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DWG. NO. 2515704 SIZE REV. B 1 SH.

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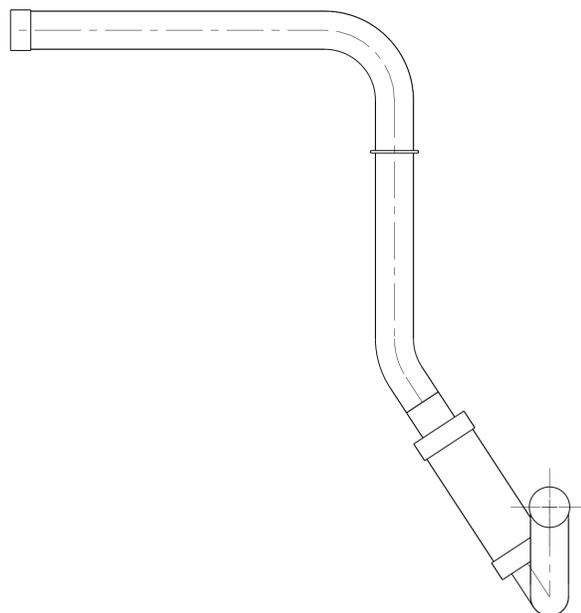
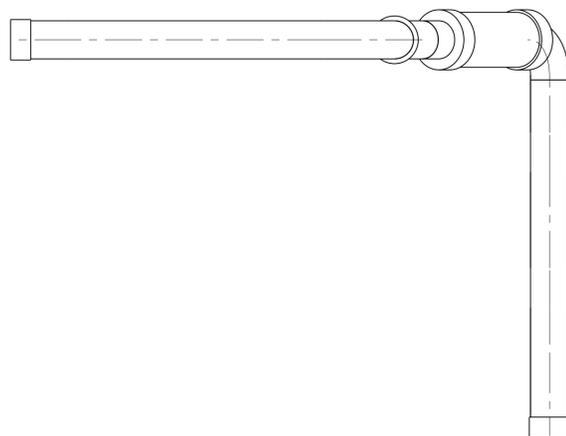
NOTES: (UNLESS OTHERWISE SPECIFIED)

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 ±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.

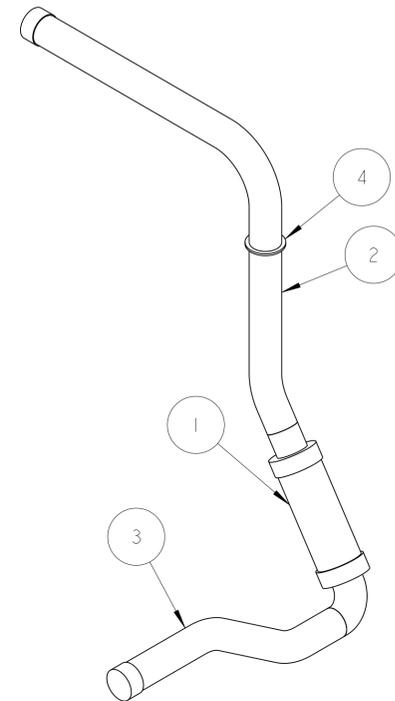
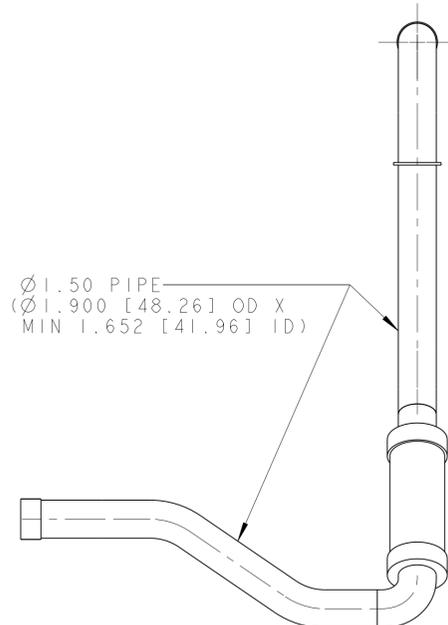
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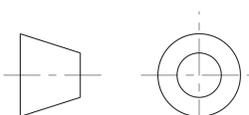


Ø 1.50 PIPE  
 (Ø 1.900 [48.26] OD X  
 MIN 1.652 [41.96] ID)



SCALE 3/16

\*\*\* FOR ADDITIONAL TUBE DIMENSIONS, SEE SHEET 2



THIRD ANGLE PROJECTION

				UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO. -		ERNEST ORLANDO LAWRENCE	
				X.X ± 0.1		ACCT. NO.		NO.		BERKELEY NATIONAL LABORATORY	
				X.XX ± 0.03		NO.		DATE		UNIVERSITY OF CALIFORNIA - BERKELEY	
				X.XXX ± 0.010		NO.		ISSD		LHC IR FEEDBOX	
				Angles ± 1.00°		NO.		RECD		CRYOGENICS	
				FINISH 125 $\sqrt{Ra}$		NO.		DATE		PIPE, LD2	
				DO NOT SCALE PRINT		NO.		DATE		SCALE: 7/32	
				THREADS ARE CLASS 2		NO.		DATE		DO NOT SCALE PRINTS	
				CHAMFER ENDS OF ALL SCREW THREADS 30°		NO.		DATE		SHEET 1 OF 2	
				CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		NO.		DATE		DWG. NO. 2515704	
				BREAK EDGES .016 MAX. ON MACHINED WORK		NO.		DATE		SIZE B	
				REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		NO.		DATE		REV.	
				IN ACCORDANCE WITH ASME Y14.5M & B46.1		NO.		DATE		2515704 B	
B	ARH	SPV	01/17/03	REVISED DRAWING NOTES 13, 16 & 17		DWG. BY R LA MANTIA		DATE 12-Dec-01		MICROFILMED:	
A	ARH	SPV	11-06-02	INITIAL RELEASE		CHK BY Jon Zbasnik/S.Virostek		DATE 05-Nov-02		DESIGN ACCT. NO. Z5LCE2	
REV	DWG	CHK	ZONE	DATE	CHANGES	APP BY Jon Zbasnik/S.Virostek		DATE 05-Nov-02		CATEGORY CODE LH2003	

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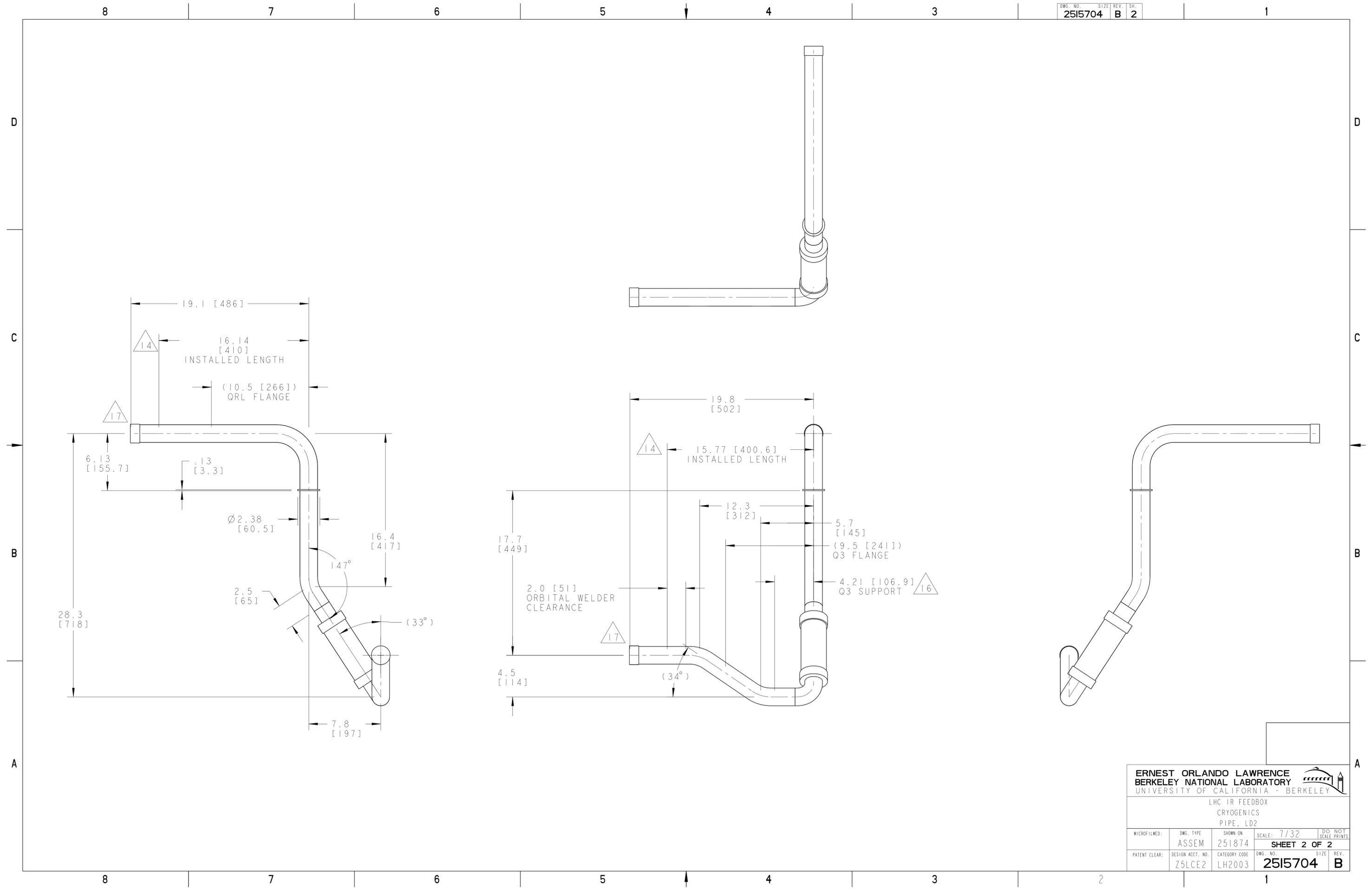
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ERNEST ORLANDO LAWRENCE  
 BERKELEY NATIONAL LABORATORY  
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX  
 CRYOGENICS  
 PIPE, LD2

MICROFILMED:	DWG. TYPE ASSEM	SHOWN ON 251874	SCALE: 7/32	DO NOT SCALE PRINTS
PATENT CLEAR:	DESIGN ACCT. NO. Z5LCE2	CATEGORY CODE LH2003	SHEET 2 OF 2	
DWG. NO. 2515704			SIZE B	REV. B