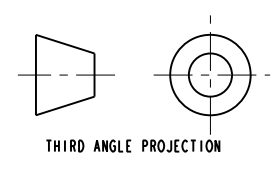
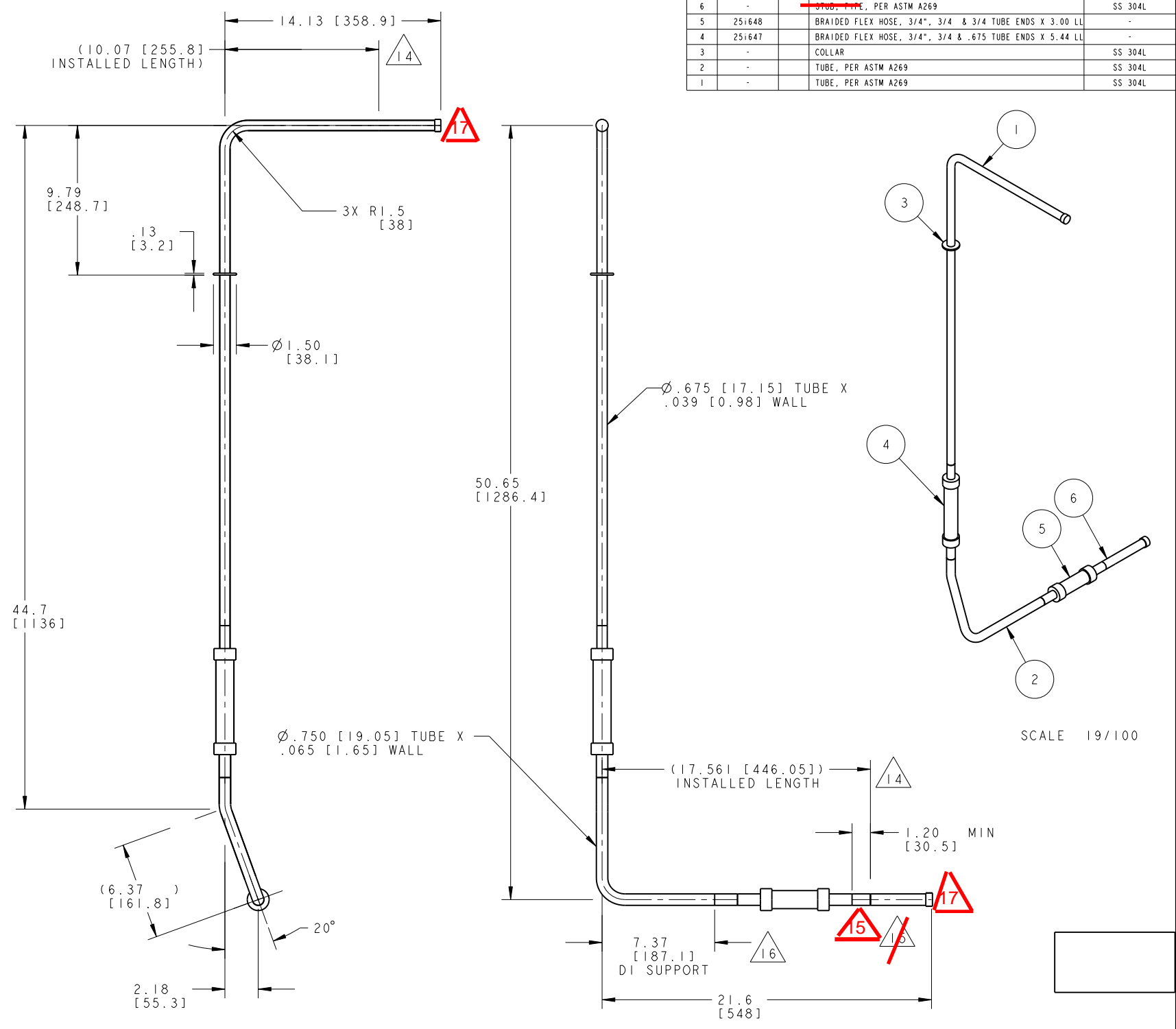


NAME: ARHARRIS OBJECT: 251214 DATE: 19-Jul-02 17:06:31

ITEM	PART NO	QTY	RECD	DESCRIPTION	MATERIAL
6	-	-	-	TUBE, PER ASTM A269	SS 304L
5	251648	-	-	BRAIDED FLEX HOSE, 3/4", 3/4 & 3/4 TUBE ENDS X 3.00 LL	-
4	251647	-	-	BRAIDED FLEX HOSE, 3/4", 3/4 & .675 TUBE ENDS X 5.44 LL	-
3	-	-	-	COLLAR	SS 304L
2	-	-	-	TUBE, PER ASTM A269	SS 304L
1	-	-	-	TUBE, PER ASTM A269	SS 304L

- NOTES: (UNLESS OTHERWISE SPECIFIED)
- THIS IS A CRYOGENIC VACUUM COMPONENT.
 - WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
 - CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
 - PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
 - 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 ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
 - VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
 - ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED.
 - VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
 - REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
 - TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
 - PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
 - 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".
 - PROVIDE A MINIMUM LENGTH OF 1.2" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
 - PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
 - CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



REV	DWG	CHK	ZONE	DATE	CHANGES
A	DPO				CHANGES PER PRODUCTION READINESS REVIEW

UNLESS OTHERWISE SPECIFIED

TOLERANCES

DO NOT SCALE PRINT

THREADS ARE CLASS 2

CHAMFER ENDS OF ALL SCREW THREADS 30°

CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS

BREAK EDGES .016 MAX. ON MACHINED WORK

REMOVE BURRS, WELD SPLATTER & LOOSE SCALE

IN ACCORDANCE WITH ANSI Y14.5M & B46.1

SHOP ORDERS

PROJECT NAME: N/A

PROJECT NUMBER: N/A

PROJECT TAG: N/A

PROJECT IDENTIFICATION NUMBER: N/A

DATE: 15-Jul-02

DATE: 18-Jul-02

DATE: 18-Jul-02

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX CRYOGENICS PIPE, E2

SCALE: 1/4

ASSEM 251226

DESIGN ACCT. NO. Z5LCE2

CATEGORY CODE LH2003

DWG. NO. 251214

SIZE A

REV. 1

SHEET 1 OF 1

8 7 6 5 4 3 2 1

D C B A