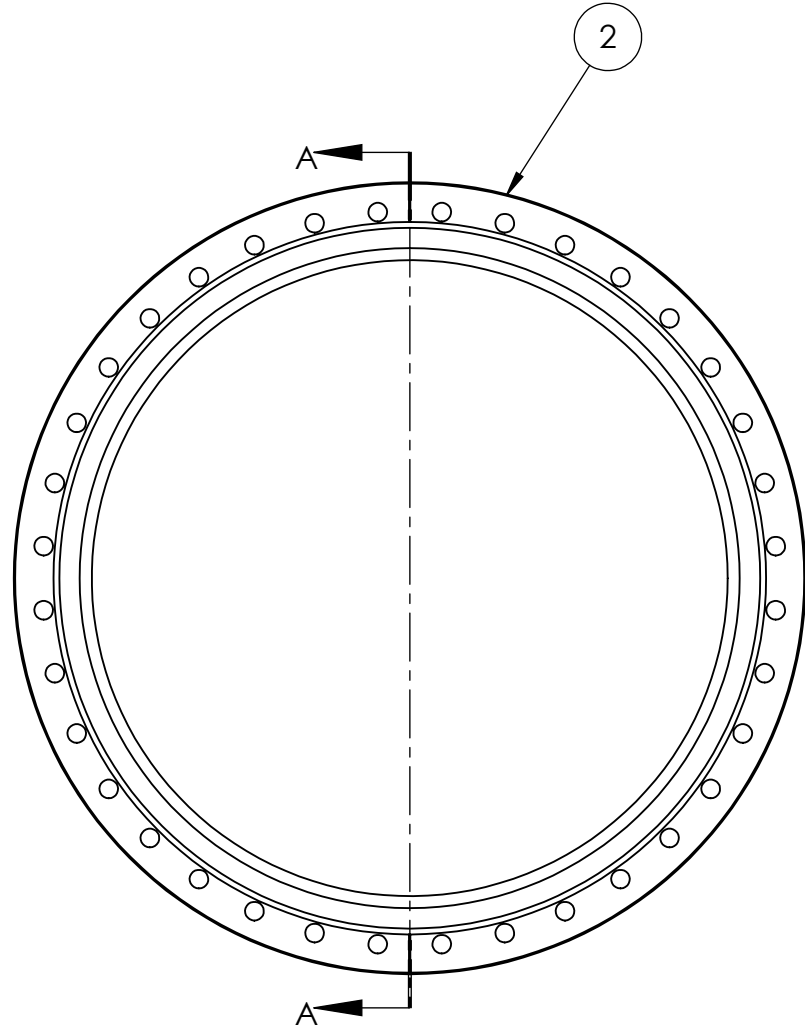
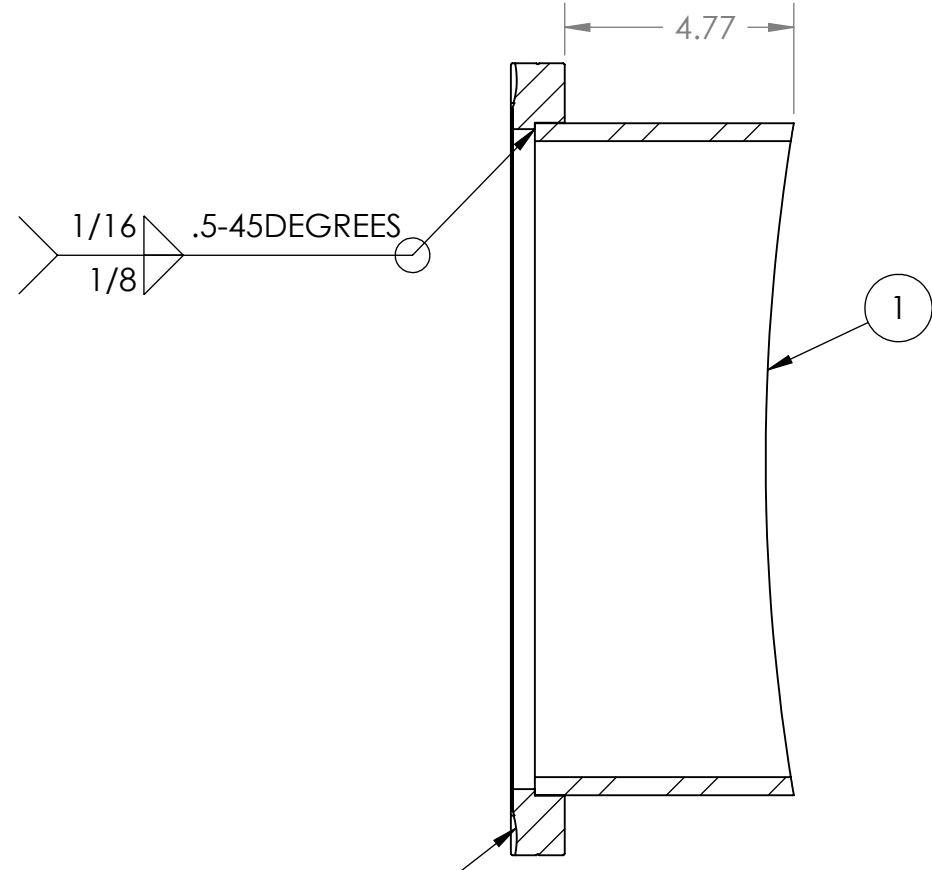


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	SPECIFIED OUTSIDE WELD LOCATION	8/11/2010	MKM2
	B	RELEASED TO PRODUCTION	8/25/2010	MKM2



VAC TIGHT
 OUTSIDE WELDS CENTERED
 BETWEEN BOLT HOLES



NOTE ORIENTATION OF GROOVE
 RELATIVE TO THE CUT OF THE TUBE

SECTION A-A

- NOTES:
1. ALL WELD PREPS TO BE DONE BY TUNGSTEN CARBIDE CUTTING TOOLS ONLY
 2. WELD PER QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE, LATEST REVISION
 3. CLEAN WELD WIRE AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
 4. INTERNAL WELD SURFACE TO BE SMOOTH BUT NOT GROUND
 5. ALL WELDS TO BE GTAW UNLESS OTHERWISE NOTED
 6. ALL INTERNAL WELDS TO BE CONTINUOUS AND VACUUM TIGHT
 7. NO POST WELD HEAT TREATMENT IS REQUIRED

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114217-00S	TUBE, PORT, 16.50" CF	1
2	1650-1400N	FLANGE, CF, 16.50 OD, NON-ROTATABLE, THRU HOLES	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: 25.90#	
APPROVALS	DATE
DRAFTER MKM2	6/25/10
CHECKER RW	7/22/10
ENGINEER MKM2	6/25/10

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 3200 DWIGHT RD. SUITE 100
 ELK GROVE, CA, 95758
 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: PORT, CF, 16.50" OD, THICK WALLED

DO NOT SCALE DRAWING	B DWG. NO. 114216-00WS	REV B
SCALE: 1:4	SHEET 1 OF 1	