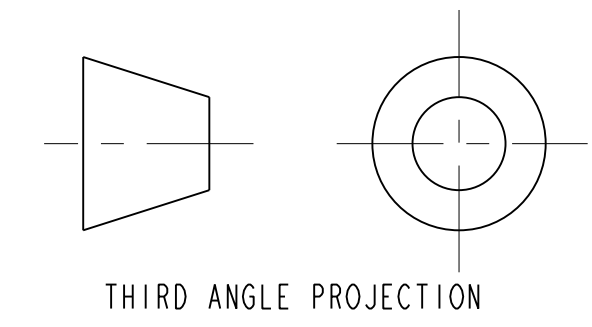
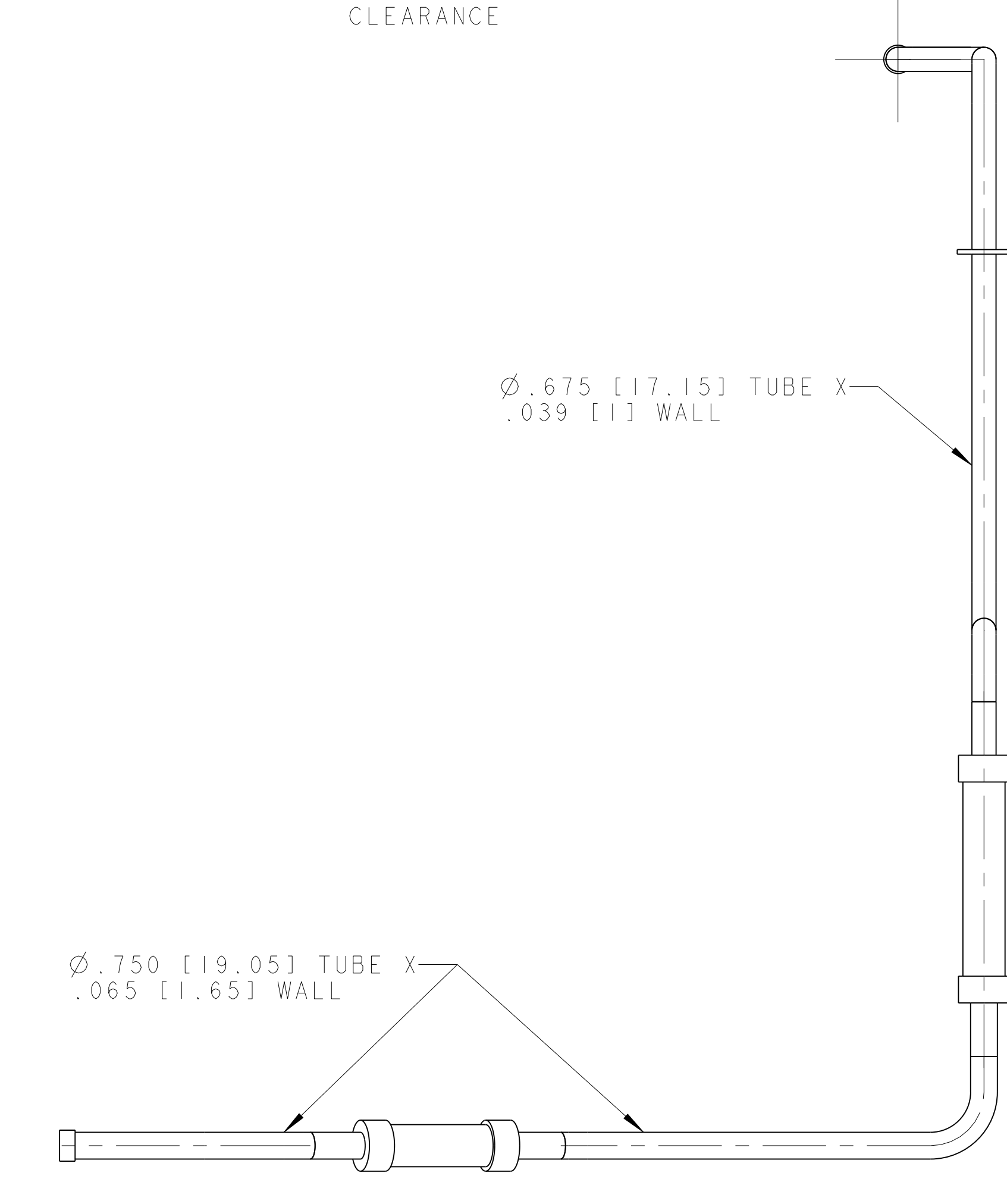
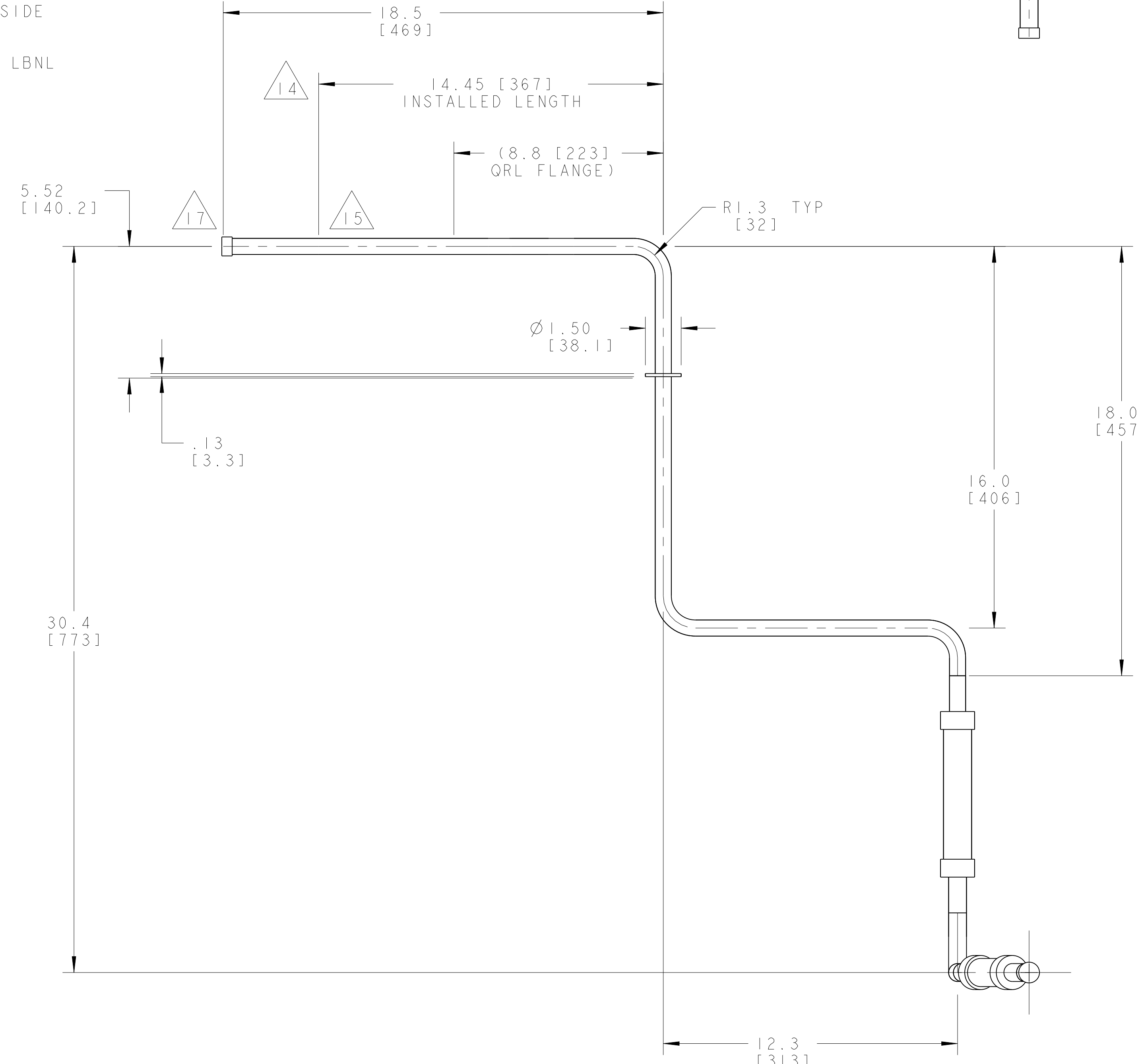
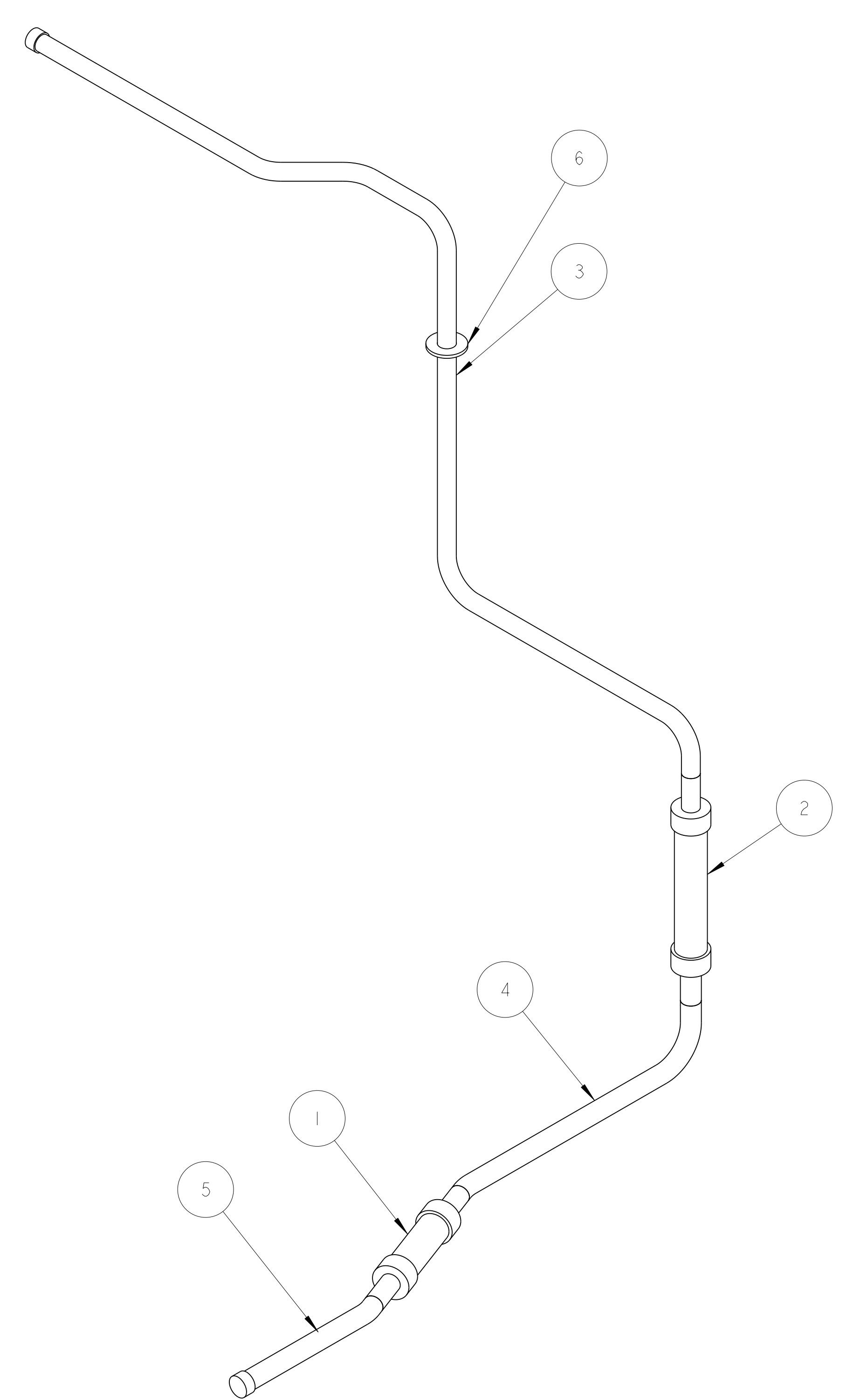
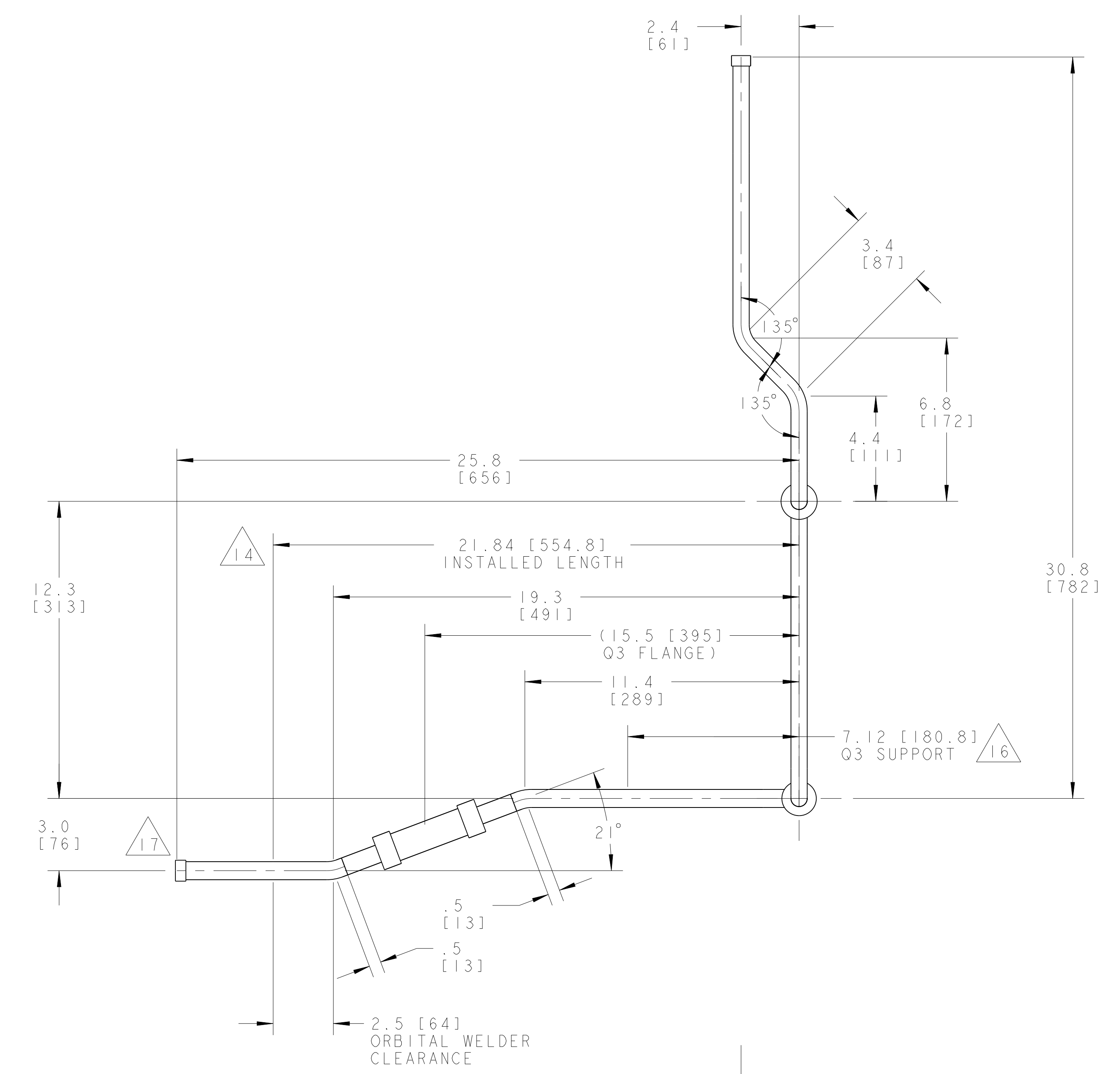
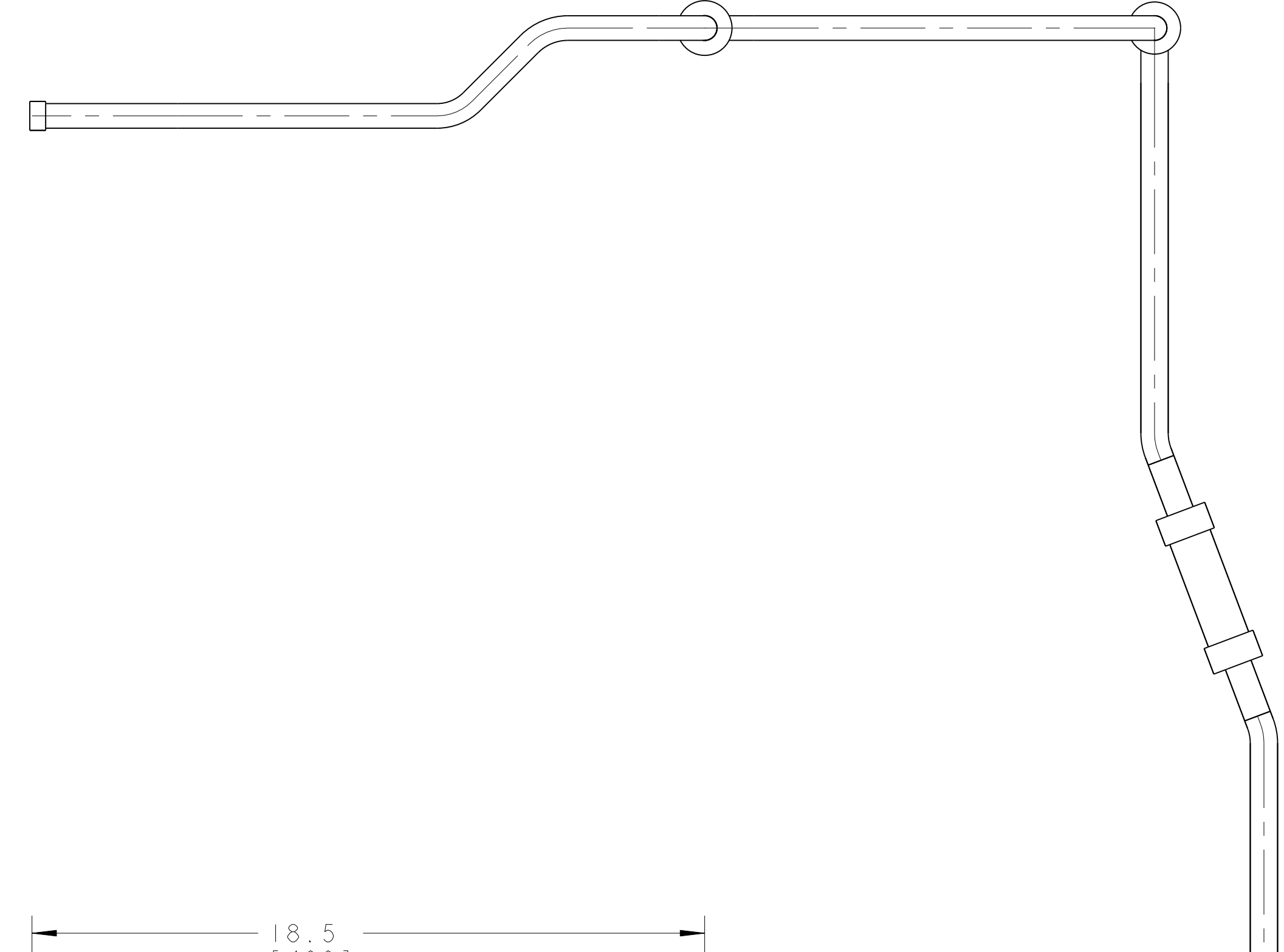


NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
- 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".
- 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.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



REV	DATE	BY	CHK	ZONE	DESCRIPTION
A	21-04-01	SPY			INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED
 TOLERANCES: X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.00°
 X.XXX ± 0.010 FINISH TO 100
 DO NOT SCALE PRINT
 THREADS AND 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 SPLATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.3M & B.01

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
6		1	COLLAR	SS 304L
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, 3/4" ID X 5.4' LL	SS 309 SERIES
1		1	BRAIDED FLEX HOSE, 3/4" ID X 3' LL	SS 309 SERIES

APPROVED:	DATE:	BY:	DATE:
ERNEST ORLANDO LAWRENCE	05-Apr-02	Jan Zbasnik/SS	31-Oct-02

PROJECT:	SCALE:	SHEET:	OF:
LHC IR FEEDBOX	5/16	1	1