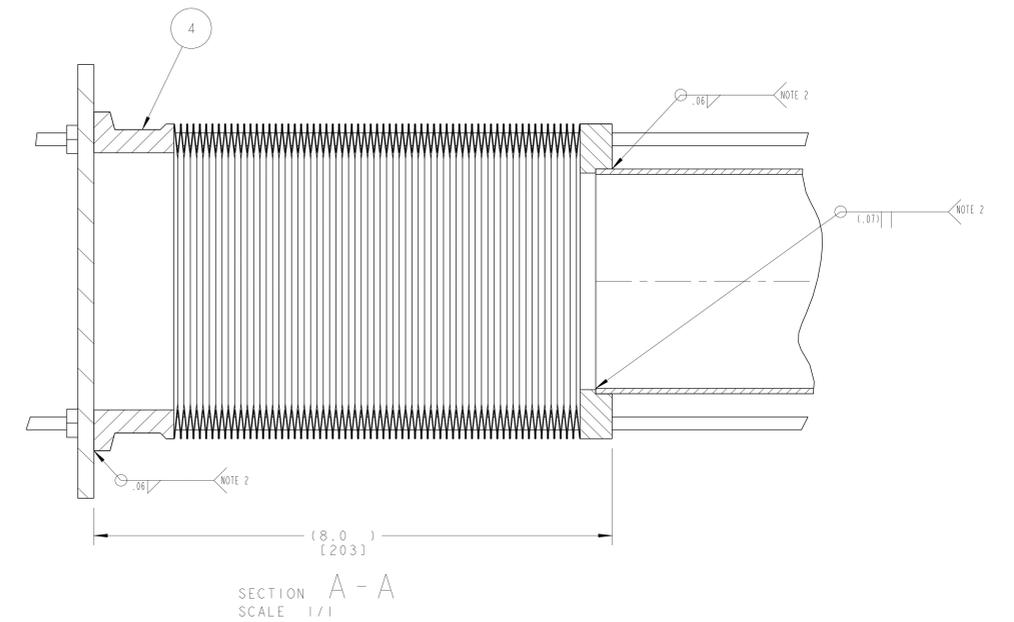
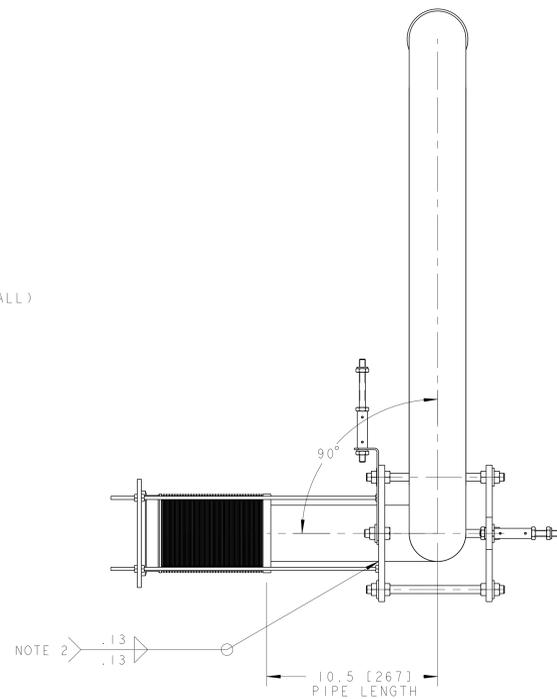
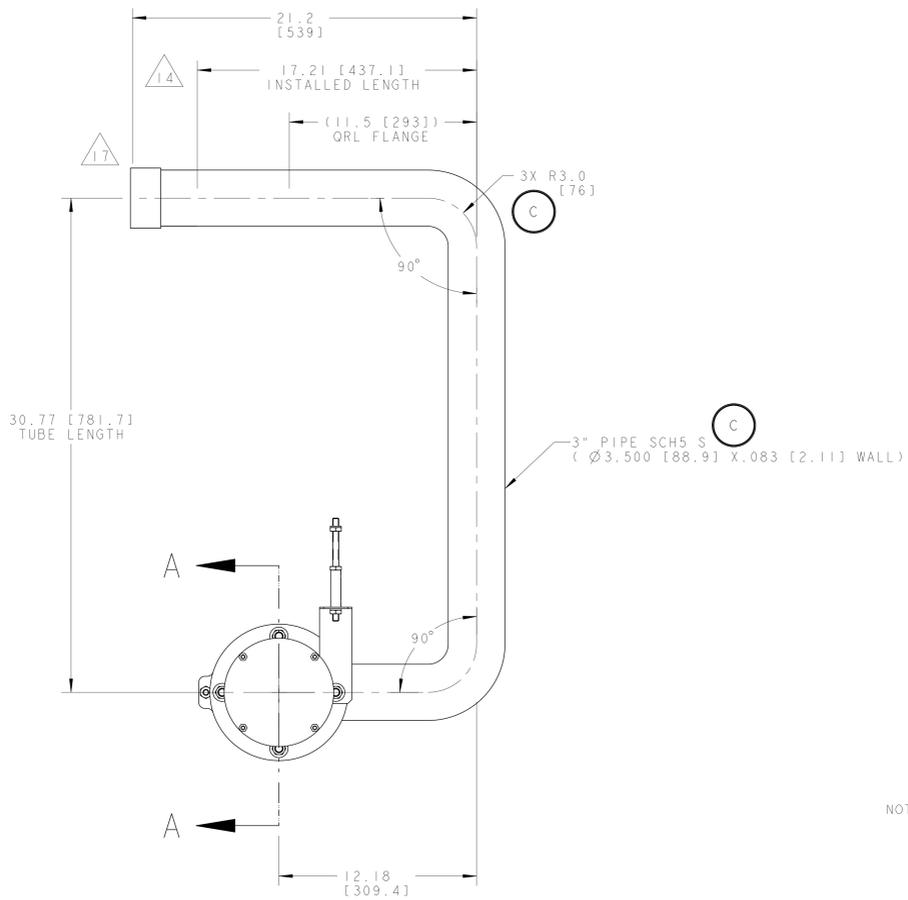
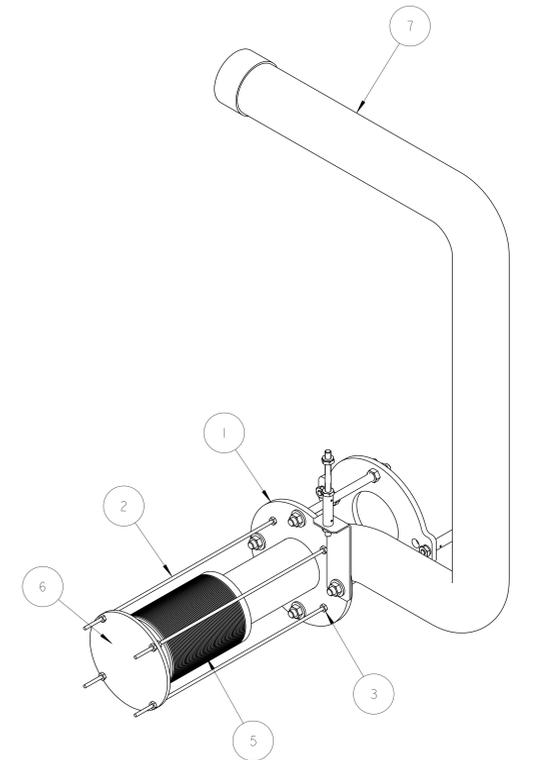
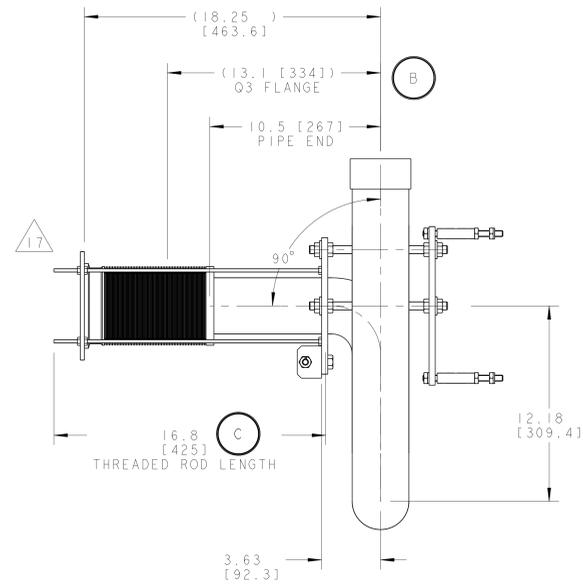


NOTES: (UNLESS OTHERWISE SPECIFIED)

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 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.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.



REV	DWG	CHK	DATE	ZONE	DATE
A	ARH	SPV	10-23-02		
B	ARH	SPV	01/07/03		
C	RLM	JER	6/30/03		

ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
7	-	1	PIPE, PER ASTM A312	SS 316L
6	-	1	1/4" PLATE	SS 304L
5	-	1	BELLOWS, FINAL 5520-MB-390073	SS 300 SERIES
4	-	1	END FLANGE, FINAL MC-390254	-
3	-	12	1/4-20 HEX NUT	-
2	-	4	1/4-20 THREADED ROD	-
1	25M923	1	XB THRUST PLATE ASSY	-

UNLESS OTHERWISE SPECIFIED  
 TOLERANCES: X.X ± 0.1 FRACTION ± 1/64  
 ANGLES ± 1.0°  
 SURFACE FINISH: X.XXX ± 0.010 FINISH 125  
 THREADS: PER ANSI B1.1  
 CHAMFER ENDS OF ALL SCREW THREADS 30°  
 BREAK EDGES .016 MAX. ON MACHINED WORK  
 REMOVE BURRS, WELD SPATTER A LOOSE SCALE  
 IN ACCORDANCE WITH ADP 114.5M-1 EN-1

SHOP ORDERS: SEE DRAWING FOR DETAILS

ERNEST ORLANDO LAWRENCE  
 BERKELEY NATIONAL LABORATORY  
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX  
 CRYOGENICS  
 PIPE WELDMENT, XB

SCALE: 1/4  
 SHEET 1 OF 1  
 2515306

