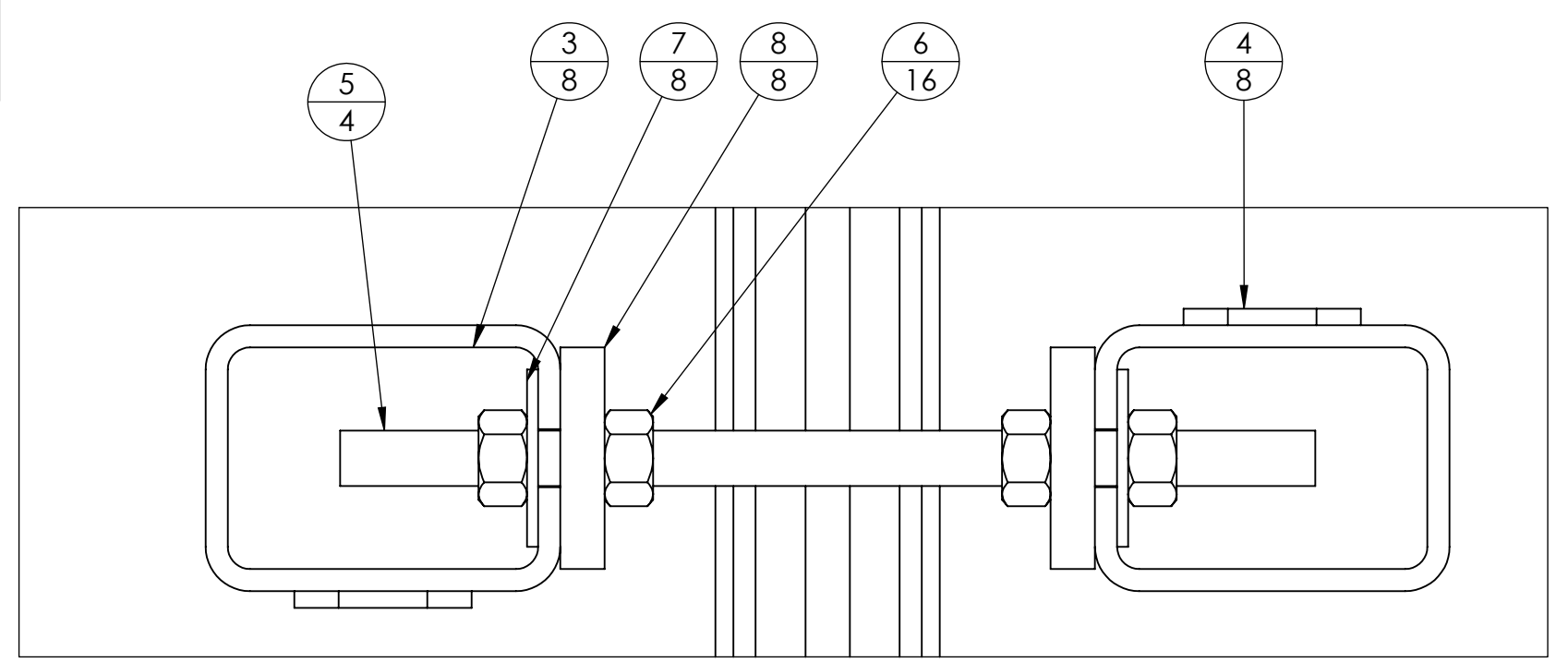
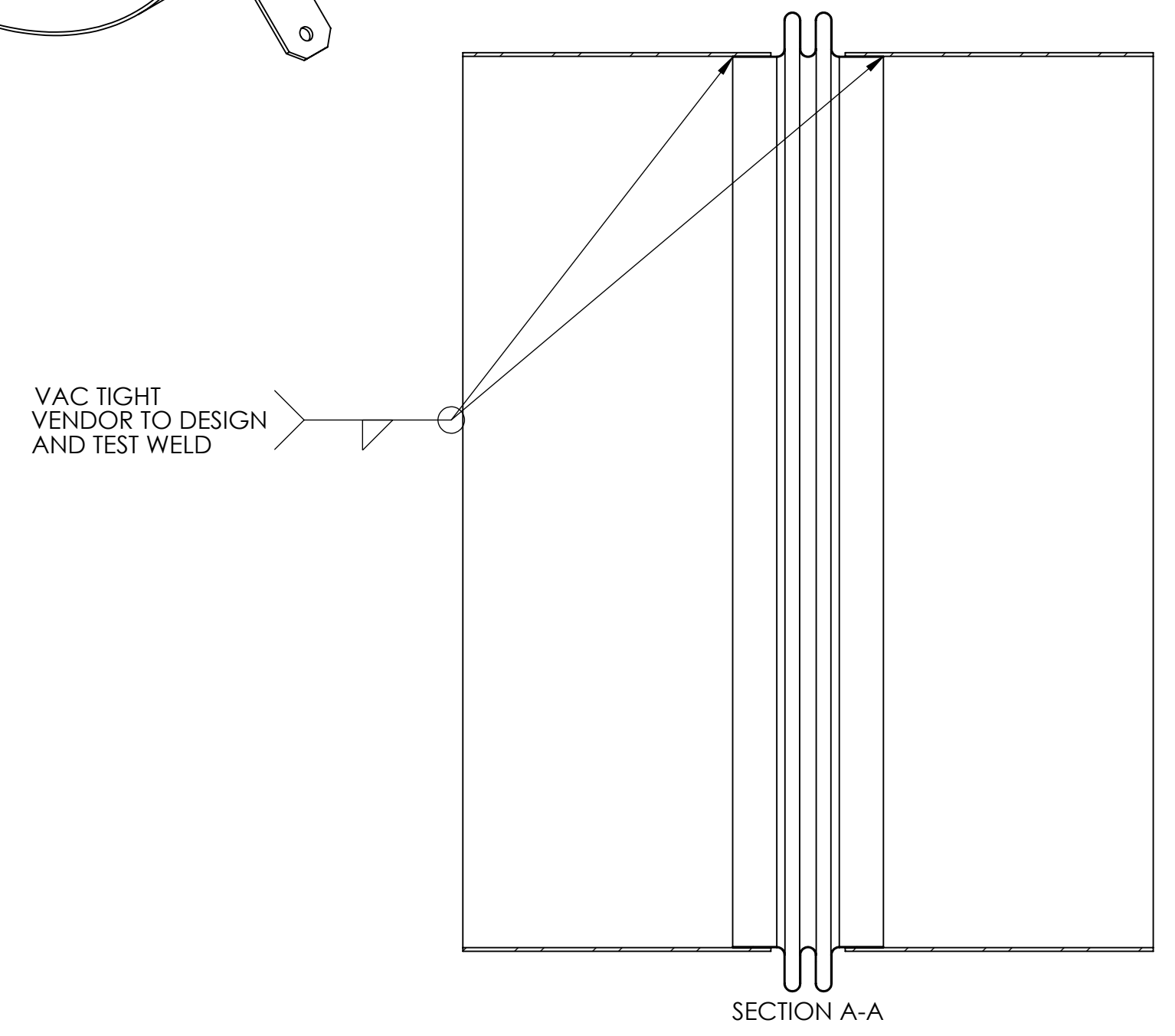
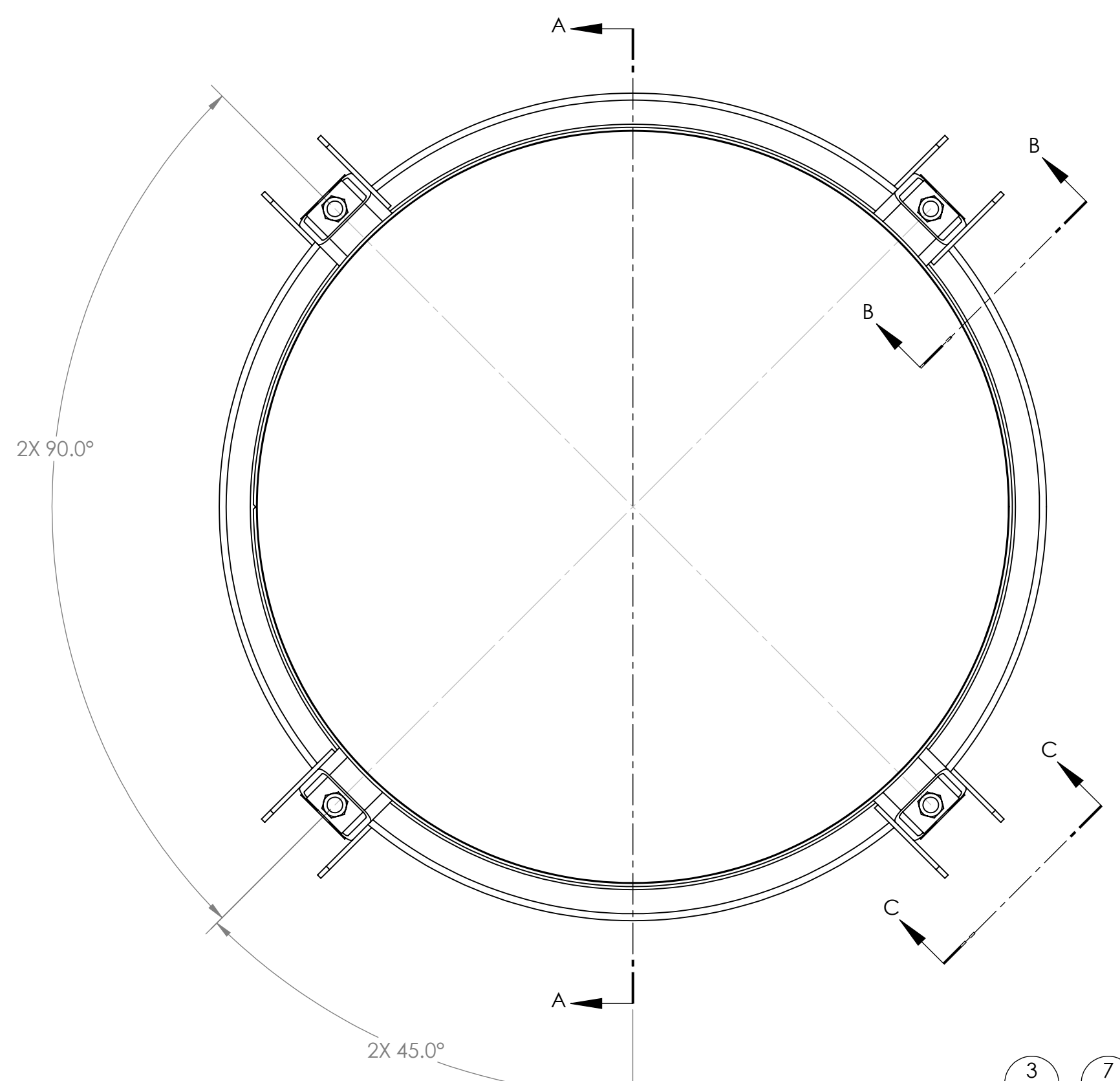
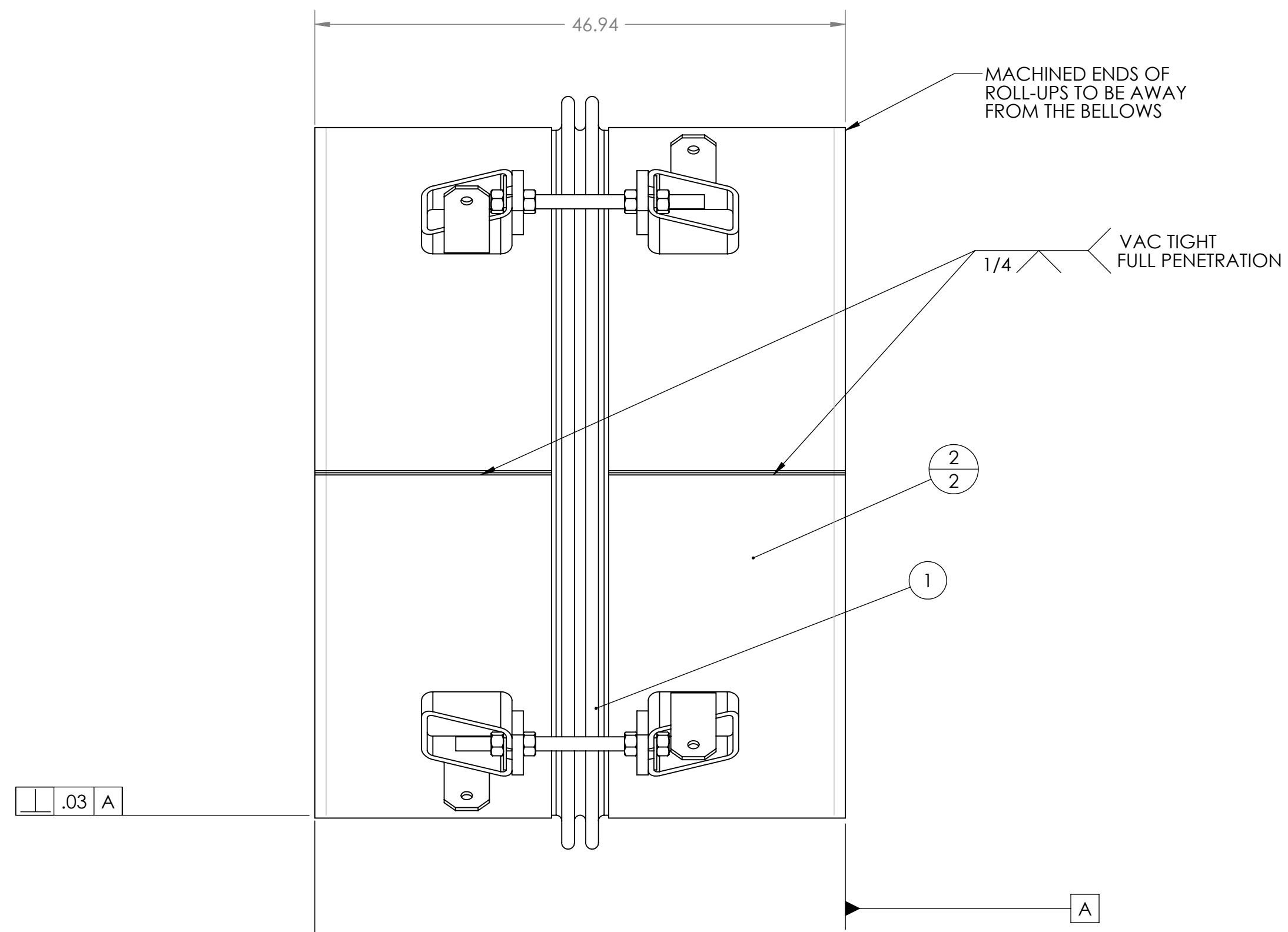
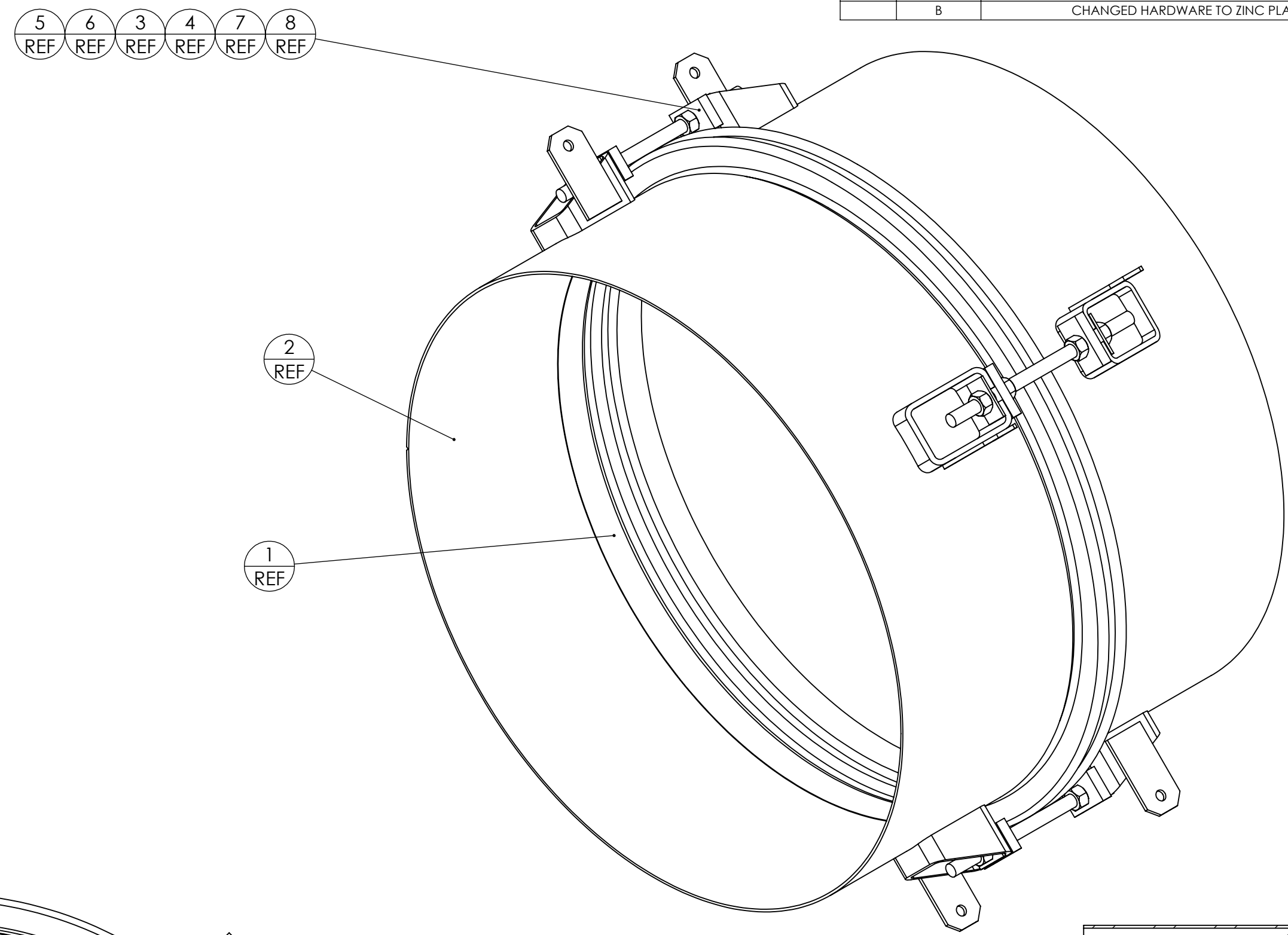
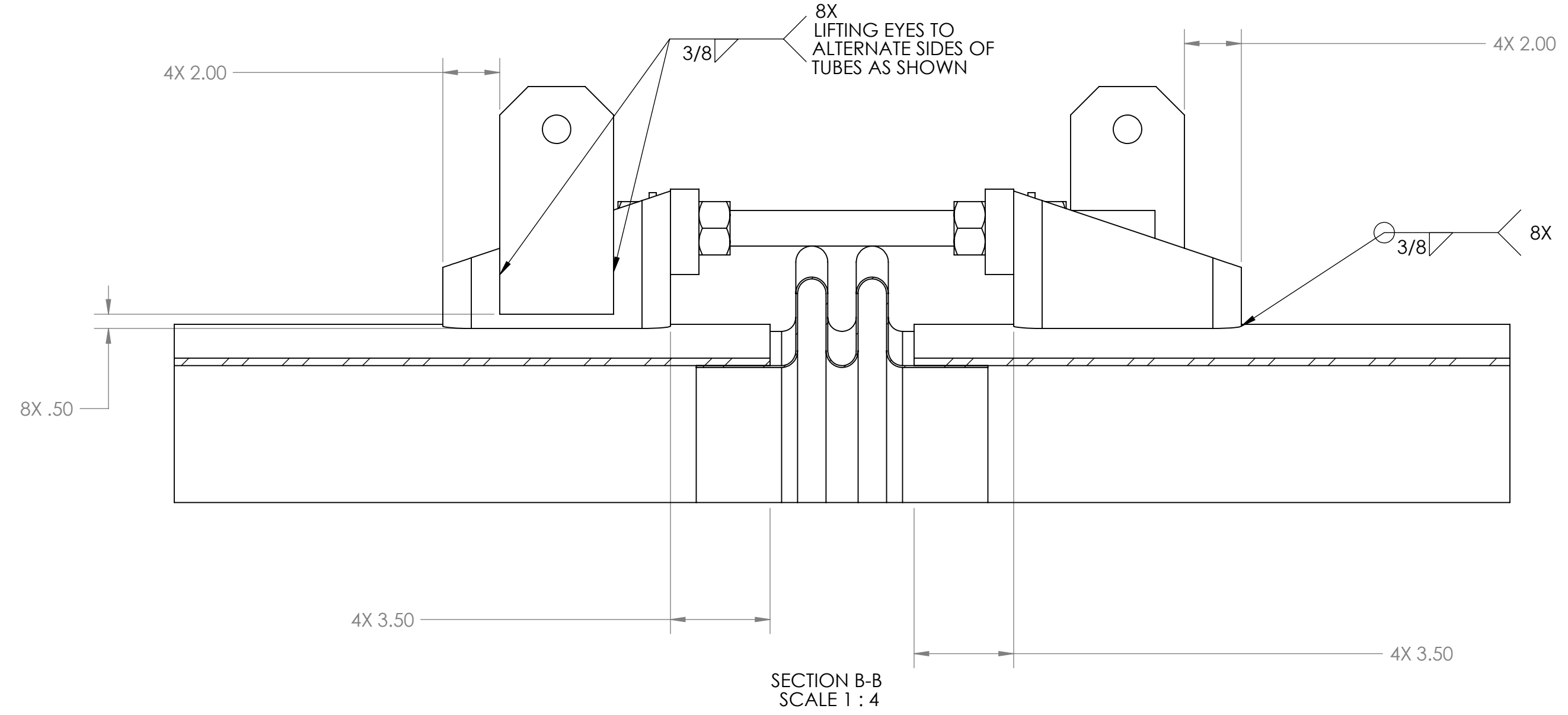


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REVISIONS		DATE	APPROVED
ZONE	REV.	DESCRIPTION	
	A	REVISED BOM AND ASSEMBLY TO MATCH PROCUREMENT PLAN	7/7/2010 MKM2
	B	CHANGED HARDWARE TO ZINC PLATED	8/3/2010 MKM2



- 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 WITH CO2
 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
 8. VENDOR IS RESPONSIBLE FOR VACUUM LEAK TESTING
 9. VENDOR TO SUPPLY LEAK TEST DOCUMENTATION. MAXIMUM ALLOWABLE LEAK RATE IS 1X10⁻⁹ TORR-LITERS/SECOND.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114225-00S	BELLOWS, 60.50 ID	1
2	114224-00S	ROLL-UP, MC BELLOWS NIPPLES	2
3	114226-00S	MOUNT, TIE ROD, MC TUBES	8
4	114227-00S	LIFTING EYE, TIE ROD, LIGO	8
5	N20C3520Z	ROD, THREADED, 1.25-7 UNC, 22.00 LG, ZINC PLATED	4
6	G20C0000Z	HEX NUT, 1-1/4-7, ZINC PLATED	16
7	114233-00S	PLATE, BACKING, NUT, SMALL	8
8	114232-00S	PLATE, BACKING NUT	8

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA-240
 UNLESS OTHERWISE SPECIFIED: WEIGHT: 850.52 #
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: ±10°/30' ±25'
 XXX ±.005
 UNSPECIFIED RADII: R.015
 BREAK EDGES: .010x45°
 REMOVE ALL BURRS
 WITHIN .03

APPROVALS: DATE: 6/18/10
 DRAFTER: MKM2
 CHECKER: RW
 ENGINEER: MKM2

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 www.gnbvalves.com

TITLE: **WELDMENT, BELLOWS SUBASSEMBLY**

DO NOT SCALE DRAWING
 DWG. NO. 114222-00WS
 SCALE: 1:10 SHEET 1 OF 1
 REV B