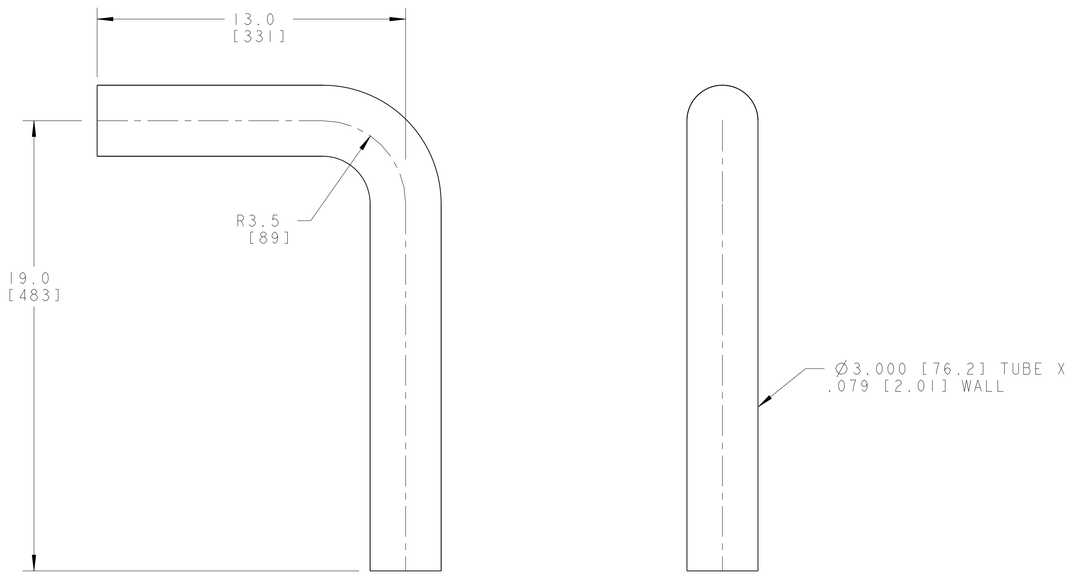
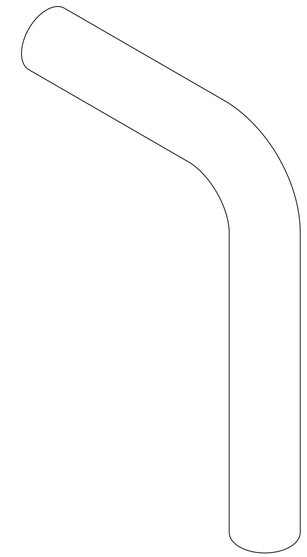
DWG. NO.	SIZE	REV.	SH.
2515494		A	1

DESCRIPTION	MATERIAL	MAT. LOCATION
TUBE, PER ASTM A269	SS 304L	-

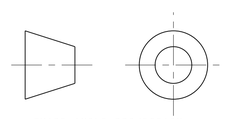
NOTES: (UNLESS OTHERWISE SPECIFIED)

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 SPCIFICATION 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; SUBECT 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; SUBECT 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.





SCALE 5/16



THIRD ANGLE PROJECTION

REV	DWG	CHK	ZONE	DATE	CHANGES
A	ARH	SV		11-01-02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED

TOLERANCES		
	X.X ± 0.1	FRAC. ± 1/64
	X.XX ± 0.03	Angles ± 1.00°
	X.XXX ± 0.010	FINISH 125 (μin)

DO NOT SCALE PRINT

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW TREADS 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

SHOP ORDERS

ACCT NO.		NO. REQD	SER NO. -
DEL TO			DATE ISSD -
SURFACE TREATMT	-		DATE REQD -
IDENT METHOD	TAG		
PROJECT NUMBER	N/A		
PROJECT NAME	N/A		
DWG BY	KNOLLS		DATE 13-Aug-01
CHK BY	Jon Zbasnik,S.Virostek		DATE 29-Oct-02
APR BY	Jon Zbasnik/D.Oshatz		DATE 29-Oct-02

ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
CRYOGENICS
PIPE, XB, SURGE TANK ATTACHMENT

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 5/16	DO NOT SCALE PRINTS
	PART	-	SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO. 2515494	SIZE / REV. A
	Z5LCE2	LH2003		

Dwg File: 2515494 Model File: 2515494