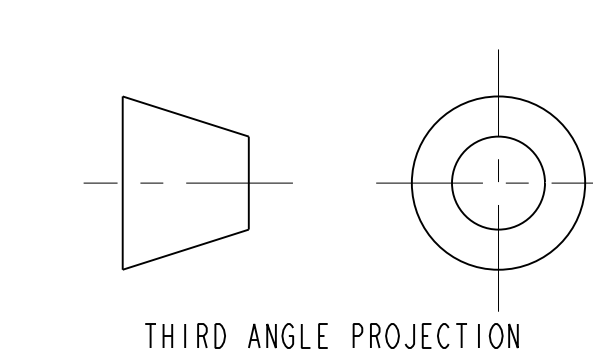
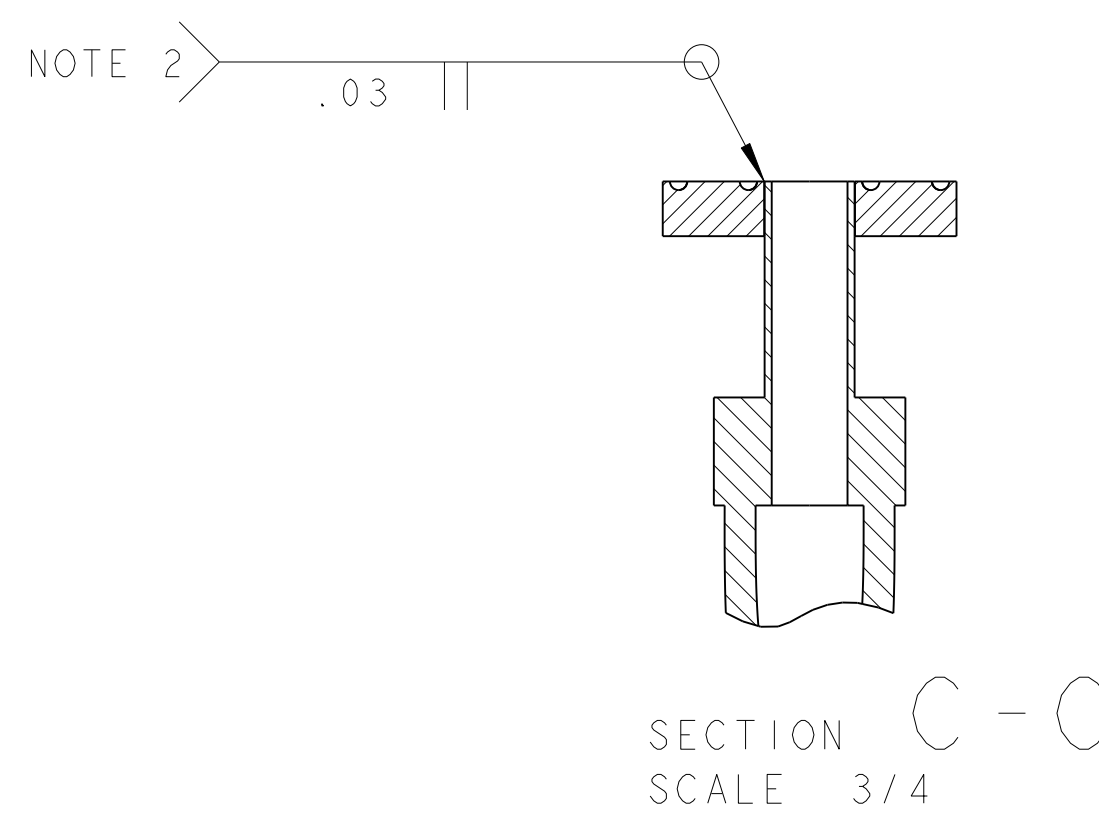
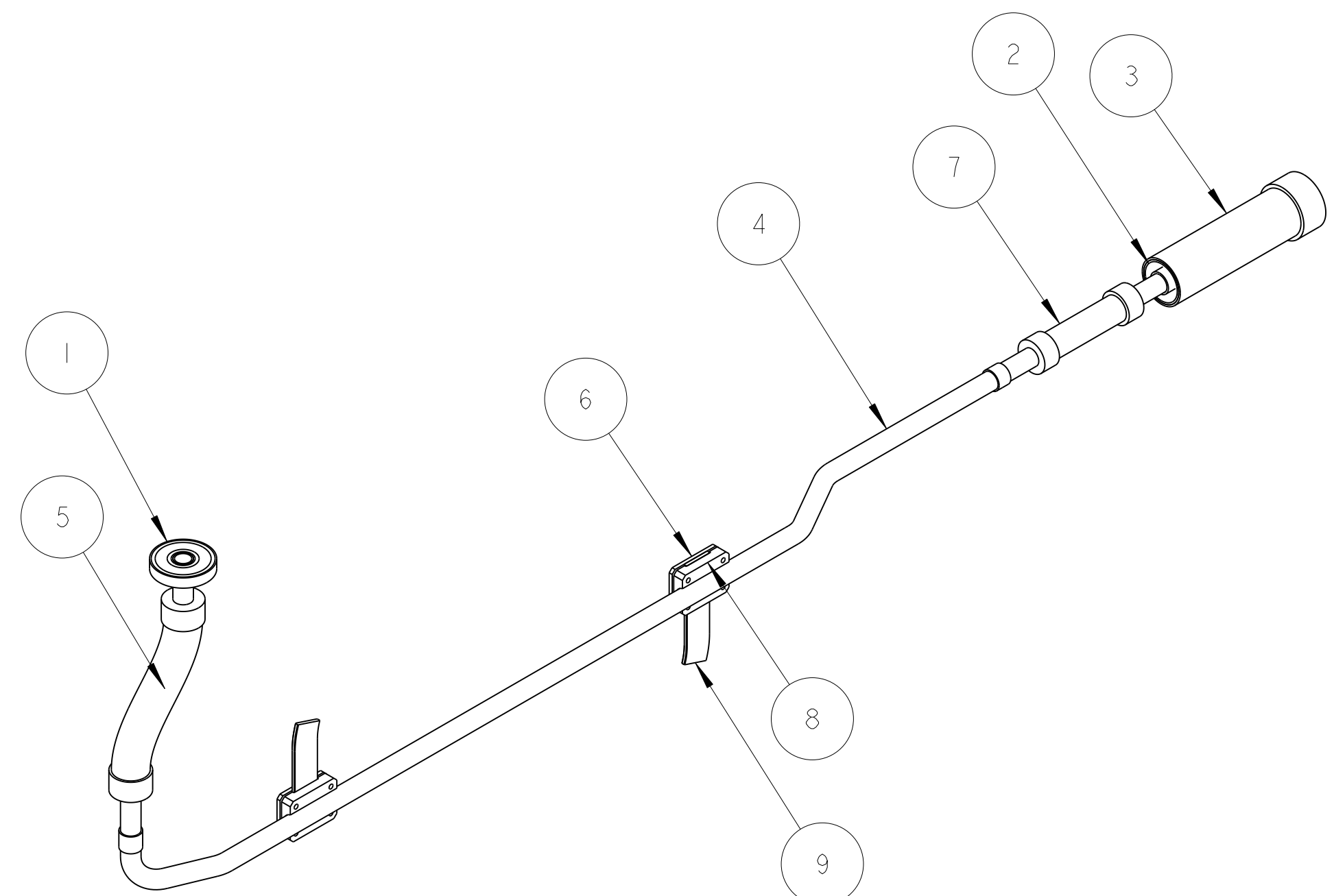
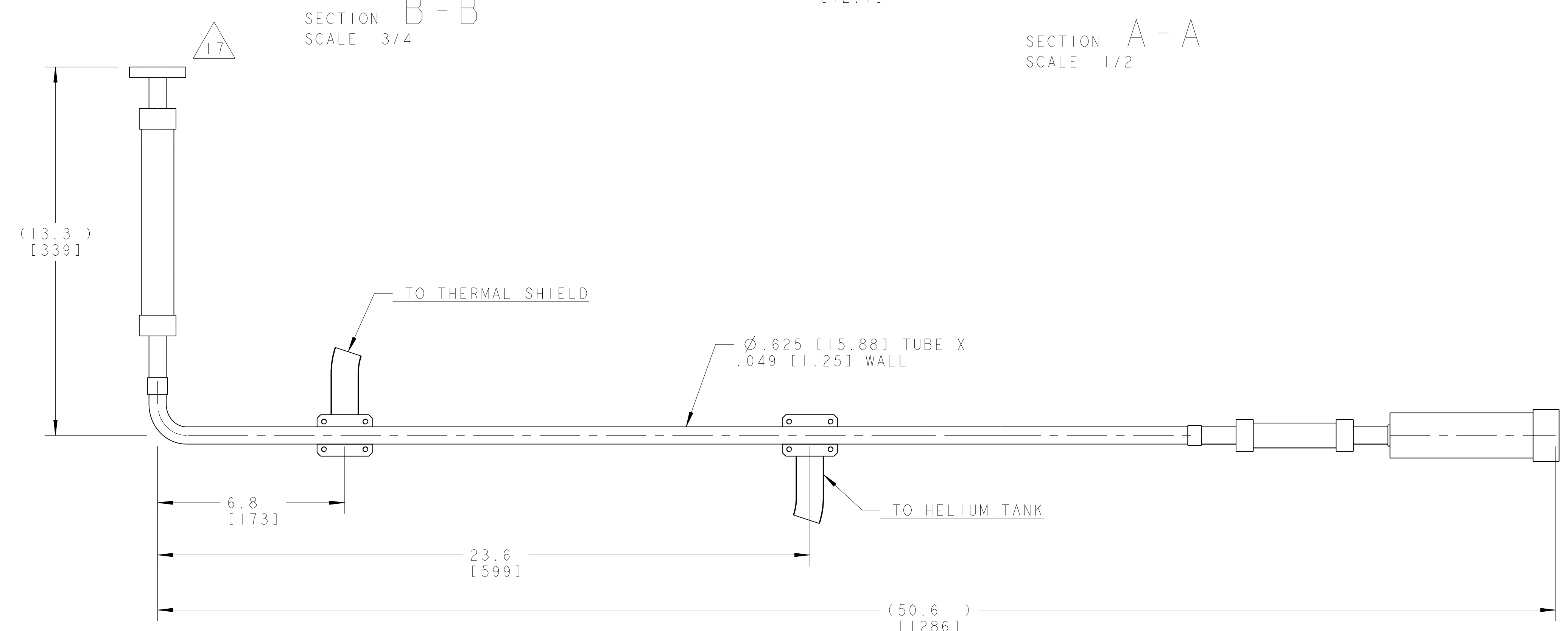
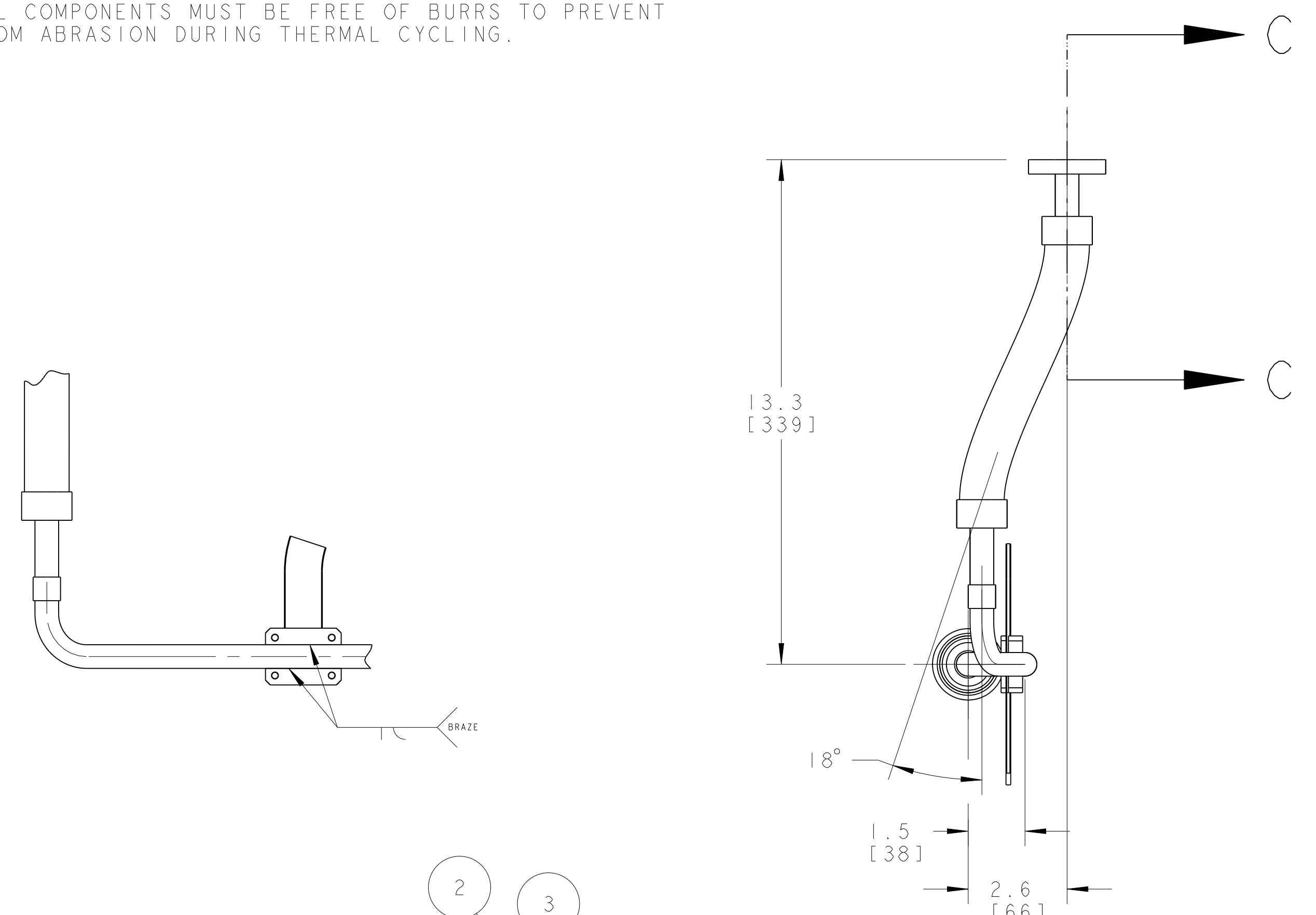
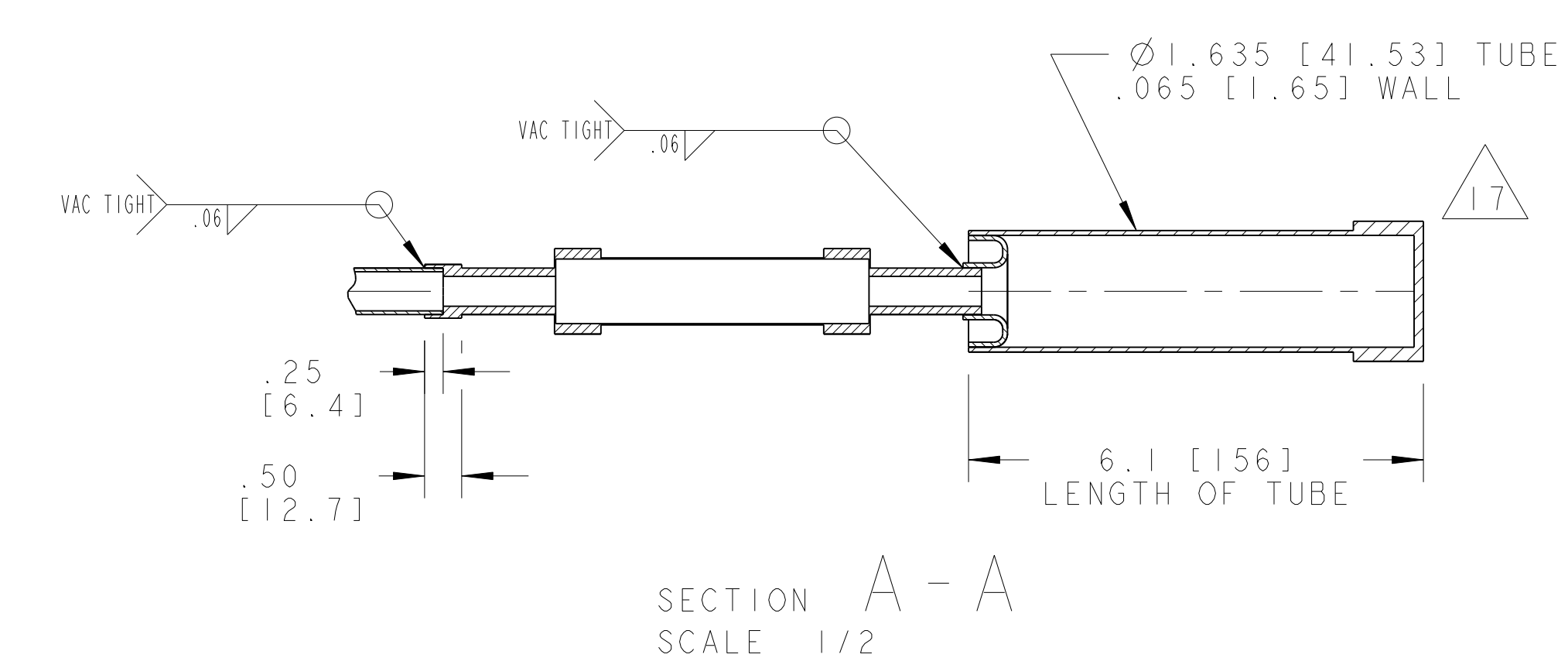
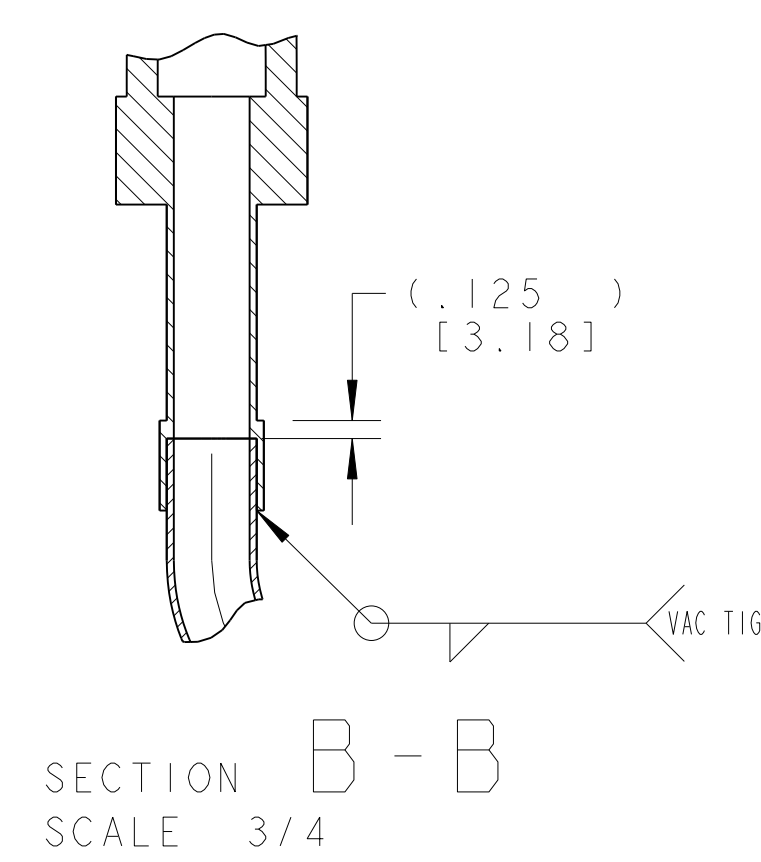
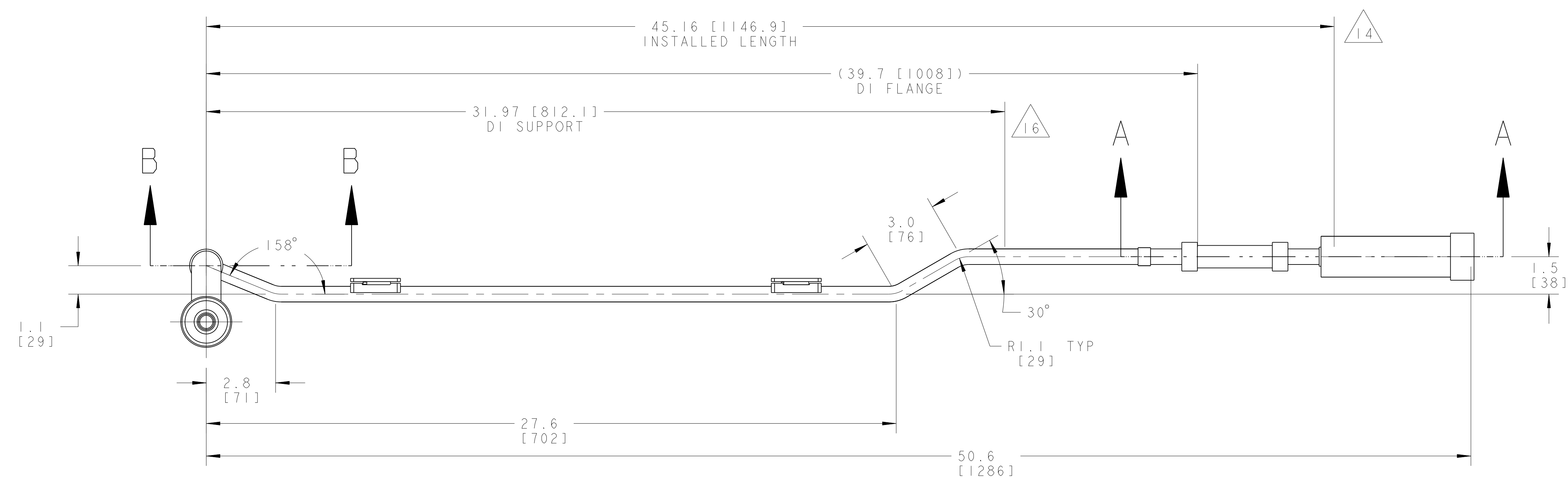


NOTES: (UNLESS OTHERWISE SPECIFIED)

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 END OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
18. PIPE SHIPPED WITH CAPPED TUBE WELDED TO BELLOWS FLANGE. THE TUBE WILL BE CUT AS SHOWN AND USED AS A WELD SLEEVE DURING FINAL INSTALLATION OF THE FEEDBOX.
19. THE INTERIOR OF ALL COMPONENTS MUST BE FREE OF BURRS TO PREVENT WIRE INSULATION FROM ABRASION DURING THERMAL CYCLING.



ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
9	-	2	COPPER BRAID, 1" X 1/8"	-
8	25M877	2	CLAMP BASE PLATE, 5/8" TUBE	COPPER, OFHC, C101
7	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3" LL, 5/8 END, 5/8 SOCKET END	SS 309 SERIES
6	25M813	2	CLAMP COVER 1"	OFHC, C101
5	-	1	BRAIDED FLEX HOSE, 3/4" ID, ELBOW & WELD SOCKET - 7.2" LL	SS 309 SERIES
4	-	1	TUBE, ASTM A269	SS 304L
3	-	1	TUBE 3, ASTM A269	SS 304L
2	251644	1	BELLOWS FLANGE, ROLLED	SS 304L
1	251641	1	INSERT, 5/8" TUBE WELD FLANGE	SS 304L

REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE
A	ARH	SPV		11-22-02	CHANGES

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	SEE
TOLERANCES	FIN	-
FRACTIONAL	NO	-
DECIMAL	YES	-
ANGLE	NO	-
SPHERICAL	NO	-
FREE SURFACE	NO	-
TEXT	NO	-
WELDING	NO	-
PROJECT	N/A	-
ASSEMBLY	N/A	-
CHANGE ENDS OF ALL SCREW THREADS 30"	-	-
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS	-	-
BREAK EDGES .516 MAX. ON MACHINED WORK	-	-
REMOVE BURRS, WELD SPATTER & LOOSE SCALE	-	-
IN ACCORDANCE WITH ASME Y14.3M & B.61	-	-

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX CRYOGENICS PIPE, MBX2

SCALE: 3/8

SHEET 1 OF 1

DATE: 07-Nov-02
REV: 11-22-02
REV: 11-07-02