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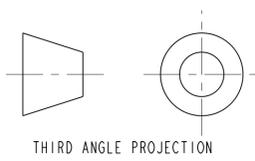
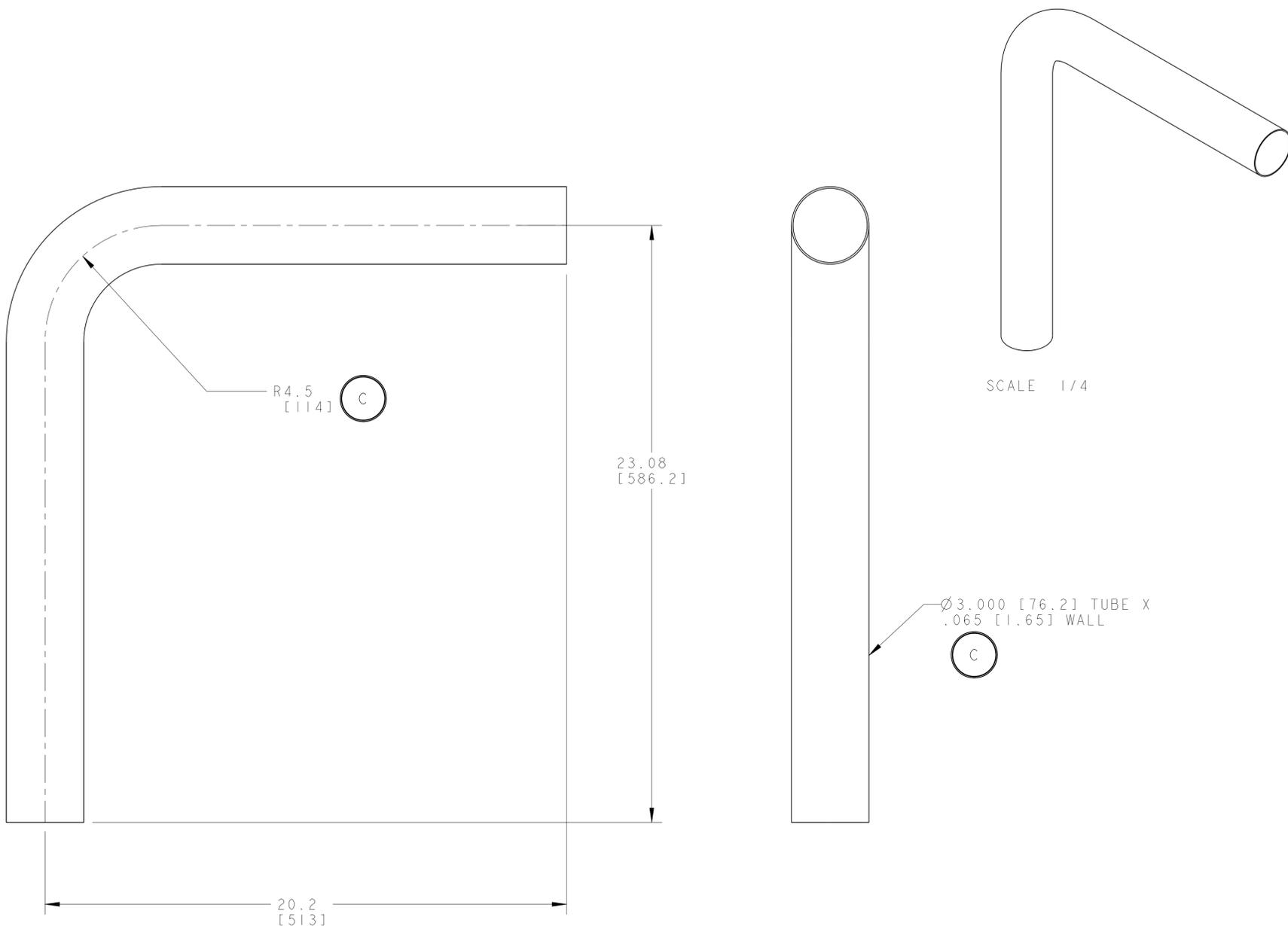
DWG. NO. 2512214 SIZE REV. C 1 SH.

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DESCRIPTION	MATERIAL	MAT. LOCATION
TUBE, PER ASTM A269	SS 304L	-

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; SUBECT 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. (B)
-
- 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. (B)



REV	DWG	CHK	ZONE	DATE	CHANGES
C	RLM	JPZ		6/9/03	TUBE WALL THK FROM .079 TO .065, BEND RADIUS TO ACCOMMODATE 90° ELBOW, SUCH AS MDC #403512.
B	ARH	SPV		01/09/03	REVISED DRAWING NOTE 13 & 16 MINOR DRAWING DIMENSIONAL CHANGES.
A	ARH	DPO		9/19/02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED	
X.X ± 0.1	FRAC. ± 1/64
X.XX ± 0.03	Angles ± 1.00°
X.XXX ± 0.010	FINISH 125 \sqrt{Ra}
DO NOT SCALE PRINT	
THREADS ARE CLASS 2	
CHAMFER ENDS OF ALL SCREW THREADS 30°	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS	
BREAK EDGES .016 MAX. ON MACHINED WORK	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE	
IN ACCORDANCE WITH ASME Y14.5M & B46.1	

SHOP ORDERS		SER. NO. -
ACCT. NO.	NO.	DATE ISSD -
DEL. TO	NO.	DATE RECD -
SURFACE TREATMT		
IDENT. METHOD	TAG	
PROJECT NUMBER	N/A	
PROJECT NAME	N/A	
DWG. NO.	DATE	27-JUL-02
CHK. BY	DATE	27-JUL-02
APP. BY	DATE	27-JUL-02

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

LHC IR FEEDBOX
CRYOGENICS
XB SURGE TANK ATTACHMENT

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 3/8	DO NOT SCALE PRINTS
	PART	-		
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE
	Z5LCE2	LH2003	2512214	REV. C

SHEET 1 OF 1

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