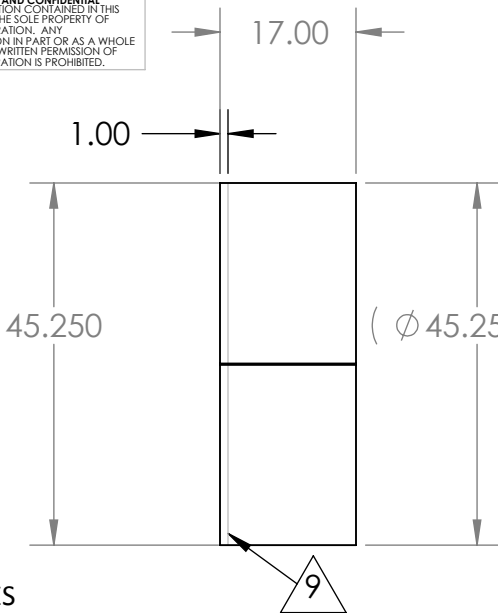
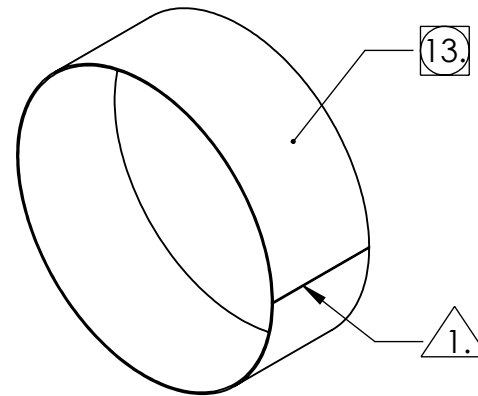
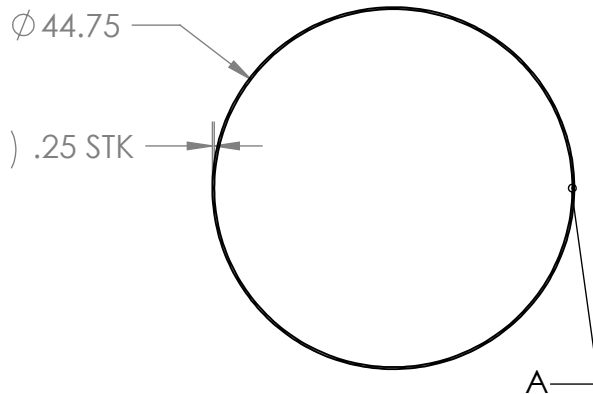


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD PREP DETAIL	7/14/2010	MKM2
	B	REVISED WELD PREP	8/11/2010	MKM2
	C	REVISED WELD PREP PER VENDOR DETAIL	8/13/2010	MKM2
	D	RELEASED TO PRODUCTION	8/20/2010	MKM2



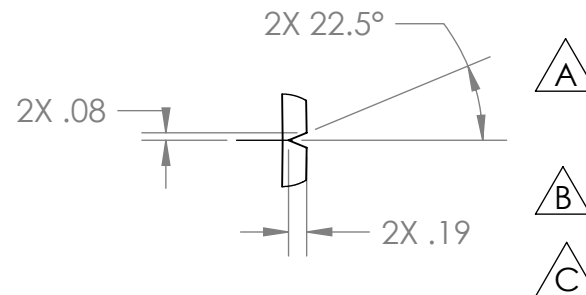
NOTES

1. SEAM TO ARRIVE WITH WELD PREPS IN PLACE.
2. TACK ROLL UP WITH CERTIFIED ROD ONLY (PROVIDED BY GNB).
3. CARBON STEEL ROLLERS SHALL BE COVERED WITH STAINLESS STEEL PRIOR TO ROLLING TO PREVENT CONTAMINATION.
4. SEAM EDGES SHALL BE PREWORKED TO ENSURE ROUNDNESS OF THE FINAL CYLINDER.
5. ROLL-UP PLATES MAY HAVE SHEARED EDGES ONLY IF THE SHEARED EDGES ARE THEN RE-CUT WITH A TUNGSTEN CARBIDE TOOL TO REMOVE CONTAMINATION BY THE ROLLING VENDOR. ACCEPTABLE CUTTING METHODS ARE PLASMA, LASER, WATER JET, OR CARBIDE CUTTING.
6. FINAL BEVELS TO BE MADE WITH TUNGSTEN CARBIDE TOOLS ONLY.
7. PLATES AND ROLL-UPS MUST REMAIN PROTECTED FROM CONTACT WITH CARBON STEEL OR OTHER SOURCES OF CONTAMINATION DURING MOVING, WORKING, AND STORAGE. COVER CARBON STEEL WITH SST OR HEAVY PAPER, AND KEEP PLATES AND ROLL-UPS WRAPPED OR COVERED AT ALL TIMES WHEN NOT BEING PROCESSED.
8. ALL MATERIAL TO BE MANUFACTURED IN THE UNITED STATES.

9. MACHINE THIS AREA TO THE SPECIFIED DIMENSIONS

10. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
11. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
  - a. WATER LEACHABLE CHLORIDES: 100PPM
  - b. TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
  - c. TOTAL SULFUR: 1000PPM
12. A 2"X12" COUPON OF MATERIAL FROM THE SAME LOT OF MATERIAL MUST BE PROVIDED TO GNB

13. ETCH HEAT LOT NUMBER AND PART NUMBER WITH A VIBRATORY TOOL WITH A MINIMUM TIP RADIUS OF .005"



DETAIL A  
 SCALE 1 : 2  
 WELD PREP DETAIL

DESCRIPTION: ROLL-UP, .25 WALL, 45.25 ID, 17.00 LG		 SCIENTIFIC AND INDUSTRIAL EQUIPMENT 3200 DWIGHT RD, SUITE 100 ELK GROVE, CA 95758 916-395-3003 FAX: 916-395-3363 WWW.GNBVALVES.COM								
MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240										
UNLESS OTHERWISE SPECIFIED:	WEIGHT: 173.58 #	APPROVALS <table border="1"> <thead> <tr> <th>NAME</th> <th>DATE</th> </tr> </thead> <tbody> <tr> <td>DRAFTER MKM2</td> <td>6/14/10</td> </tr> <tr> <td>CHECKER RW</td> <td>6/14/10</td> </tr> <tr> <td>ENGINEER MKM2</td> <td>6/14/10</td> </tr> </tbody> </table>	NAME	DATE	DRAFTER MKM2	6/14/10	CHECKER RW	6/14/10	ENGINEER MKM2	6/14/10
NAME	DATE									
DRAFTER MKM2	6/14/10									
CHECKER RW	6/14/10									
ENGINEER MKM2	6/14/10									
DIMENSIONS ARE IN INCHES	FINISH 125									
TOLERANCES: ANGULAR: ± 1°	.XX ± .06									
.XXX ± .005	UNSPECIFIED FILLETS: R.015									
BREAK EDGES .010 x 45°	REMOVE ALL BURRS									
// . / . ⊥ WITHIN .03		TITLE: ROLL-UP, ADAPTER, A-17 DWG. NO. 114301-00S SCALE: 1:24 SHEET 1 OF 1								
THIRD ANGLE PROJECTION		DO NOT SCALE DRAWING REV D								