

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 BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.

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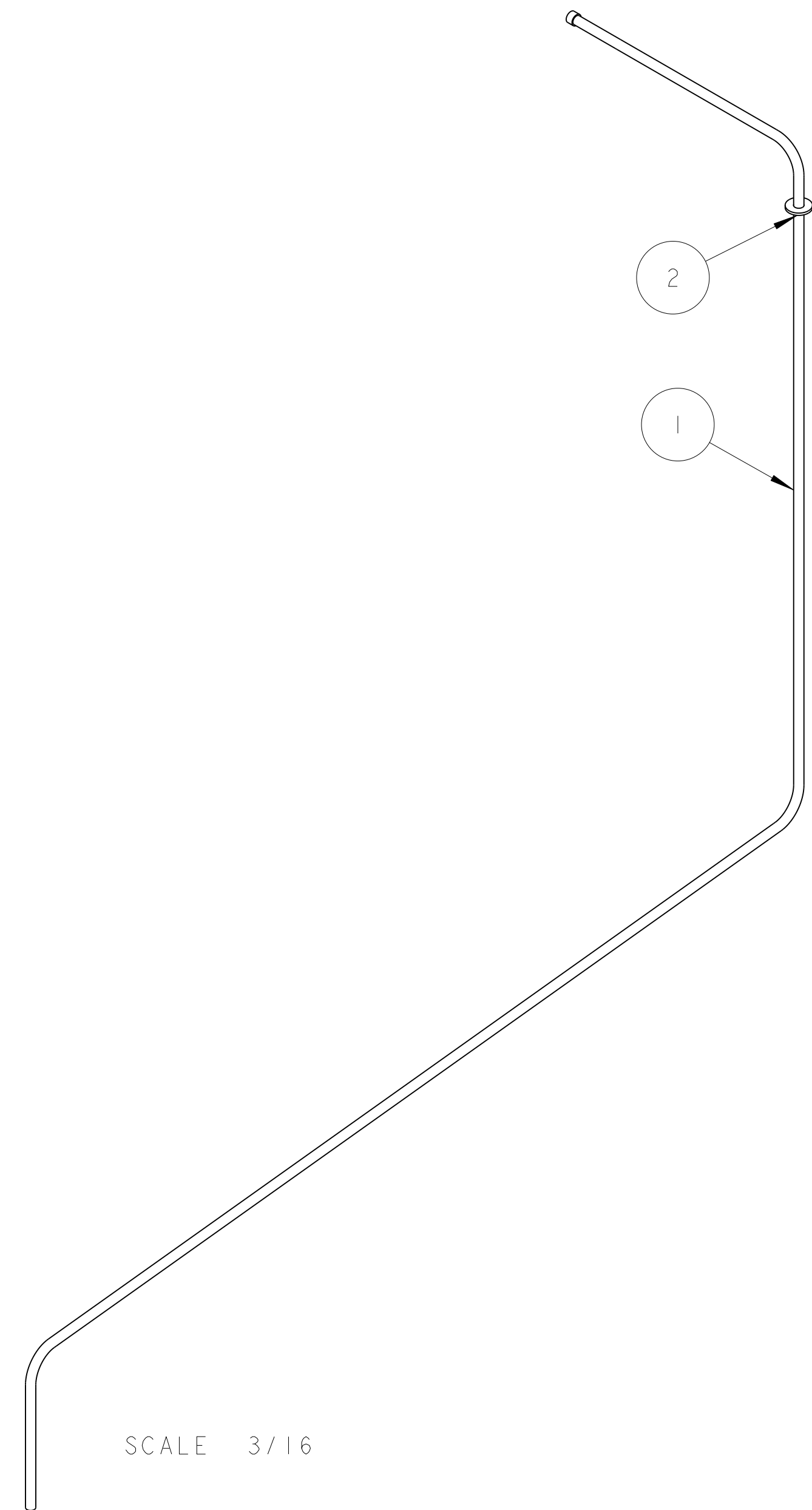
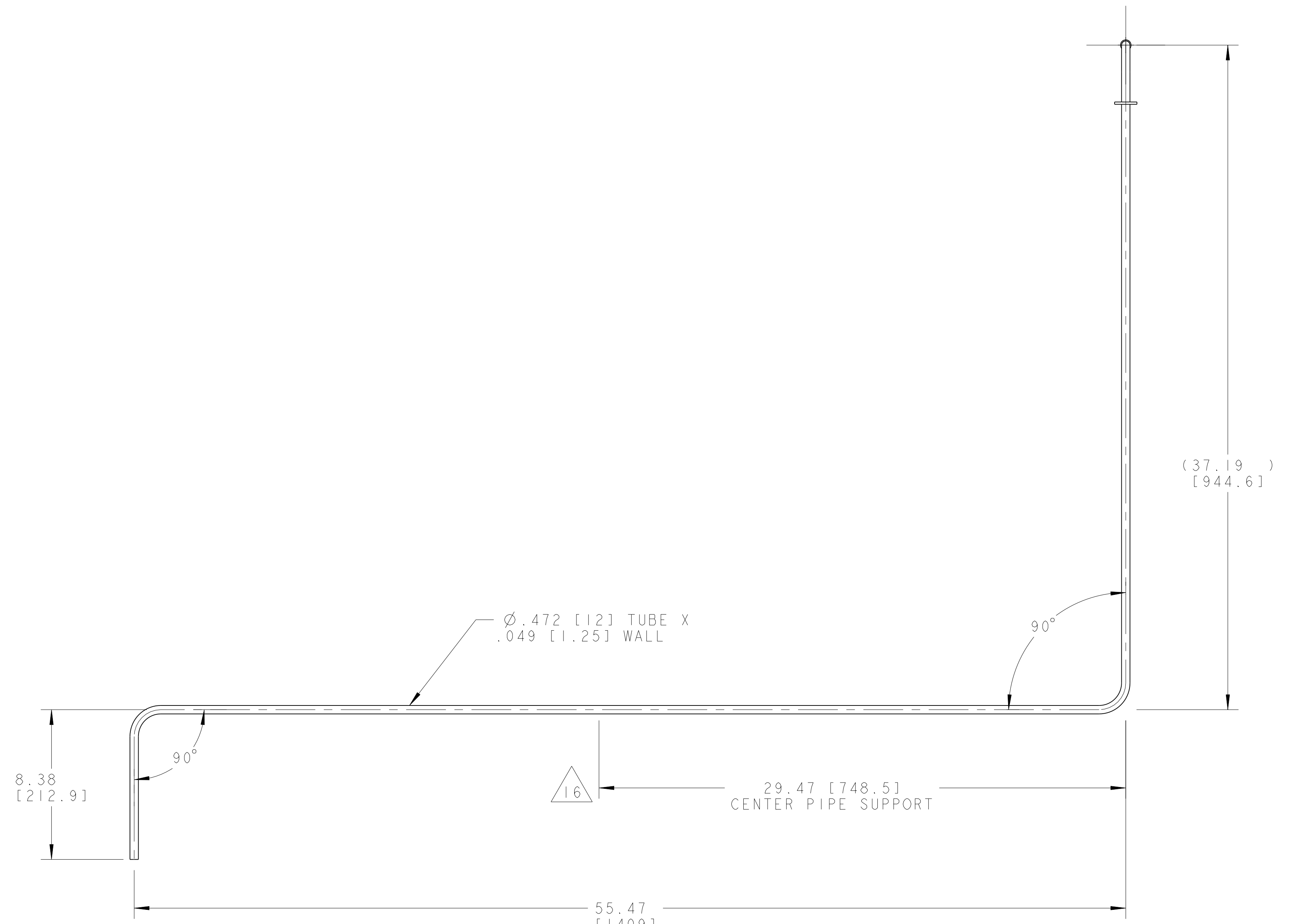
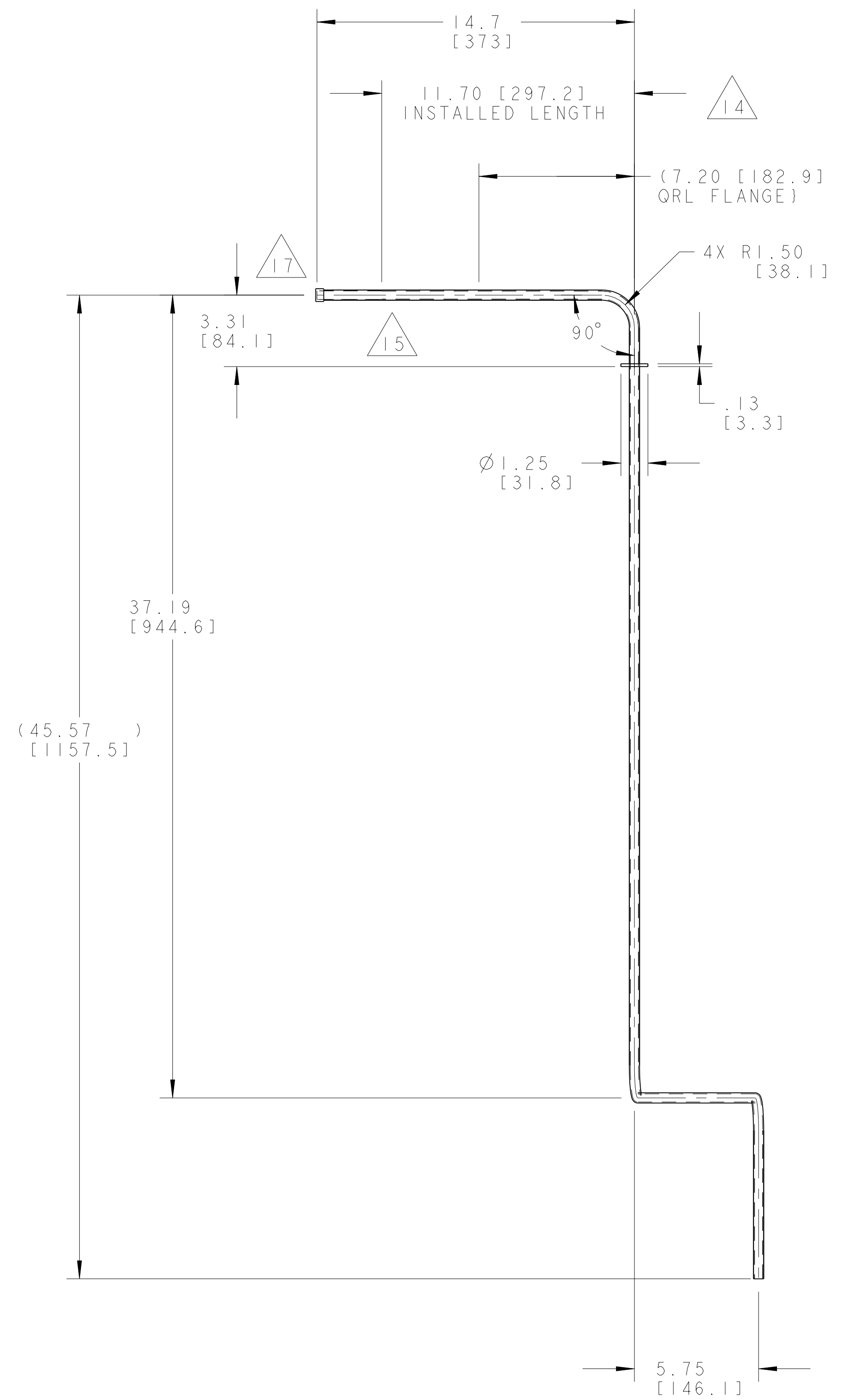
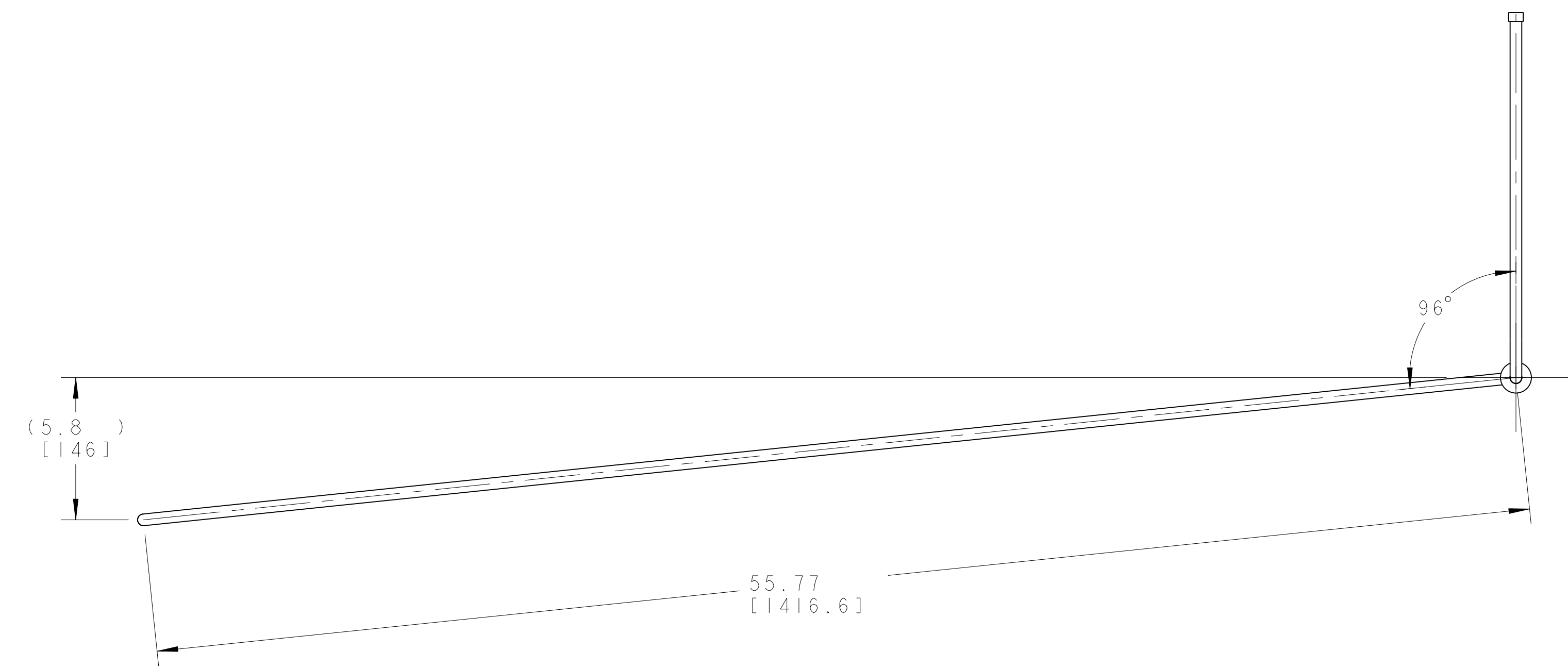
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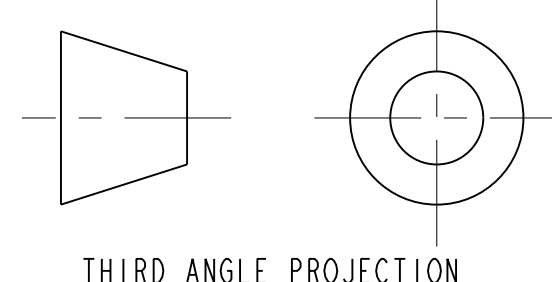
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SCALE 3/16



THIRD ANGLE PROJECTION

REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE	CHANGES
A	ARH	SPV		11-01-00		

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
2	-	1	FLANGE, SPIDER INTERFACE	SS 304L
1	-	1	TUBE, PER ASTM A269	SS 304L

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
FINISH	Y.X ± 0.1	FRAC	± 1/64
DRY	Y.XX ± 0.03	ANGLE	± 1.00°
DRY	Y.XXX ± 0.010	FINISH	10/20
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 .150 MAX. ON MACHINED WORK			
REMOVE BURRS, WELD SPATTER & LOOSE SCALE			
IN ACCORDANCE WITH ASME Y14.3M & B46.1			

ERNEST ORLANDO LAWRENCE	UNIVERSITY OF CALIFORNIA	BERKELEY
LHC IR FEEDBOX		
CRYOGENICS		
PIPE, CCI		
DWG. NO.	SCALE	SHEET 1 OF 1
Z5LCE2	1/4	2515196

NAME: ARHARRIS OBJECT: 251519 DATE: 25-Nov-02 15:21:51

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