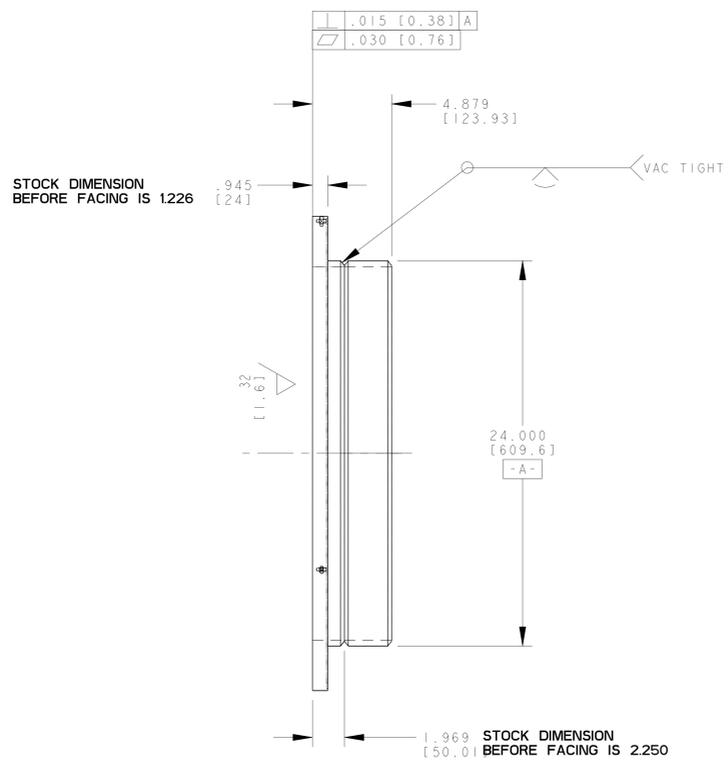
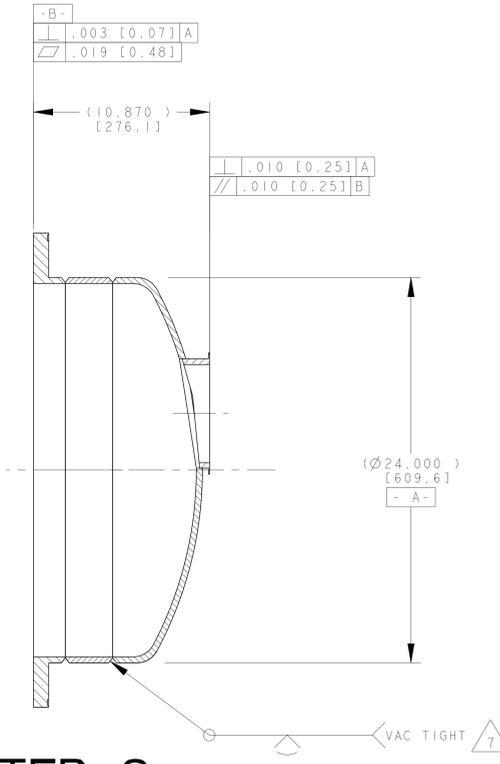
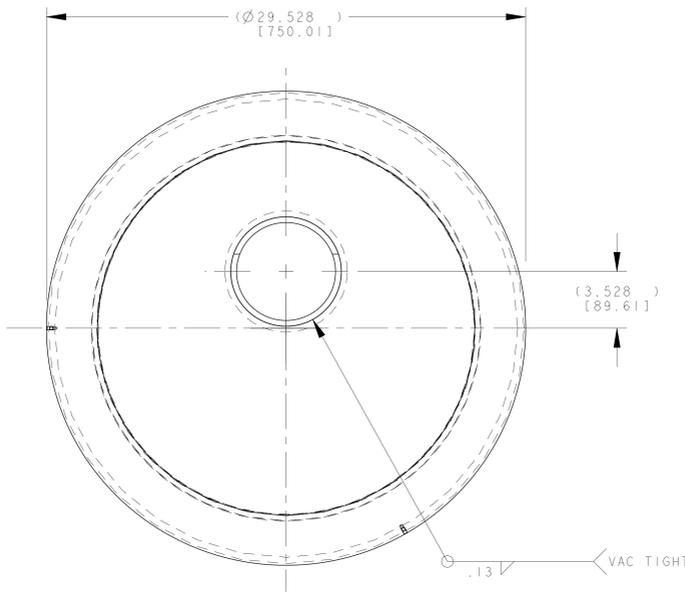
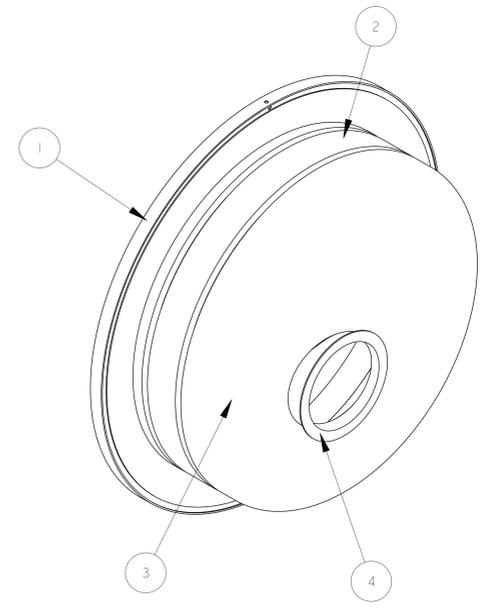
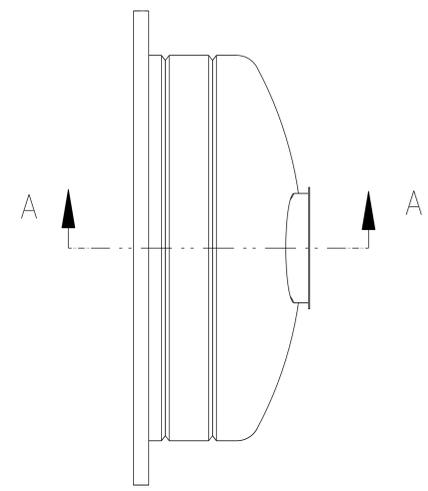


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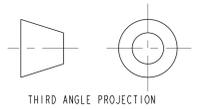


STEP 1



STEP 2

SECTION A - A



- NOTES: UNLESS OTHERWISE SPECIFIED,
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982 UNITS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
 - USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
 - USE OF RESIN OR RUBBER BONDED ADHESIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
 - VACUUM LEAK CHECK. LEAK RATE SHALL NOT EXCEED 1 X 10⁻⁹ STANDARD CC/SEC HELIUM.
 - PROTECT SEAL SURFACES ON ALL FLANGES WHEN MACHINING AND HANDLING.
 - TIG WELD MANUALLY USING FILLER WIRE.
 - WELD FLANGE ITEM #1 TO DISH HEAD EXTENSION ITEM #2. THEN MACHINE FACE TO TOLERANCE SHOWN IN STEP 1 AND COMPLETE THE ASSEMBLY PROCESS AS SHOWN IN STEP 2.
 - CLEAN AFTER MACHINING PER VENDOR SPECIFICATION; SUBJECT TO LBNL APPROVAL.
 - VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
 - PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO PROTECT AND MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE.

ITEM	PART NO.	RECD	DESCRIPTION	MATERIAL
4	25M829	1	WELD FLANGE	304L SS
3	25M828	1	DISH HEAD BNL 14060211	304L SS
2	25M827	1	DISH HEAD EXTENSION	304L SS
1	25M826	1	BNL FLANGE 14060045	304L SS

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		ERNEST ORLANDO LAWRENCE	
COLEMAN	X.X ± 0.1	FRAC. ± 1/64	NO. _____	UNIVERSITY OF CALIFORNIA - BERKELEY	
DO NOT SCALE PRINT	X.XX ± 0.03	ANGLES ± 1.00°	DATE 12/12/02	LHC IR FEEDBOX	
TREAS. AND CLASS.	X.XXX ± 0.010	FINISH 125 μm	DATE 12/13/02	CRYOGENICS	
CHAMFER ENDS OF ALL SCREW THREADS 30°			DATE 12/13/02	DISH HEAD VACUUM ASSY	
GET ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS				SCALE: 1/4	
BREAK EDGES .016 MAX. ON MACHINED WORK				SHEET 1 OF 1	
REMOVE BURRS, WELD SPATTER & LOOSE SCALE				DO NOT SCALE PRINTS	
IN ACCORDANCE WITH ADP 114.5M-1 ENCL. 1				REV. _____	

REV	DATE	BY	CHK	ZONE	DATE
A	12/16/02				

INITIAL RELEASE CHANGES

25M8256 A 1