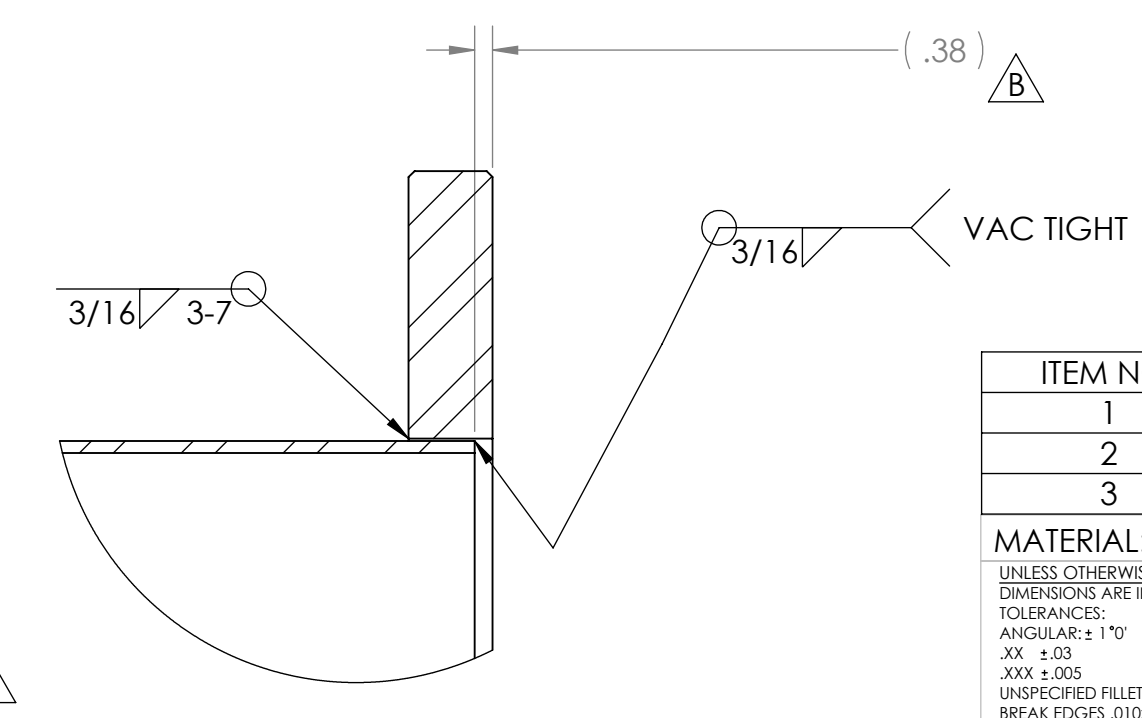
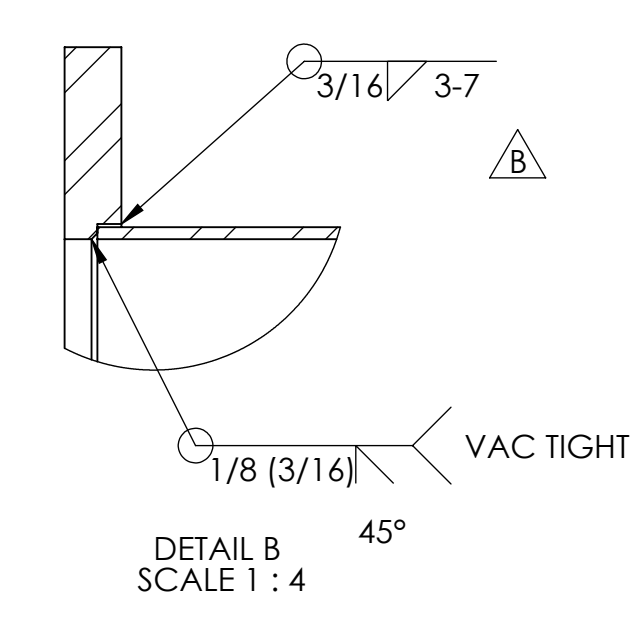
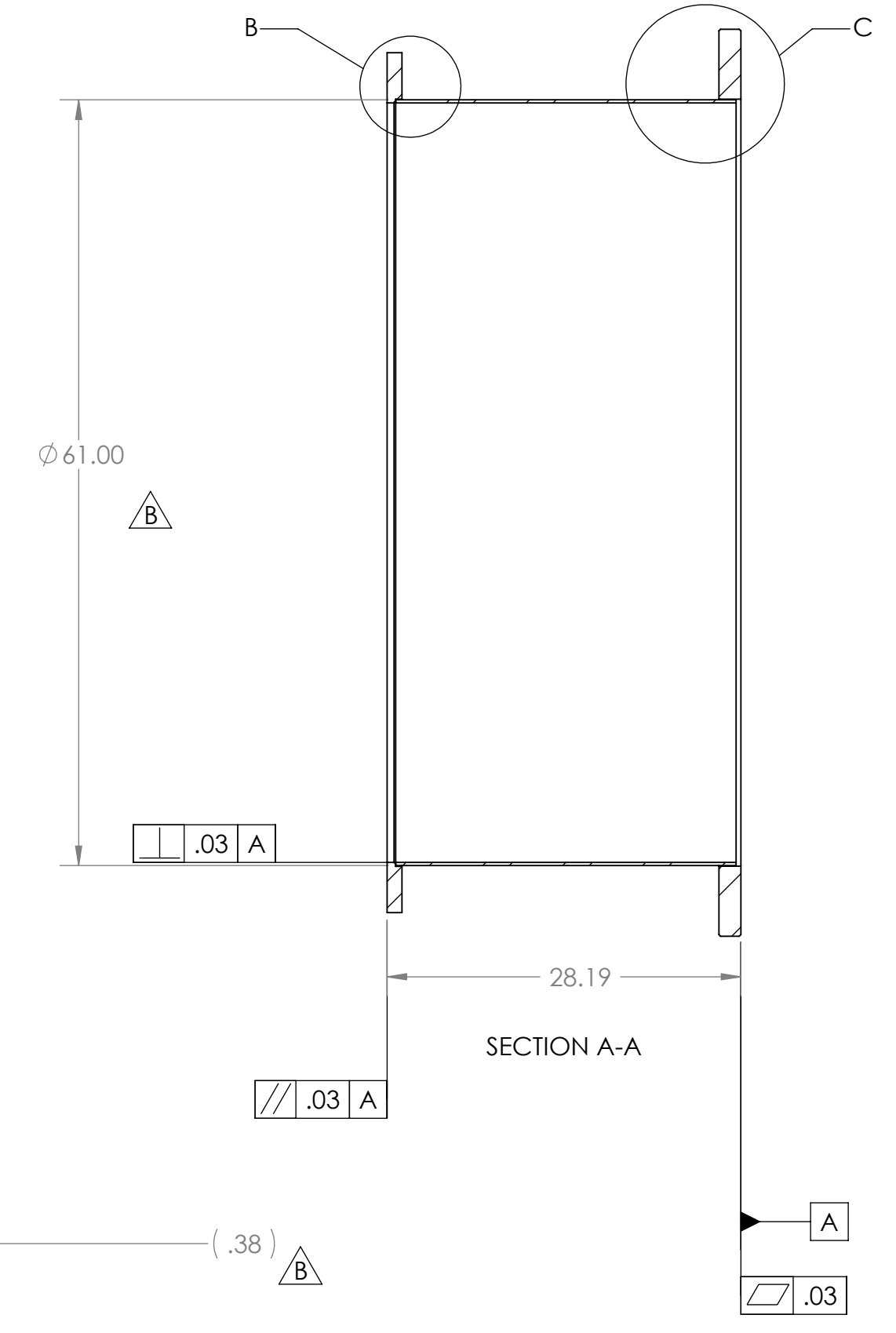
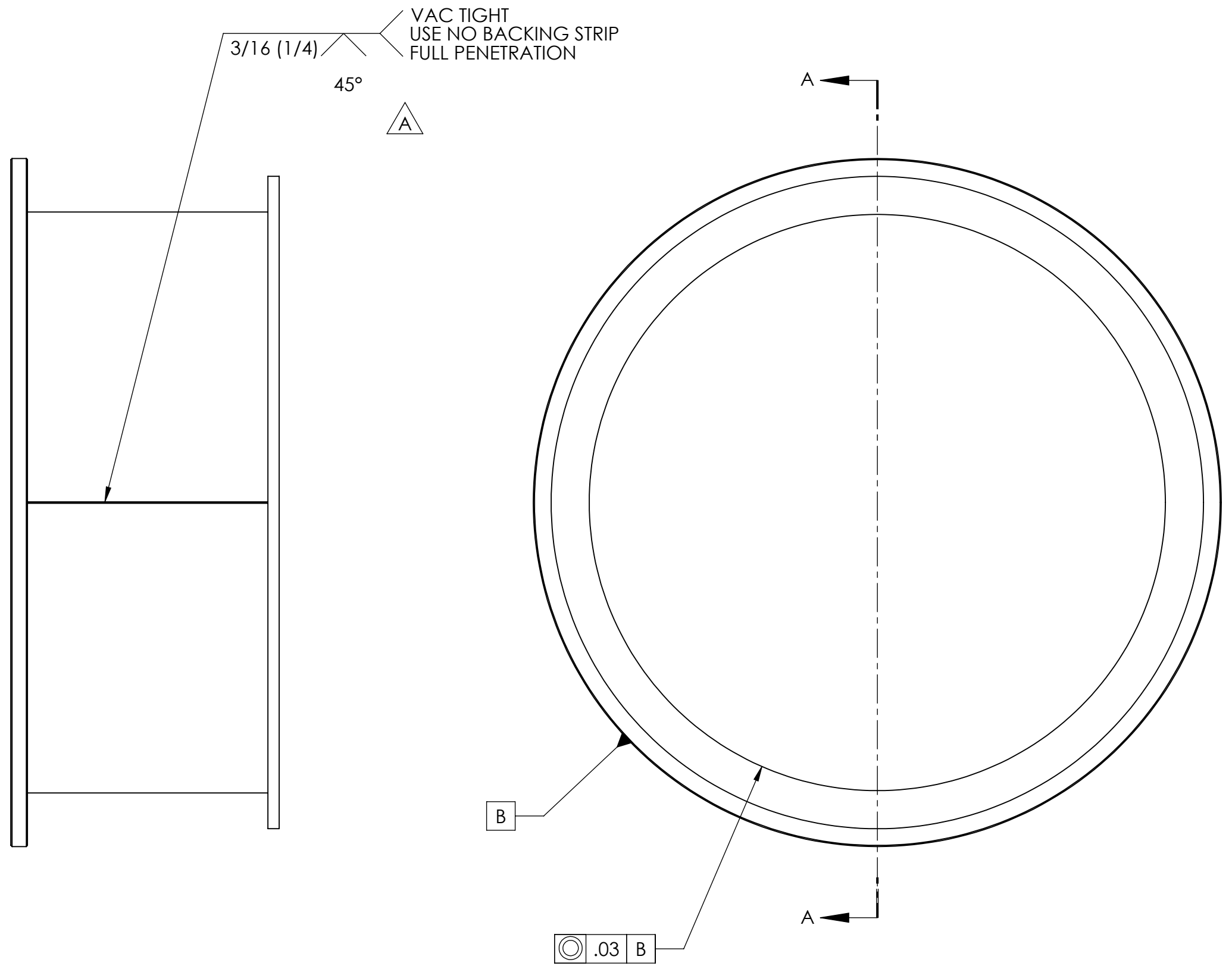


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED WELD CALL-OUTS, ROTATED VIEW TO SHOW SEAM WELD	8/11/2010	MKM2
	B	FIXED WELD SYMBOL, .38 WAS .13, ADDED ROLL-UP OD	8/19/2010	MKM2
	C	RELEASED TO PRODUCTION	8/23/2010	MKM2



- 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 AND SURFACES TO BE WELDED WITH CO2 SCRUBBING
 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

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	114323-00S	FLANGE, SMALL, ADAPTER A-18	1
2	114321-00S	ROLL-UP, ADAPTER A-18, SMALLER	1
3	114318-00S	PLATE, REDUCER, ADAPTER A-18	1

MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA 240
 WEIGHT: 1232.68#

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH
 ANGULAR: ± 1°
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010x45°
 REMOVE ALL BURRS
 // □ ⊥ WITHIN .03

APPROVALS: DATE
 DRAFTER MKM2 6/28/10
 CHECKER RW 7/22/10
 ENGINEER MKM2 6/28/10

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 www.gnbvalves.com

TITLE: **WELDMENT, SMALLER, ADAPTER A-18**

DO NOT SCALE DRAWING	C	DWG. NO. 114315-00WS	REV C
SCALE: 1:12	SHEET 1 OF 1		