Daryl Oshatz

Tom Peterson

DESCRIPTION	MATERIAL	MAT. LOCATION
	SS 316L????	-

NOTES: (UNLESS OTHERWISE SPECIFIED)

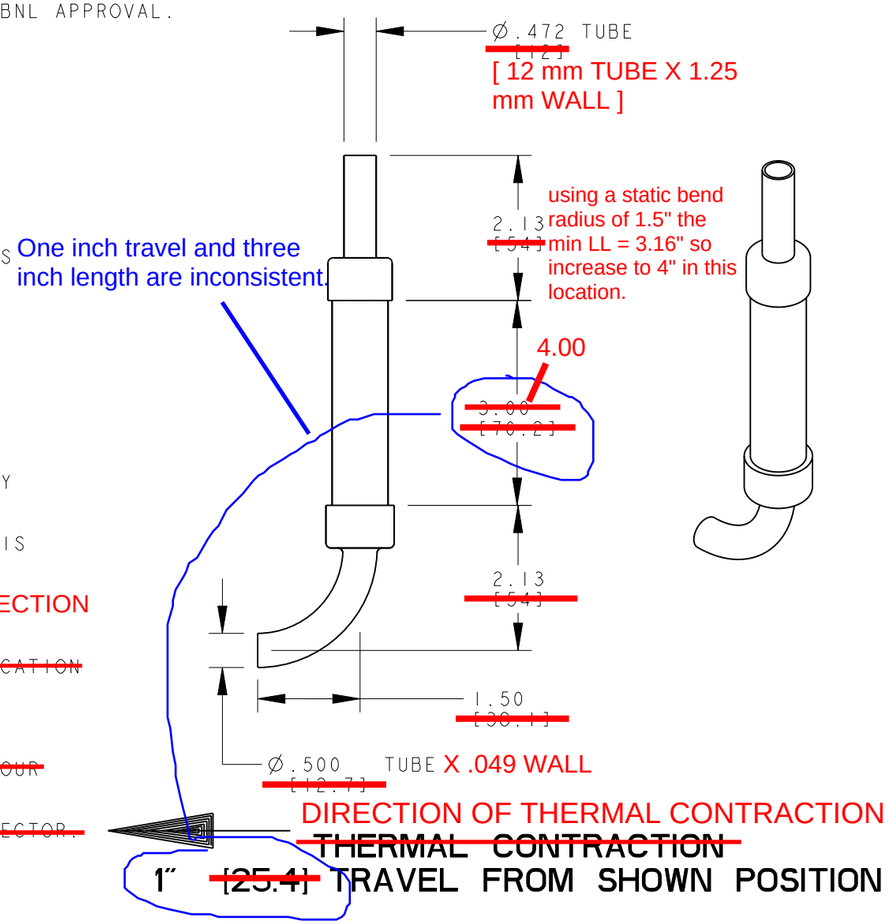
1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPCIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBECT TO LBNL APPROVAL.
9. ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED.
11. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBECT TO LBNL APPROVAL.
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.

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

~~PERFORMANCES PER LBNL ACCEPTANCE CRITERIA SEE SPECIFICATION NUMBER LBNL No. M0056 AND BY VENDOR AND LBNL APPROVED SPECIFICATION.~~

~~a) OPERATING TEMPERATURE 4.2°K.~~
~~b) THERMAL SHOCK WELDS TO LN TEMEPRATURE 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 X 10-9 STD CC/SEC.~~

~~15. EST. WT.: WEIGHT: LB~~



DIRECTION OF THERMAL CONTRACTION

~~THERMAL CONTRACTION~~

1" ~~[25.4]~~ TRAVEL FROM SHOWN POSITION

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED

TOLERANCES: X.X ± 0.1 | FRAC. ± 1/64 | X.XX ± 0.03 | Angles ± 1.00° | X.XXX ± 0.010 | FINISH 125 (µin)

DO NOT SCALE PRINT

THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW TREADS 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

SHOP ORDERS

ACCT NO.	NO. REQD	SER NO.	-
DEL TO		DATE ISSD	-
SURFACE TREATMT		DATE REQD	-
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: 3/4	DO NOT SCALE PRINTS
	PART	VARIOUS	SHEET 1 OF 1	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE / REV.
	Z5LCE2	LH2003	2516523	1

Des. File: 251652 Model File: 251652

DWG. NO. 2516523 SIZE REV. SH. 1 1

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