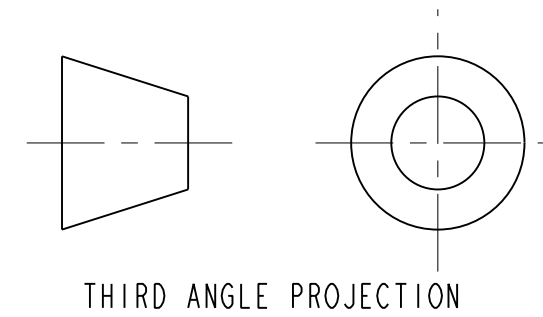
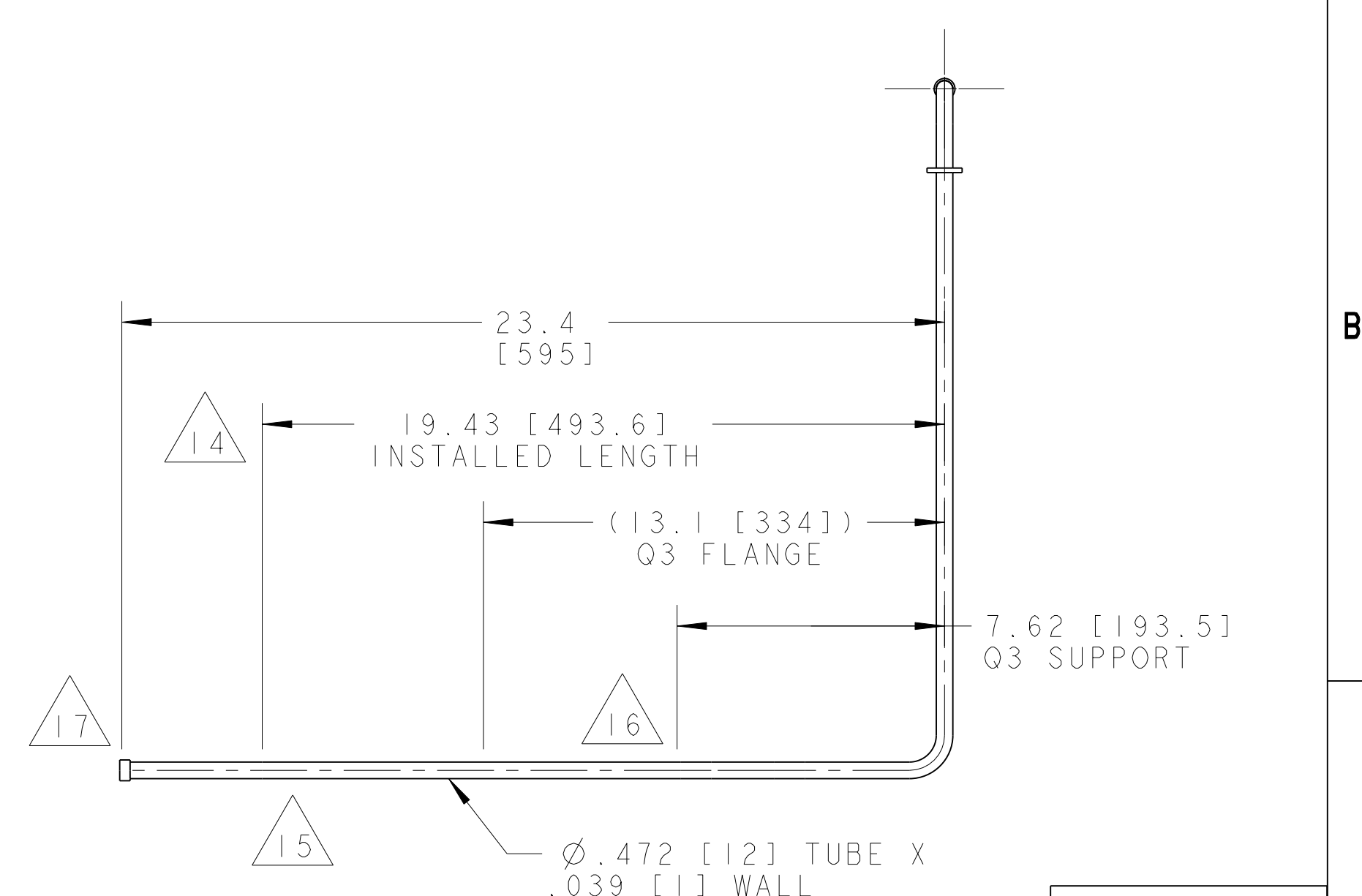
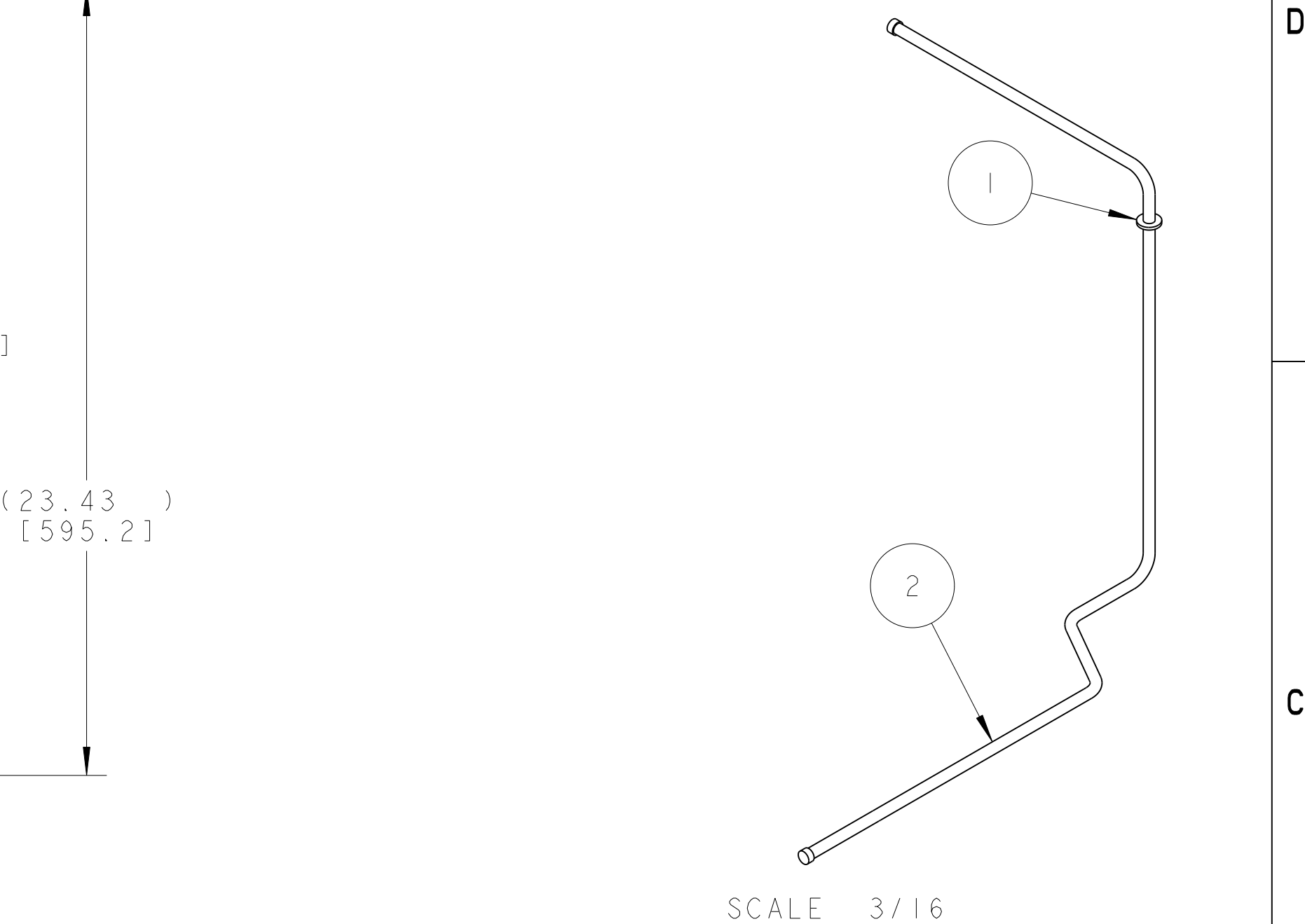
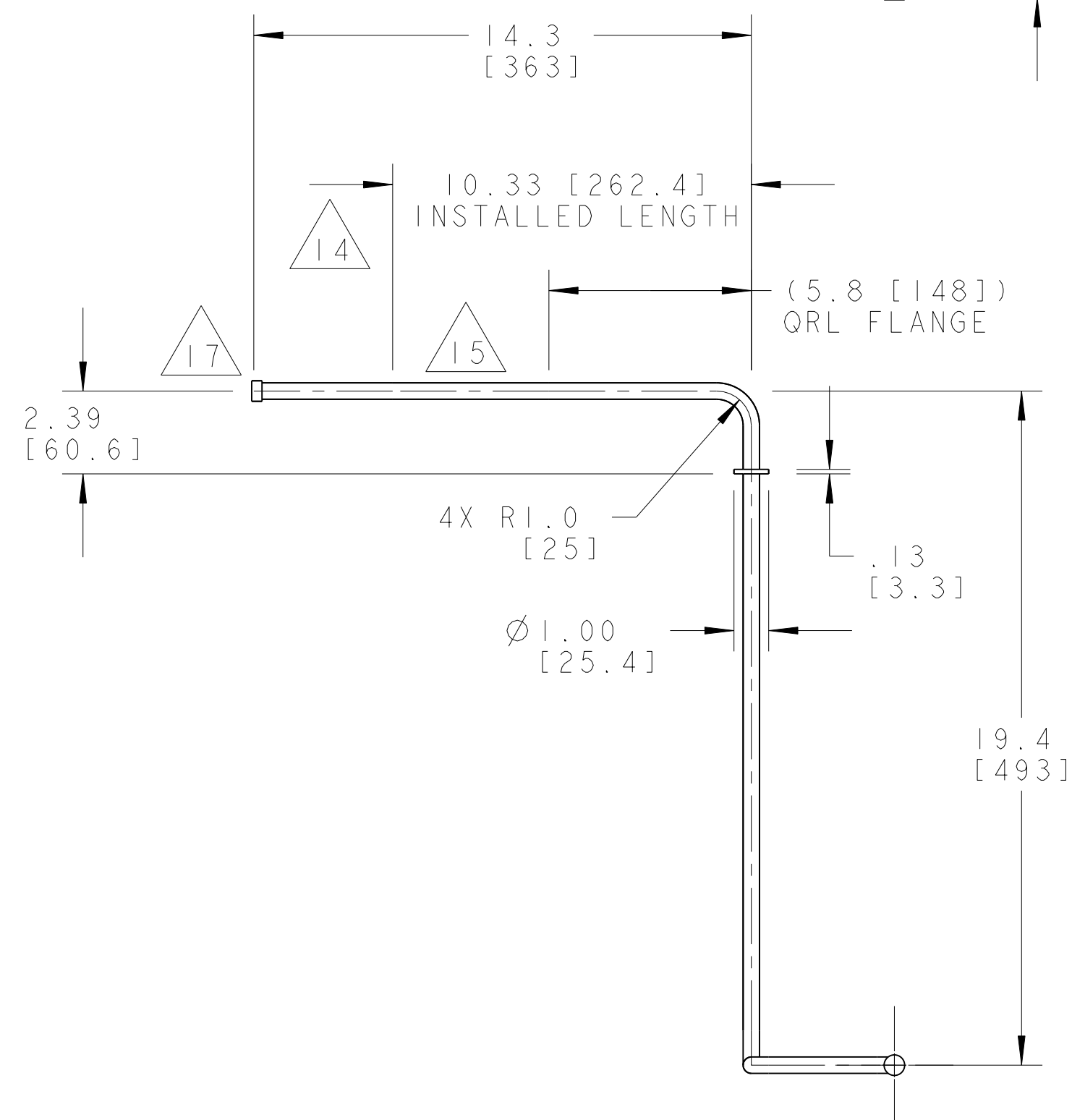
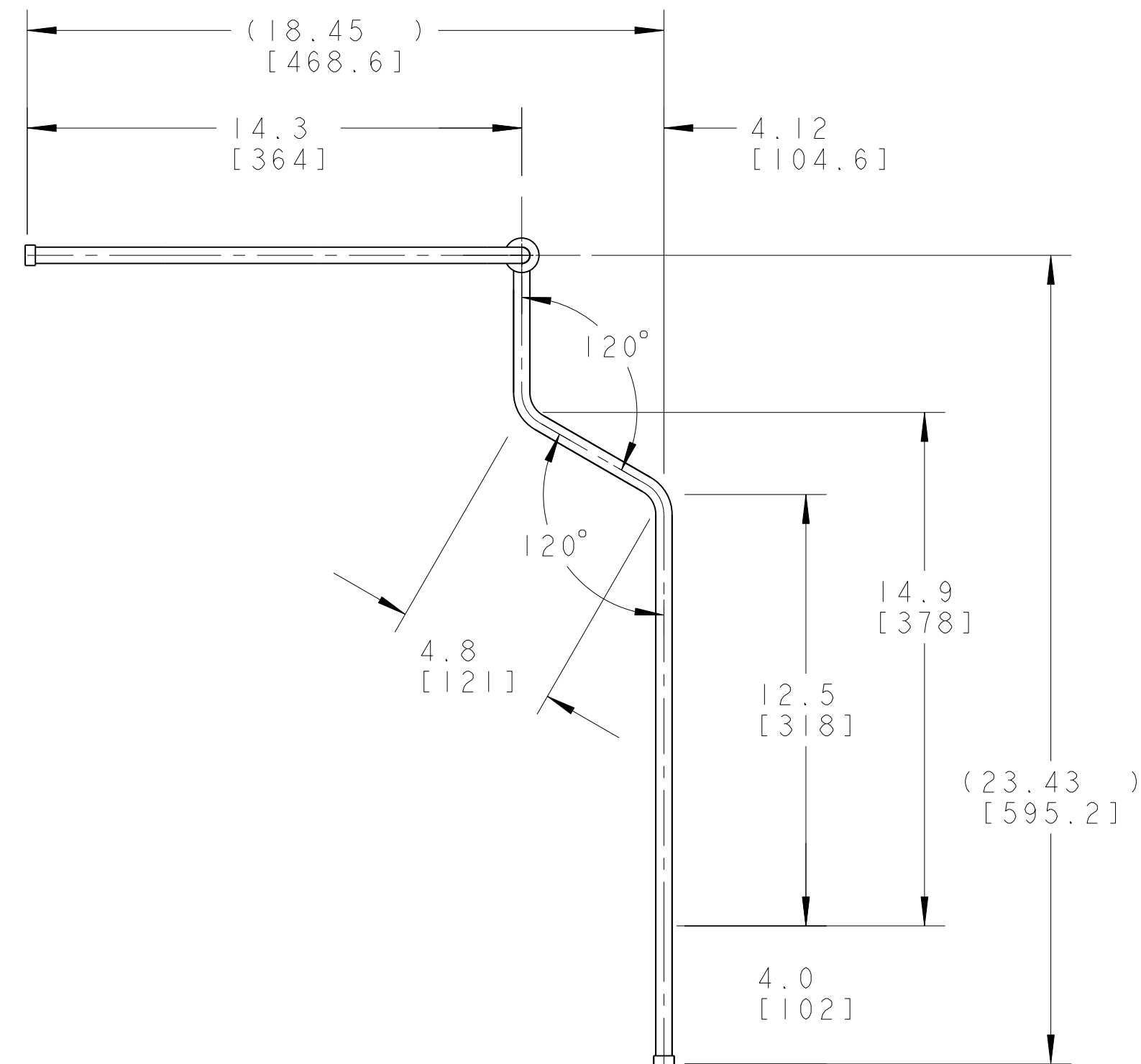


DWG. NO. 2513034		SIZE A	REV. 1	SH. 1
2	-	1	TUBE, PER ASTM A269	
1	-	1	COLLAR	
ITEM	PART NO	REOD	DESCRIPTION	MATERIAL
				SS 304L
				SS 304L

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
- 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".
- 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.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



TOLERANCES		UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER -		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY	
X.X ± 0.1	FRAC. ± 1/64	ACCT NO.	NO. REOD	NO.	DATE	NO.	DATE	LHC IR FEEDBOX CRYOGENICS PIPE, CYI	
X.XX ± 0.03	Angles ± 1.00°	DEL TO		TAG				MICROFILMED: ASSEM	
X.XXX ± 0.010	FINISH 125 $\sqrt{R_{a16}}$	SURFACE TREATMT -		PROJECT NAME		DATE		SCALE: 1/4	
DO NOT SCALE PRINT				PROJECT NUMBER		DATE		SHEET 1 OF 1	
THREADS ARE CLASS 2				PROJECT NAME		DATE		DWG. NO. 2513034	
CHAMFER ENDS OF ALL SCREW THREADS 30°				PROJECT NAME		DATE		REV. A	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				PROJECT NAME		DATE		CATEGORY CODE LH2003	
BREAK EDGES .016 MAX. ON MACHINED WORK				PROJECT NAME		DATE		DWG. NO. 2513034	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				PROJECT NAME		DATE		REV. A	
IN ACCORDANCE WITH ASME Y14.5M & B46.1				PROJECT NAME		DATE		DWG. NO. 2513034	

REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE	CHANGES	BY	DATE
A	ARH	SPV		11-01-02			Jon Zbosnik/S.Virostek	01-Nov-02
							Jon Zbosnik/D.Oshatz	08-AUG-02

SCALE: 1/4

SHEET 1 OF 1

DWG. NO. 2513034

REV. A