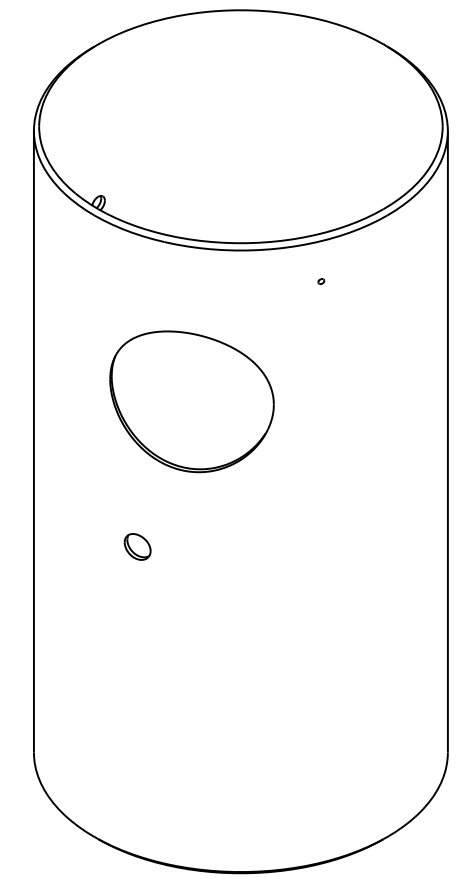
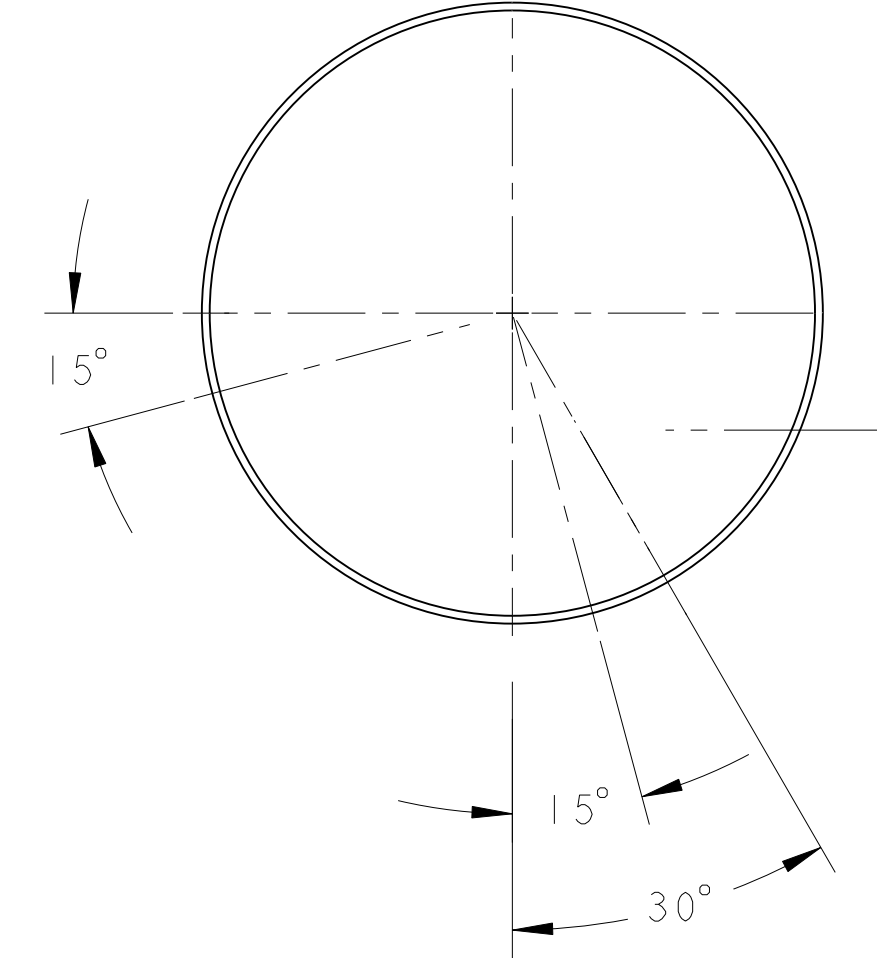


NAME: ARHARRIS OBJECT: 251547 DATE: 08-Nov-02 08:02:44

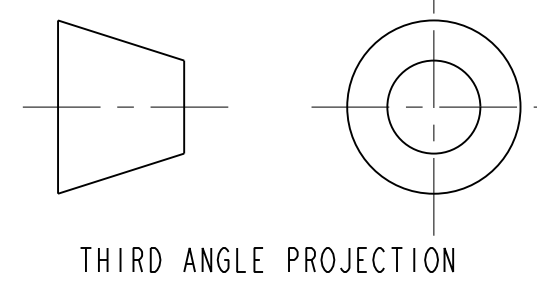
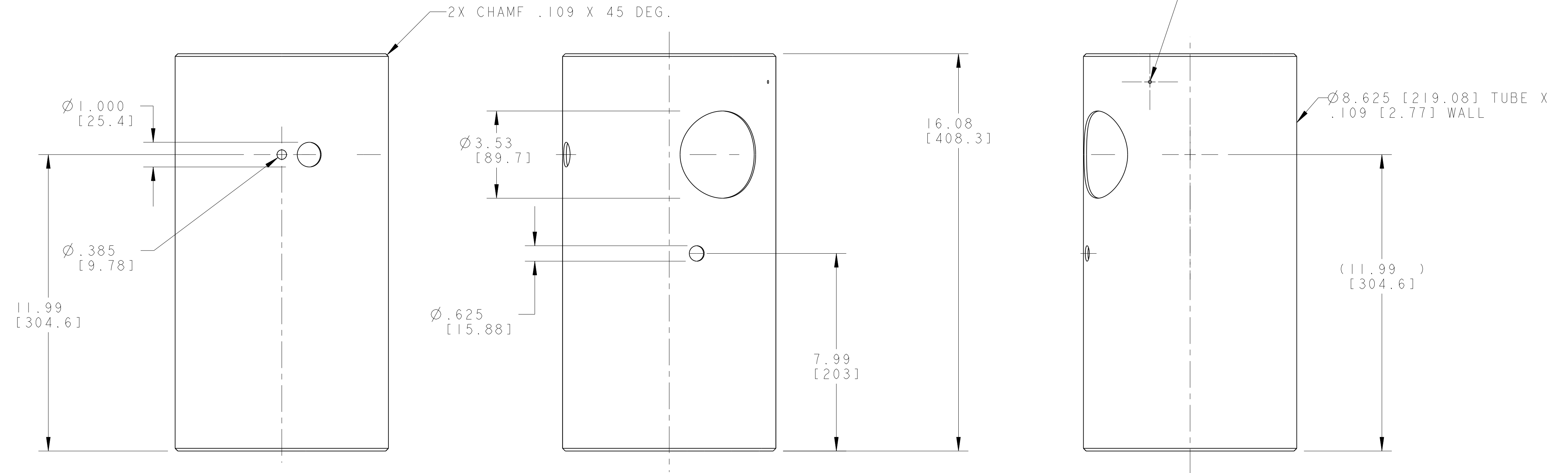
DWG. NO. <b>2515474</b>	SIZE <b>A</b>	REV. <b>1</b>	SH.
DESCRIPTION PIPE, SCHEDULE 5S, PER ASTM A312		MATERIAL SS 304L	MAT. LOCATION

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.



SCALE 1/4



UNLESS OTHERWISE SPECIFIED				SHOP ORDERS		SER. NO. -		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY					
TOLERANCES		FRAC. ± 1/64		NO. RECD		DATE ISSD		LHC IR FEEDBOX CRYOGENICS SURGE TANK BODY					
X.X ± 0.1		X.XX ± 0.03		DEL TO		DATE RECD		MICROFILMED: -					
X.XXX ± 0.010		FINISH 125 μm		SURFACE TREATMT		TAG		SCALE: 3/8					
DO NOT SCALE PRINT								SHEET 1 OF 1					
THREADS ARE CLASS 2				PROJECT NUMBER N/A		PROJECT NAME N/A		DWG. TYPE PART					
CHAMFER ENDS OF ALL SCREW THREADS 30°				CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		BREAK EDGES .016 MAX. ON MACHINED WORK		REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		IN ACCORDANCE WITH ASME Y14.5M & B46.1		PATENT CLEAR: -	
REV A				ARH SPV		11-01-02		INITIAL RELEASE		DESIGN ACCT. NO. Z5LCE2		CATEGORY CODE LH2003	
REV				DWG		CHK		DATE		DWG. NO. 2515474		REV. A	

8 7 6 5 4 3 2 1

A B C D