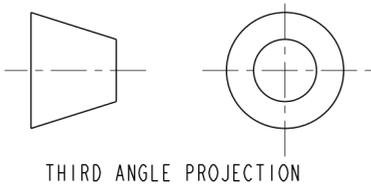
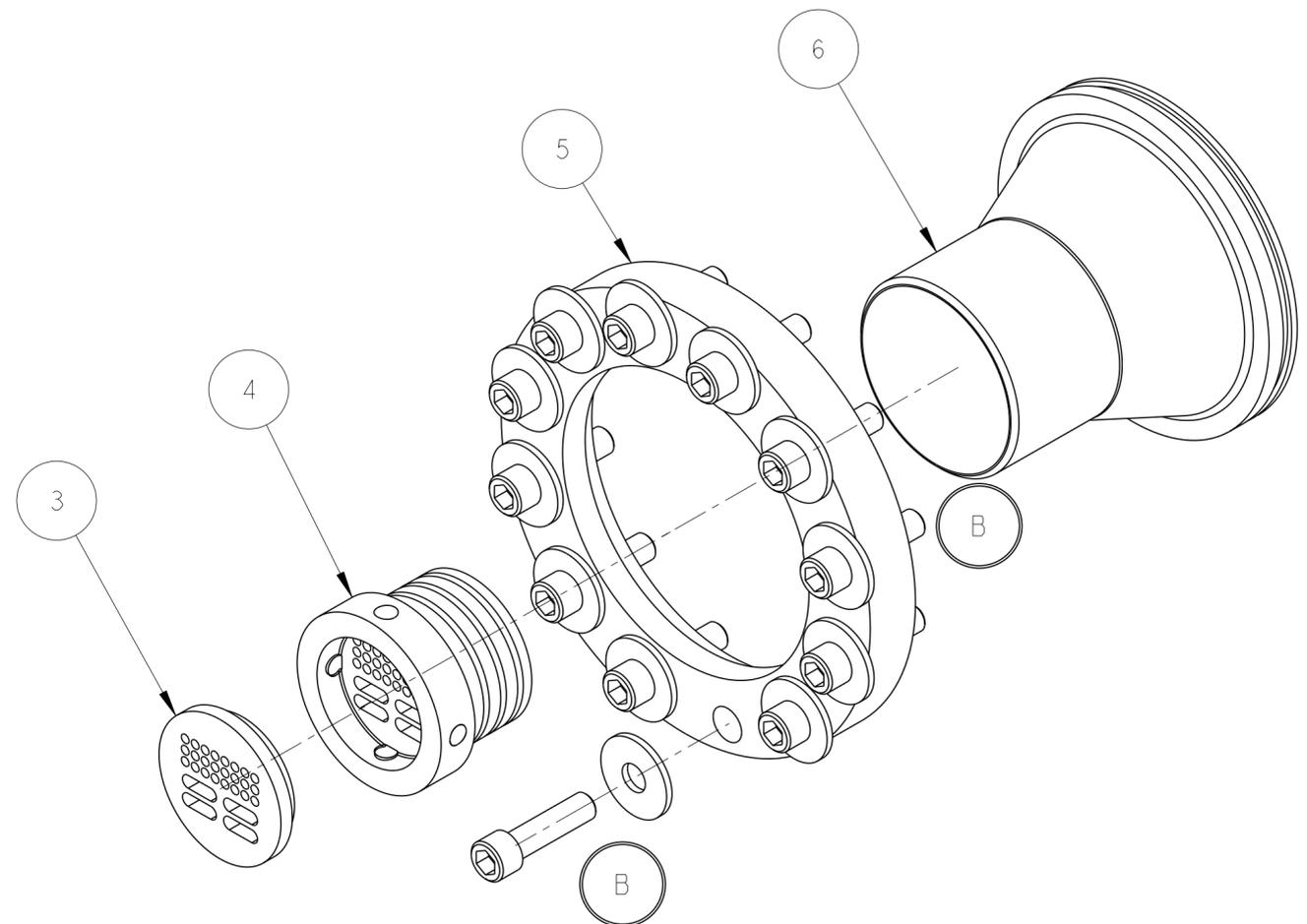
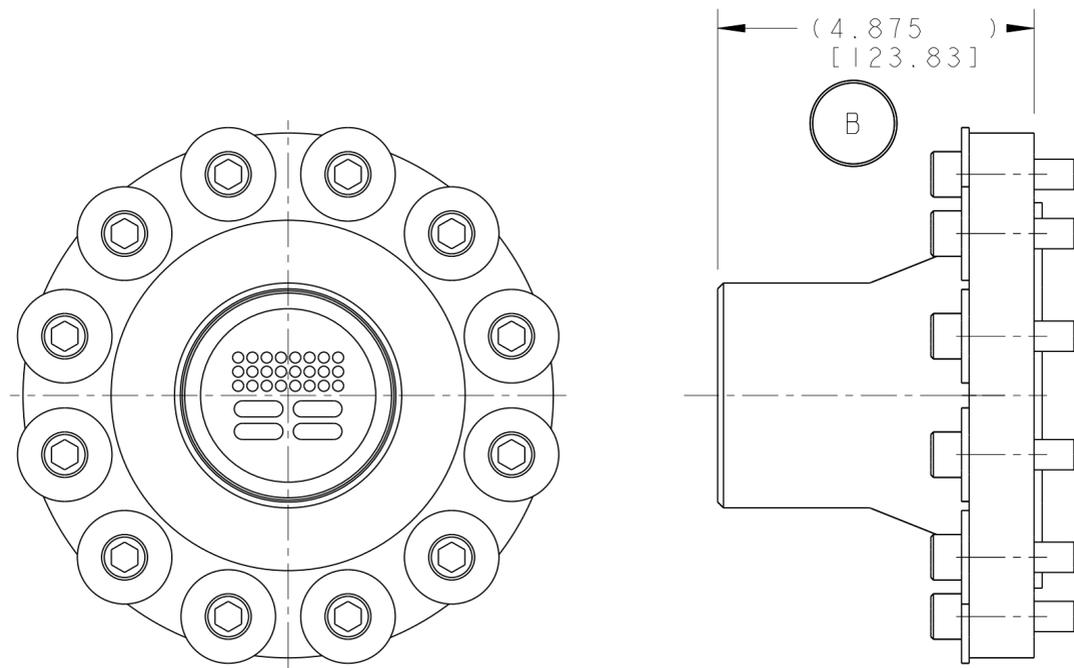


NOTES: (UNLESS OTHERWISE SPECIFIED)

1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
6	251448	1	LAMBDA PLUG, WELD NECK FLANGE	SS 304L
5	251447	1	LAMBDA PLUG, TIE DOWN RING	SS 304L
4	25M946	1	LAMBDA PLUG MAIN BODY	
3	25M947	1	LAMBDA PLUG CAP	-
2	-	12	WASHER, M12, MC MASTER #91116A180	SS
1	-	12	SHCS M12, 45mm LG., MC MASTER #91292A229	SS



REV	DWG	CHK	ZONE	DATE	CHANGES
B	RLM	JPZ		1/8/03	25M946 WAS ERRONEOUSLY NAMED 25H404; 25M947 WAS ERRONEOUSLY NAMED 25H403; EXPLODED VIEW CORRECTION; DIM TO SHOW AS INSTALLED M12 SCREW WAS 40LG, M12 WSHR WAS SMALLER OD
A	ARH	DPO		9-16-02	INITIAL RELEASE

TOLERANCES		SHOP ORDERS		SER NO.
X.X ± 0.1	FRAC. ± 1/64	ACCT NO.	NO. REQD	DATE ISSD
X.XX ± 0.03	Angles ± 1.00°	DEL TO		DATE REQD
X.XXX ± 0.010	FINISH $\sqrt{125}$ (µin)	SURFACE TREATMT		
DO NOT SCALE PRINT		IDENT METHOD	TAG	
THREADS ARE CLASS 2		PROJECT NUMBER	N/A	
CHAMFER ENDS OF ALL SCREW TREADS 30°		PROJECT NAME	N/A	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG BY	KNOLLS	DATE 31-JUL-02
BREAK EDGES .016 MAX. ON MACHINED WORK		CHK BY	ZBASNIK, OSHATZ	DATE 31-JUL-02
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		APR BY	ZBASNIK, OSHATZ	DATE 31-JUL-02
IN ACCORDANCE WITH ASME Y14.5M & B46.1				

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY					
LHC IR FEEDBOX CRYOGENICS LAMBDA PLUG ASSY					
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1/2	DO NOT SCALE PRINTS	
	ASSEM	-		SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
	Z5LCE2	LH2003	25H4003	B	

DWG. NO. 25H4003 B 1
 SIZE REV. SH. 1