

8

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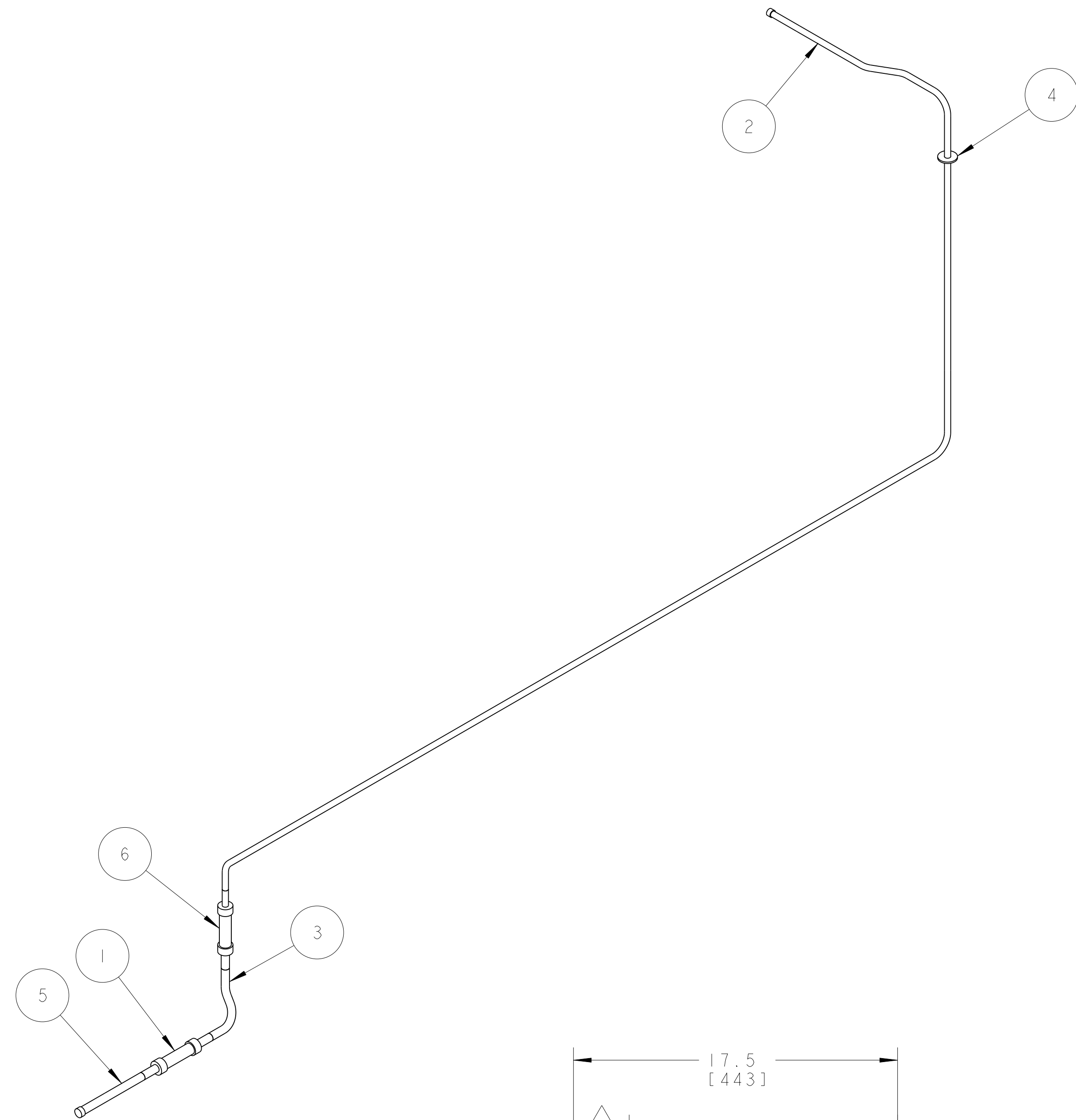
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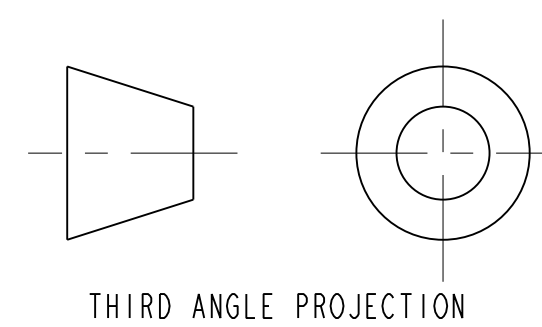
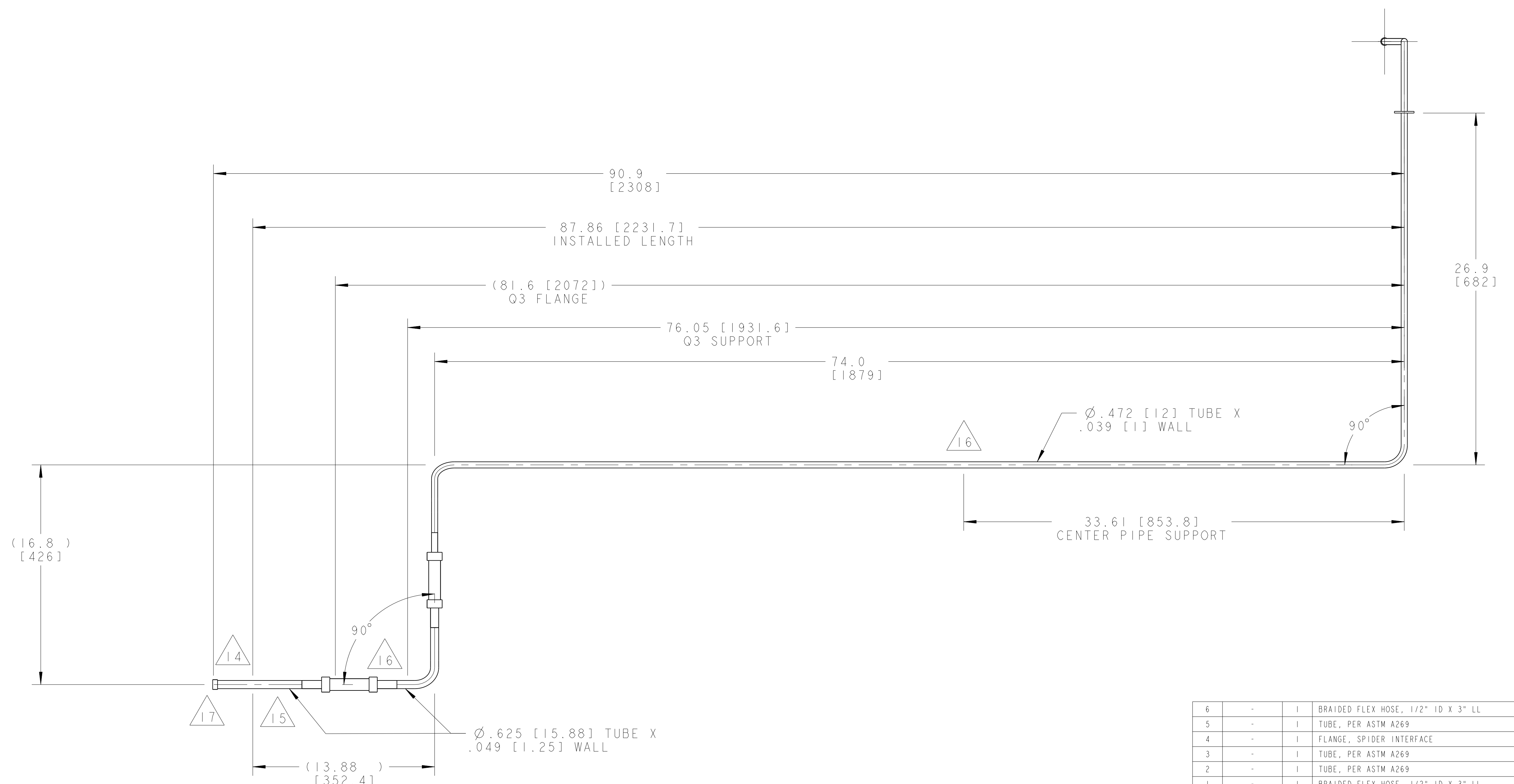
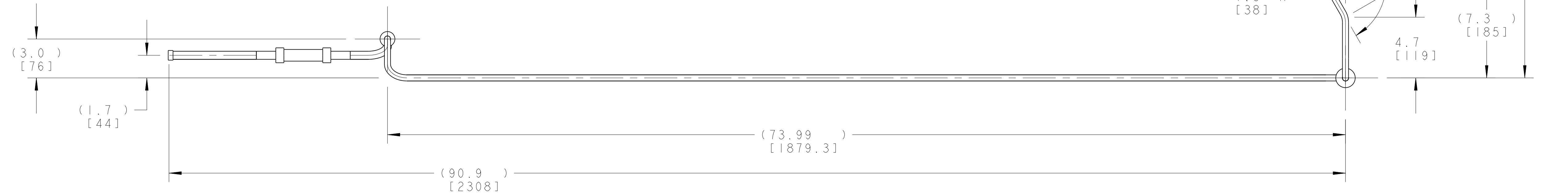
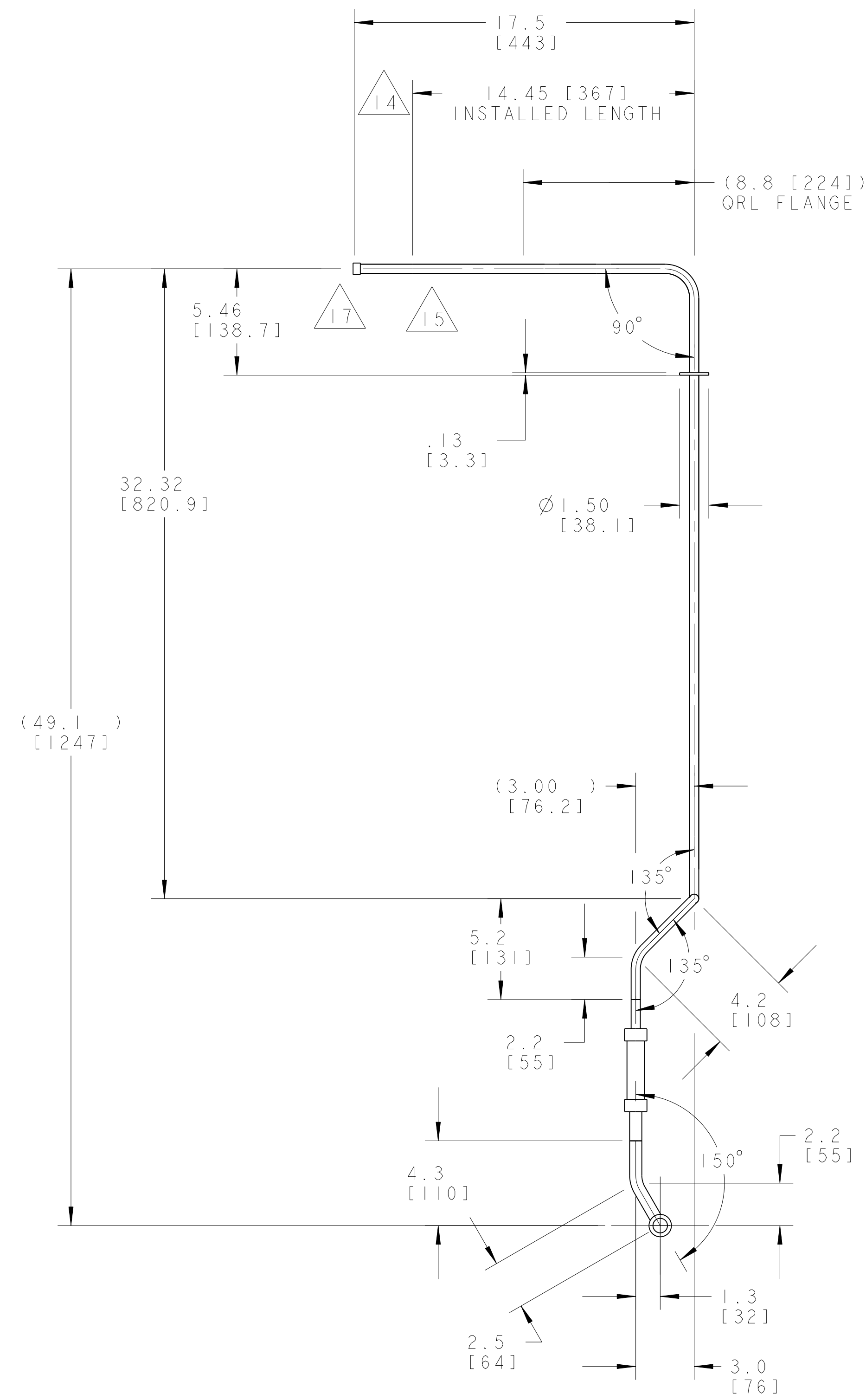
NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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 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.



SCALE 5/32



THIRD ANGLE PROJECTION

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

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
 TOLERANCES ARE CLASS 2
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES .010 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.3M & B46.1

6	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 309 SERIES
5	-	1	TUBE, PER ASTM A269	SS 304L
4	-	1	FLANGE, SPIDER INTERFACE	SS 304L
3	-	1	TUBE, PER ASTM A269	SS 304L
2	-	1	TUBE, PER ASTM A269	SS 304L
1	-	1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 309 SERIES

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	FLANGE, SPIDER INTERFACE	SS 304L
3		1	TUBE, PER ASTM A269	SS 304L
2		1	TUBE, PER ASTM A269	SS 304L
1		1	BRAIDED FLEX HOSE, 1/2" ID X 3' LL	SS 309 SERIES

SHOP ORDERS	REV	DATE	BY	CHK	ZONE

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA BERKELEY	LHC IR FEEDBOX CRYOGENICS PIPE, CC2	SCALE: 7/32	DO NOT SCALE PRINTS
DATE: 13-Dec-01	REV: 1	SIZE: A	REV: 1
DESIGNER: Jan Zbasnik/S. Wierzbicki	DATE: 01-Nov-02	CATEGORY CODE: LH2003	DWG. NO: 2515226
APP: Jan Zbasnik/V.D. Oshatz	DATE: 28-Sep-02	REV: 1	REV: 1