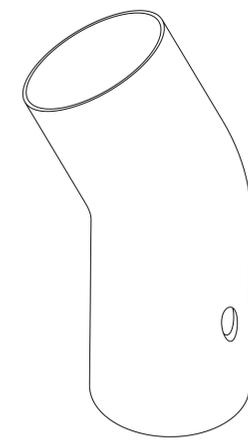
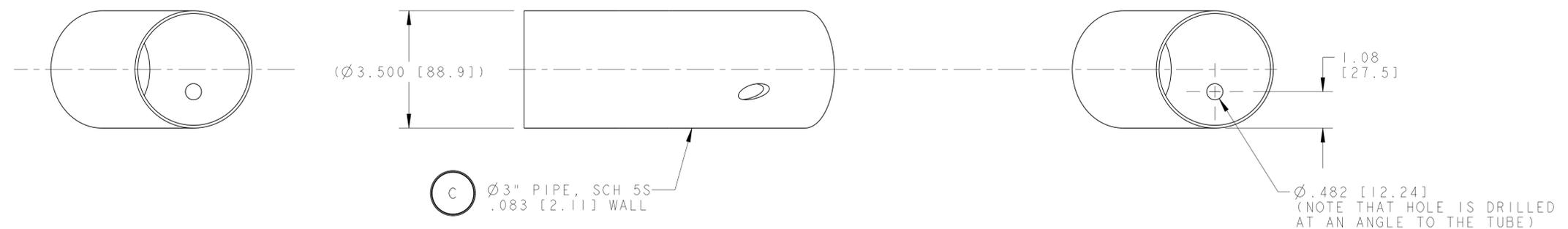
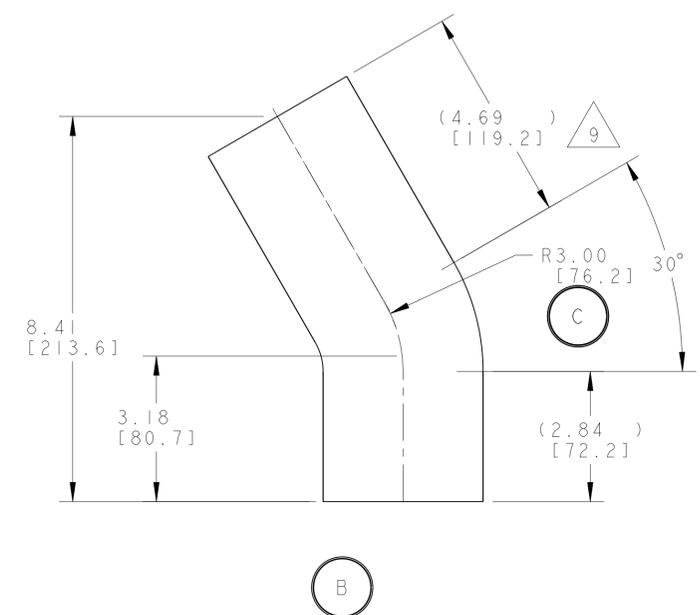


NOTES: (UNLESS OTHERWISE SPECIFIED)

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.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.

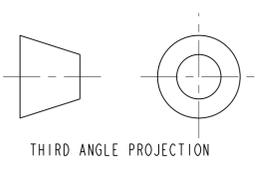


SCALE 1/2



Ø 3" PIPE, SCH 5S
.083 [2.11] WALL

Ø .482 [12.24]
(NOTE THAT HOLE IS DRILLED AT AN ANGLE TO THE TUBE)



REV	DWG	CHK	ZONE	DATE	CHANGES
C	RLM	JPZ		6/9/03	3" PIPE SCH5S WAS A 3.5" TUBE, R3.0 WAS R3.5
B	ARH	SPV		12-09-02	ADDED DWG NOTES 12 & 13, REMOVED HIDDEN LINES, MOVED DWG DIM, CHANGED MATERIAL CALLOUT FROM PIPE TO TUBE & UPDATED DWG CALLOUT, MINOR DRAWING DIMENSIONAL CHANGES
A	ARH	DPO		9/19/02	INITIAL RELEASE

TOLERANCES		SHOP ORDERS	
X.X ± 0.1	FRAC. ± 1/64	ACCT. NO.	SER. NO.
X.XX ± 0.03	Angles ± 1.00°	NO. REQD.	DATE ISSD.
X.XXX ± 0.010	FINISH 125 \sqrt{Ra}	DATE RECD.	
DO NOT SCALE PRINT		SURFACE TREATMENT	
THREADS ARE CLASS 2		IDENT. TAG	
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NUMBER	
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS		PROJECT NAME	
BREAK EDGES .016 MAX. ON MACHINED WORK		DWG. NO.	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		DATE	
IN ACCORDANCE WITH ASME Y14.5M & B46.1		BY	

**ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY**
UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
CRYOGENICS
PIPE, XB, SURGE TANK ATTACHMENT

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1/2	DO NOT SCALE PRINTS
	PART			
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE
	Z5LCE2	LH2003	2512204	REV. C

SHEET 1 OF 1