

В Α DESCRIPTION MATERIAL MAT. LOCATION NOTES: (UNLESS OTHERWISE SPECIFIED) I. THIS IS A CRYOGENIC VACUUM COMPONENT. 2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL. 3. CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL. Ø.472 [12] TUBE X PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: .049 [1.24] WALL PER VENDOR SPCIFICATION WITH LBNL APPROVAL. 5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHESAUNLESS OTHERWISE SPECIFIED. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED. [54] USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES 8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBECT TO 3 LBNL APPROVAL. 9. ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED. II. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE 4.00 FABRICATION OR ASSEMBLY: SUBECT TO LBNL APPROVAL. [101.6] 12. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS. 13. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN + / - .010. Ø.500 [12.7] TUBE X -14. PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL .049 [1.24] WALL SPECIFICATION M856. [54] 2 15. MATERIAL IS 300 SERIES STAINLESS STEEL PER VENDOR SPECIFICATION AND SUBJECT TO LBNL APPROVAL. ALLOY MUST BE COMPATIBLE WITH WELDING TO 304L STAINLESS STEEL TUBING. 1.50 [38.1] DIRECTION OF THERMAL CONTRACTION 1" [25.4] TRAVEL FROM SHOWN POSITION UNLESS OTHERWISE SPECIFIED | SHOP ORDERS ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY LHC IR FEEDBOX DO NOT SCALE PRINT CRYOGENICS BRAIDED FLEX HOSE, 1/2" ID X 4" LIVE LENGTH, 12mm X 1/2" ELBOW WELD ENDS THREADS ARE CLASS 2 CHAMFER ENDS OF ALL SCREW TREADS 30° CHAMFER ENDS OF ALL SCREW INEADS 30

CUT ROUND, I.5 THREAD RELIEF ON MACHINED THREADS DWG A. HARRIS DWG. TYPE SHOWN ON SCALE: 3/4 DO NOT SCALE PRINTS PART VARIOUS SHEET 1 OF 1 DATE | 3-Jul-02 BREAK EDGES .016 MAX. ON MACHINED WORK PATENT CLEAR: DESIGN ACCT. NO. CATEGORY CODE CHANGES PER PRODUCTION READINESS REVIEW K J. ZBASNIK DATE REMOVE BURRS. WELD SPLATTER & LOOSE SCALE 2516523 Z5LCE2 | LH2003 | CHANGES R J. ZBASNIK |REV|DWG|CHK|ZONE|DATE| IN ACCORDANCE WITH ASME YI4.5M & B46.I DATE В D