

8 7 6 5 4 3 1

DWG. NO.	2513034	SIZE	D	REV.	1	SH.	1
3	-	1	TUBE, PER ASTM A269				SS 304L
2	-	1	THERMOMETER MOUNTING PAD, 12X1mm, CERN #LHCLHC01TP_0002				-
1	-	1	COLLAR				SS 304L
ITEM	PART NO	REQD	DESCRIPTION				MATERIAL

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] 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.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.
- A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ±0.063".
- PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.

SCALE 3/16

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO. -		ERNEST ORLANDO LAWRENCE	
X.X ± 0.1		ACCT. NO.		NO. -		BERKELEY NATIONAL LABORATORY	
X.XX ± 0.03		DEL. TO		DATE ISSD -		UNIVERSITY OF CALIFORNIA - BERKELEY	
X.XXX ± 0.010		PROJECT NAME		DATE RECD -		LHC IR FEEDBOX	
FINISH 125 $\sqrt{Ra}$		PROJECT TAG		DATE RECD -		CRYOGENICS	
TOLERANCES		PROJECT NUMBER		DATE RECD -		PIPE, CYI, DFBX B, D&H	
DO NOT SCALE PRINT		PROJECT NAME		DATE RECD -		MICROFILMED: -	
THREADS ARE CLASS 2		PROJECT NAME		DATE RECD -		DWG. TYPE: ASSEM	
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NAME		DATE RECD -		SHOWN ON: -	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		PROJECT NAME		DATE RECD -		SCALE: 1/4	
BREAK EDGES .016 MAX. ON MACHINED WORK		PROJECT NAME		DATE RECD -		DO NOT SCALE PRINTS	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		PROJECT NAME		DATE RECD -		SHEET 1 OF 1	
IN ACCORDANCE WITH ASME Y14.5M & B&E.1		PROJECT NAME		DATE RECD -		DWG. NO. 2513034	
REV	DWG	CHK	ZONE	DATE	CHANGES	PATENT CLEAR: Z5LCE2	REV. D

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