

NAME: ARHARRIS OBJECT: 251242_1 DATE: 25-Nov-02 15:04:51

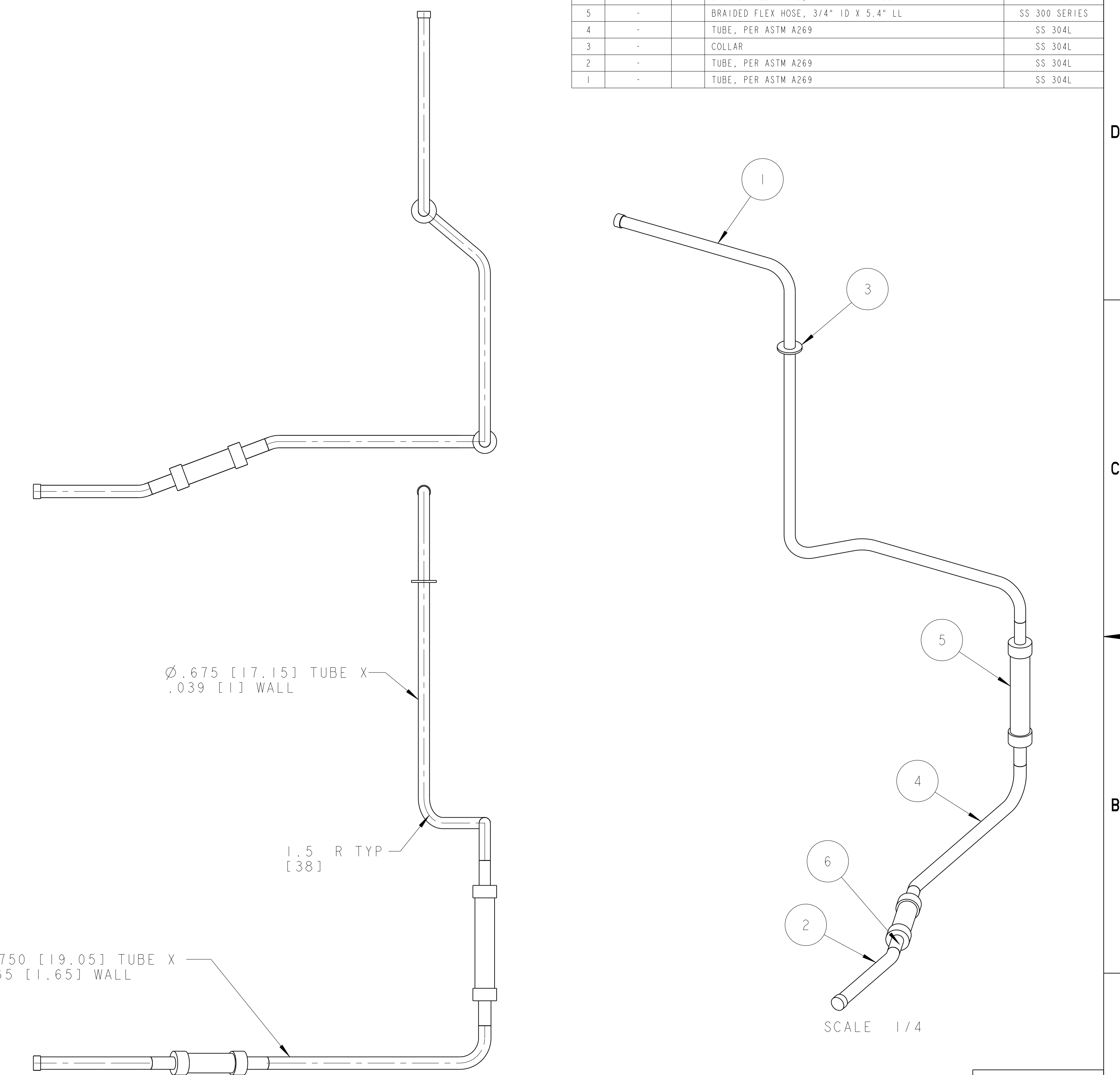
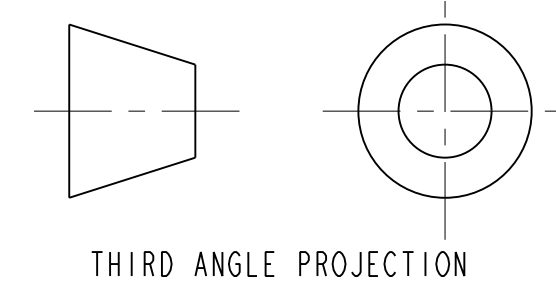
DWG. NO. 2512424 SIZE REV. SH. A 1

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.

ITEM	PART NO	RECD	DESCRIPTION	MATERIAL
6	-		BRAIDED FLEX HOSE, 3/4" ID X 3" LL	SS 300 SERIES
5	-		BRAIDED FLEX HOSE, 3/4" ID X 5.4" LL	SS 300 SERIES
4	-		TUBE, PER ASTM A269	SS 304L
3	-		COLLAR	SS 304L
2	-		TUBE, PER ASTM A269	SS 304L
1	-		TUBE, PER ASTM A269	SS 304L

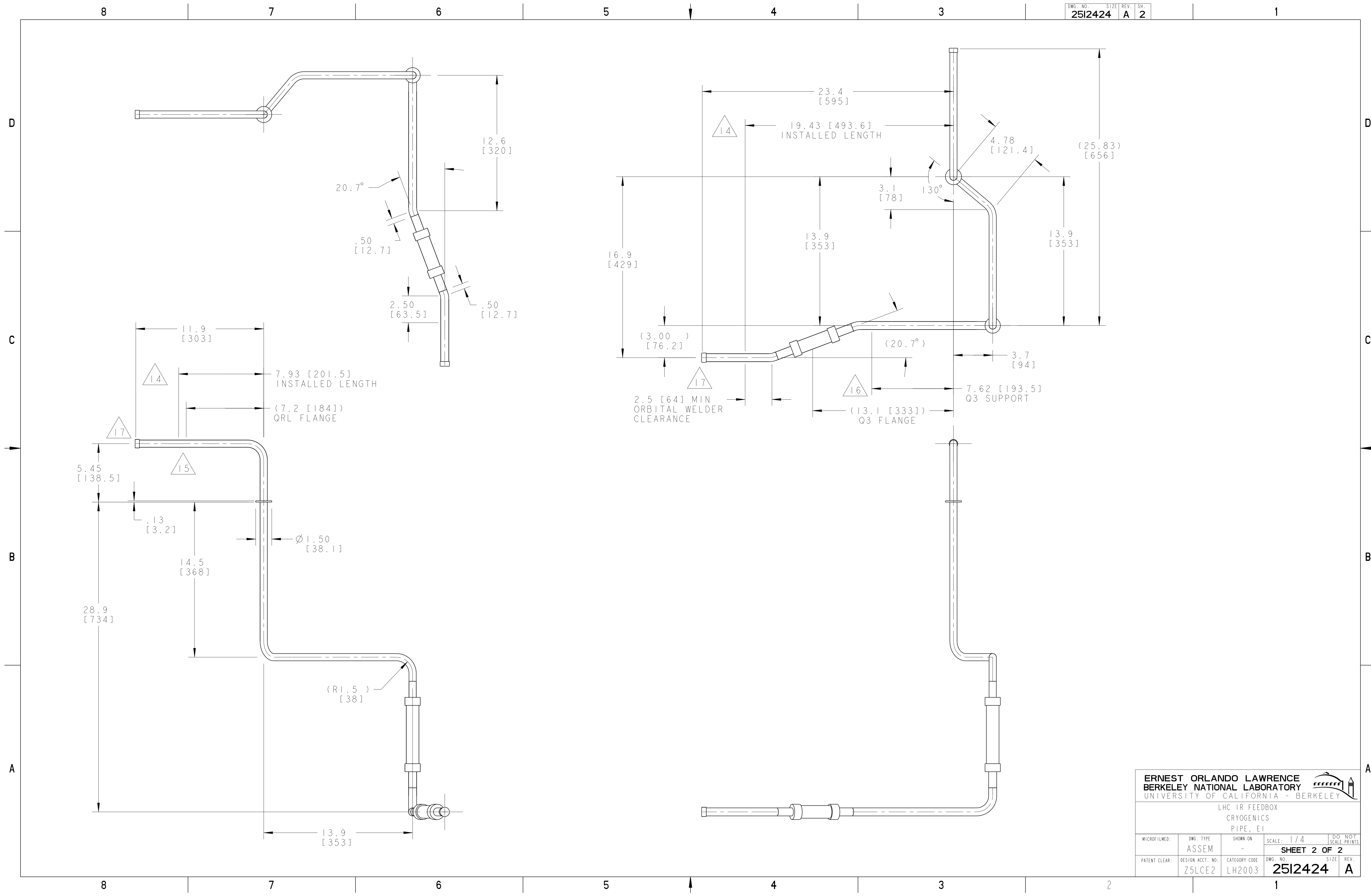
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION 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.



**** SEE SHEET 2 FOR DIMENSIONS**

<table border="1"> <tr> <th>REV</th> <th>DWG</th> <th>CHK</th> <th>ZONE</th> <th>DATE</th> <th>CHANGES</th> </tr> <tr> <td>A</td> <td>ARH</td> <td>SPV</td> <td></td> <td>10-25-02</td> <td>INITIAL RELEASE</td> </tr> </table>		REV	DWG	CHK	ZONE	DATE	CHANGES	A	ARH	SPV		10-25-02	INITIAL RELEASE	<p>UNLESS OTHERWISE SPECIFIED</p> <p>TOLERANCES X.X ± 0.1 X.XX ± 0.03 X.XXX ± 0.010</p> <p>FINISH 125 \sqrt{Ra}</p> <p>DO NOT SCALE PRINT</p> <p>THREADS ARE CLASS 2</p> <p>CHAMFER ENDS OF ALL SCREW THREADS 30°</p> <p>CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS</p> <p>BREAK EDGES .016 MAX. ON MACHINED WORK</p> <p>REMOVE BURRS, WELD SPLATTER & LOOSE SCALE</p> <p>IN ACCORDANCE WITH ASME Y14.5M & B46.1</p>		<p>SHOP ORDERS</p> <table border="1"> <tr> <th>ACCT NO.</th> <th>NO.</th> <th>DATE</th> </tr> <tr> <td></td> <td></td> <td></td> </tr> </table> <p>TOLERANCES</p> <table border="1"> <tr> <th>FRAC.</th> <th>±</th> </tr> <tr> <td>1/64</td> <td></td> </tr> </table> <p>ANGLES ± 1.00°</p> <p>FINISH 125 \sqrt{Ra}</p> <p>SURFACE TREATMT -</p> <p>TREATMENT TAG</p> <p>PROJECT NUMBER N/A</p> <p>PROJECT NAME N/A</p> <p>DWG BY R.LA MANTIA</p> <p>CHK BY S.VIROSTEK</p> <p>APP BY D.OSHATZ</p> <p>DATE 22-Mar-02</p> <p>DATE 25-Oct-02</p> <p>DATE 11-Oct-02</p>		ACCT NO.	NO.	DATE				FRAC.	±	1/64		<p>ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY</p> <p>LHC IR FEEDBOX CRYOGENICS PIPE, E1</p> <p>MICROFILMED: -</p> <p>DWG. TYPE: ASSEM</p> <p>SHOWN ON: -</p> <p>SCALE: 1/4</p> <p>DO NOT SCALE PRINTS</p> <p>SHEET 1 OF 2</p> <p>DWG. NO. 2512424</p> <p>REV. A</p>	
REV	DWG	CHK	ZONE	DATE	CHANGES																								
A	ARH	SPV		10-25-02	INITIAL RELEASE																								
ACCT NO.	NO.	DATE																											
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NAME: ARHARRIS OBJECT: 251242-2 DATE: 25-Nov-02 15:04:52



ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY				
LHC IR FEEDBOX CRYOGENICS PIPE, E1				
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1/4	DO NOT SCALE PRINTS
	ASSEM	-	SHEET 2 OF 2	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE REV.
	Z5LCE2	LH2003	2512424	A