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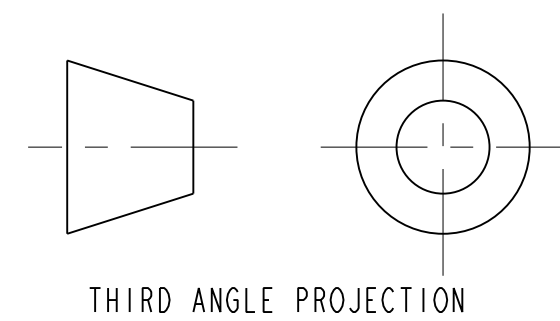
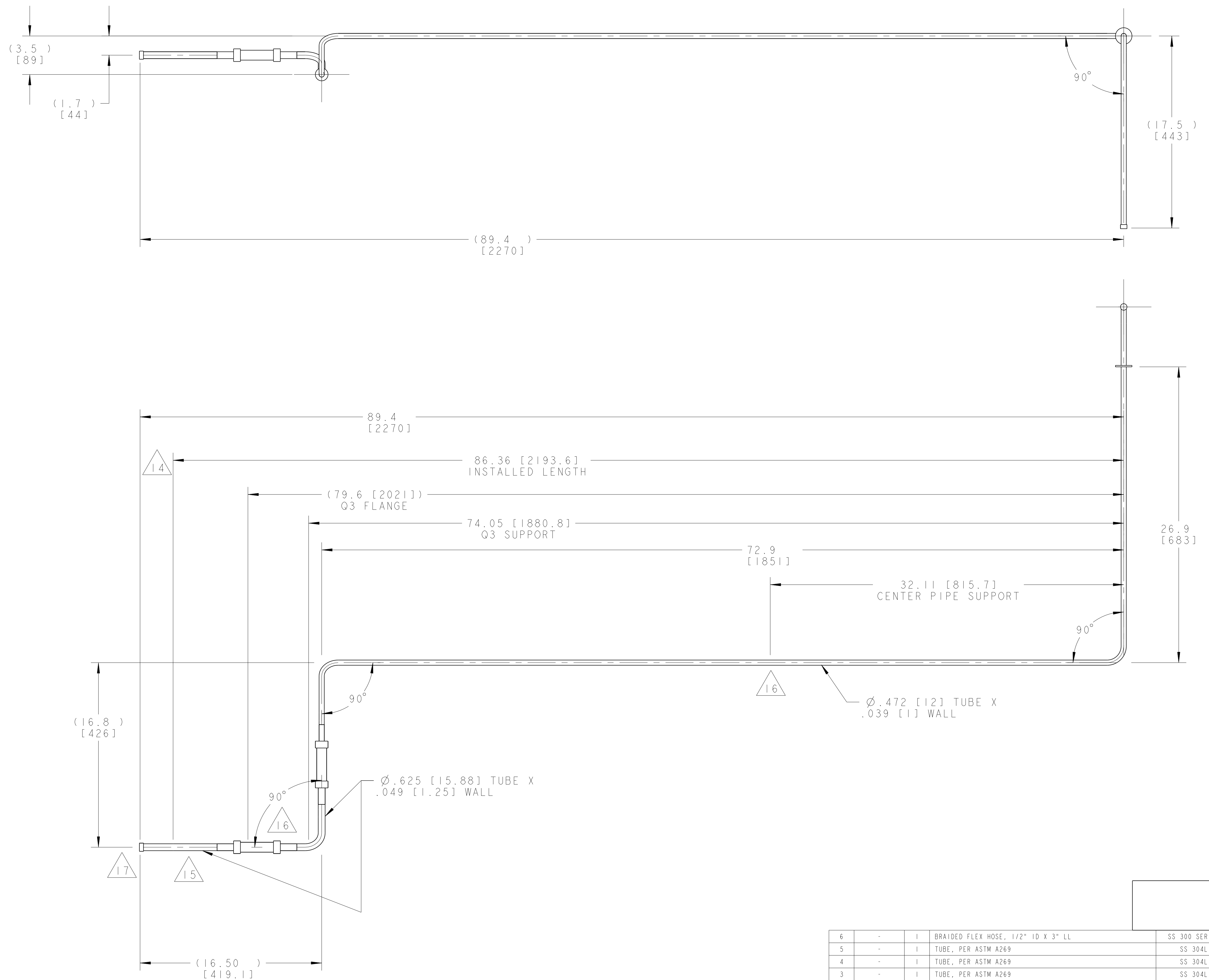
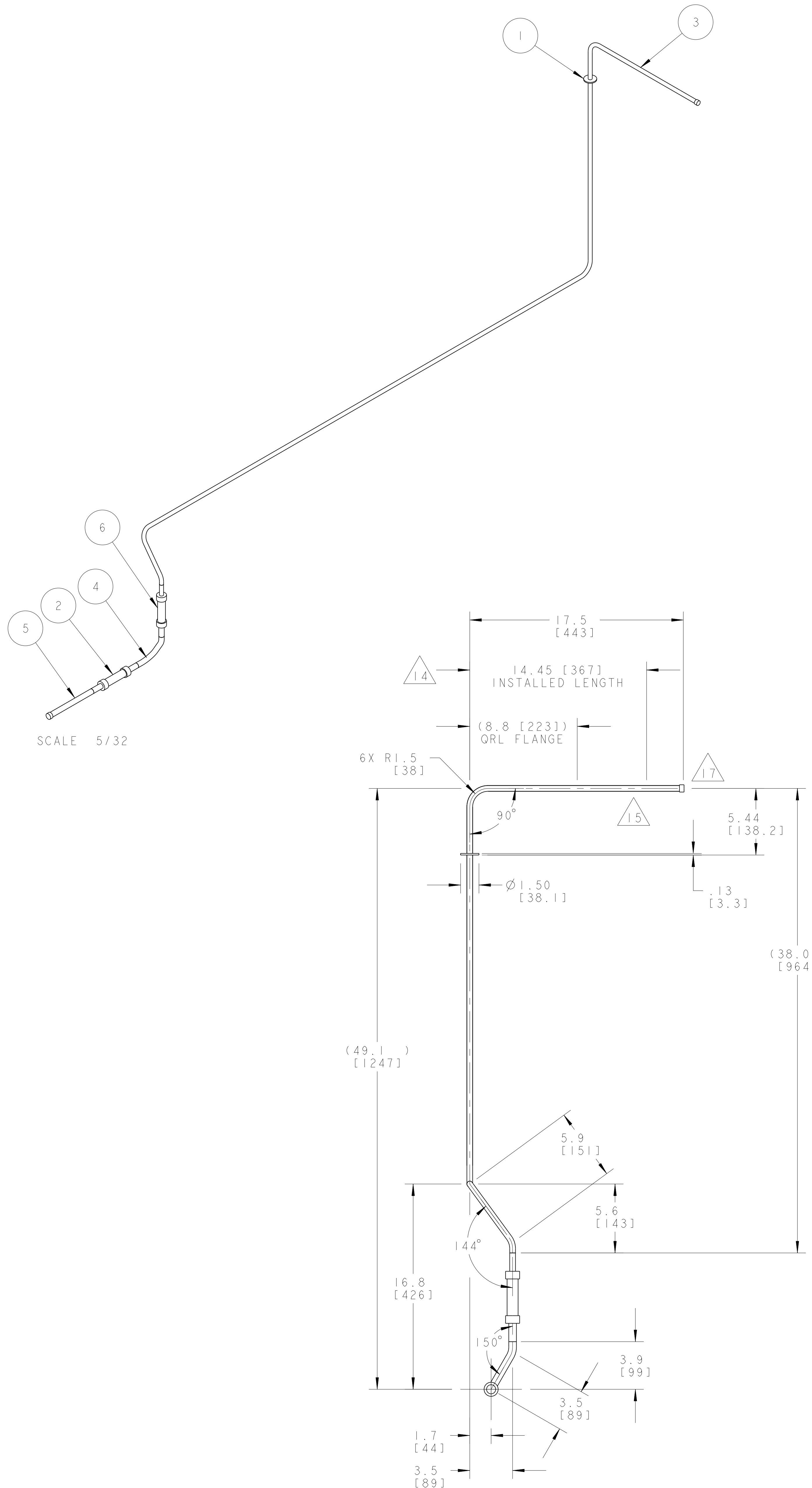
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NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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. 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.



THIRD ANGLE PROJECTION

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

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
6	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 309 SERIES
5	-	1	TUBE, PER ASTM A269	SS 304L
4	-	1	TUBE, PER ASTM A269	SS 304L
3	-	1	TUBE, PER ASTM A269	SS 304L
2	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 309 SERIES
1	-	1	FLANGE, SPIDER INTERFACE	SS 304L

UNLESS OTHERWISE SPECIFIED  
 X.X ± 0.1 FRACTION ± 1/64  
 X.XX ± 0.03 ANGLES ± 1.00°  
 X.XXX ± 0.010 FINISH TO 100µ  
 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

SHOP ORDERS  
 SET NO. -  
 DATE -  
 REVISION -  
 DATE -  
 PROJECT -  
 TAG -  
 WELDING -  
 PROJECT -  
 DATE -

ERNEST ORLANDO LAWRENCE  
 BERKELEY NATIONAL LABORATORY  
 UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX  
 CRYOGENICS  
 PIPE, CC2

DWG. NO. 2515076  
 SHEET 1 OF 1  
 SCALE: 7/32  
 DATE: 13-DEC-01  
 DRAWN BY: J. ZBANSKI  
 CHECKED BY: J. ZBANSKI  
 DATE: 01-NOV-02  
 PATENT CLEAR: REVISION NO. Z5LCE2  
 CATEGORY CODE LH2003

2515076 A 1

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NAME: ARHARRIS OBJECT: 251507 DATE: 25-Nov-02 14:23:05