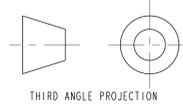


SCALE 7/32

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.
- 14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE DEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF 0.063".
- 15. 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.
- 16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- 17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.



REV	DWG	CHK	ZONE	DATE	CHANGES
B	ARH	DPO		02/26/03	ADDED VIEW DIMENSIONS TO SHEET 2, REMOVED UN-NECESSARY WELD CALLOUTS
A	ARH	SPV		10-23-02	INITIAL RELEASE

ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
4	-	2	WELD RING, 10 75mm, FINAL SUPPLIED	SS 304L
3	25M916	1	PIPE WELDMENT, LD ORL / LD CROSSOVER	-
2	25M859	1	PIPE WELDMENT, MDX1	-
1	25M857	1	PIPE WELDMENT, MDX1	-

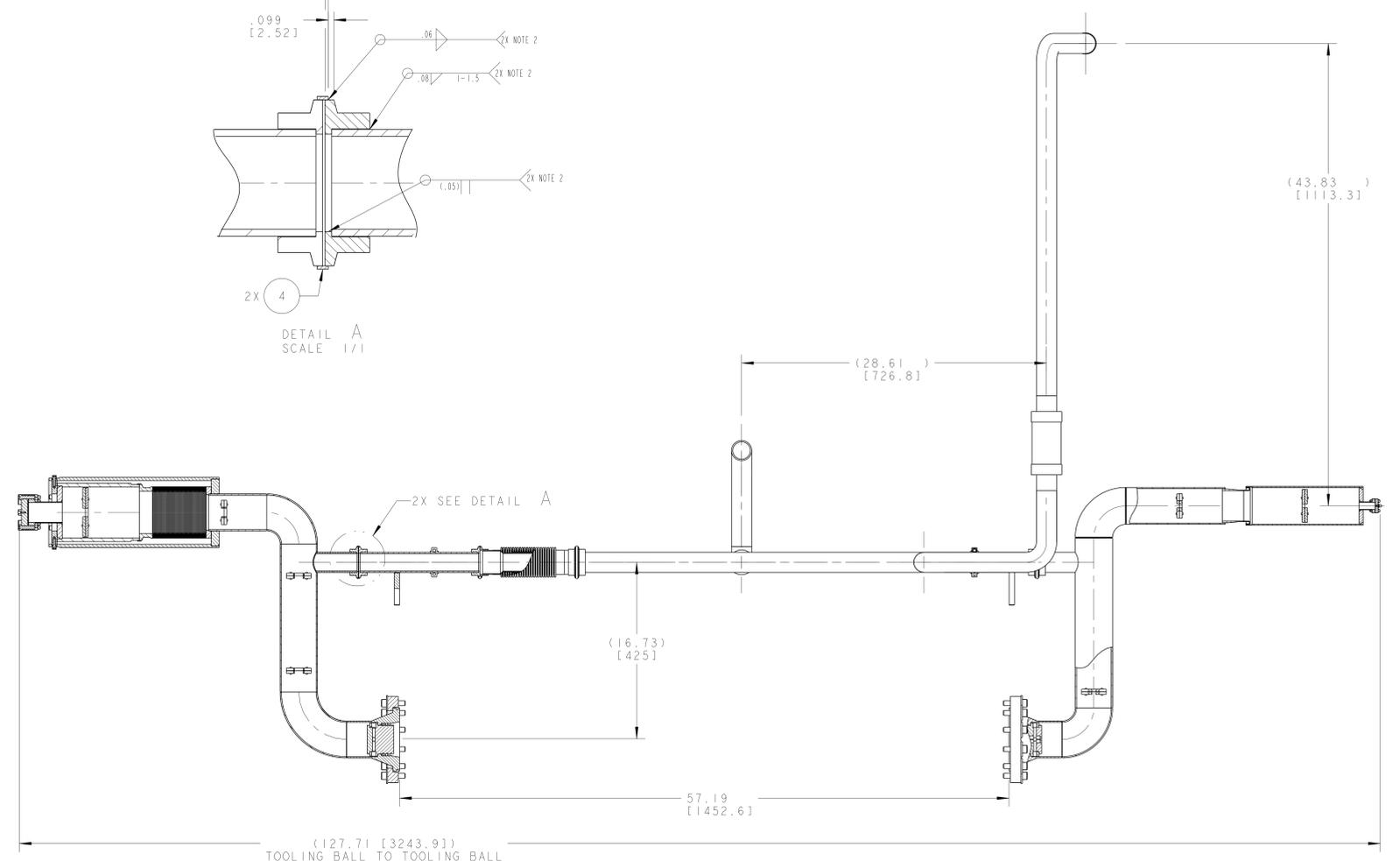
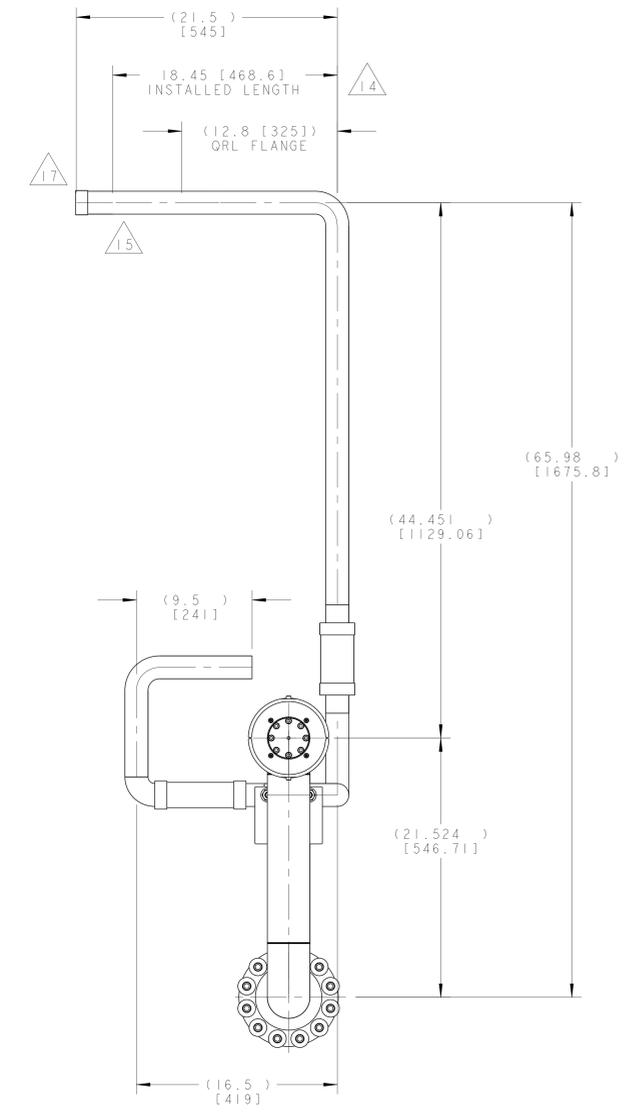
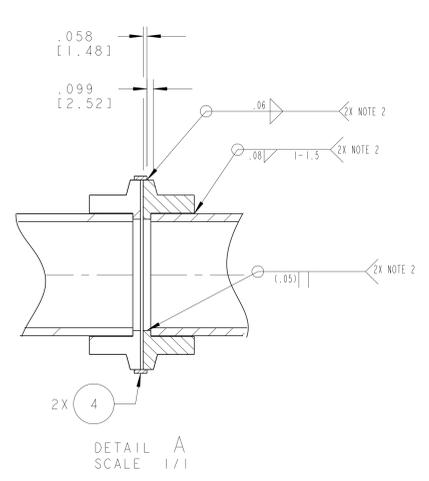
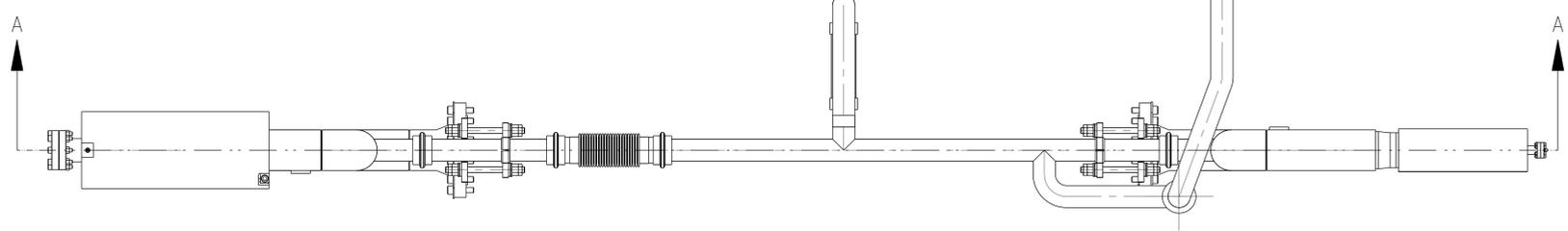
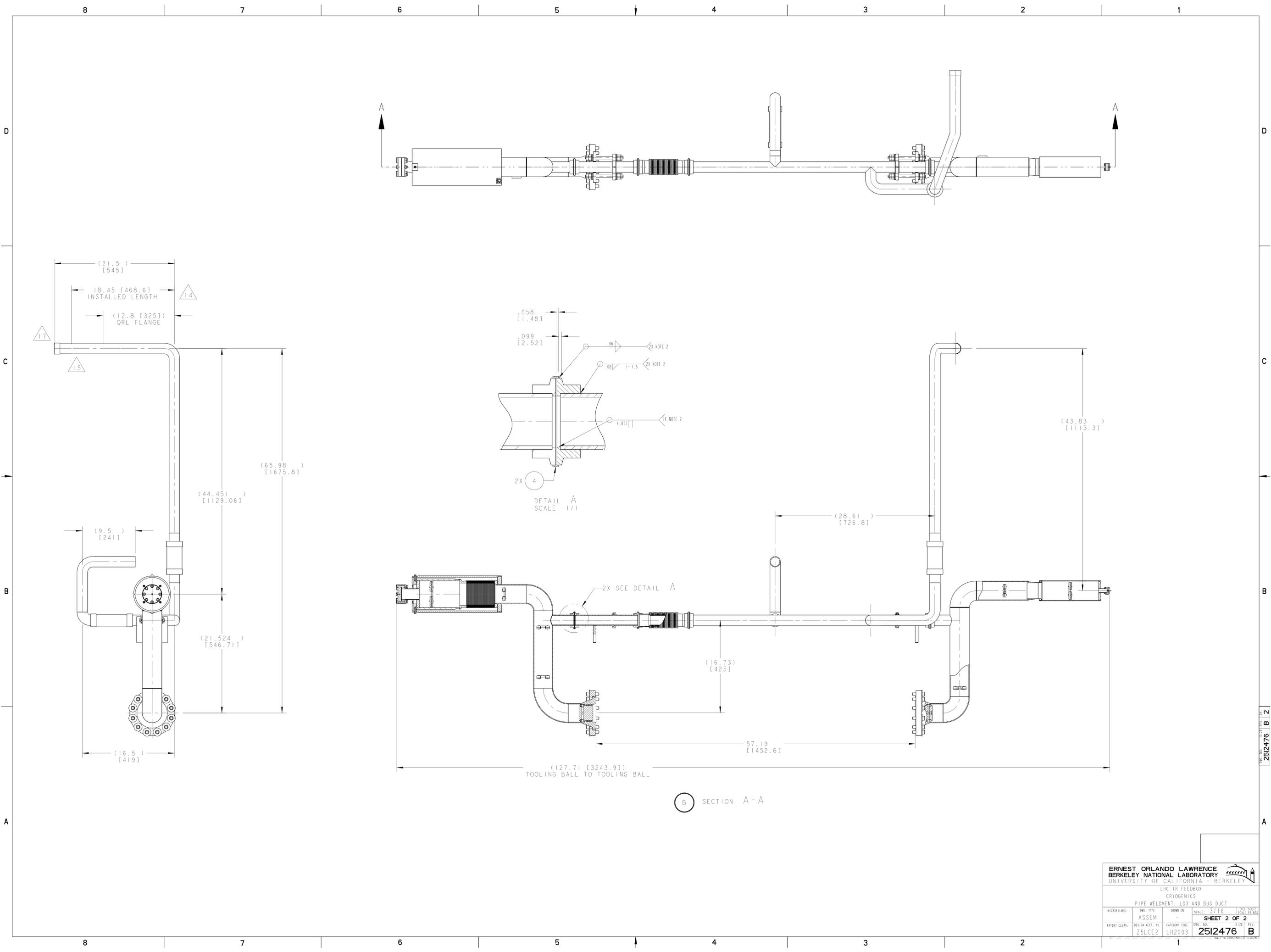
UNLESS OTHERWISE SPECIFIED:
 DECIMALS: X.X ± 0.1 FRACTIONS: 1/64
 TOLERANCES: X.XX ± 0.03 ANGLES: ± 1.00°
 SURFACE FINISH: X.XXX ± 0.010 FINISH: 125 μm
 DO NOT SCALE PRINT
 TITLES AND CLASSES:
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 BREAK EDGES .016 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ADME 114-SM-1-ENG-1

SHOP ORDERS
 DATE: 10-Apr-02
 DATE: 22-Oct-02
 DATE: 22-Oct-02

ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 PIPE WELDMENT, LD3 AND BUS DUCT

MICROFILMED: DWG. TYPE: SHOWN ON: SCALE: 3/16 DO NOT SCALE PRINTS
 ASSEM - SHEET 1 OF 2
 PATENT CLEAR: DESIGN ACCT. NO: CATEGORY CODE: DWG. NO: 2512476
 ZSLCE2 LH2003



(B) SECTION A-A

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY			
LHC IR FEEDBOX CRYOGENICS			
PIPE WELDMENT, LD3 AND BUS DUCT			
MICROFILMED:	DWG. TYPE:	SHOWN ON:	SCALE: 3/16
	ASSEM	-	DO NOT SCALE PRINTS
PATENT CLEAR:	DESIGN ACCT. NO:	CATEGORY CODE:	DWG. NO. 2512476
	ZSLCE2	LH2003	SIZE: REV. B