

NAME: ARHARRIS OBJECT: 251215 DATE: 19-Jul-02 11:28:03

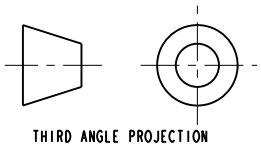
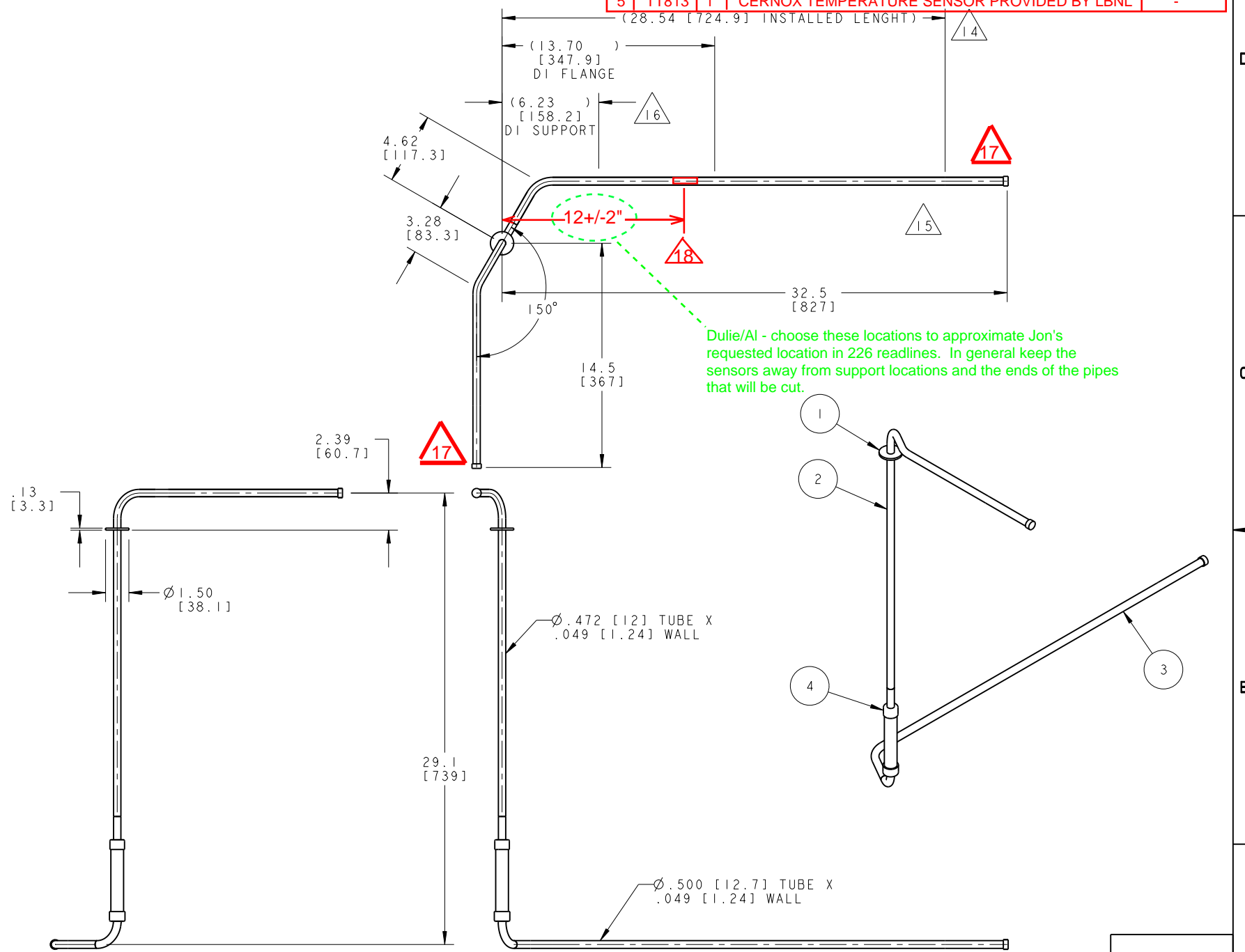
ITEM	PART NO	RECD	DESCRIPTION	MATERIAL
4	251652	1	BRAIDED FLEX HOSE, 1/2" ID X 4" LIVE LENGTH, 12mm X 1/2" ELBOW WELD ENDS	
3	-	1	TUBE 2, PER ASTM A269	SS 304L
2	-	1	TUBE 1, PER ASTM A269	SS 304L
1	-	1	FLANGE	SS 304L

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} 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.
- 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.

18. INSTALL TEMPERATURE SENSOR PER LHC SPECIFICATION LHC-QIT-ES-0002. SENSOR TO BE PROVIDED BY LBNL.

5 | TT813 | 1 | CERNOX TEMPERATURE SENSOR PROVIDED BY LBNL | -
(28.54 [724.9] INSTALLED LENGTH)



REV	DWG	CHK	ZONE	DATE	CHANGES
A	DO			7/15/02	CHANGES PER PRODUCTION READINESS REVIEW

TOLERANCES		FRAC.		ANGLES	
X.X ± 0.1	FRAC. ± 1/64	Angles ± 1.00°			
X.XX ± 0.03					
X.XXX ± 0.010					

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
DO NOT SCALE PRINT	THREADS ARE CLASS 2	CHAMFER ENDS OF ALL SCREW THREADS 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	

PROJECT	DATE	SCALE	DO NOT SCALE PRINTS
LHC IR FEEDBOX CRYOGENICS PIPE, CY2	12-Dec-01	1/4	

DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
Z5LCE2	LH2003	2512154	A	1