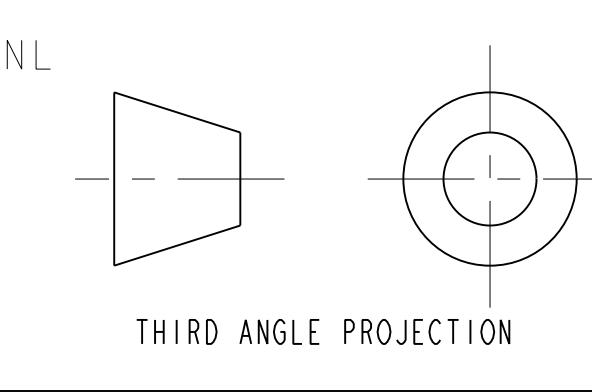


NOTES: (UNLESS OTHERWISE SPECIFIED)

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.



REVISION	DATE	BY	CHK	ZONE	DATE
A	10-25-02	ARH	SPV		

INITIAL RELEASE  
CHANGES

UNLESS OTHERWISE SPECIFIED  
 X.X ± 0.1 FRACTION ± 1/64  
 X.XX ± 0.03 ANGLES ± 1.0°  
 X.XXX ± 0.010 FINISH 125  
 DO NOT SCALE PRINT  
 TOLERANCES ARE CLASS 2  
 CHAMFER ENDS OF ALL SCREEN THREADS 30°  
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS  
 BREAK EDGES .156 MAX. ON MACHINED WORK  
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE  
 IN ACCORDANCE WITH ASME B16.5 & B31.1

ITEM	PART NO.	REQD.	DESCRIPTION	MATERIAL
3	-	1	WELD RING, ID 75mm, FINAL SUPPLIED	SS 304L
2	25M818	1	PIPE WELDMENT, LD ORL / LD CROSSOVER	-
1	25M857	1	PIPE WELDMENT, MORT	-

**SHOP ORDERS**

DATE	22-Sep-02
DATE	11-Oct-02
DATE	11-Oct-02

**ERNEST ORLANDO LAWRENCE  
BERKELEY NATIONAL LABORATORY**  
UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX  
CRYOGENICS

PIPE WELDMENT, LD1 AND BUS DUCT

SCALE: 7/32

SHEET 1 OF 1

2515156 A

NAME: ARHARRIS OBJECT: 251515 DATE: 08-Nov-02 10:10:36

2515156 A 1