



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.

ITEM	PART NO.	REQD.	DESCRIPTION	MATERIAL
3	-	1	WELD RING, ID 75mm, FINAL SUPPLIED	SS 304L
2	25M917	1	PIPE WELDMENT, LD ORL / LD CROSSOVER	-
1	25M857	1	PIPE WELDMENT, MOXI	-

REV	DATE	BY	CHK	ZONE	DATE
A	10-25-02	SPY			

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	SET	-
TOLERANCES	REV	NO.	-
FINISHES	DATE	REQD.	-
DO NOT SCALE PRINT	PROJECT	NO.	-
CHANGES ARE CLASS 2	DATE	REQD.	-
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS	DATE	REQD.	-
BREAK EDGES .016 MAX. ON MACHINED WORK	DATE	REQD.	-
REMOVE BURRS, WELD SPATTER & LOOSE SCALE	DATE	REQD.	-
IN ACCORDANCE WITH ASME Y14.3M & B46.1	DATE	REQD.	-

ERNEST ORLANDO LAWRENCE	UNIVERSITY OF CALIFORNIA	BERKELEY
LHC IR FEEDBOX	CRYOGENICS	PIPE WELDMENT, LD2 AND BUS DUCT
ASSEM	SCALE: 7/32	SHEET 1 OF 1
Z5LCE2	LH2003	2515426

NAME: ARHARRIS OBJECT: 251542 DATE: 26-Nov-02 13:26:54

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