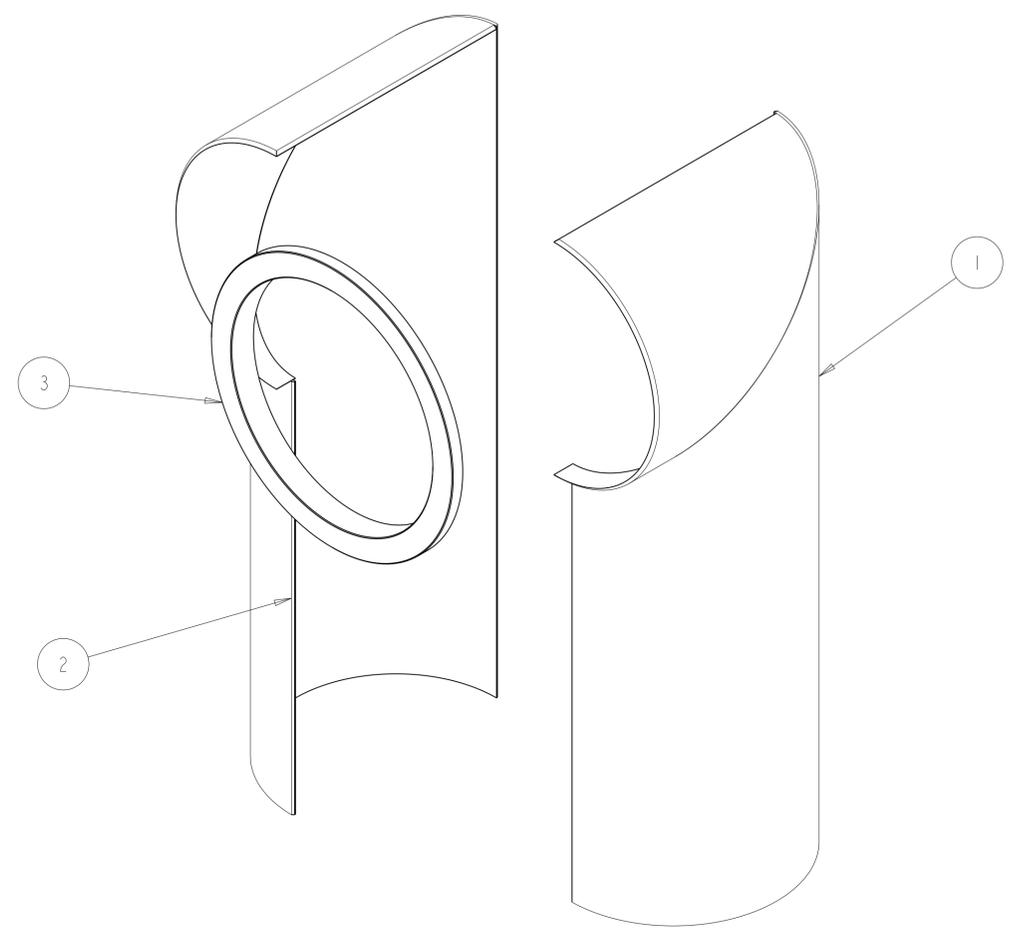
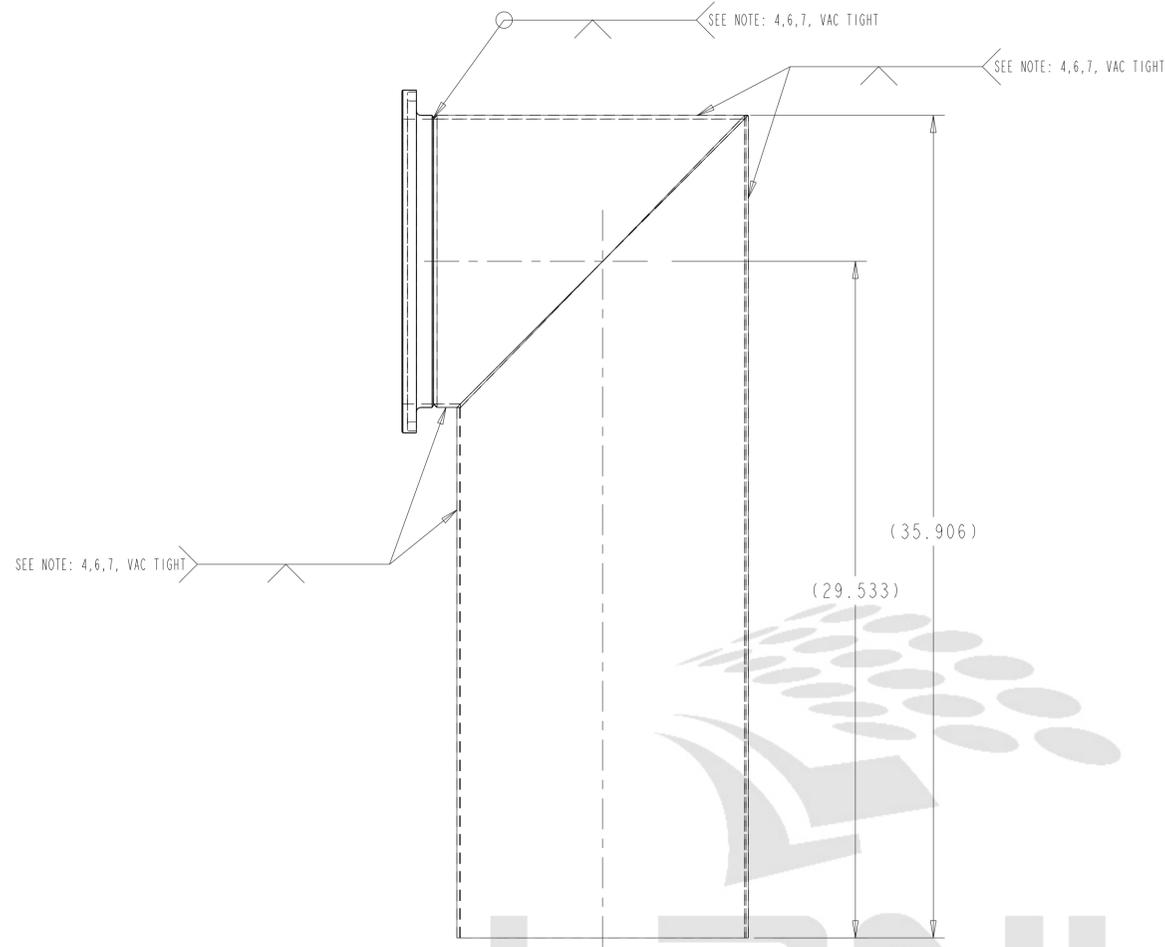
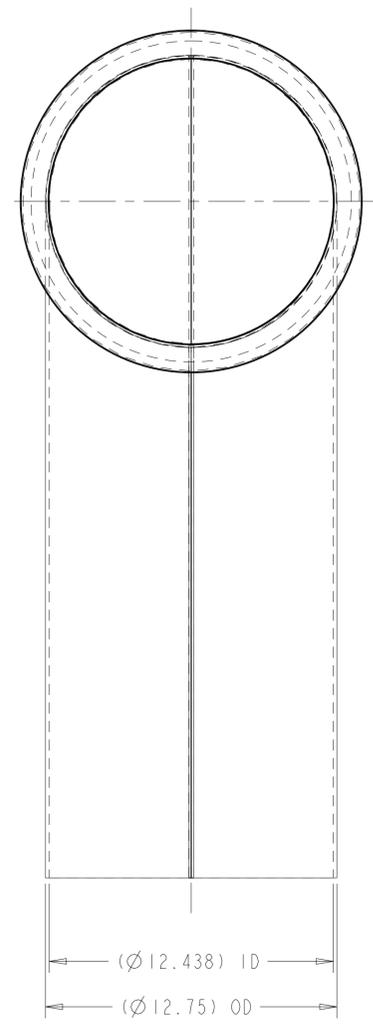
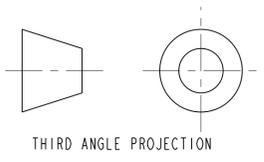


DWG. NO.		SIZE		REV.	SH.
2511674		B		1	
ITEM	PART NO	RECD	DESCRIPTION		MATERIAL
3	251169		ORL CHIMNEY FLANGE		304L SS
2	251323		ENCLOSURE CHIMNEY HALF 2, JC2		304L SS
1	251324		ENCLOSURE CHIMNEY HALF 1, JC2		304L SS



- NOTES: UNLESS OTHERWISE SPECIFIED,
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982 UNITS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
  - USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED
  - USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
  - CLEAN AFTER MACHINING PER VENDOR SPECIFICATION; SUBJECT TO LBNL APPROVAL.
  - VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
  - PERFORM ALL WELDS AT THE TOP ASSEMBLY.
  - ALL VACUUM WELDS TO BE CONTINUOUS FUSION WELDS UTILIZING THE TIG PROCESS AND DONE IN A CLEAN FACILITY. NO FILLER ROD ALLOWED.
  - PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO PROTECT AND MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE.
  - VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE ASSEMBLY; SUBJECT TO LBNL APPROVAL
  - ESTIMATED WEIGHT = 55 LBS

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TOLERANCES		UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE	
X.X ± 0.1	FRAC. ± 1/64							BERKELEY NATIONAL LABORATORY	
X.XX ± 0.01	Angles ± 1.00°							UNIVERSITY OF CALIFORNIA - BERKELEY	
X.XXX ± 0.005	FINISH 125 $\sqrt{Ra}$							LHC IR FEEDBOX	
DO NOT SCALE PRINT								VACUUM	
THREADS ARE CLASS 2								ENCLOSURE JUMPER, JC2	
CHAMFER ENDS OF ALL SCREW TREADS 30°								MICROFILMED:	
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS								DWG. TYPE	
BREAK EDGES .016 MAX. ON MACHINED WORK								ASSEM	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE								SHOWN ON	
IN ACCORDANCE WITH ASME Y14.5M & B46.1								VARIOUS	
								SCALE: 0.250	
								DO NOT SCALE PRINTS	
B	JDR	DPO	10-28-02	CHANGED MATERIAL CALLOUT ITEM 2				SHEET 1 OF 1	
A	RLM	DPO	10-4-02	INITIAL RELEASE				DWG. NO.	
REV	DWG	CHK	ZONE	DATE	CHANGES			2511674	
								REV.	
								B	

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Released: March 5th, 2003 DCC Auth Key: 8G1BHMD4FQ