

NAME: APHARRIS OBJECT: 251215 DATE: 05-Dec-02 08:15:59

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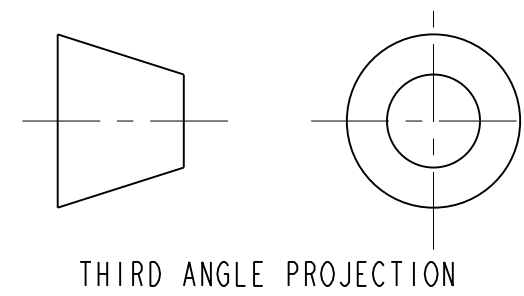
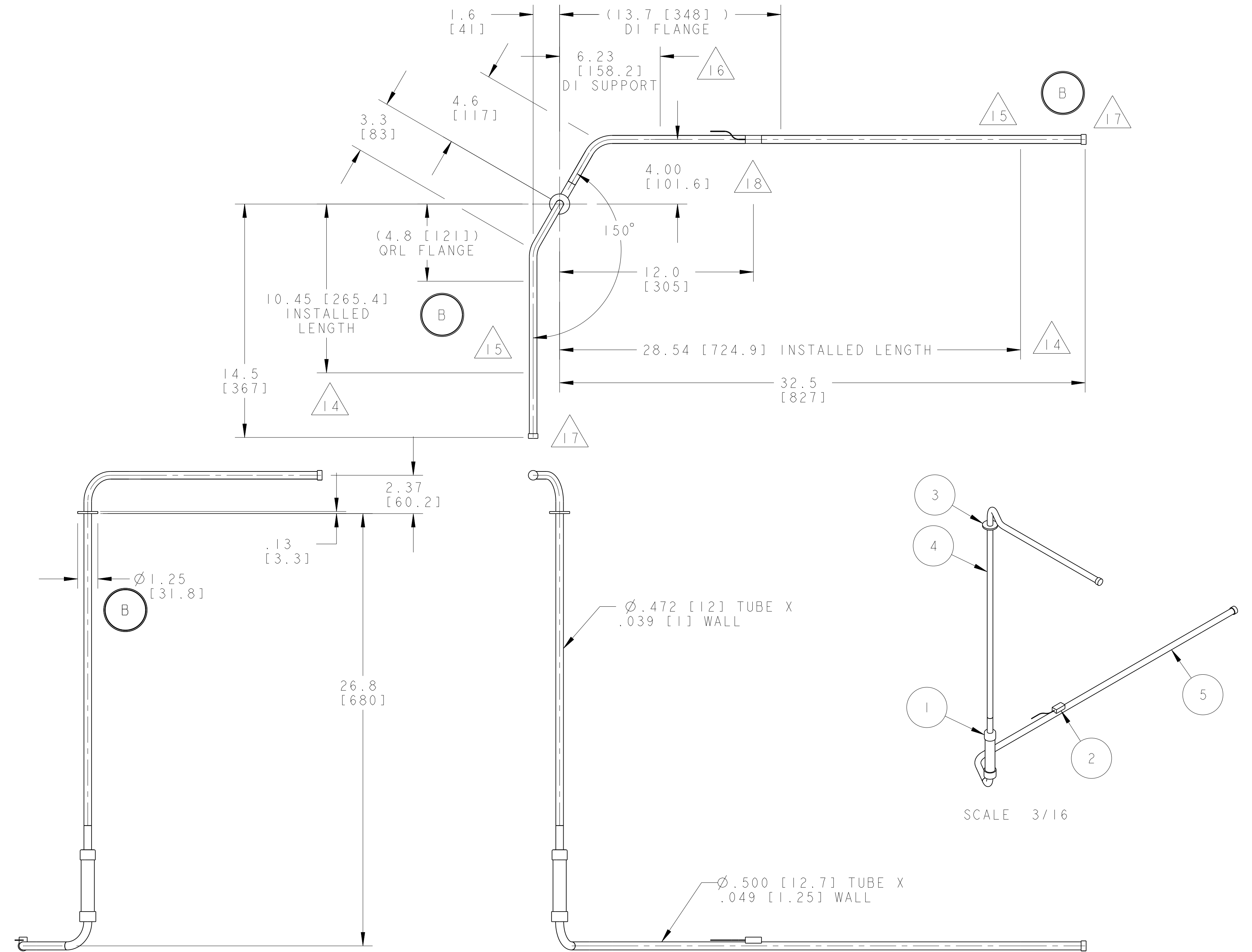
DWG. NO. 2512154 SIZE REV. B 1

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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 SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] 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; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
14. 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".
15. 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.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. 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.

ITEM	PART NO	RECD	DESCRIPTION	MATERIAL
5	-	1	TUBE, PER ASTM A269	SS 304L
4	-	1	TUBE, PER ASTM A269	SS 304L
3	-	1	FLANGE	SS 304L
2	-	1	CERNOX - TT813, TEMP SENSOR	-
1	-	1	BRAIDED FLEX HOSE, 1/2" ID X 4" LL	SS 300 SERIES



REV	DWG	CHK	ZONE	DATE	CHANGES
B	RLM	DPO		11-20-02	CHANGED FLANGE DIAMETER, ADDED OQL FLANGE CALLOUT, ADDED NOTE 15 CALLOUT TO VIEW, CHANGED DESCRIPTION OF BOM ITEMS 4 & 5, DELETED DIM ( ).
A	ARH	DPO		9-17-02	INITIAL RELEASE

TOLERANCES		SHOP ORDERS		SER
X.X ± 0.1	FRAC. ± 1/64	ACCT NO.	NO. RECD	NO.
X.XX ± 0.03	Angles ± 1.00°	DEL TO	DATE	ISSD
X.XXX ± 0.010	FINISH 125 $\sqrt{Ra}$	SURFACE TREATMT	DATE	RECD

**ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY**  
UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX  
CRYOGENICS  
PIPE, CY2

PROJECT NUMBER: N/A  
PROJECT NAME: N/A  
DWG BY: R LA MANTIA  
CHK BY: Jon Zbasnik  
APR BY: Jon Zbasnik

DATE: 12-Dec-01  
DATE: 4-02-02  
DATE: 4-02-02

SCALE: 1/4  
SHEET 1 OF 1  
DWG. NO. 2512154  
REV. B

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