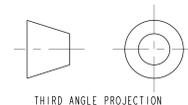
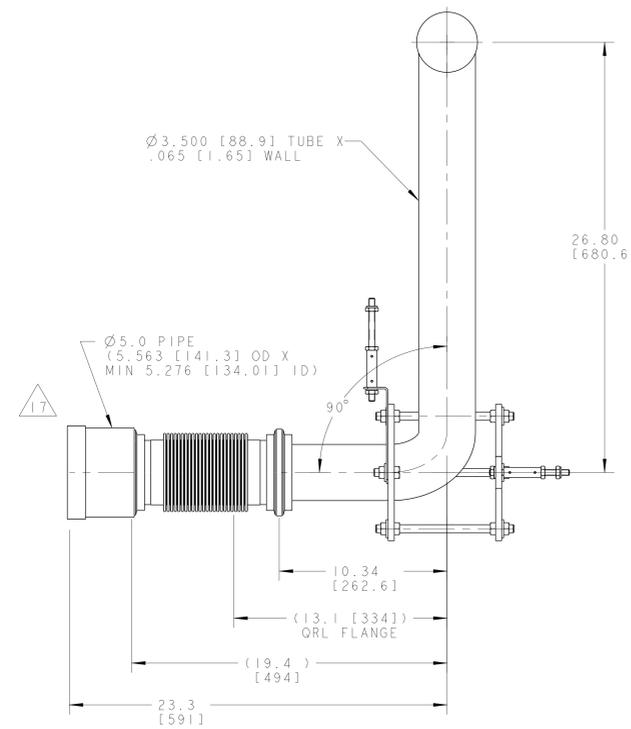
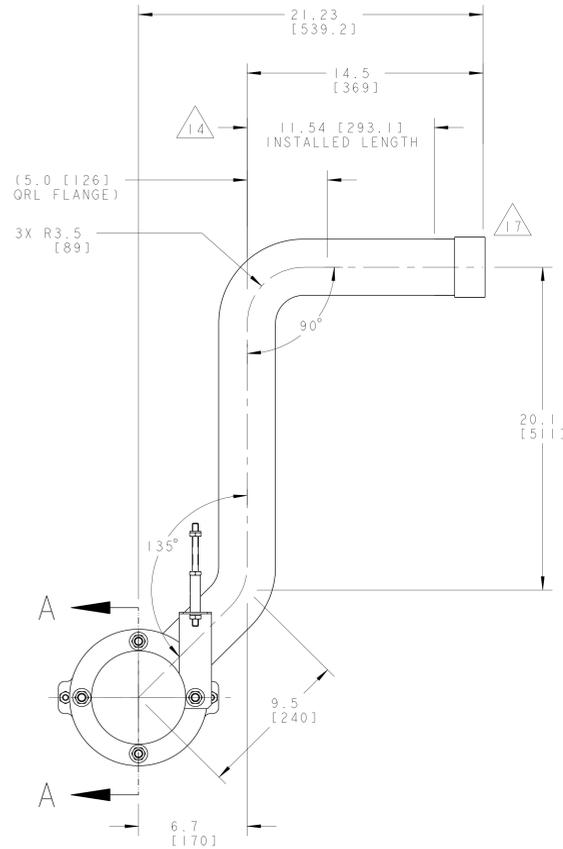
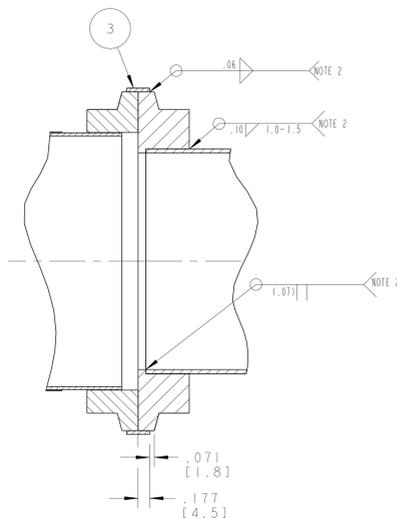
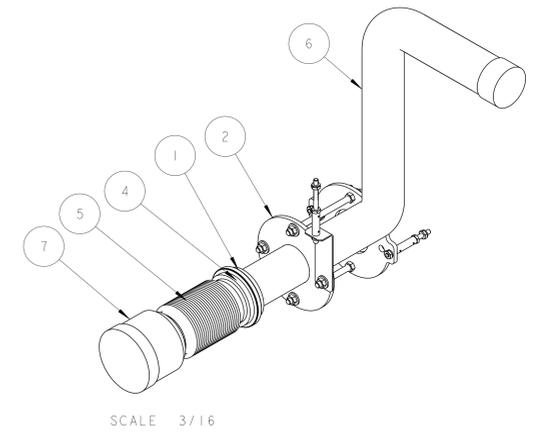
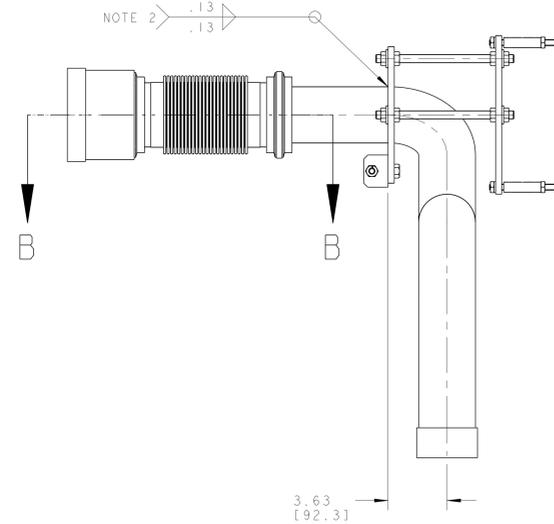
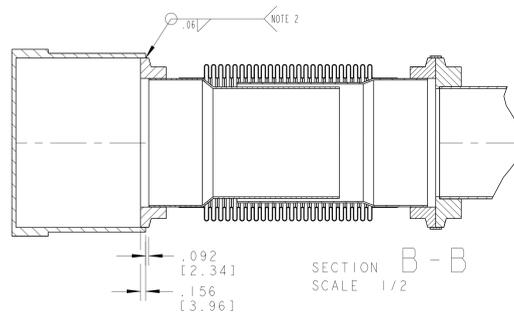


NOTES: (UNLESS OTHERWISE SPECIFIED)

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



ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
7	-	1	PIPE, PER ASTM A312	SS 304L
6	-	1	TUBE, PER ASTM A269	SS 304L
5	251314	1	BELLOWS, FINAL# 5520-MD-390065	SS 300 SERIES
4	251306	1	FLANGE, FINAL# 5520-MC-390032	SS 300 SERIES
3	-	1	THREADED ROD	BOM STRN.HRD.316 SS
2	25M923	1	XB THRUST PLATE ASSY	-
1	-	1	WELD RING, ID 134mm, FINAL SUPPLIED	-

REV	DATE	BY	CHK	ZONE	DATE	DESCRIPTION
A	10-25-02	SPV	ARH			INITIAL RELEASE CHANGES

UNLESS OTHERWISE SPECIFIED	FRAC. ± 1/64	DEC. ± 0.001	ANGLES ± 1.00°	FINISH: 32	DO NOT SCALE PRINT
DIAPHRAGMS: X.XX ± 0.1	FRAC. ± 1/64	NO	NO	NO	NO
COILS: X.XX ± 0.03	FRAC. ± 1/64	NO	NO	NO	NO
PIPE: X.XXX ± 0.010	FRAC. ± 1/64	NO	NO	NO	NO
THREADS: PER ANSI B1.1	FRAC. ± 1/64	NO	NO	NO	NO
WELDS: PER AWS D16.1	FRAC. ± 1/64	NO	NO	NO	NO
CHAMFER ENDS OF ALL SCREW THREADS 30°	FRAC. ± 1/64	NO	NO	NO	NO
KEYWAYS: 1.5 THREAD RELIEF ON MACHINED THREADS	FRAC. ± 1/64	NO	NO	NO	NO
BREAK EDGES .015 MAX. ON MACHINED WORK	FRAC. ± 1/64	NO	NO	NO	NO
REMOVE BURRS, WELD SPATTER A LOOSE SCALE	FRAC. ± 1/64	NO	NO	NO	NO
IN ACCORDANCE WITH ADP 114 SM 1 ENG. 1	FRAC. ± 1/64	NO	NO	NO	NO

SHOP ORDERS	DATE: 13-Mar-02	SCALE: 1/4	REV: 1
ERNEST ORLANDO LAWRENCE	DATE: 23-Oct-02	SCALE: 1/4	REV: 1
BERKELEY NATIONAL LABORATORY	DATE: 16-Oct-02	SCALE: 1/4	REV: 1
UNIVERSITY OF CALIFORNIA - BERKELEY	DATE: 16-Oct-02	SCALE: 1/4	REV: 1
LHC IR FEEDBOX	DATE: 16-Oct-02	SCALE: 1/4	REV: 1
CRYOGENICS	DATE: 16-Oct-02	SCALE: 1/4	REV: 1
PIPE WELDMENT, XB	DATE: 16-Oct-02	SCALE: 1/4	REV: 1