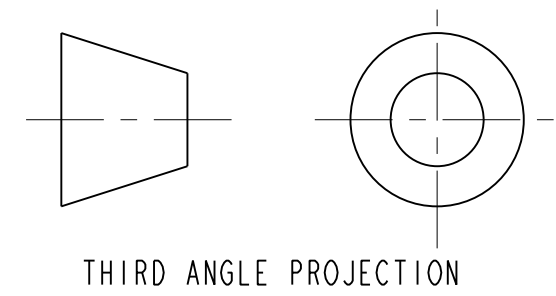
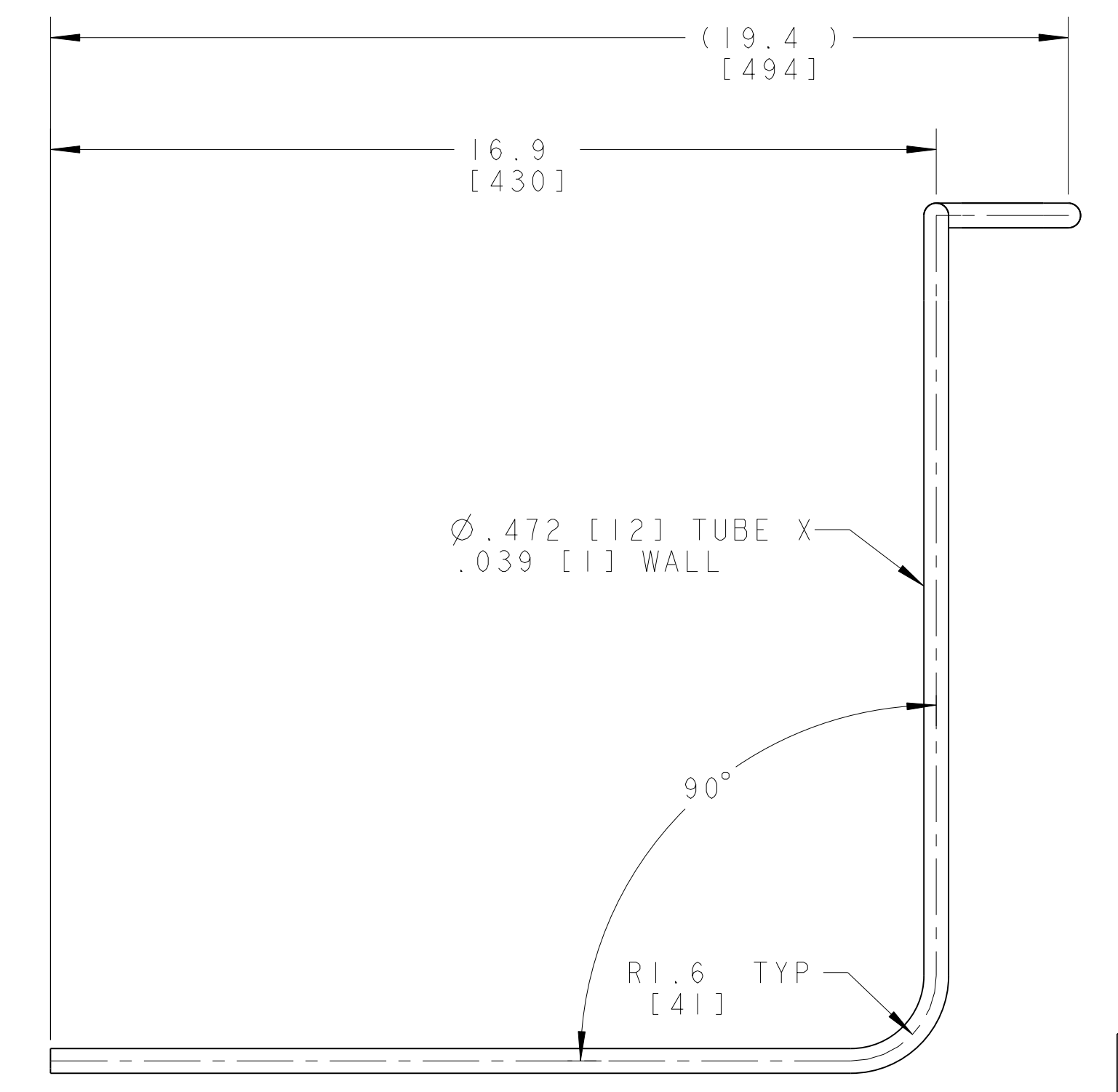
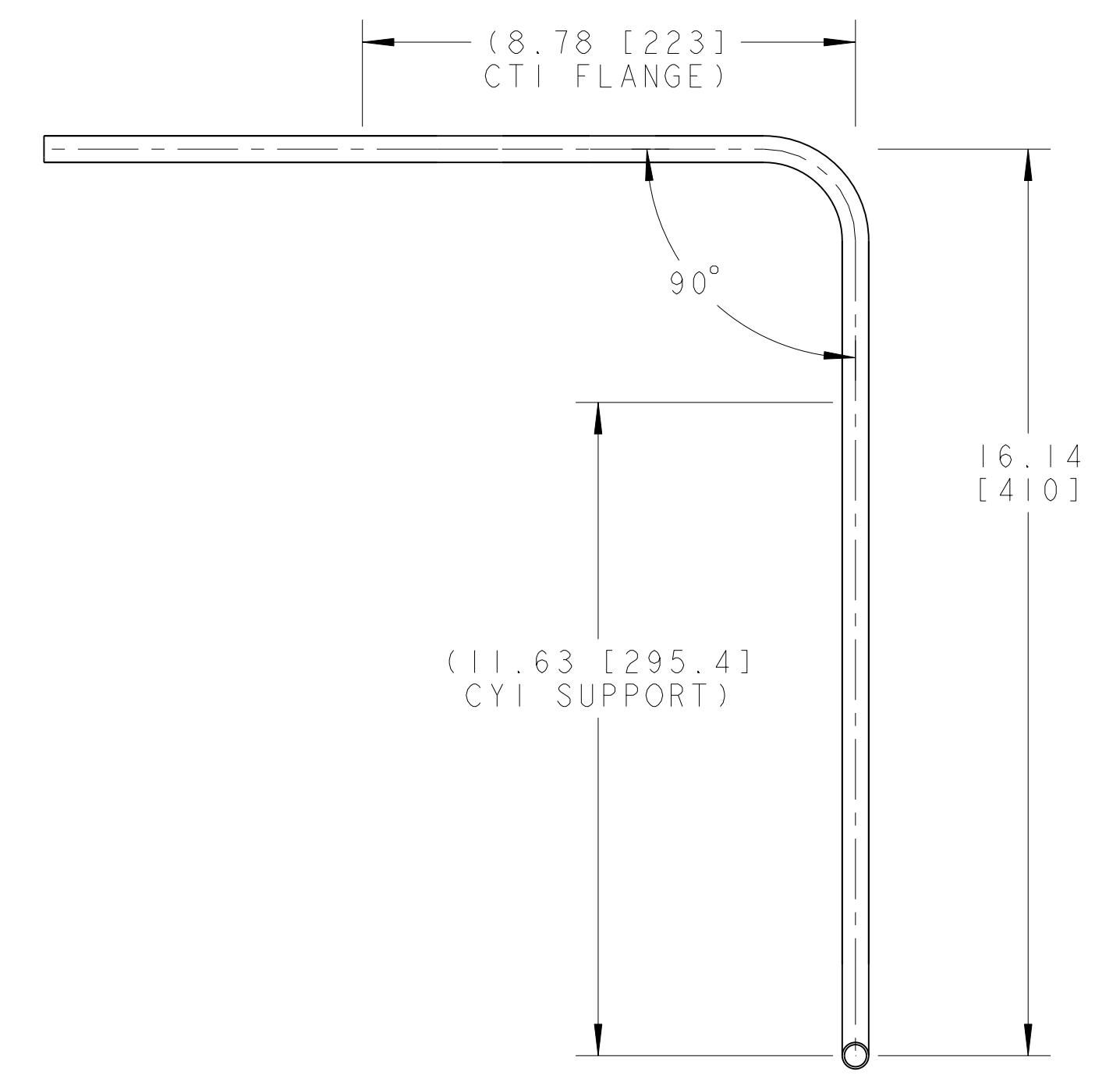
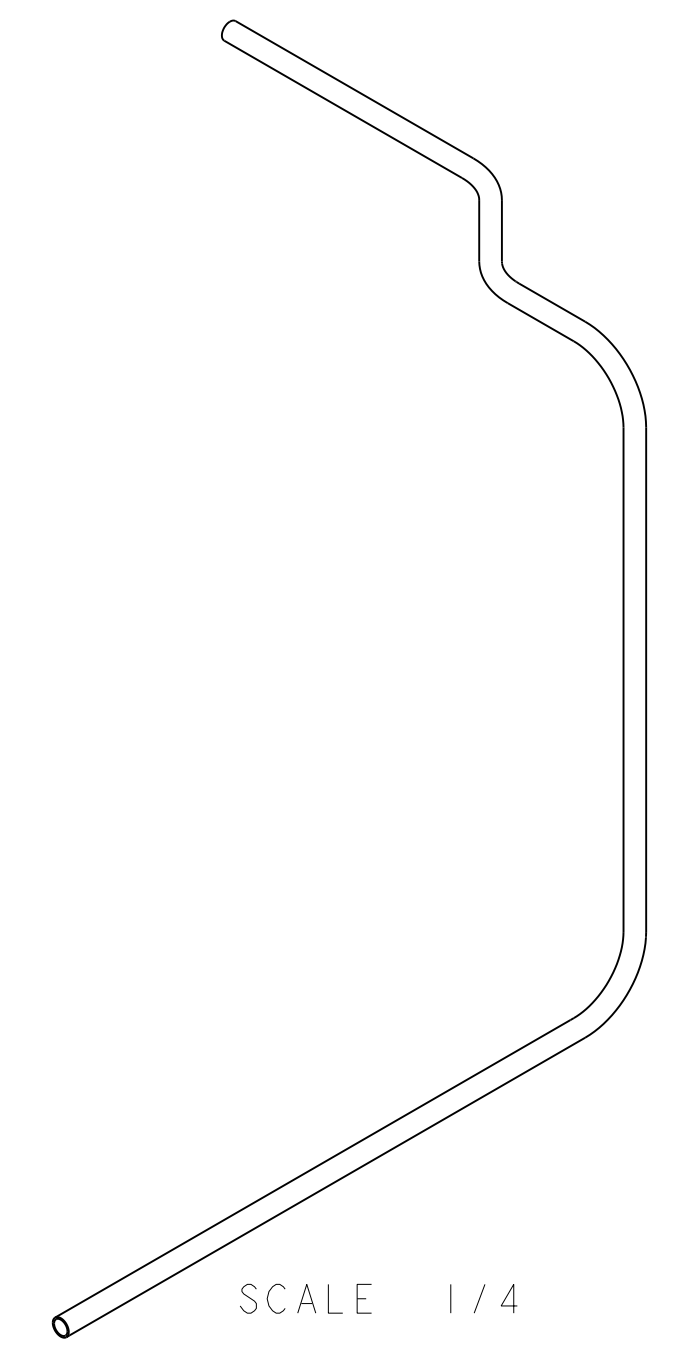
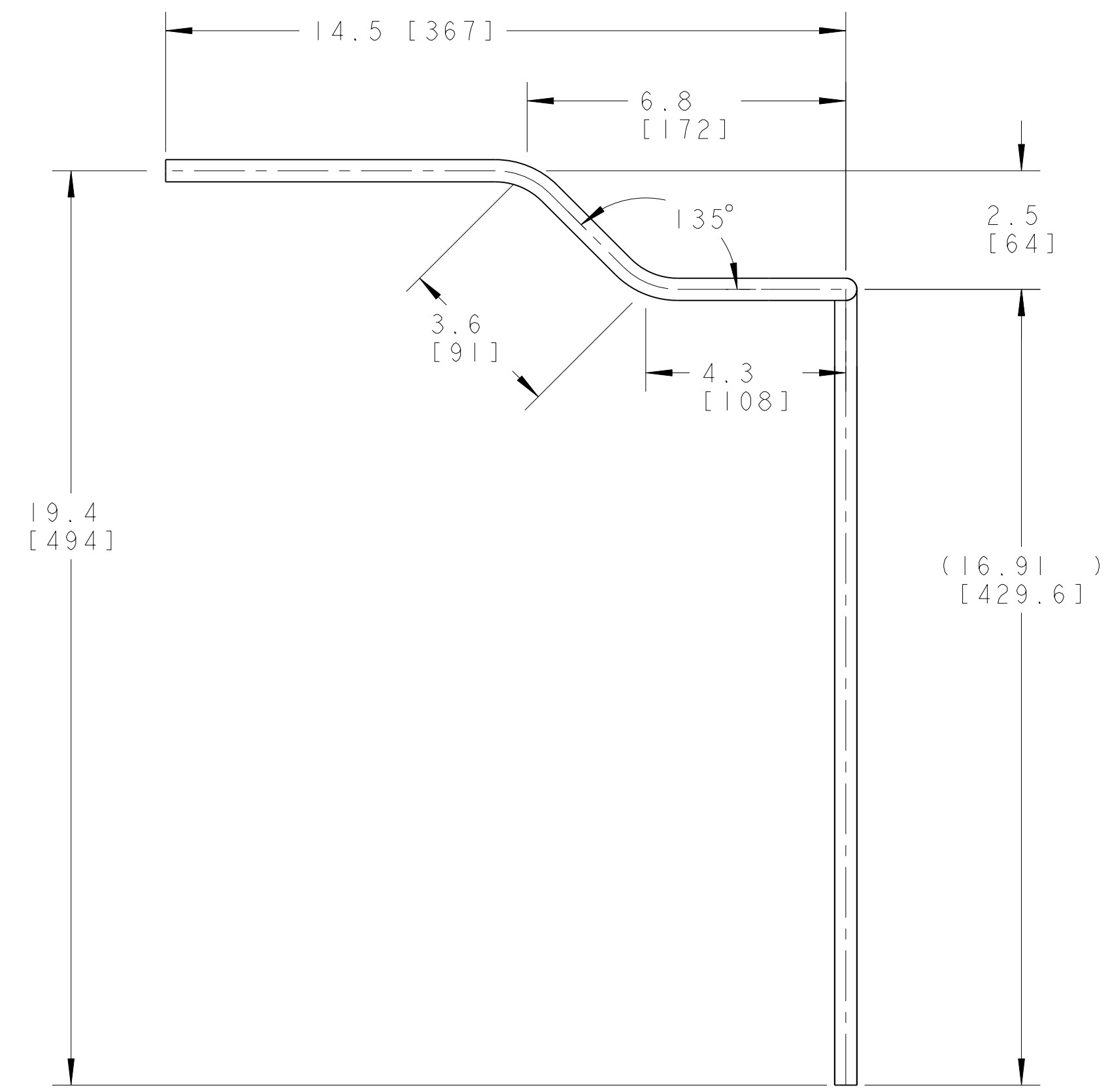


NAME: ARHARRIS OBJECT: 2515484 DATE: 02-Dec-02 14:10:58

DWG. NO.	SIZE	REV.	SH.
2515484	A	1	
DESCRIPTION		MATERIAL	MAT. LOCATION
TUBE, PER ASTM A269		SS 304L	-

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; SUBECT 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.



TOLERANCES				UNLESS OTHERWISE SPECIFIED				SHOP ORDERS				ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY			
X.X ± 0.1				FRAC. ± 1/64				ACCT NO.				SER NO.			
X.XX ± 0.03				Angles ± 1.00°				DEL TO				DATE ISSD			
X.XXX ± 0.010				FINISH 125 μm				SURFACE TREATMT				DATE RECD			
DO NOT SCALE PRINT				THREADS ARE CLASS 2				TIDENT METHOD				LHC IR FEEDBOX CRYOGENICS PIPE, CYI			
CHAMFER ENDS OF ALL SCREW THREADS 30°				CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS				PROJECT NUMBER				MICROFILMED:			
BREAK EDGES .016 MAX. ON MACHINED WORK				REMOVE BURRS, WELD SPLATTER & LOOSE SCALE				PROJECT NAME				DWG. TYPE			
IN ACCORDANCE WITH ASME Y14.5M & B46.1				INITIAL RELEASE				KNOLLS				PART			
REV				CHG				DATE				CATEGORY CODE			
A				ARH SPV				11-01-02				LH2003			
CHANGES				2515484				A				SHEET 1 OF 1			

8 7 6 5 4 3 2 1

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