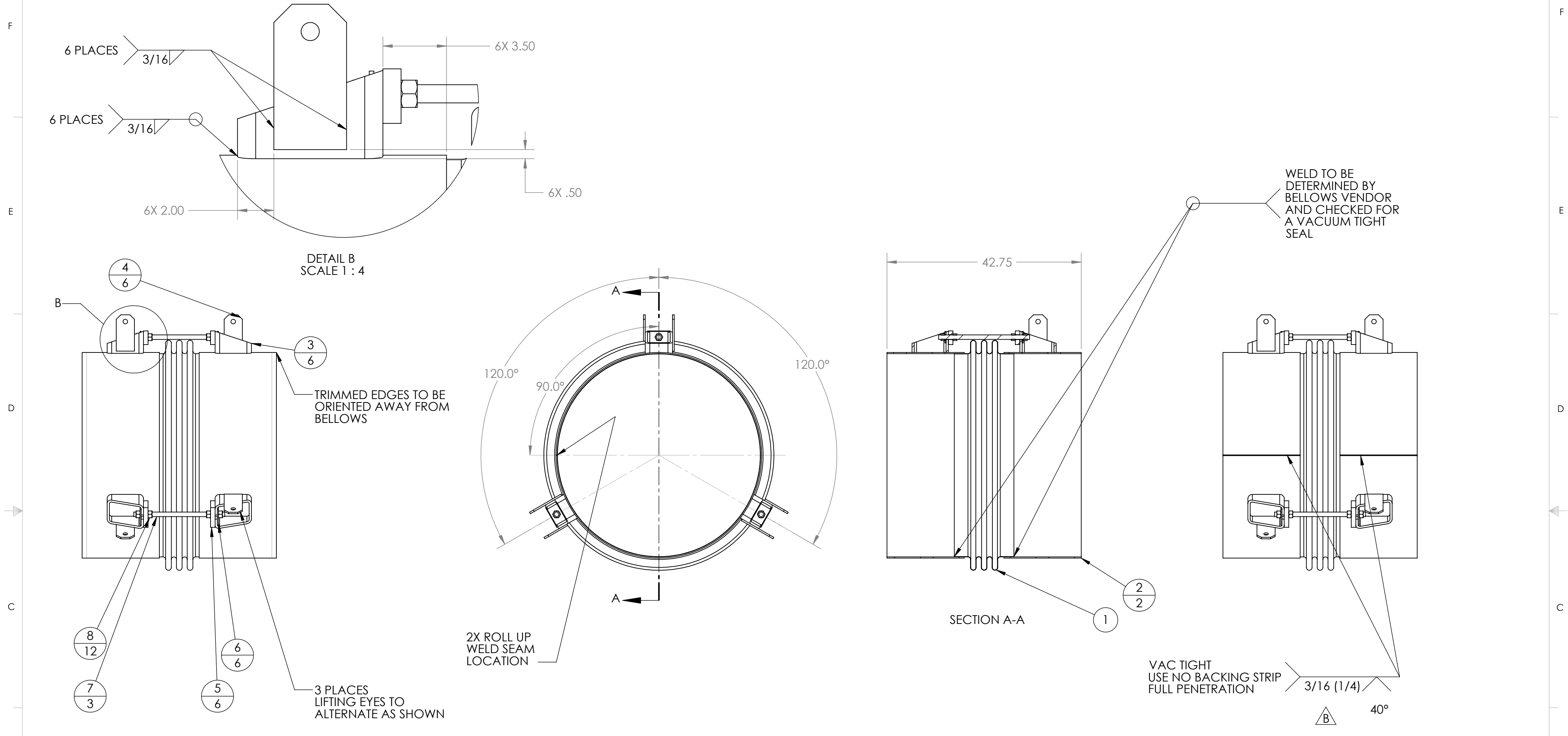


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CHANGED HARDWARE FROM SST TO ZINC PLATED	8/3/2010	MKM2
	B	REVISED WELD SIZE	8/11/2010	MKM2
	C	RELEASED TO PRODUCTION	8/20/2010	MKM2



- NOTES:
1. WELD ROD TO BE CERTIFIED ROD CLEANED WITH CO2 SCRUBBING
 2. ALL WELDS TO BE SMOOTH BUT NO GRINDING IS ALLOWED.
 3. ALL WELDS TO BE GTAW.
 4. ALL WELD PREPARATION TO BE DONE BY TUNGSTON CARBIDE TOOLING IF NEEDED.
 5. ALL WELDING TO BE IN ACCORDANCE WITH QP1750-W2, LIGO WELDING AND REPAIR PROCEDURE.
 6. AFTER WELDING, COMPLETE COMPONENT TO BE CLEANED PER
 7. COMPONENT TO BE FREE FROM CONTAMINATION PER QP1730-10, CONTAMINATION CONTROL PLAN
 8. VENDOR TO CLEAN COMPLETE ASSEMBLY TO IEST-STD-CC1246C
 9. BELLOWS COMPLETE ASSEMBLY TO BE LEAK CHECKED PRIOR TO SHIPMENT TO GNB. ALL TEST RESULTS MUST ACCOMPANY COMPONENT. LEAK RATE MUST BE 1.0×10^{-9} TORR-L/SEC.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114306-00S	BELLOWS, 44.625 ID	1
2	114301-00S	ROLL-UP, ADAPTER, A-17	2
3	114226-01S	MOUNT, TIE ROD, ADAPTER A-17	6
4	114227-00S	LIFTING EYE, TIE ROD, LIGO	6
5	114232-01S	PLATE, BACKING, NUT,	6
6	114233-01S	PLATE, BACKING, NUT SMALL	6
7	N16C3200Z	ROD, THREADED, 1-8 UNC, 20.00 LG ZINC PLATED	3
8	G16C0000Z	HEX NUT, 1-8, ZINC PLATED	12

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: $\pm 0^{\circ}30'$
 .XX $\pm .03$
 .XXX $\pm .005$
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS
 // \square .L WITHIN .03

WEIGHT: 559.17#

APPROVALS: DATE: 6/29/10
 DRAFTER: MKM2
 CHECKER: RW 7/9/10
 ENGINEER: MKM2 6/29/10

GNB CORPORATION
 SCIENTIFIC AND INDUSTRIAL EQUIPMENT
 3200 DWIGHT RD. SUITE 100
 ELK GROVE, CA 95758
 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: **WELDMENT, BELLOWS AND TUBES**

DO NOT SCALE DRAWING

SCALE: 1:16

DWG. NO. 114300-00WS

REV C

SHEET 1 OF 1