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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. ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED.
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.

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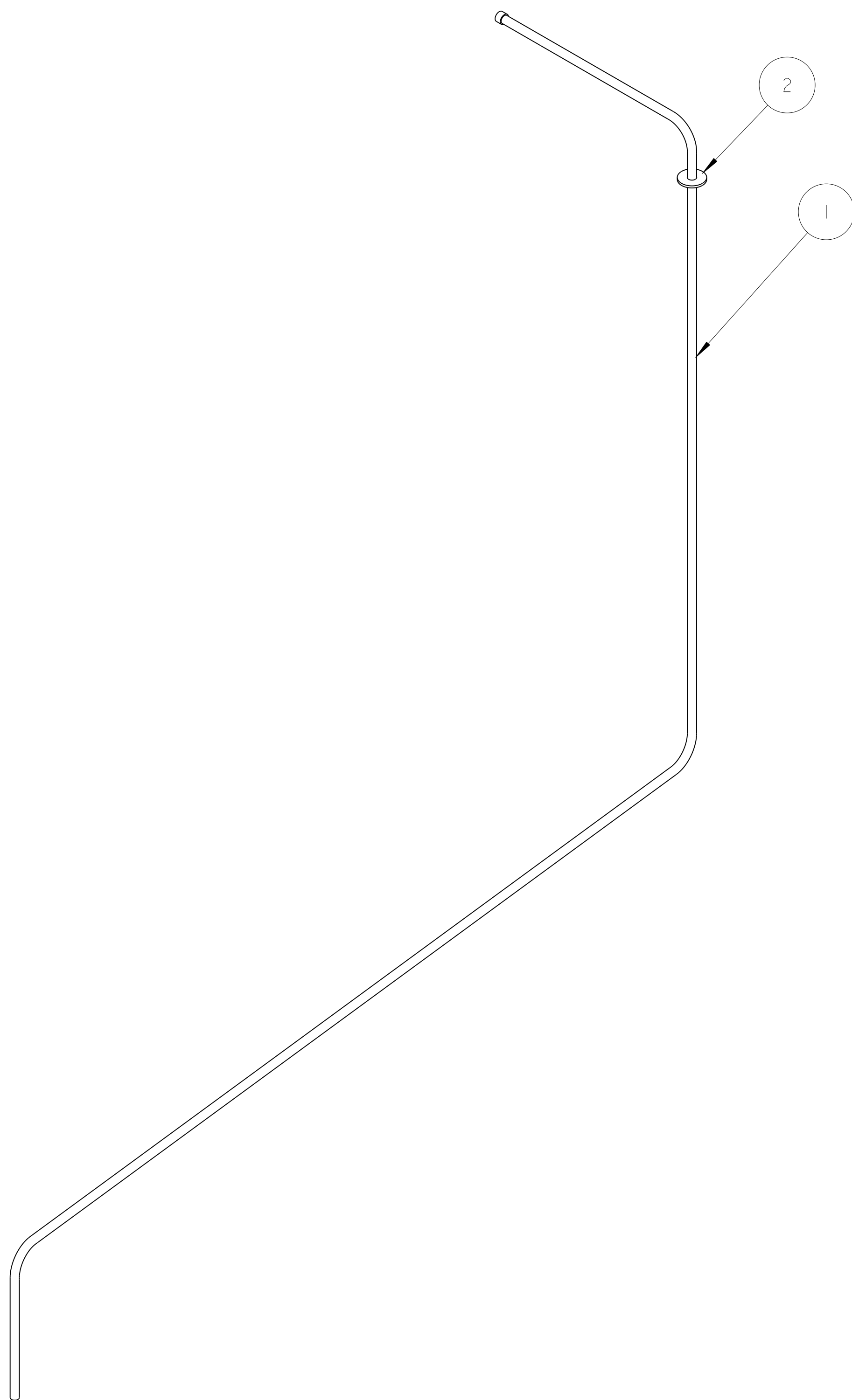
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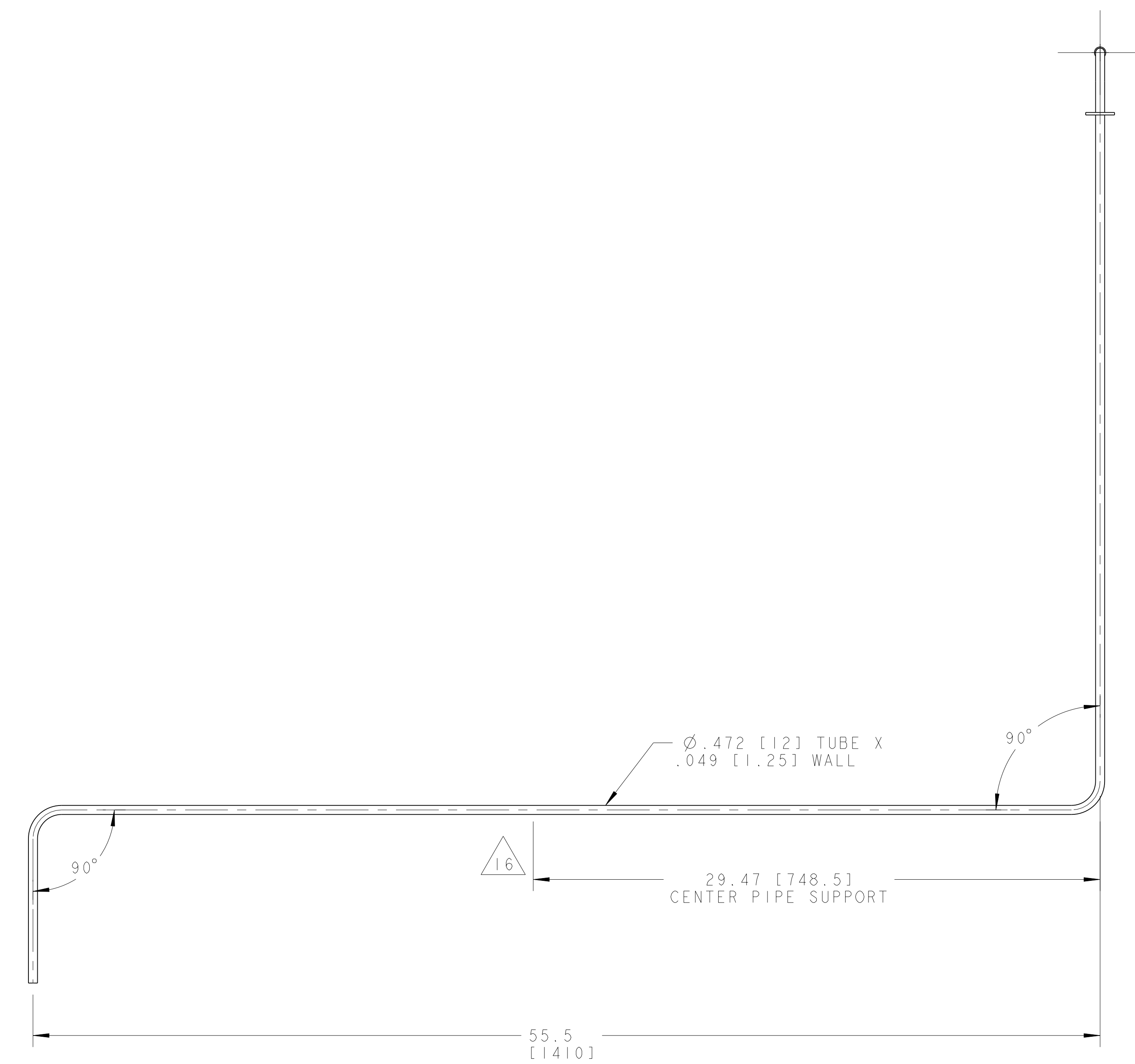
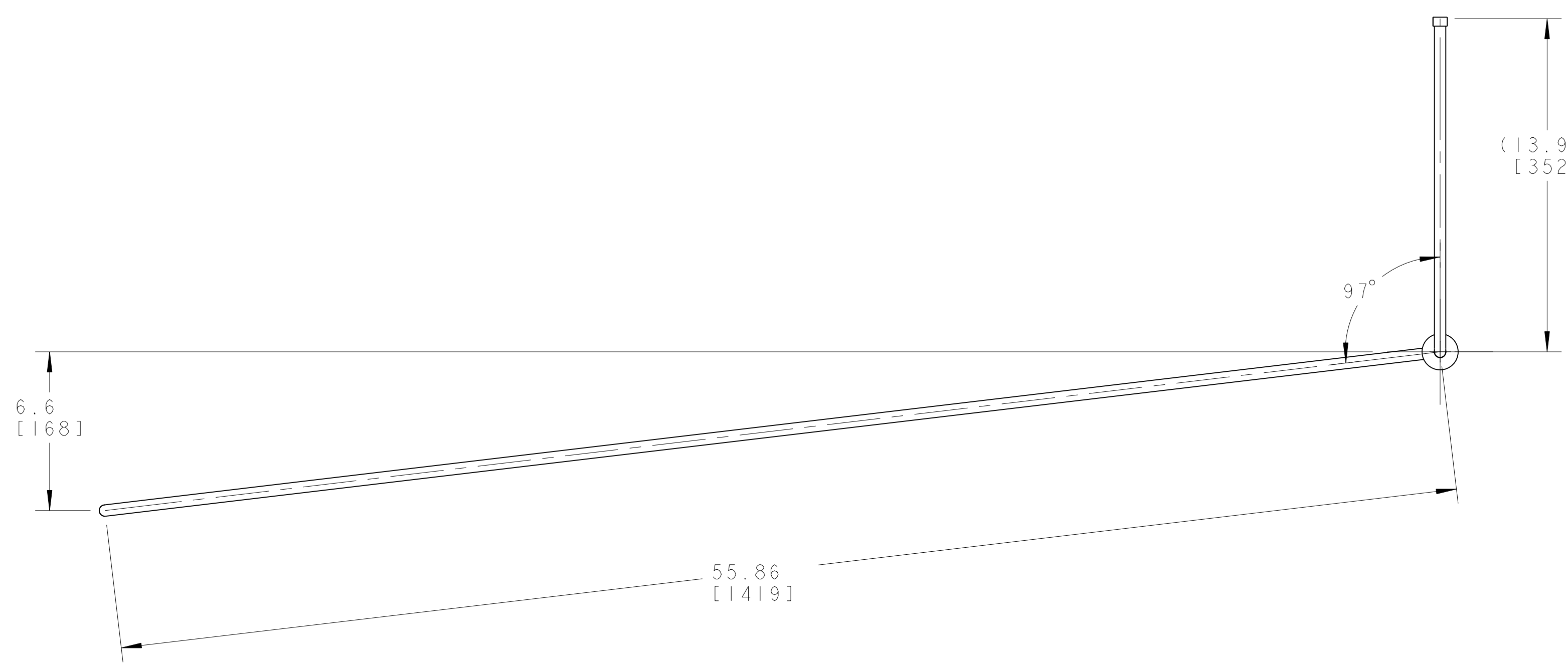
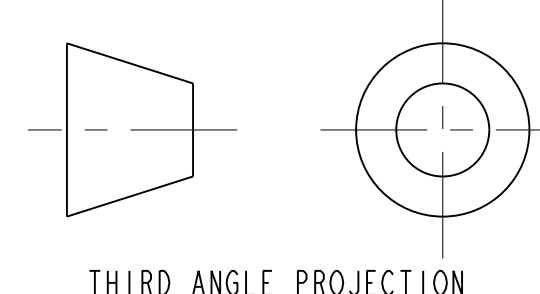
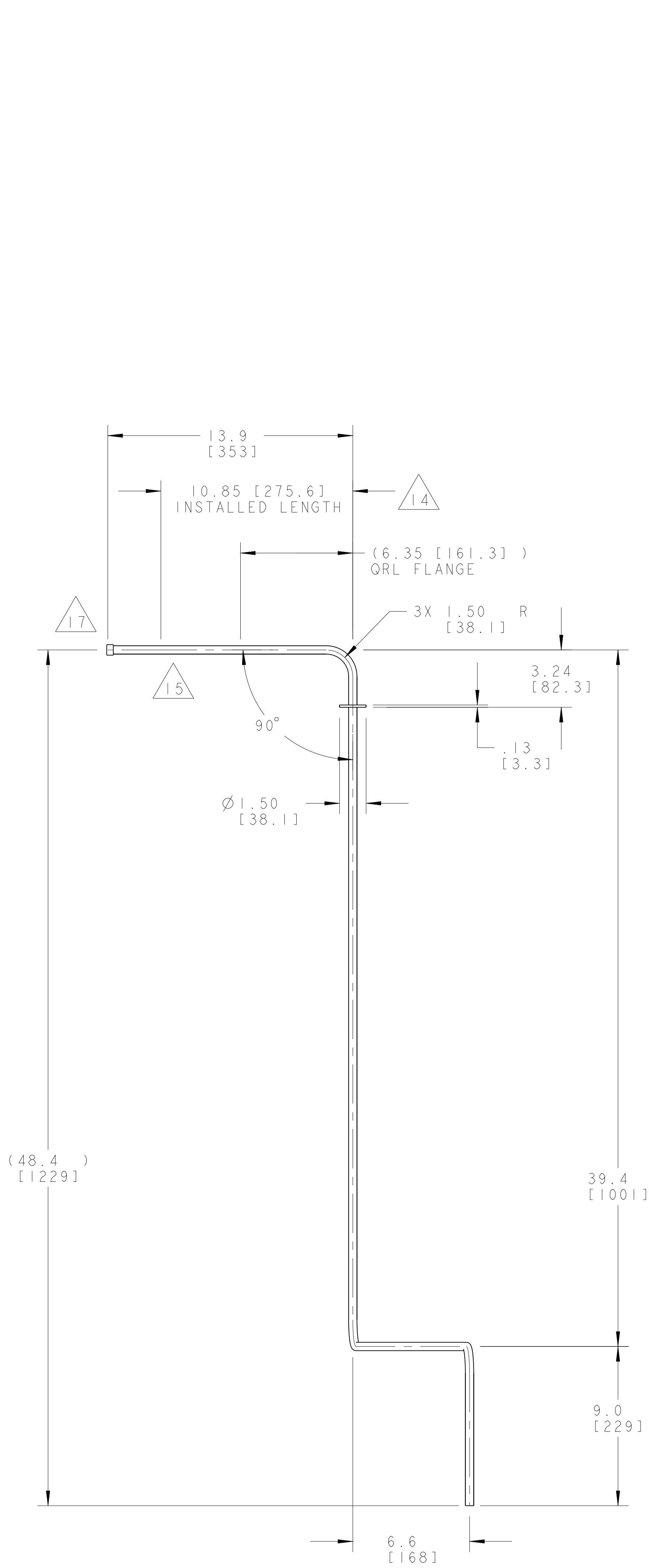
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SCALE 7/32



REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE	CHANGES
A	ARH	SPY		11-01-02		

2	-	1	FLANGE, SPIDER INTERFACE	SS 304L
1	-	1	TUBE, PER ASTM A269	SS 304L
ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
SHOP ORDERS UNLESS OTHERWISE SPECIFIED: X.X ± 0.1 FRACTION ± 1/64 X.XX ± 0.03 ANGLES ± 1.0° X.XXX ± 0.010 FINISH DO NOT SCALE PRINT TOLERANCES ARE CLASS 2 CHAMFER ENDS OF ALL SCREW THREADS 30° CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS BREAK EDGES .016 MAX. ON MACHINED WORK REMOVE BURRS, WELD SPATTER & LOOSE SCALE IN ACCORDANCE WITH ASME B16.9 & B31.1				
ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA BERKELEY LHC IR FEEDBOX CRYOGENICS PIPE, CCI ASSEMBLY SCALE: 1/4 SHEET 1 OF 1 Z5LCE2 LH2003 2512366 A				

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NAME: ARHARRIS OBJECT: 251236 DATE: 11-Nov-02 12:46:57