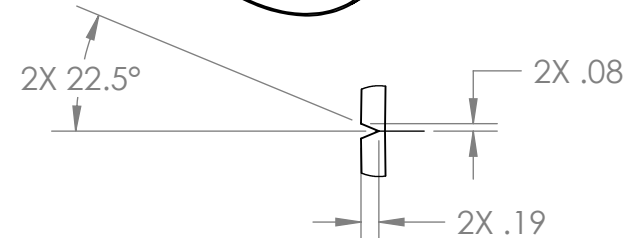
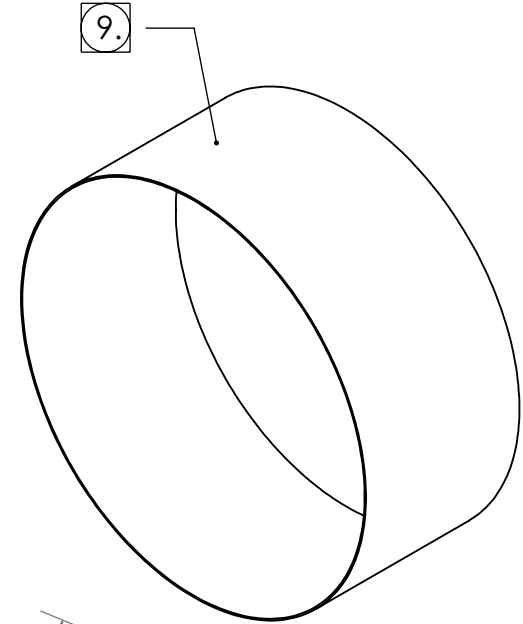
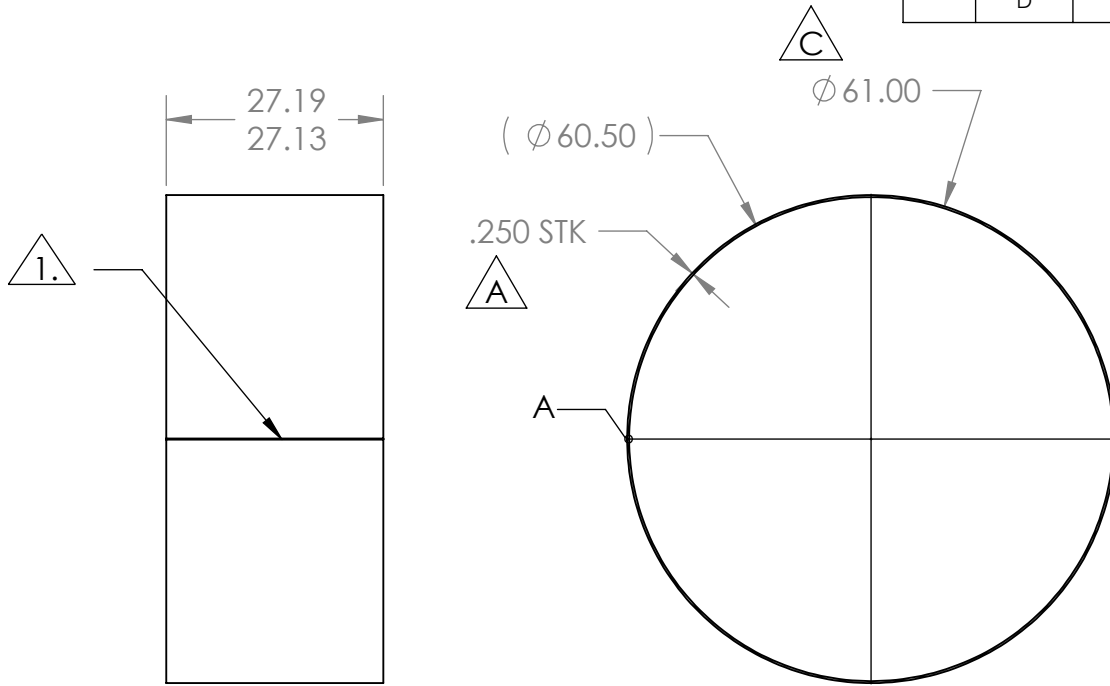


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REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	REVISED THICKNESS, .25 WAS .313	7/1/2010	MKM2
	B	REVISED WELD PREP	8/11/2010	MKM2
	C	REVISED WELD PREP, REMOVED SPECIAL TOLERANCE ON OD	8/19/2010	MKM2
	D	RELEASED TO PRODUCTION	8/20/2010	MKM2



DETAIL A
 SCALE 1 : 2
 WELD PREP DETAIL

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. A 2"X12" COUPON OF MATERIAL FROM THE SAME LOT OF MATERIAL MUST BE PROVIDED WITH EACH PIECE.

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

DESCRIPTION: ROLL-UP, .250 WALL, 60.50 ID, 27.13 LG
 MATERIAL: AISI 304/ AISI 304L DUAL CERT PER SA240

UNLESS OTHERWISE SPECIFIED: WEIGHT: 373.94 #

DIMENSIONS ARE IN INCHES
 TOLERANCES: FINISH 125
 ANGULAR: ± 1°
 .XX ± .03
 .XXX ± .005
 UNSPECIFIED FILLETS: R.015
 BREAK EDGES .010 x 45°
 REMOVE ALL BURRS

APPROVALS

	NAME	DATE
DRAFTER	MKM2	6/14/10
CHECKER	RW	6/14/10
ENGINEER	MKM2	6/14/10

DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION

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TITLE:
 ROLL-UP, ADAPTER A-18, SMALLER

DWG. NO.
 A 114321-00S

SCALE: 1:24 SHEET 1 OF 1

REV
 D