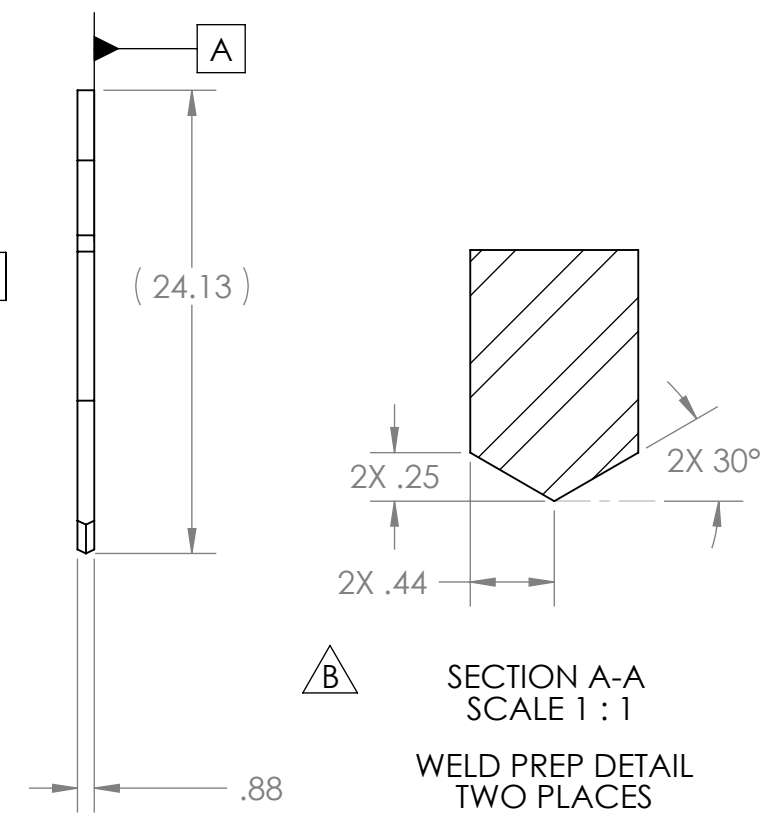
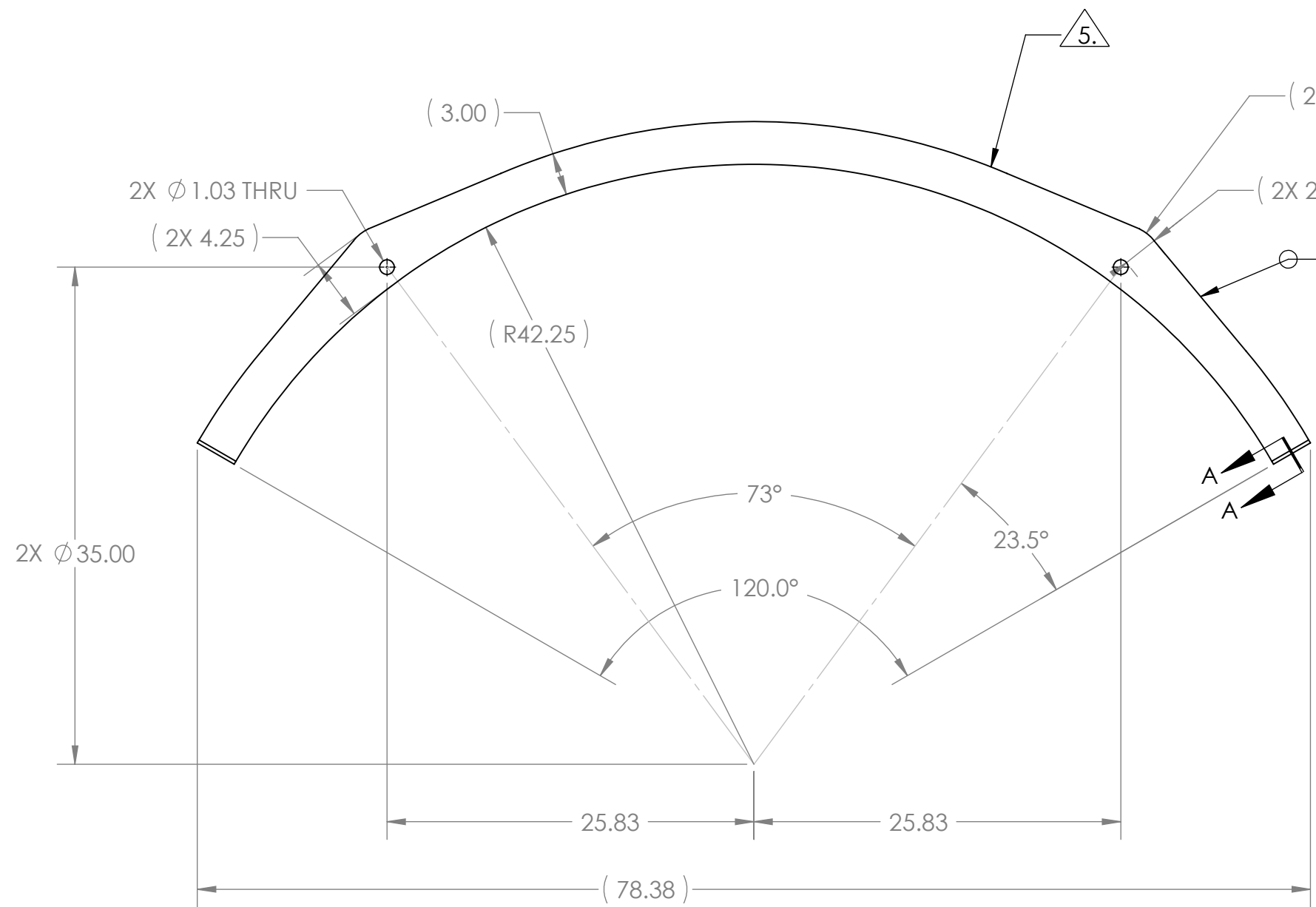


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| REVISIONS | | | | |
|-----------|------|--|-----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| | A | REMOVED CHAMFERS; RELEASED TO PRODUCTION | 8/24/2010 | MKM2 |
| | B | REVISED WELD PREP | 8/25/2010 | MKM2 |

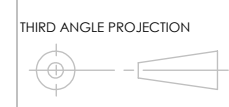


- NOTES:
- THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING.
 - NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
 - WATER LEACHABLE CHLORIDES: 100PPM
 - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
 - TOTAL SULFUR: 1000PPM
 - DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
 - MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.

5. USING A VIBRATORY TOOL WITH A TIP WITH A MINIMUM RADIUS OF .005", ENGRAVE THE FOLLOWING ON THE INDICATED SURFACE:
- HEAT NUMBER
 - LOT NUMBER
 - PART NUMBER
6. BASIC DIMENSIONS TO BE DERIVED FROM CAD FILE.

DESCRIPTION PLT, .88 THK, 25.13 WD, 78.38 LG
 MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240

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



| APPROVALS | | DATE |
|-----------|------|---------|
| DRAFTER | MKM2 | 6/14/10 |
| CHECKER | ER | 6/14/10 |
| ENGINEER | MKM2 | 6/14/10 |

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 ELK GROVE, CA, 95758
 916-395-3003 FAX: 916-395-3363
 www.gnbvalves.com

TITLE: **STIFFENER, LIFTING, MC TUBES**

| | | |
|-----------------------------|------------------------------|-------|
| DO NOT SCALE DRAWING | B DWG. NO. 114205-00S | REV B |
| SCALE: 1:10 | SHEET 1 OF 1 | |