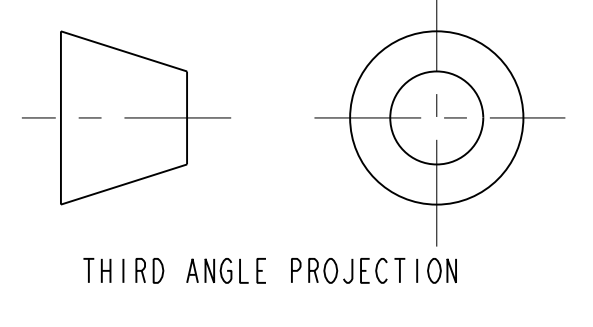
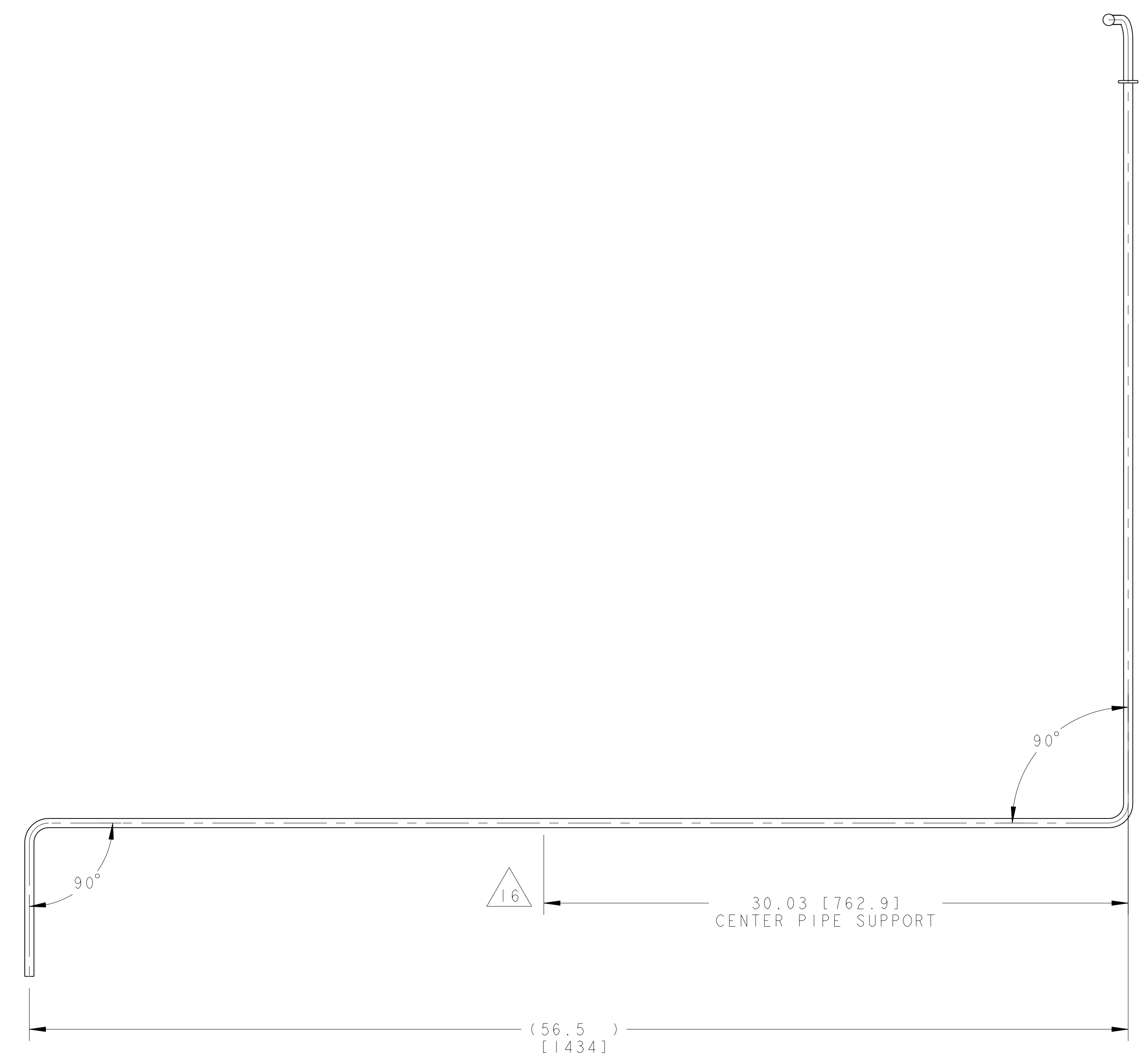
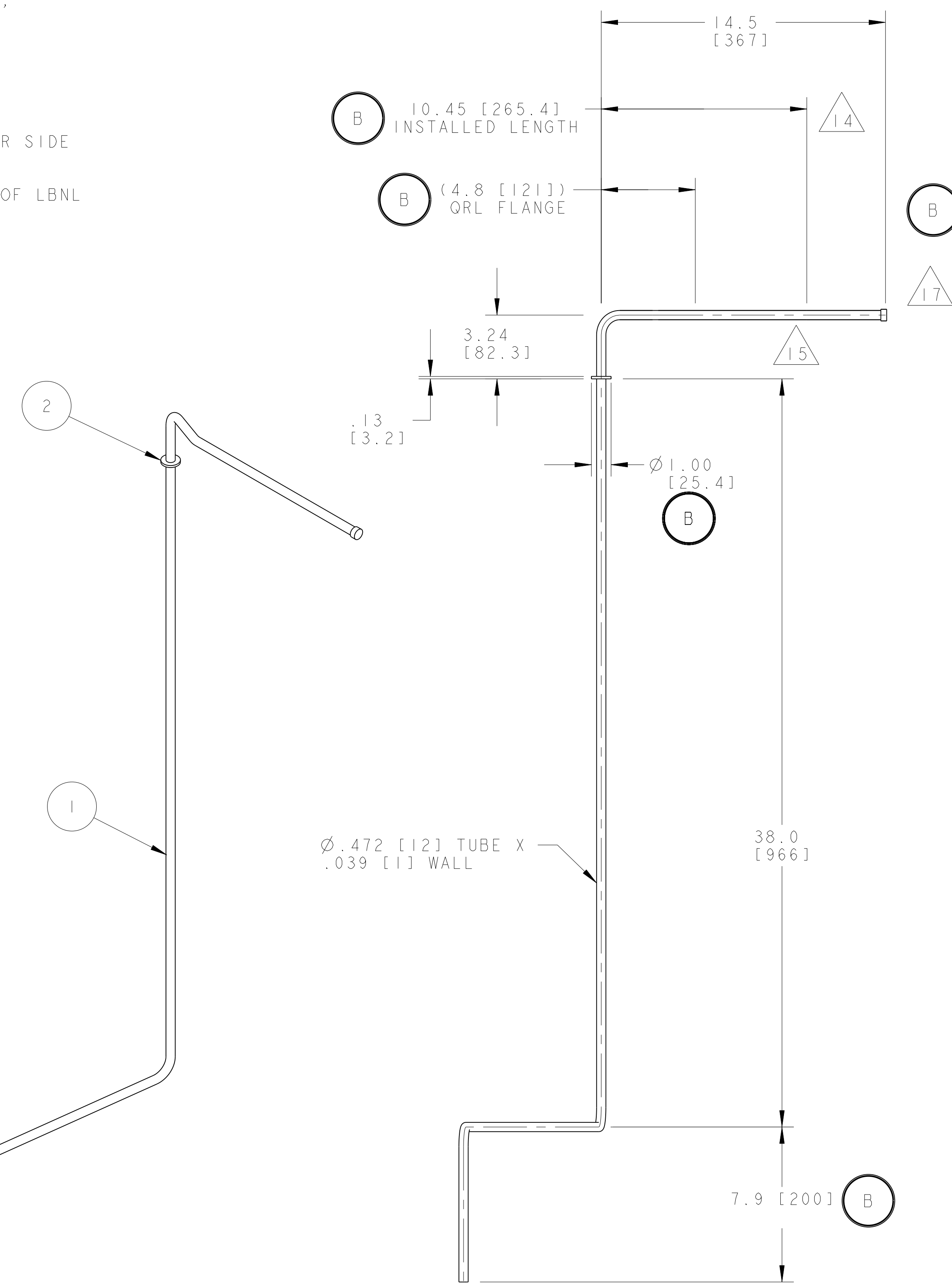
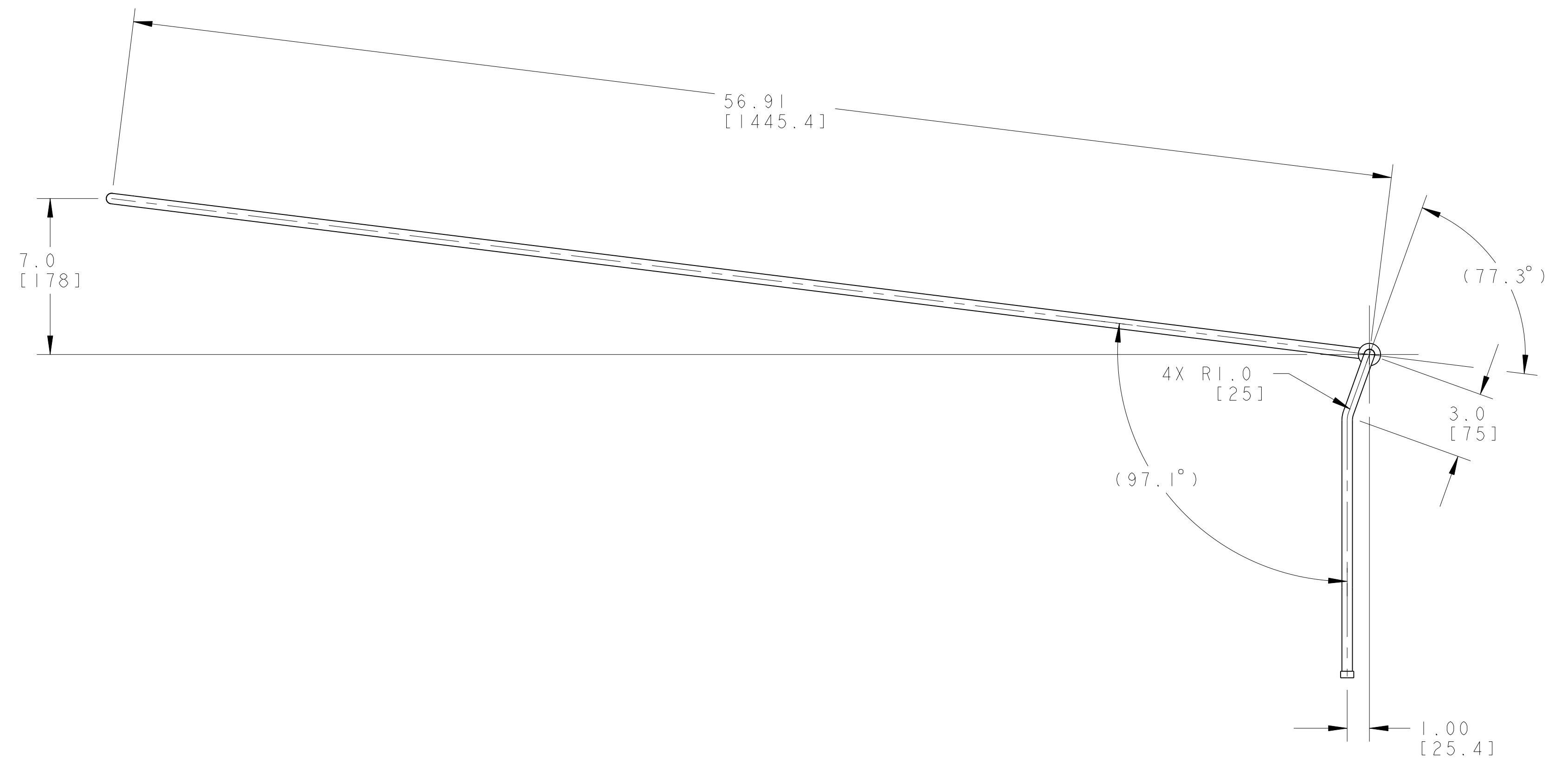


NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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 [mm] 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.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- 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.



REV	DWG	CHK	ZONE	DATE	CHANGES
B	RLM	DPO		11-20-02	CHANGED FLANGE DIAMETER, ADDED ORL FLANGE CALLOUT TO DWG VIEW, DELETED ORB WELD CLEARANCE CALLOUT, ADDED NOTE 15 TO DWG VIEW, DIM 15.7.9 WAS 1.88.
A	ARH	DPO		8-17-02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED
 TOLERANCES: X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.00°
 SURFACE FINISH: X.XXX ± 0.010
 DO NOT SCALE PRINT
 CHECKED: ALL DIMENSIONS
 CUT ROUNDS: 1.5 THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES: 1/16 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.5M & B.6.1

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
2	-	1	COLLAR	SS 304L
1	-	1	TUBE, PER ASTM A269	SS 304L

SHOP ORDERS

SET	DATE	BY	REASON
NO			
ISS			
REV			

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 PIPE, CCI

SCALE: 1/4
 SHEET 1 OF 1
 2512186

NAME: ARHARRIS OBJECT: 251218 DATE: 04-Dec-02 15:32:07

2512186 B 1