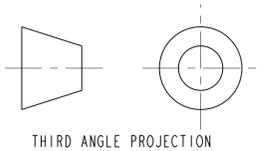
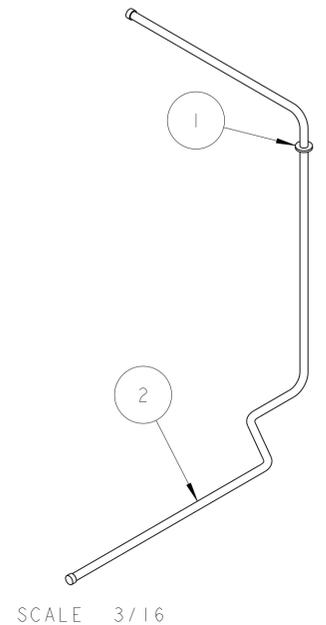
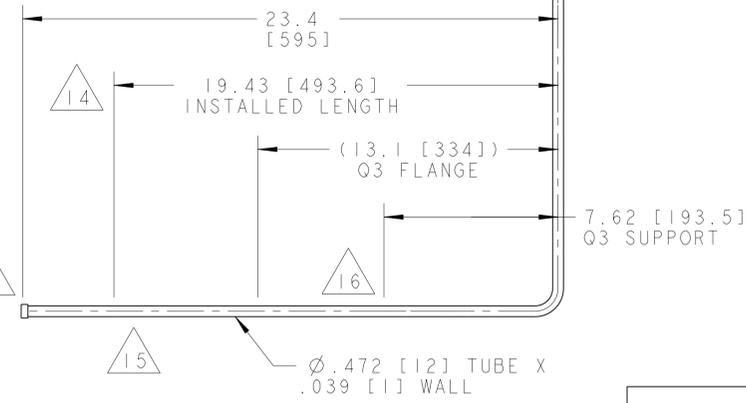
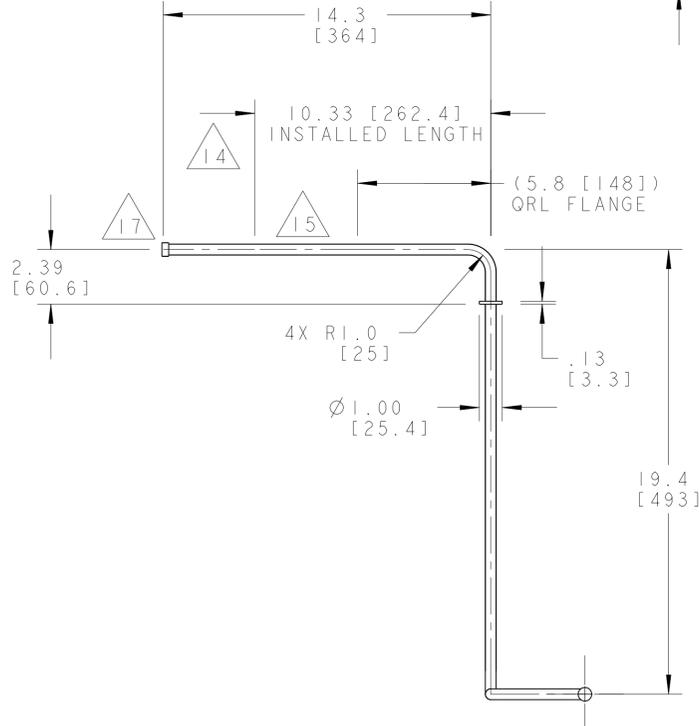
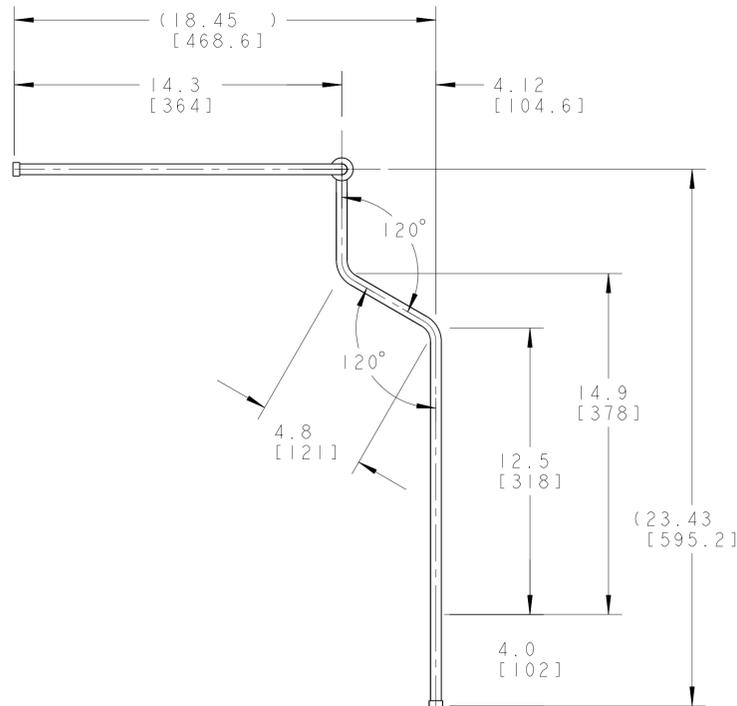


DWG. NO.		SIZE	REV.	SH.		
2513034		A	1			
2	-	1	TUBE, PER ASTM A269	SS 304L		
1	-	1	COLLAR	SS 304L		
ITEM	PART NO	REQD	DESCRIPTION	MATERIAL		

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; SUBJECT 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 SECTION 3.2 OF LBNL SPECIFICATION M856.
- 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 ±0.063".
- 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 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



				UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO. -		ERNEST ORLANDO LAWRENCE	
				X.X ± 0.1		ACCT. NO.		NO.		BERKELEY NATIONAL LABORATORY	
				X.XX ± 0.03		FRAC. ± 1/64		DATE ISSD		UNIVERSITY OF CALIFORNIA - BERKELEY	
				X.XXX ± 0.010		Angles ± 1.00°		DATE RECD		LHC IR FEEDBOX	
				FINISH 125 <sup>µ</sup>		SURFACE TREATMT		IDENT. METHOD		CRYOGENICS	
				DO NOT SCALE PRINT		PROJECT NUMBER		TAG		PIPE, CYI	
				THREADS ARE CLASS 2		PROJECT NAME		N/A		MICROFILMED:	
				CHAMFER ENDS OF ALL SCREW THREADS 30°		DWN. BY		DATE		DWG. TYPE	
				CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS		M. KNOLLS		27-Mar-02		ASSEM	
				BREAK EDGES .016 MAX. ON MACHINED WORK		CHK BY		DATE		SHOWN ON	
				REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		Jon Zbasnik/S.Virostek		01-Nov-02		-	
				IN ACCORDANCE WITH ASME Y14.5M & B46.1		APR BY		DATE		PATENT CLEAR:	
						Jon Zbasnik/D.Oshatz		08-AUG-02		DESIGN ACCT. NO.	
										CATEGORY CODE	
										LH2003	
										DWG. NO.	
										2513034	
										SIZE	
										A	
										REV.	
										1	