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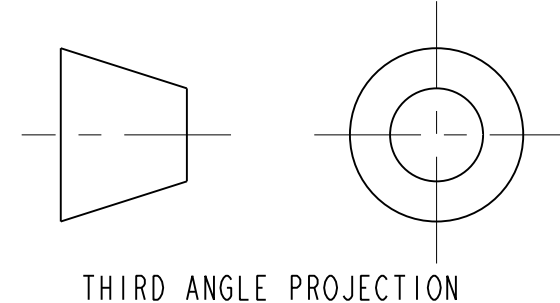
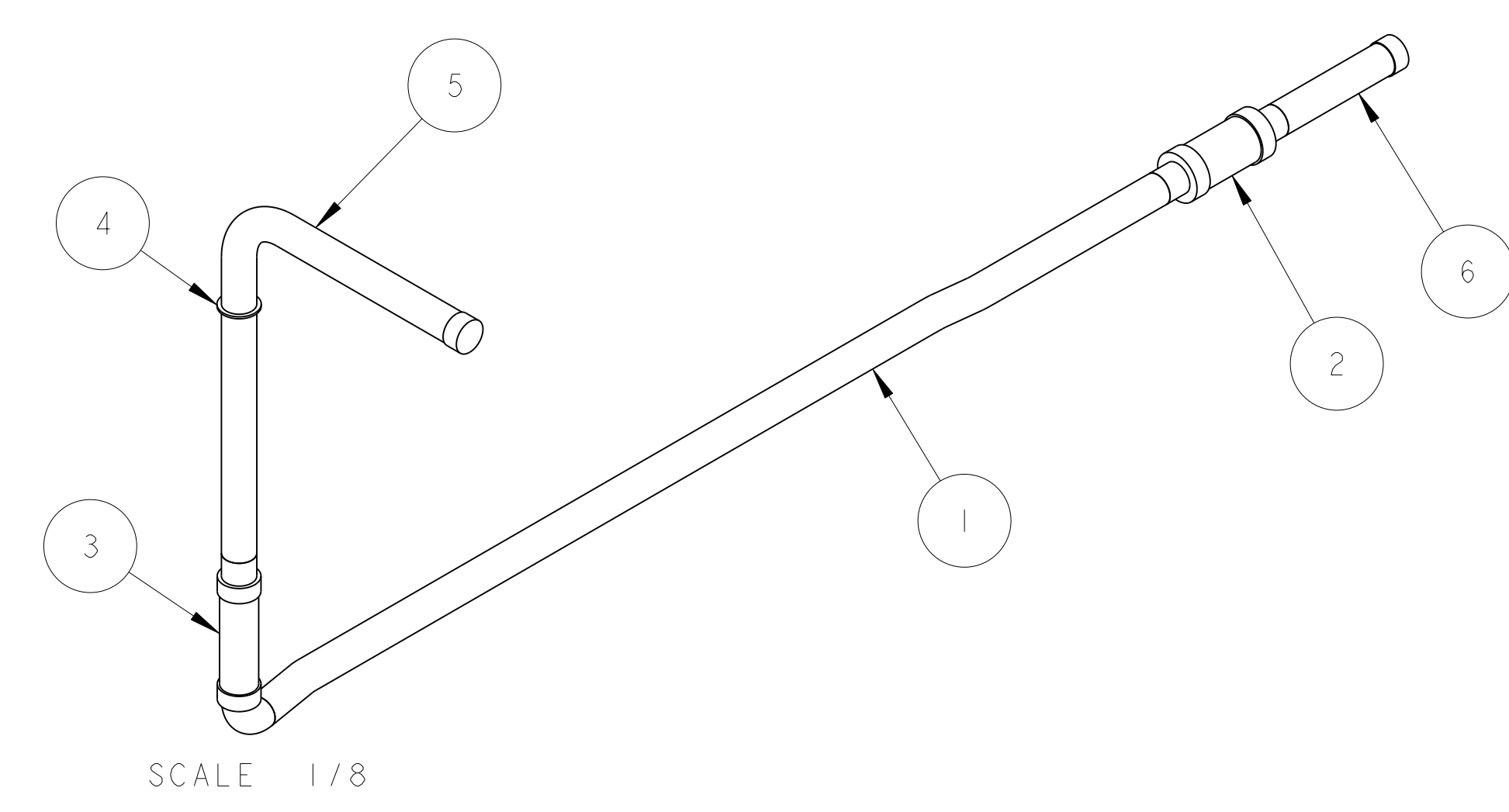
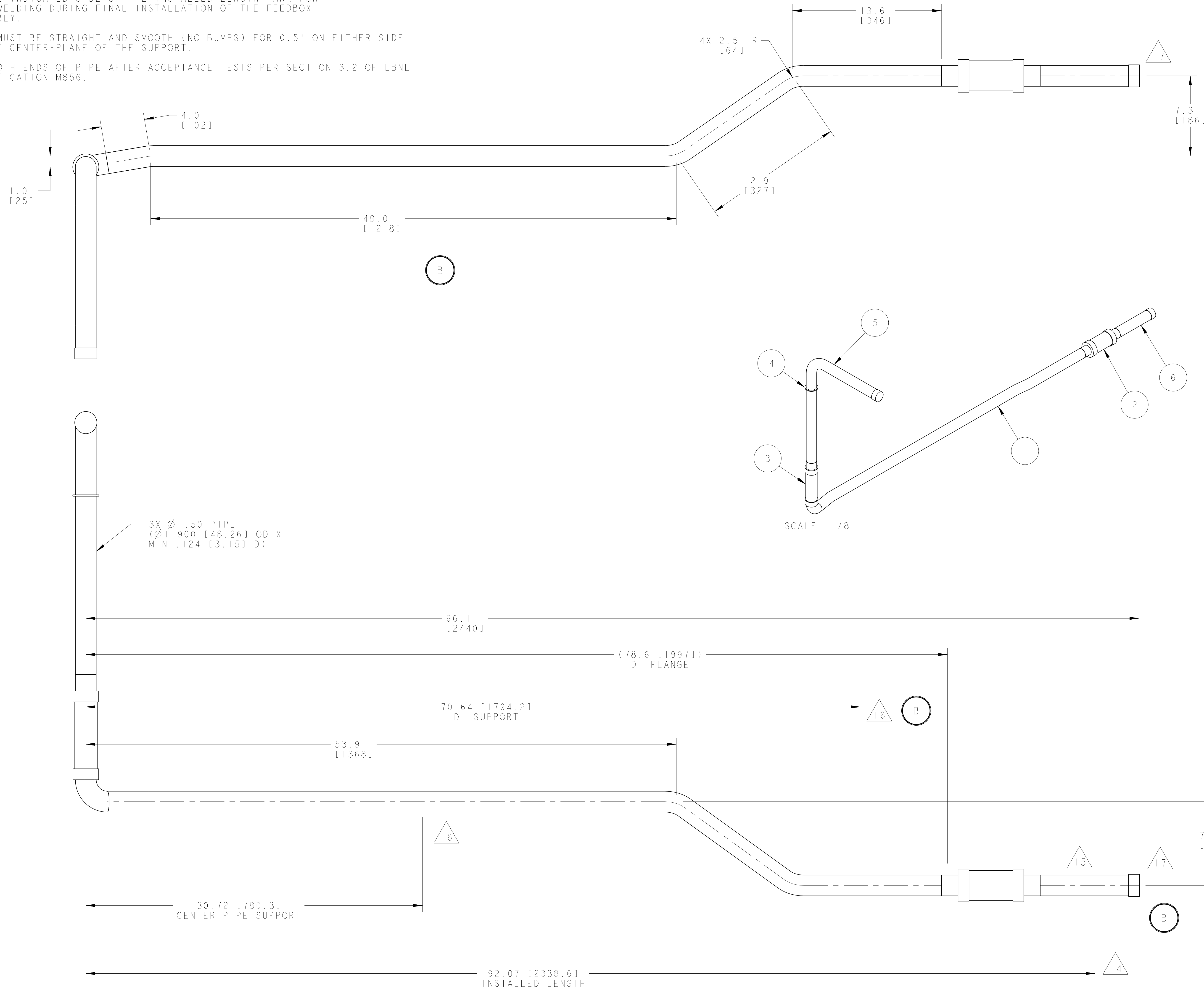
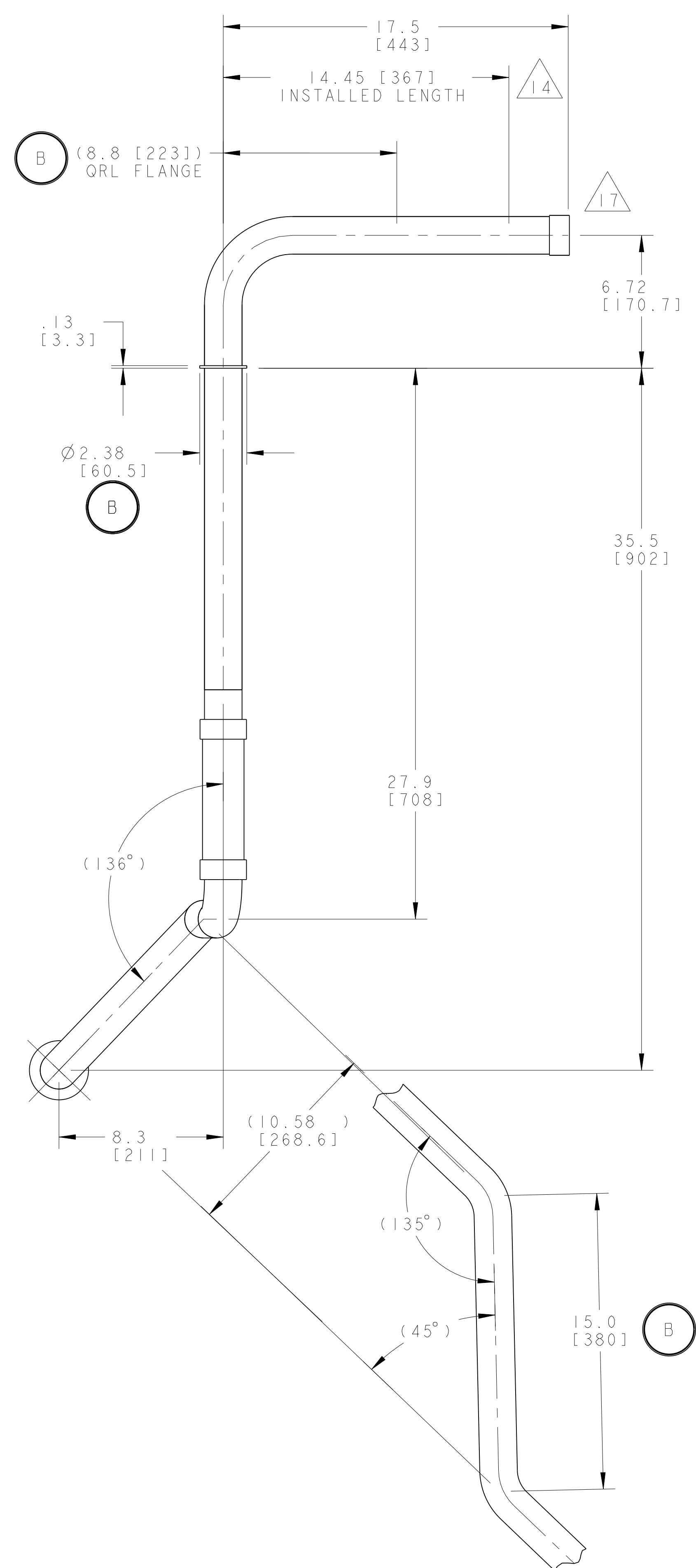
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NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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; SUBECT 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.



REV	DWG	CHK	ZONE	DATE	INITIALS	RELEASE	CHANGES
A	ARH	DPO		11-20-02			
B	RLM	DPO		11-20-02			CHANGED FLANGE DIAMETER, REVISED DECIMAL PLACES IN TOP VIEW, CHANGED DESCRIPTION CALLOUT FOR BOM ITEMS 5 & 6, DELETED ORB WELD CLEARANCE CALLOUT, ADDED NOTE 16 CALLOUT TO VIEW, ADDED ORL FLANGE CALLOUT TO DWG VIEW

UNLESS OTHERWISE SPECIFIED
 X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.00°
 X.XXX ± 0.010 FINISH 12.5
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES .156 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.5M & B.01

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
6		1	PIPE, PER ASTM A312	SS 304L
5		1	PIPE, PER ASTM A312	SS 304L
4		1	SUPPORT COLLAR	SS 304L
3		1	BRAIDED FLEX HOSE, 2" ID X 6.1" LL	SS 309 SERIES
2		1	BRAIDED FLEX HOSE, 2" ID X 4" LL	SS 309 SERIES
1		1	PIPE, PER ASTM A312	SS 304L

SHOP ORDERS
 DATE: 15-Dec-01
 DATE: 4-02-02
 DATE: 4-02-02
 DATE: 4-02-02

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY
 LHC IR FEEDBOX
 CRYOGENICS
 PIPE, LDI
 ASSEM 251226
 Z5LCE2 LH2003
 SCALE: 1/4
 SHEET 1 OF 1
 2512236

NAME: ARHARRIS OBJECT: 251223 DATE: 05-Dec-02 13:44:53

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