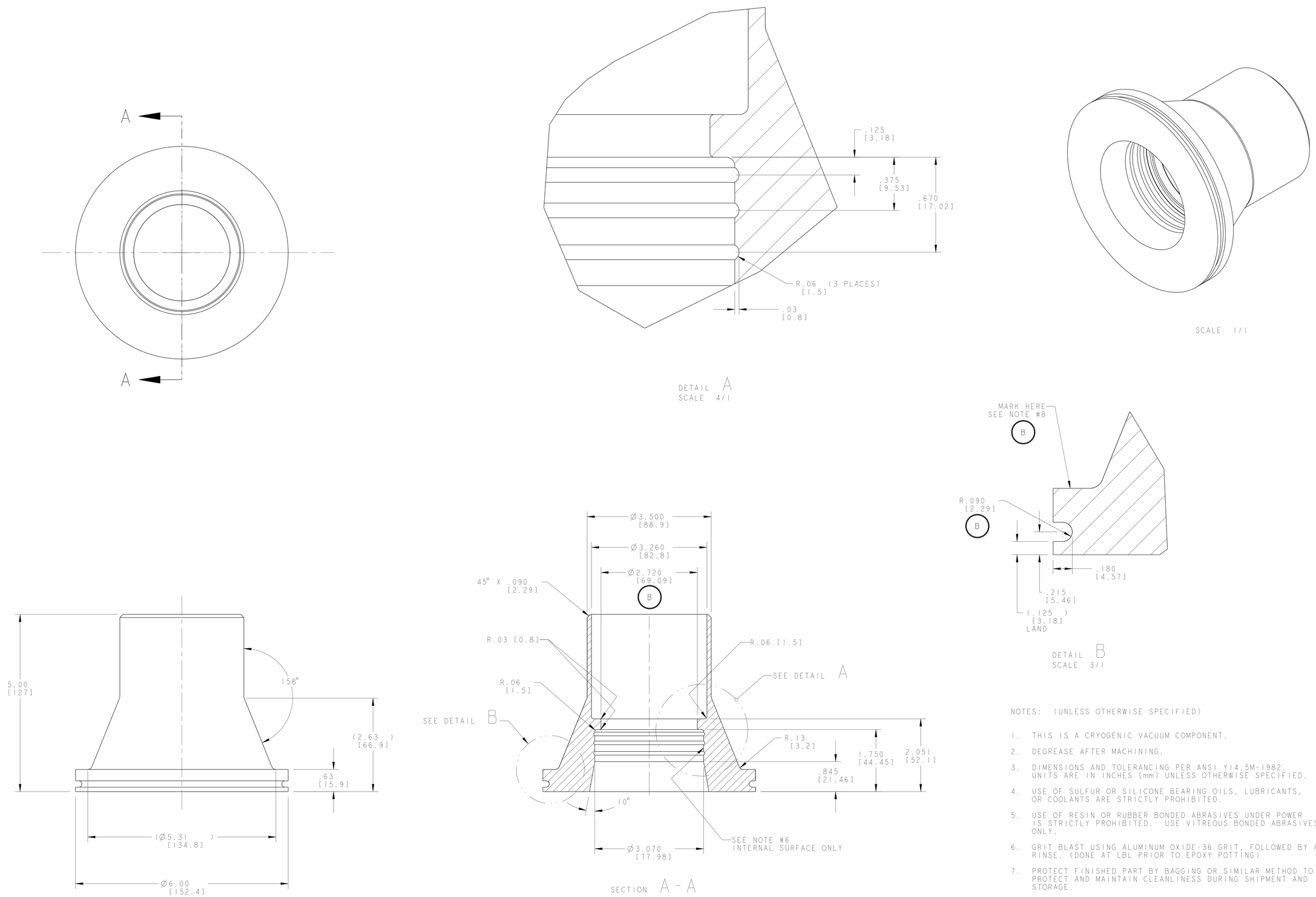

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. DEGREASE AFTER MACHINING.
3. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
4. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
5. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
6. GRIT BLAST USING ALUMINUM OXIDE-36 GRIT, FOLLOWED BY ALCHOHOL RINSE. (DONE AT LBL PRIOR TO EPOXY POTTING)
7. PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO PROTECT AND MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE.
8. MARK WITH 251448 AND SEQUENTIAL SERIAL NUMBER USING LOW-STRESS STAMPS ON ELECTRO-ETCH; LETTERS 1/8" HIGH

THIRD ANGLE PROJECTION

REV	DWG	CHK	ZONE	DATE	CHANGES
C	RLM	DPO		12/17/02	UPDATED REVISION BLOCK INFORMATION FOR REV. B, DEF TOLS USED TO BE XX=.03, XXX=.010
B	SEB	DPO		10/25/02	Ø USED TO BE 2.700, WELD RELIEF DETAIL B USED TO BE R .125 AND .125 ⊽, NOTE 8 AND CALL OUT NEW.
A	ARH	DPO		9/19/02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED

TOLERANCES		
	X.X ± 0.1	FRAC. ± 1/64
	X.XX ± 0.02	Angles ± 1.00°
	X.XXX ± 0.005	FINISH 125/

DO NOT SCALE PRINT

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THEADS 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

ITEM	PART NO	REQD	DESCRIPTION	DESCRIPTION	MATERIAL	MATERIAL DESCRIPTION
			-		SS 304L	-

SHOP ORDERS

ACCT NO.	NO. REQD	SER NO.
DEL TO		DATE ISSD
		DATE REQD
SURFACE TREATMT	-	
IDENT METHOD	TAG	
PROJECT NUMBER	N/A	
PROJECT NAME	N/A	
DWG BY	KNOLLS	DATE 20-Aug-02
CHK BY	ZBASNIK, OSHATZ	DATE 31-JUL-02
APR BY	ZBASNIK, OSHATZ	DATE 31-JUL-02

ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
CRYOGENICS
LAMBDA PLUG, WELD NECK FLANGE

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1/1	DO NOT SCALE PRINTS
	PART	-	SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	Z5LCE2	LH2003	2514486	C

DWG. NO. 2514486 SIZE C REV. 1 SH. 1