

Daryl Oshatz

Tom Peterson

NAME: DULIE OBJECT: 251652 DATE: 13-Jul-02 22:01:34

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.

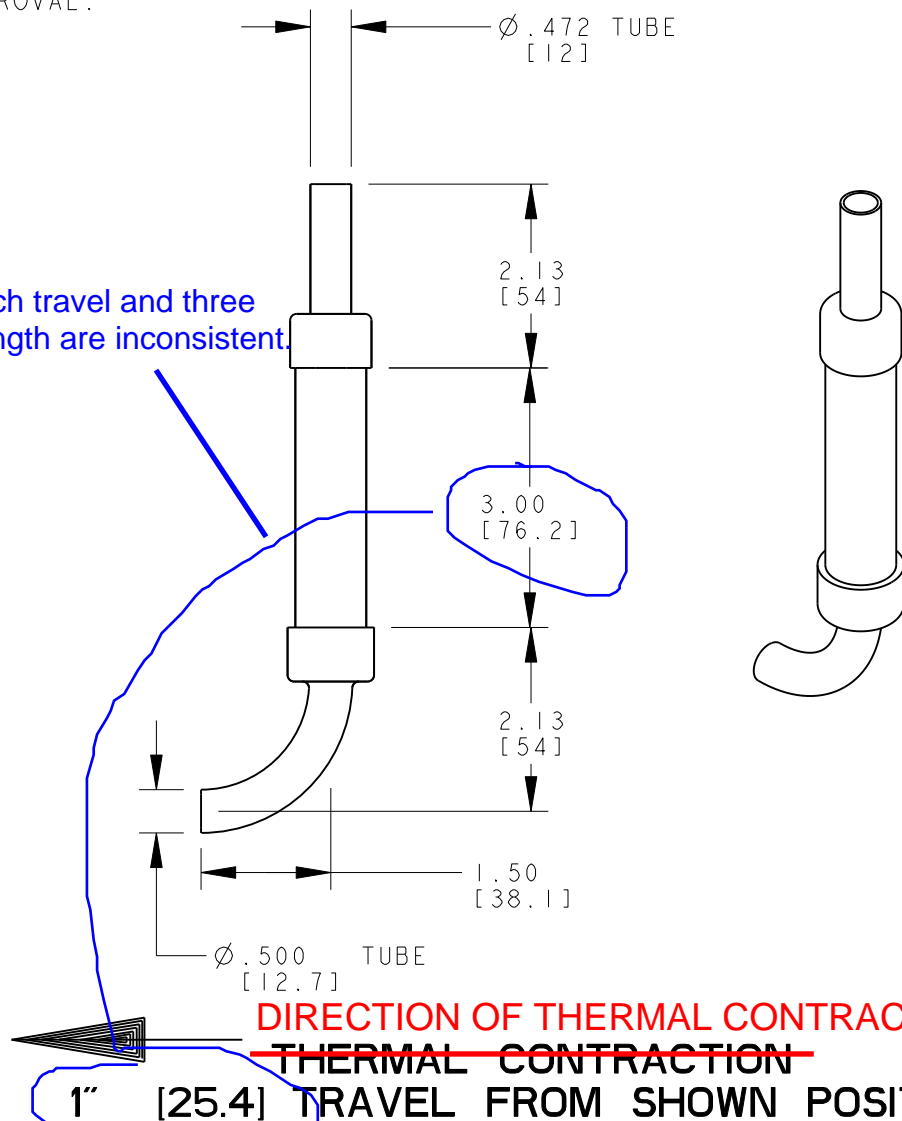
14. PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.

~~PERFORMANCES PER LBNL ACCEPTANCE CRITERIA SEE SPECIFICATION NUMBER LBNL NO. M8056 AND BY VENDOR AND LBNL APPROVED SPECIFICATION.~~

- ~~a) OPERATING TEMPERATURE 4.2°K.~~
- ~~b) THERMAL SHOCK WELDS TO LN TEMPERATURE 2 TIMES ONE HOUR INTERVAL.~~
- ~~c) TEST PRESSURE 375 PSIG.~~
- ~~d) VACUUM CHECK WITH HELIUM LEAK MASS SPECTROMETER DETECTOR. THE LEAK RATE AT ANY LOCATION SHALL NOT EXCEED 1×10^{-9} STD CC/SEC.~~

15. EST. WT.: WEIGHT: **?** LB

DESCRIPTION	MATERIAL	MAT. LOCATION



UNLESS OTHERWISE SPECIFIED				SHOP ORDERS		SER. NO.
TOLERANCES	X.X ± 0.1	FRAC. ± 1/64	ACCT. NO.	NO. REQ.	DATE ISSD.	
	X.XX ± 0.03	Angles ± 1.00°	DEL. TO		DATE RECD.	
	X.XXX ± 0.010	FINISH 125/μm	SURFACE TREATMT			
			IDENT. METHOD	TAG		
			PROJECT NUMBER	N/A		
			PROJECT NAME			
			DWG. BY	A. HARRIS	DATE	13-Jul-02
			CHK. BY	J. ZBASNIK	DATE	
			APR. BY	J. ZBASNIK	DATE	

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY				UNIVERSITY OF CALIFORNIA - BERKELEY	
LHC IR FEEDBOX CRYOGENICS					
BRAIDED FLEX HOSE, 1/2" ID X 3" LIVE LENGTH, 12mm X 1/2" ELBOW WELD ENDS					
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE:	DO NOT SCALE PRINTS	
	PART	VARIOUS	3/4	SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE	REV.
	Z5LCE2	LH2003	2516523	1	1

DWG. NO. 2516523

REV. 1