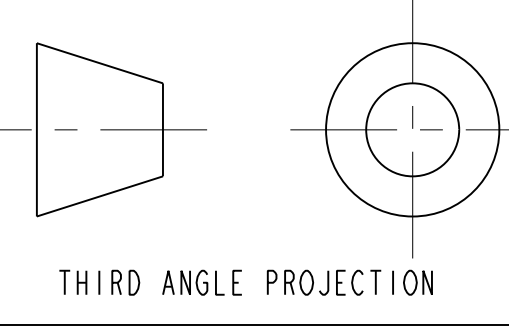


NOTES: (UNLESS OTHERWISE SPECIFIED)

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 DEEDBOX 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	DESCRIPTION
A	ARH	SPV		10-25-02	INITIAL RELEASE
					CHANGES

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
12		1	PIPE, PER ASTM A312	SS 304L
11		1	PIPE, PER ASTM A312	SS 304L
10		1	PIPE, PER ASTM A312	SS 304L
9		1	TUBE, PER ASTM A269	SS 304L
8		1	PIPE, PER ASTM A312	SS 304L
7	254862	1	WELD BRACKET	SS 304L
6		1	BRAIDED FLEXHOSE, 2" ID X 4.25" LL	SS 309 SERIES
5		1	BRAIDED FLEXHOSE, 2" ID X 7" LL	SS 309 SERIES
4	251314	1	BELLOWS, FINAL# 5520-MD-390065	SS 309 SERIES
3	251306	1	FLANGE, FINAL# 5520-MC-390032	SS 309 SERIES
2	254823	1	XB THRUST PLATE ASSY	
1		1	WELD RING, ID 134mm, FINAL SUPPLIED	

**SHOP ORDERS**  
 UNLESS OTHERWISE SPECIFIED  
 X.X ± 0.1 FRACTION ± 1/64  
 X.XX ± 0.03 ANGLES ± 1.00°  
 X.XXX ± 0.010 FINISH  
 DO NOT SCALE PRINT  
 BREAK EDGES 1:16 MAX ON MACHINED PARTS  
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE  
 IN ACCORDANCE WITH ASME B1.9.1 & B.1.1

**ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY**  
 UNIVERSITY OF CALIFORNIA BERKELEY  
 LHC IR FEEDBOX CRYOGENICS  
 PIPE WELDMENT, XB  
 DWG. TYPE: ASSEM  
 DATE: 13-May-02  
 PATENT CLEAR: REVIEW ACCT. NO. Z5LCE2  
 CATEGORY CODE: LH2003  
 SCALE: ~13/64  
 SHEET 1 OF 1  
 2512536 A

NAME: ARHARRIS OBJECT: 251253 DATE: 27-Nov-02 13:54:32

2512536 A 1