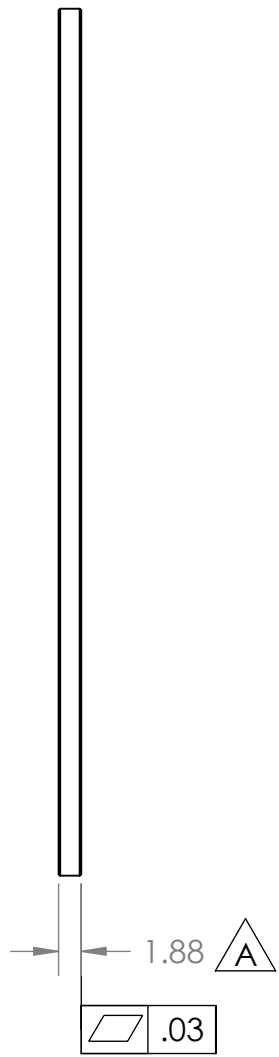
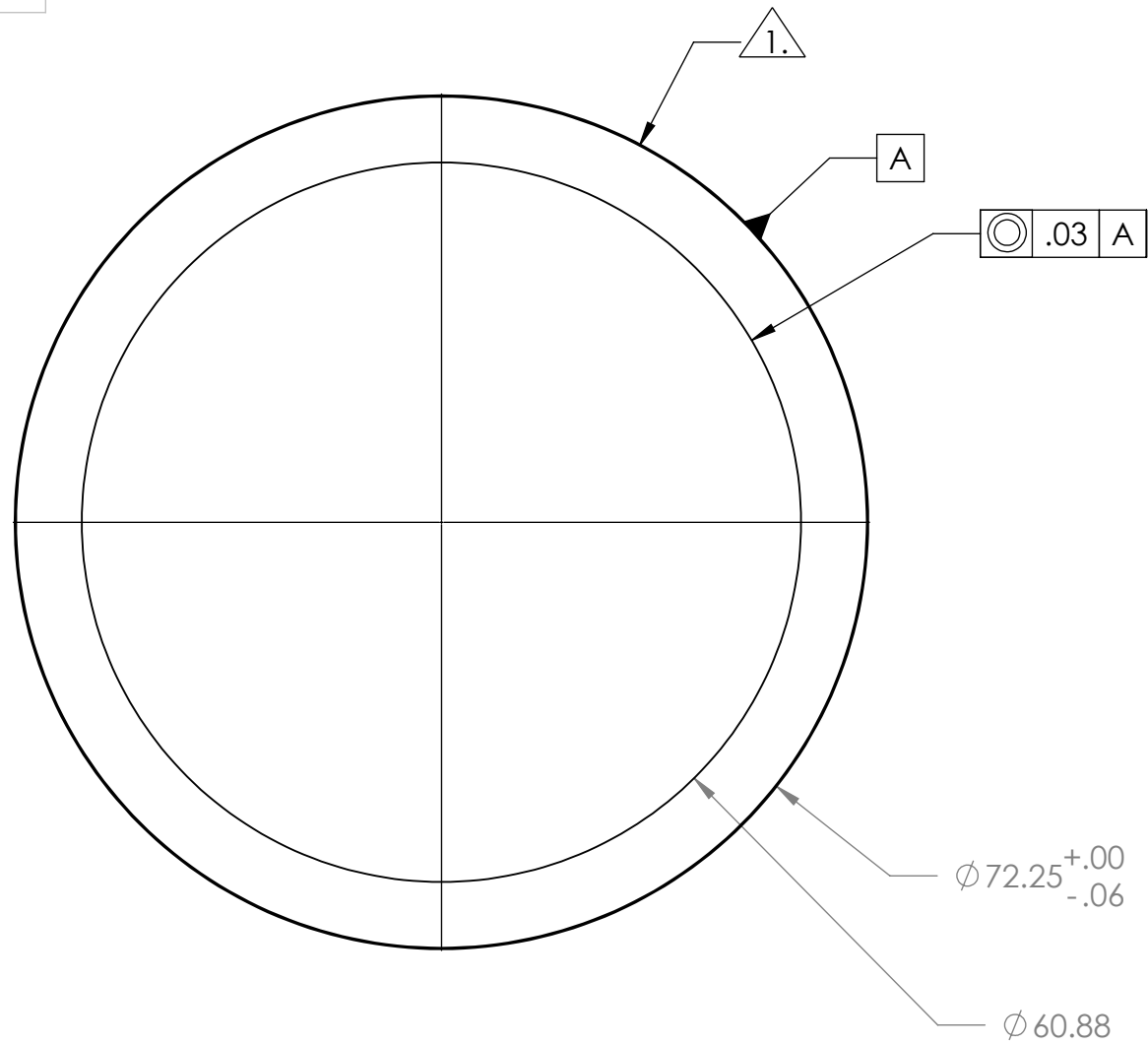


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	1.88 WAS 1.50, EXPANDED NOTES	7/15/2010	MKM2
	B	RELEASED TO PRODUCTION	8/20/2010	MKM2



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. THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
3. 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
3. DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
4. MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.
5. PROVIDE A COUPON, SIZED 2" X 2", FROM THE SAME HEAT NUMBER, LOT, AND THICKNESS OF THE MATERIAL.
6. NO WELD SPLICES OR REPAIR WELDING ALLOWED
7. MATERIAL IDENTIFICATION TO BE MAINTAINED AT ALL TIMES. IF IDENTIFICATION IS LOST, TESTING REQUIRED FOR THE MATERIAL MUST BE REPEATED.
8. PACKAGE FORGINGS PER ASTM A-700.

DESCRIPTION FORGING, 1.88 THK, 60.88 ID, 72.25 OD		WEIGHT: 643.48#		<p>SCIENTIFIC AND INDUSTRIAL EQUIPMENT</p> <p>3200 DWIGHT RD. SUITE 100 ELK GROVE, CA, 95758 916-395-3003 FAX: 916-395-3363 www.gnbvalves.com</p>
MATERIAL: AISI 304L PER ASME SPEC SA-182 GRADE F; MAX SULFUR CONTENT .006%		APPROVALS	DATE	
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		DRAFTER	MKM2 6/14/10	
FINISH 250		CHECKER	RW 6/14/10	
//, □, ⊥ WITHIN .03		ENGINEER	MKM2 6/14/10	TITLE: FORGING, PLATE, REDUCER, ADAPTER A-18
THIRD ANGLE PROJECTION		DO NOT SCALE DRAWING		
		DWG. NO. B 114318-00SL SCALE: 1:16 SHEET 1 OF 1		
		REV B		