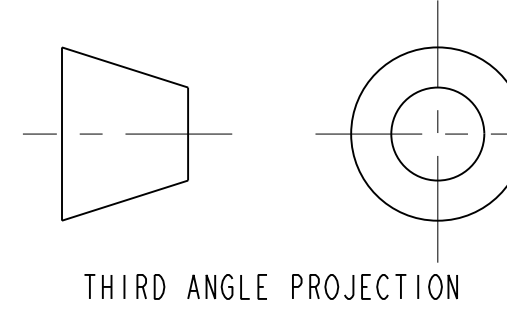
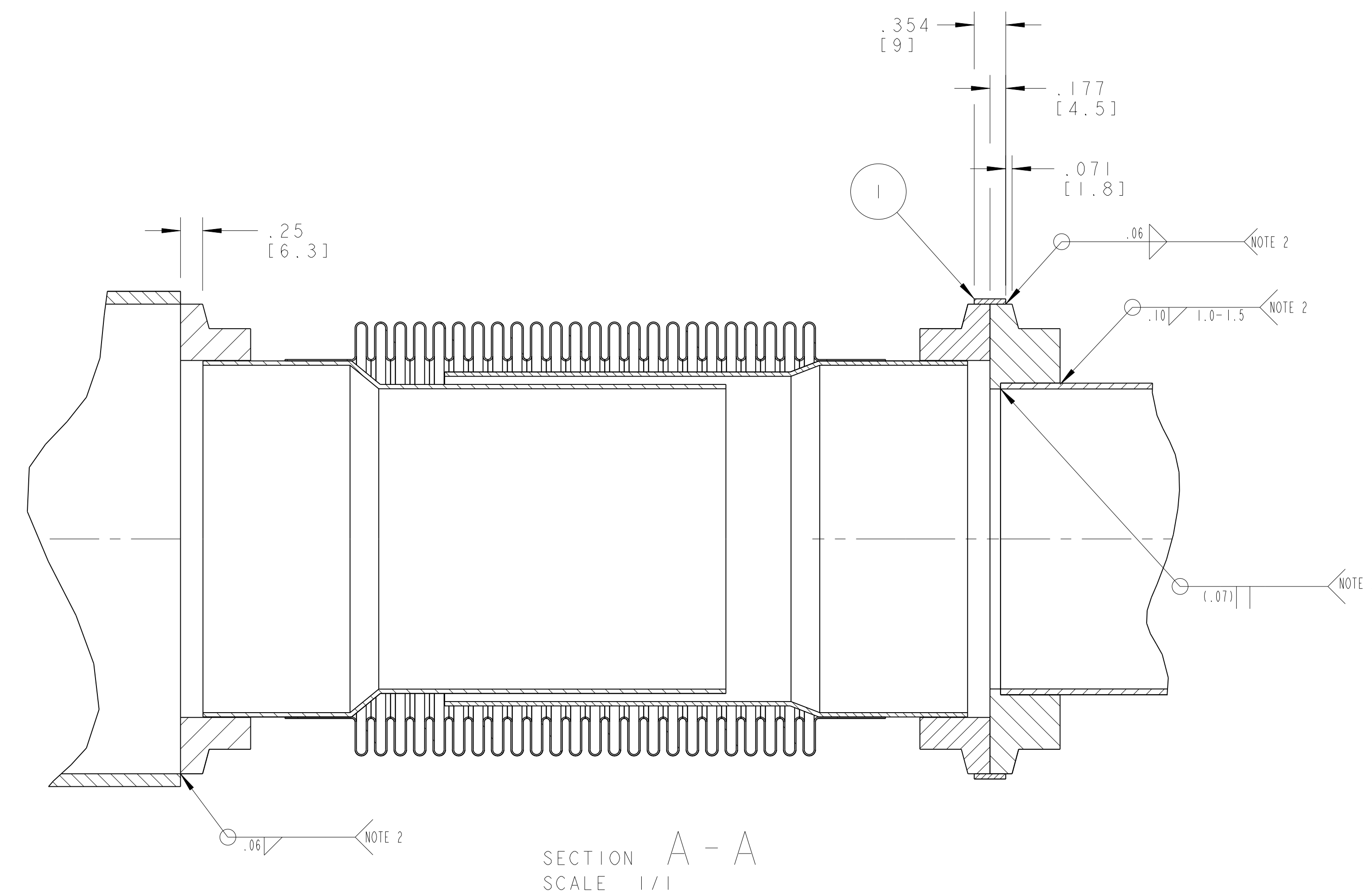
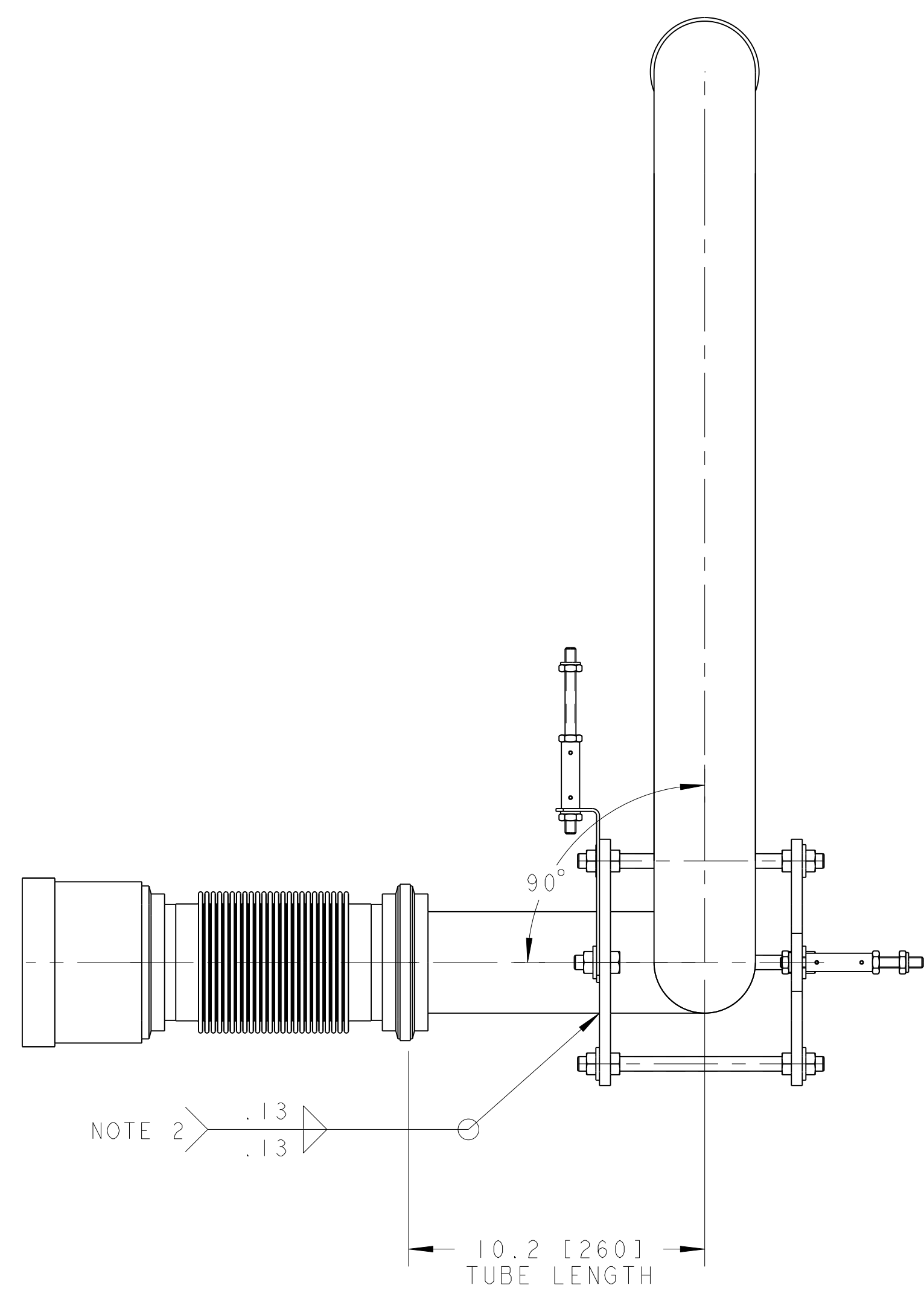
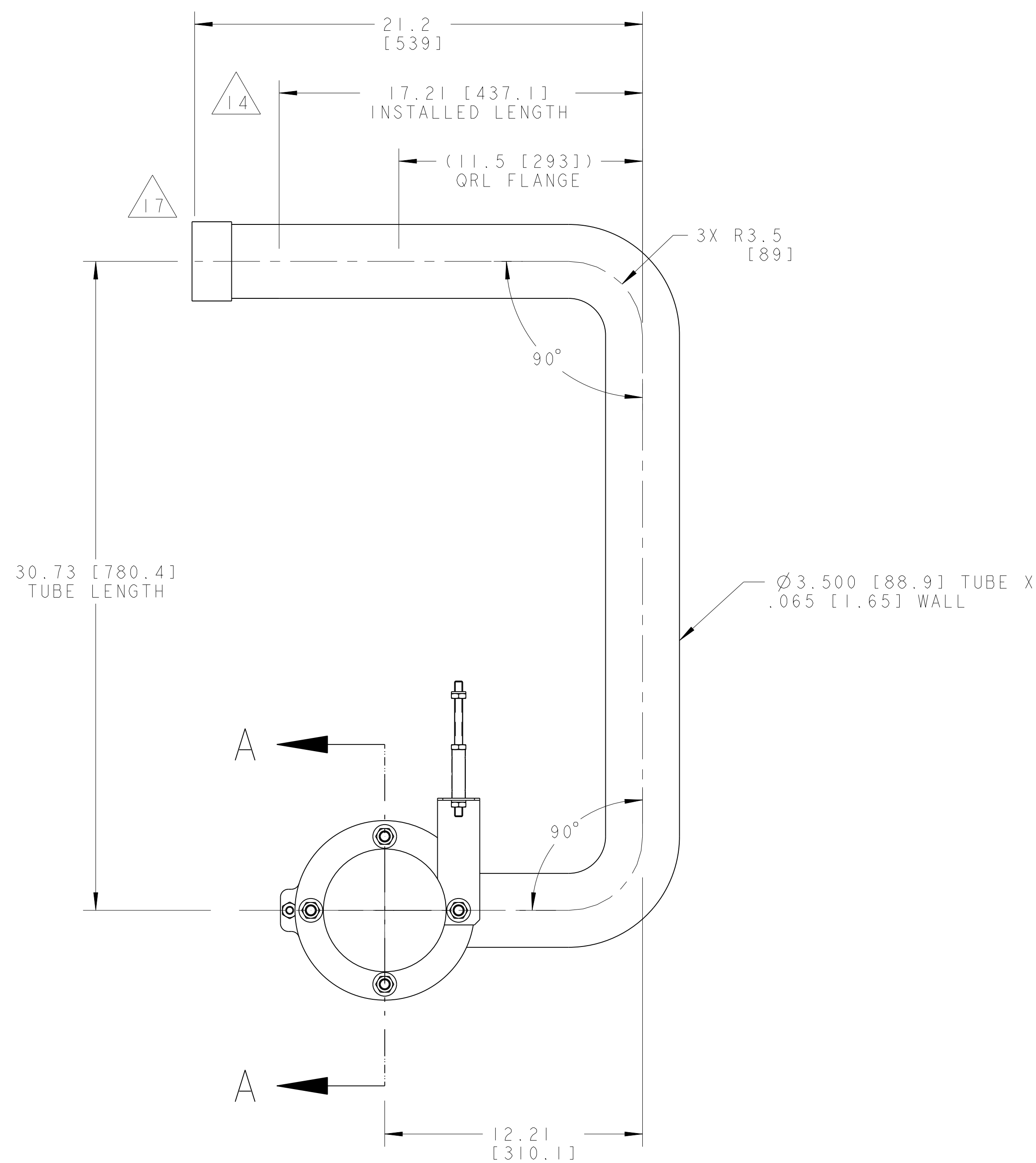
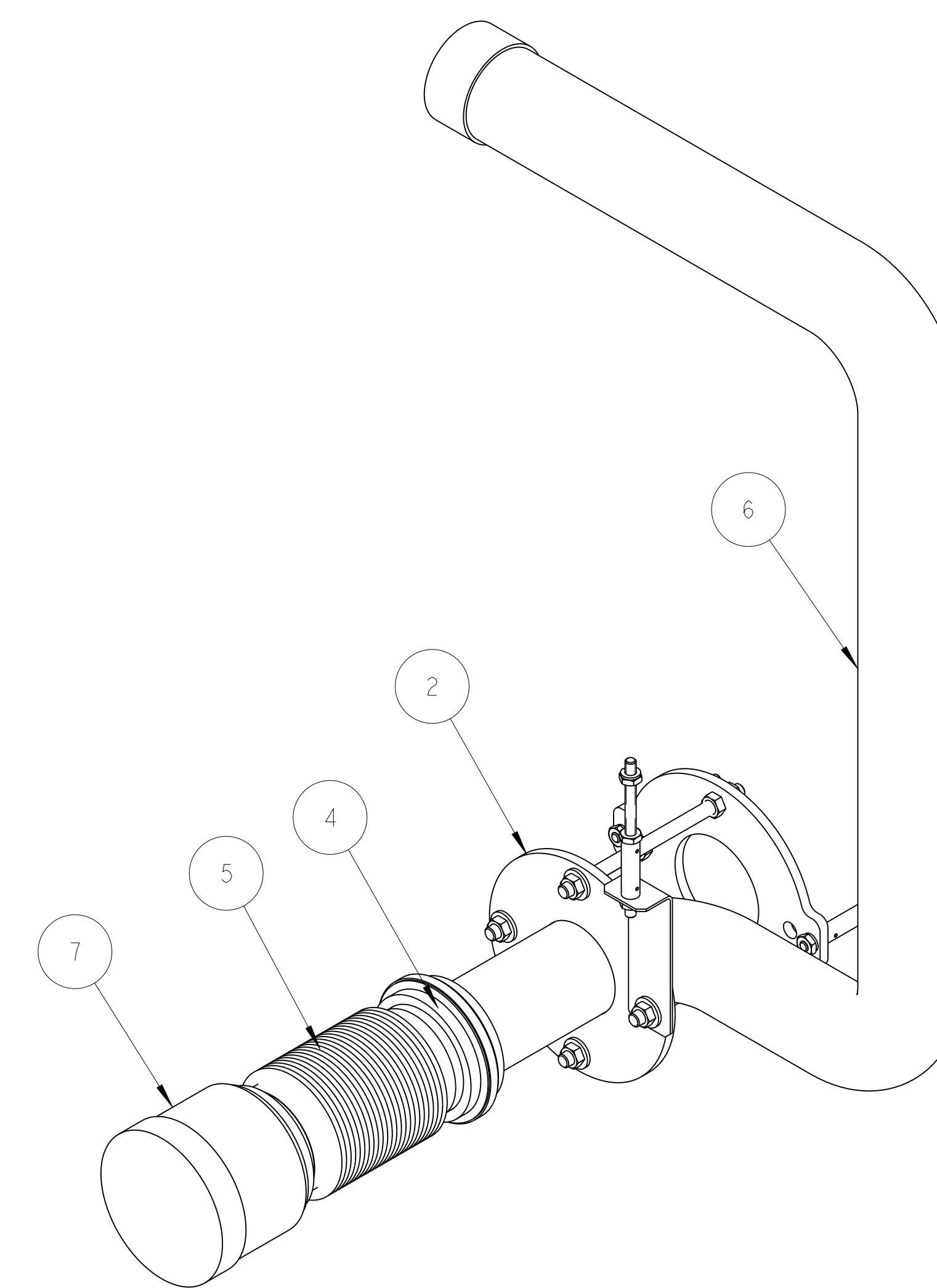
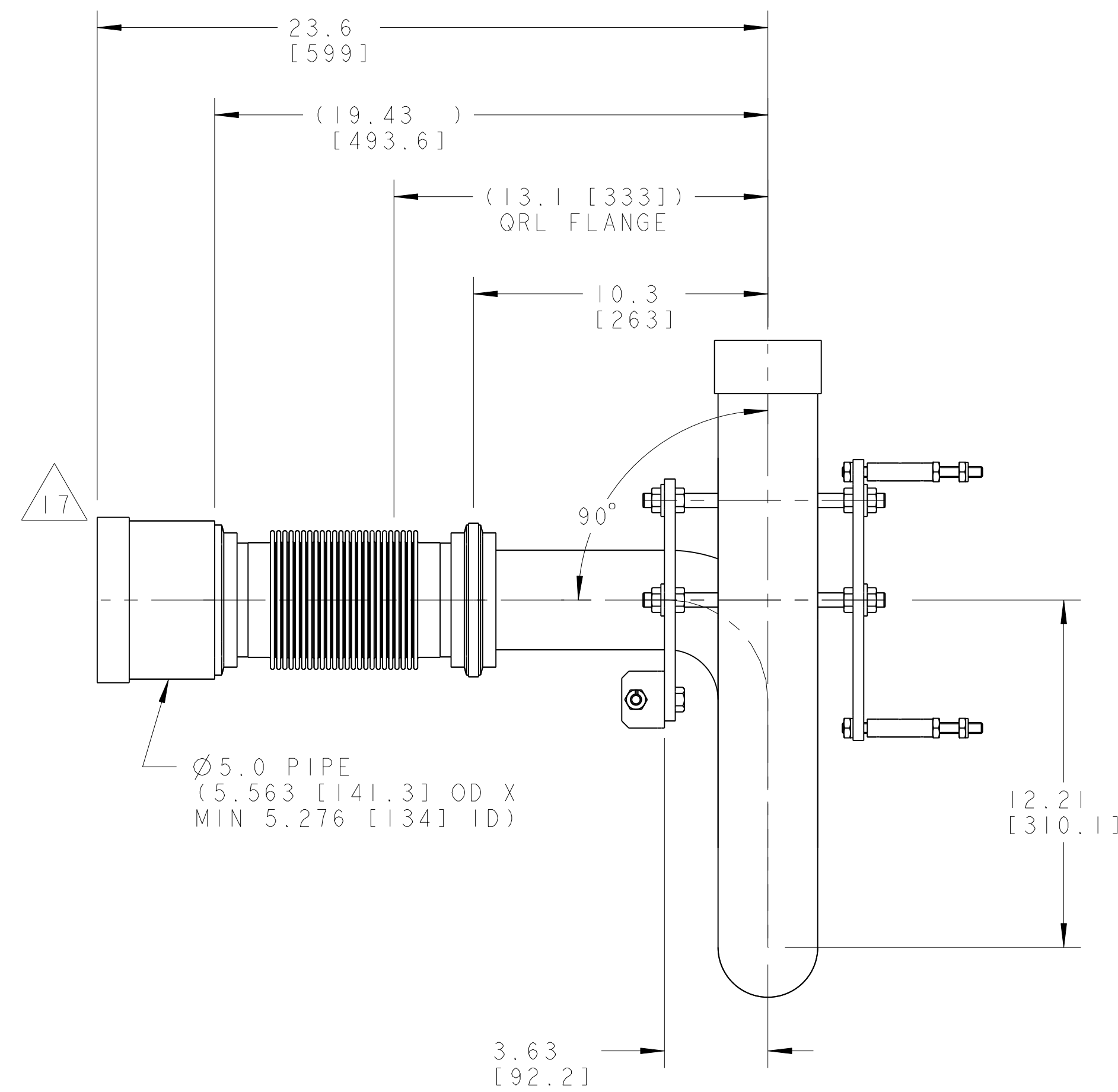


NOTES: (UNLESS OTHERWISE SPECIFIED):

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.



REVISION	DATE	BY	CHK	ZONE
A	10-25-01	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
 DO NOT SCALE PRINT
 TOLERANCES ARE CLASS 2
 CHAMFER EDGES 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 B14.9 & B.86.1

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
7	-	1	PIPE, PER ASTM A312	SS 304L
6	-	1	TUBE, PER ASTM A269	SS 304L
5	251314	1	BELLOWS, FINAL# 5520-MD-390065	SS 300 SERIES
4	251306	1	FLANGE, FINAL# 5520-MC-390032	SS 300 SERIES
3	-	1	THREADED ROD	SS 300 SERIES
2	25M923	1	XB THRUST PLATE ASSY	SS 300 SERIES
1	-	1	WELD RING, ID 134mm, FINAL SUPPLIED	-

SHOP ORDERS

ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX
CRYOGENICS
PIPE WELDMENT, XB

SCALE: 1/4

SHEET 1 OF 1

2515306 A

2515306 A 1

NAME: ARH:SPV OBJECT: 251530 DATE: 27-Nov-02 13:56:50