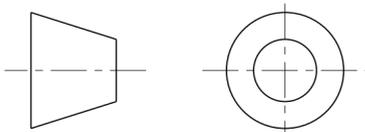
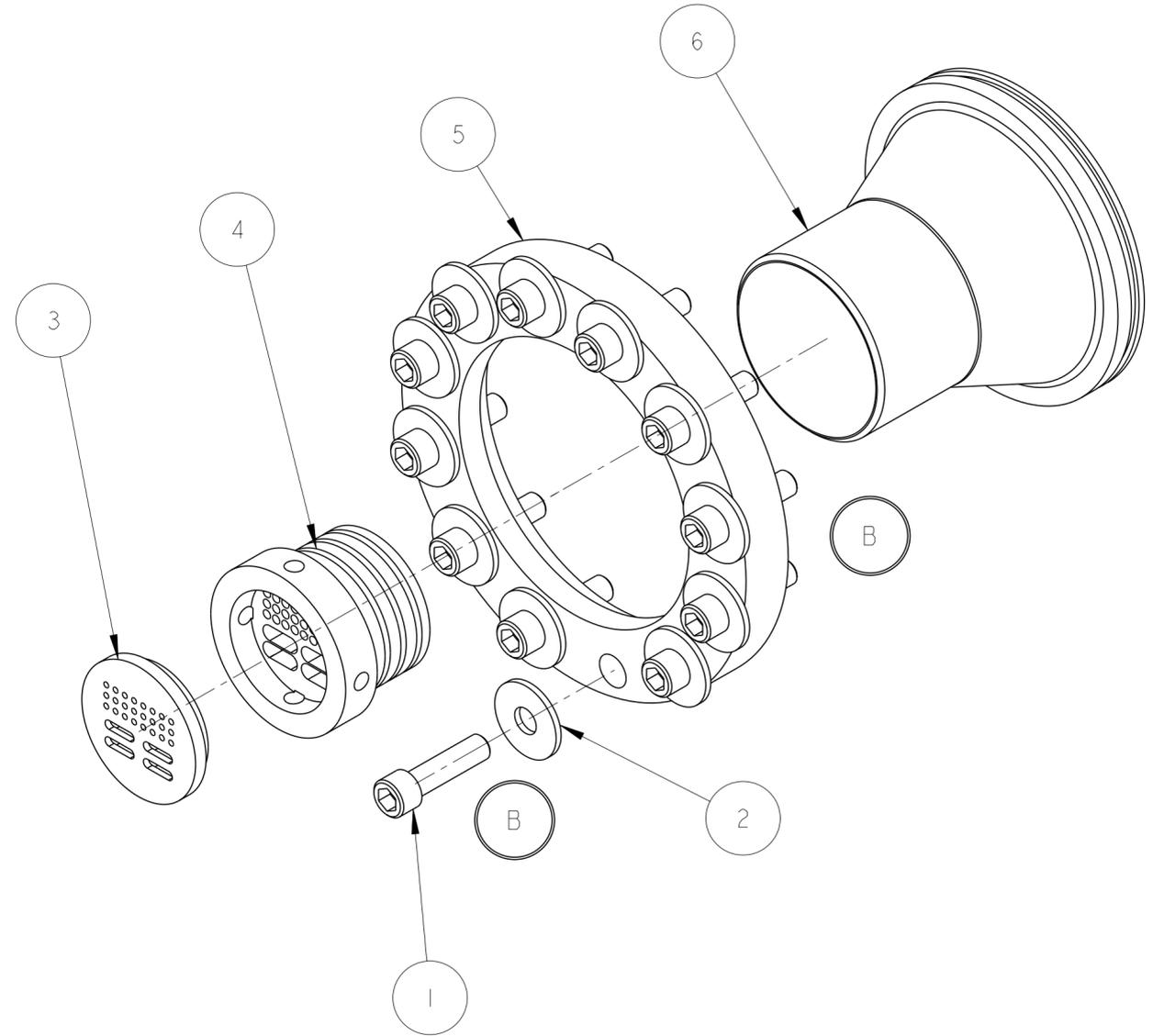
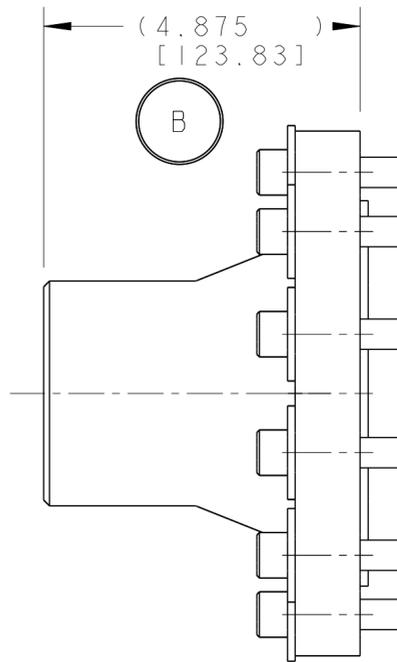
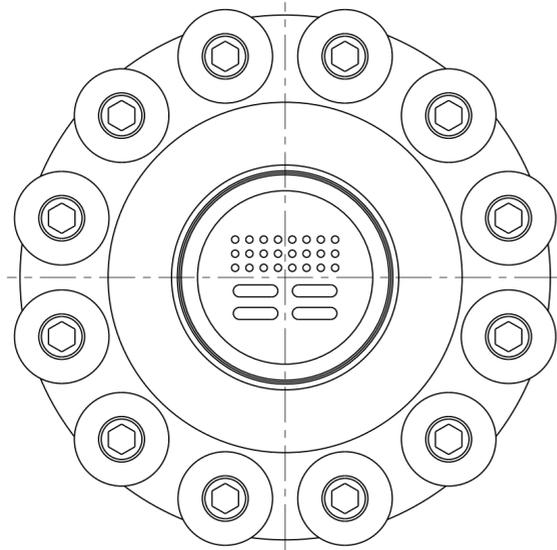


NOTES: (UNLESS OTHERWISE SPECIFIED)

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	251483	1	LAMBDA PLUG MAIN BODY, MQXI	NEMA G10-CR
3	251484	1	LAMBDA PLUG CAP, MQXI	NEMA G10
2	-	12	WASHER, M12, MC MASTER #91116A180	SS
1	-	12	SHCS M12, 45mm LG., MC MASTER #91292A229	SS



THIRD ANGLE PROJECTION

REV	DWG	CHK	ZONE	DATE	CHANGES	TOLERANCES	UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	SER. NO.	DATE	ISSD	DATE	REQD	DATE	REQD	MATERIAL	DESCRIPTION	
C	RLM	JPZ		6/23/03	25M946 REPLACED BY 251483; 25M947 REPLACED BY 251484; CLARIFIED TITLE	X.X ± 0.1	FRAC. ± 1/64	ACCT. NO.	-	-	-	-	-	-	-	-	-	-
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	X.XX ± 0.03	Angles ± 1.00°	DEL TO	-	-	-	-	-	-	-	-	-	-
A	ARH	DPO		9-16-02	INITIAL RELEASE	X.XXX ± 0.010	FINISH $\sqrt{25}$ (µin)	IDENT. METHOD	TAG	-	-	-	-	-	-	-	-	-
					CHANGES	DO NOT SCALE PRINT		PROJECT NUMBER	N/A	LHC IR FEEDBOX		SCALE: 1/2		DO NOT SCALE PRINTS		ERNEST ORLANDO LAWRENCE		
						THREADS ARE CLASS 2		PROJECT NAME	N/A	CRYOGENICS		SHEET 1 OF 1		UNIVERSITY OF CALIFORNIA - BERKELEY		LAMBDA PLUG ASSY, MQXI		
						CHAMFER ENDS OF ALL SCREW TREADS 30°		DWG BY	KNOLLS	DATE	31-JUL-02	ASSEM		Z5LCE2		LH2003		
						CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		CHK BY	ZBASNIK, OSHATZ	DATE	31-JUL-02	PATENT CLEAR:		Z5LCE2		LH2003		
						BREAK EDGES .016 MAX. ON MACHINED WORK		APR BY	ZBASNIK, OSHATZ	DATE	31-JUL-02	DESIGN ACCT. NO.		Z5LCE2		LH2003		
						REMOVE BURRS, WELD SPLATTER & LOOSE SCALE						CATEGORY CODE		LH2003		25H4003		
						IN ACCORDANCE WITH ASME Y14.5M & B46.1						DWG. NO.		25H4003		C		

DWG. NO. 25H4003 REV. C 1

REV. 1/23/03 J. VORPHEI