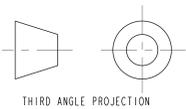
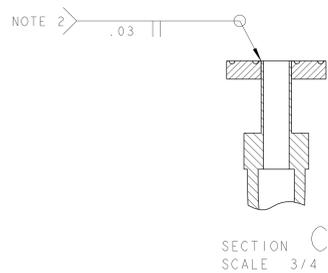
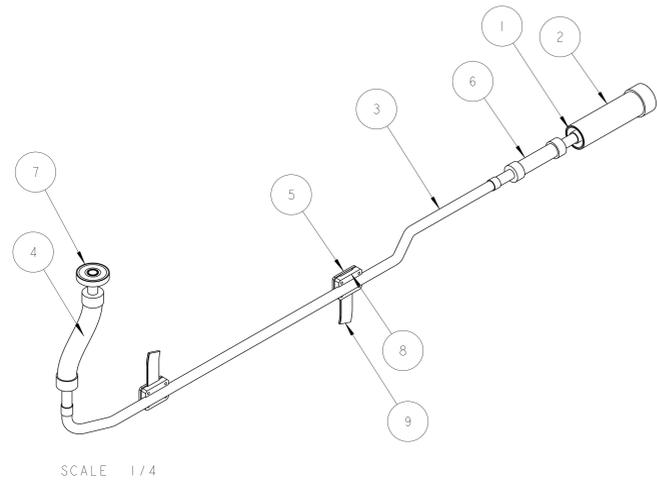
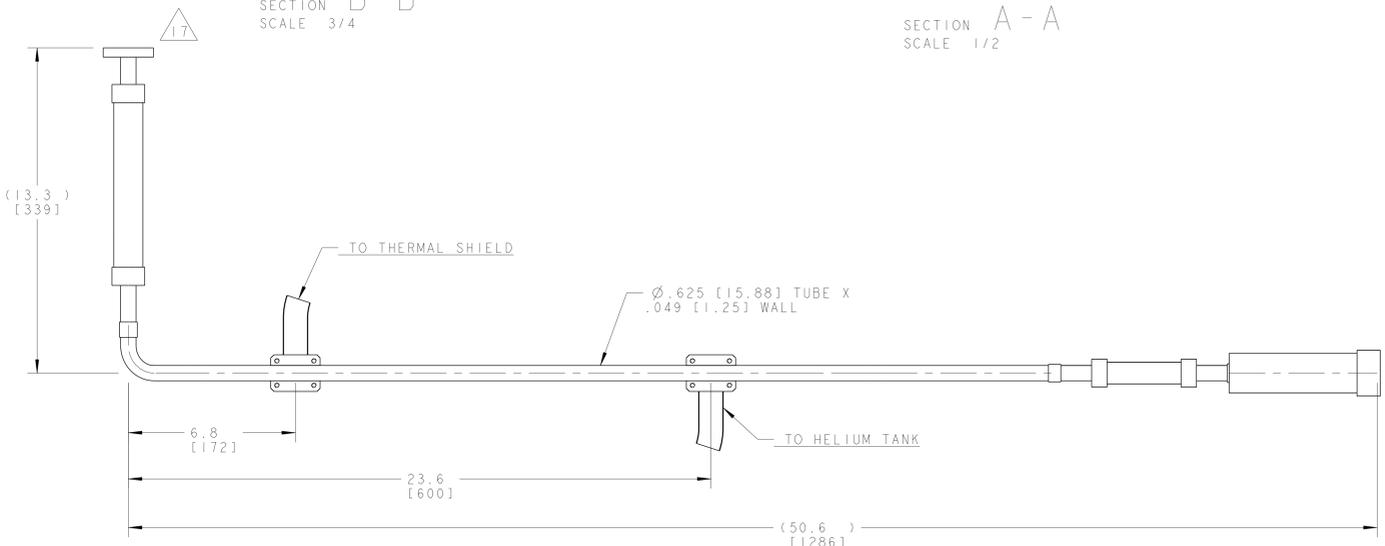
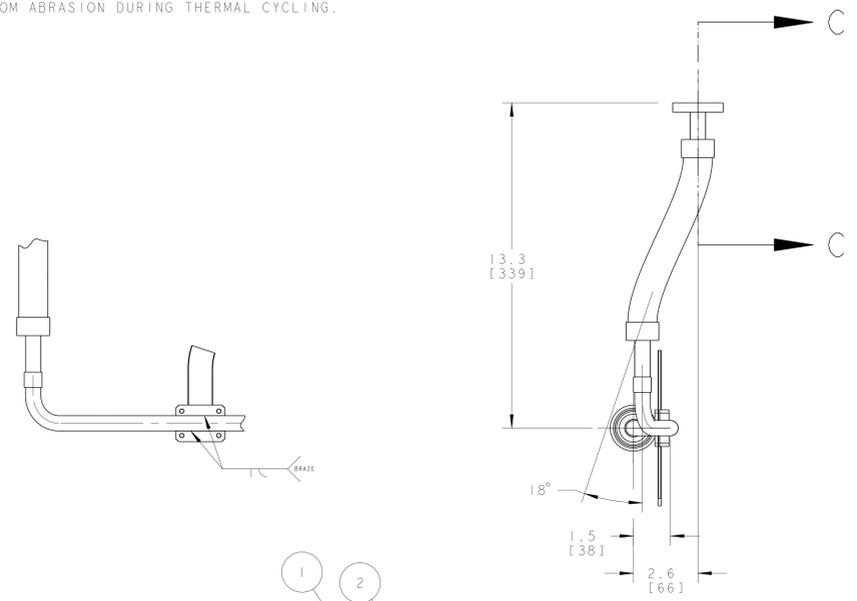
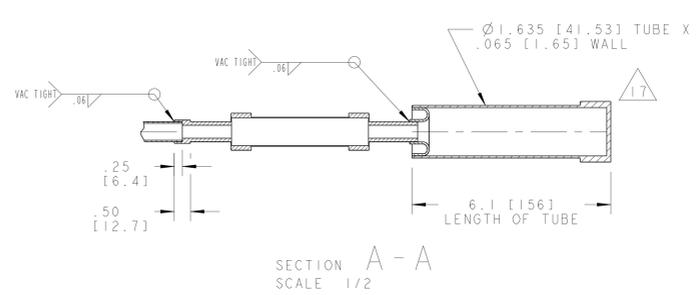
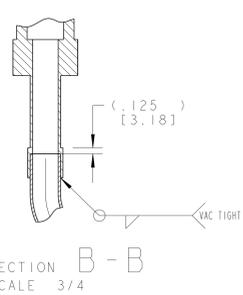
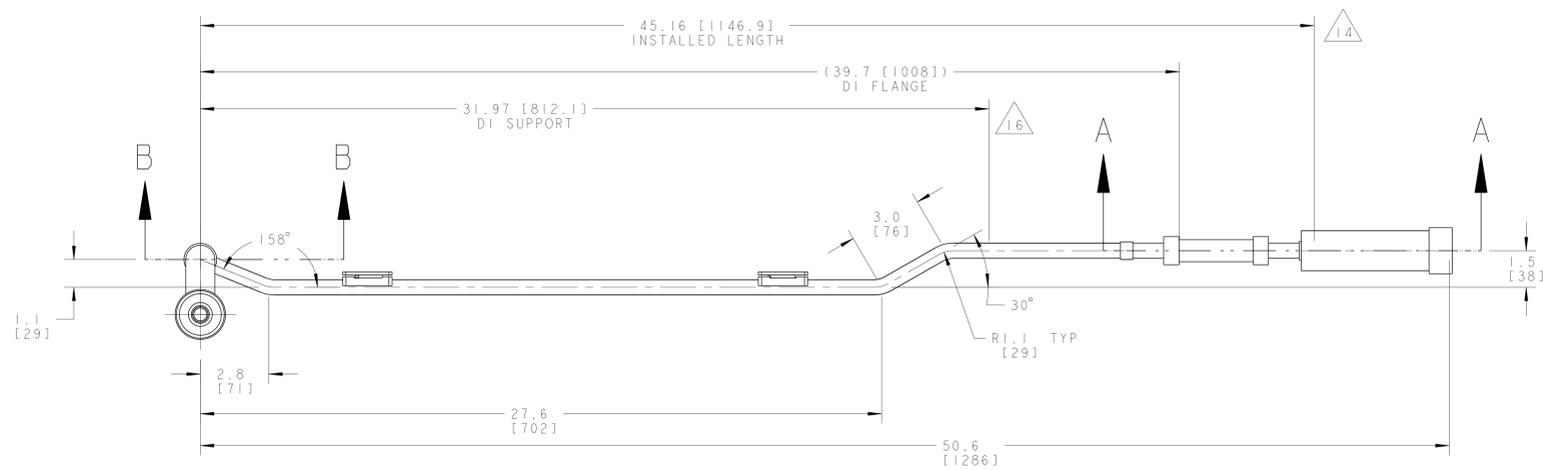


NOTES: (UNLESS OTHERWISE SPECIFIED)

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. (B)
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063$ ".
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. (B)
17. CAP END OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)
18. PIPE SHIPPED WITH CAPPED TUBE WELDED TO BELLOWS FLANGE. THE TUBE WILL BE CUT AS SHOWN AND USED AS A WELD SLEEVE DURING FINAL INSTALLATION OF THE FEEDBOX.
19. THE INTERIOR OF ALL COMPONENTS MUST BE FREE OF BURRS TO PREVENT WIRE INSULATION FROM ABRASION DURING THERMAL CYCLING.



ITEM	PART NO.	RECD	DESCRIPTION	MATERIAL
9	-	2	COPPER BRAID, 1" X 1/8"	-
8	25M877	2	CLAMP BASE PLATE, 5/8" TUBE	COPPER, OFHC, C101
7	25I641	1	INSERT, 5/8" TUBE WELD FLANGE	SS 304L
6	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 300 SERIES
5	25M813	2	CLAMP COVER 1"	OFHC, C101
4	-	1	BRAIDED FLEX HOSE, 3/4" ID, ELBOW & WELD SOCKET - 7.2' LL	SS 300 SERIES
3	-	1	TUBE, ASTM A269	SS 304L
2	-	1	TUBE, PER ASTM A269	SS 304L
1	25I644	1	BELLOWS FLANGE, ROLLED	SS 304L

UNLESS OTHERWISE SPECIFIED  
 TOLERANCES: X.X ± 0.1 FRACTION ± 1/64  
 X.XX ± 0.03 ANGLES ± 1.00°  
 X.XXX ± 0.010 FINISH: 125 μm  
 DO NOT SCALE PRINT  
 THREADS ARE CLASS 2  
 CHAMFER ENDS OF ALL SCREW THREADS 30°  
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS  
 BREAK EDGES .015 MAX. ON MACHINED WORK  
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE  
 IN ACCORDANCE WITH ADP-TM-58-1-0-1

SHOP ORDERS  
 NO. \_\_\_\_\_  
 DATE \_\_\_\_\_  
 BY \_\_\_\_\_

ERNEST ORLANDO LAWRENCE  
 BERKELEY NATIONAL LABORATORY  
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX  
 CRYOGENICS  
 PIPE, MBX2

SCALE: 3/8  
 SHEET 1 OF 1  
 SIZE: REV. B

REV. DWG. CHK. ZONE DATE  
 B ARH SPV 01/09/02 REVISED DRAWING NOTES 13, 16 & 17, MINOR DRAWING DIMENSIONAL CHANGES  
 A ARH SPV 11-22-02 INITIAL RELEASE  
 REV. DWG. CHK. ZONE DATE

UNLESS OTHERWISE SPECIFIED  
 MICROFILMED: \_\_\_\_\_  
 DWG. TYPE: ASSEM  
 SHOWN ON: \_\_\_\_\_  
 SCALE: 3/8  
 SHEET 1 OF 1  
 SIZE: REV. B

DESIGN ACCT. NO. ZSLCE2  
 CATEGORY CODE LH2003  
 DWG. NO. 2512496  
 DATE 11-07-02

2512496 B 1