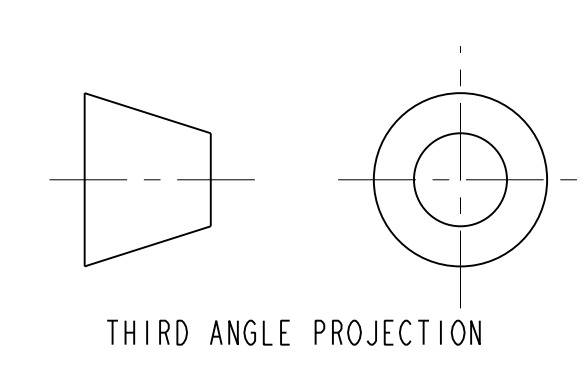
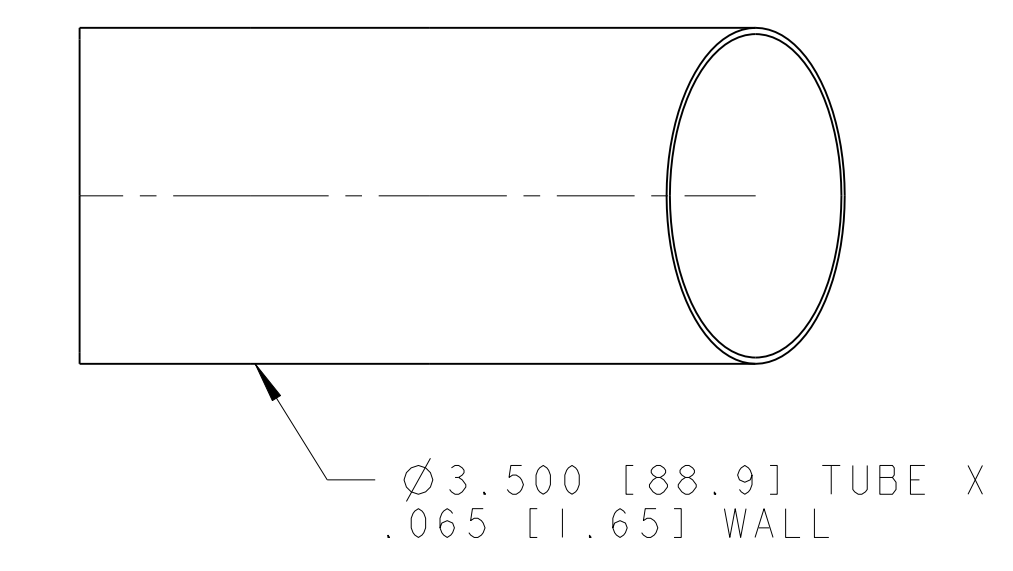
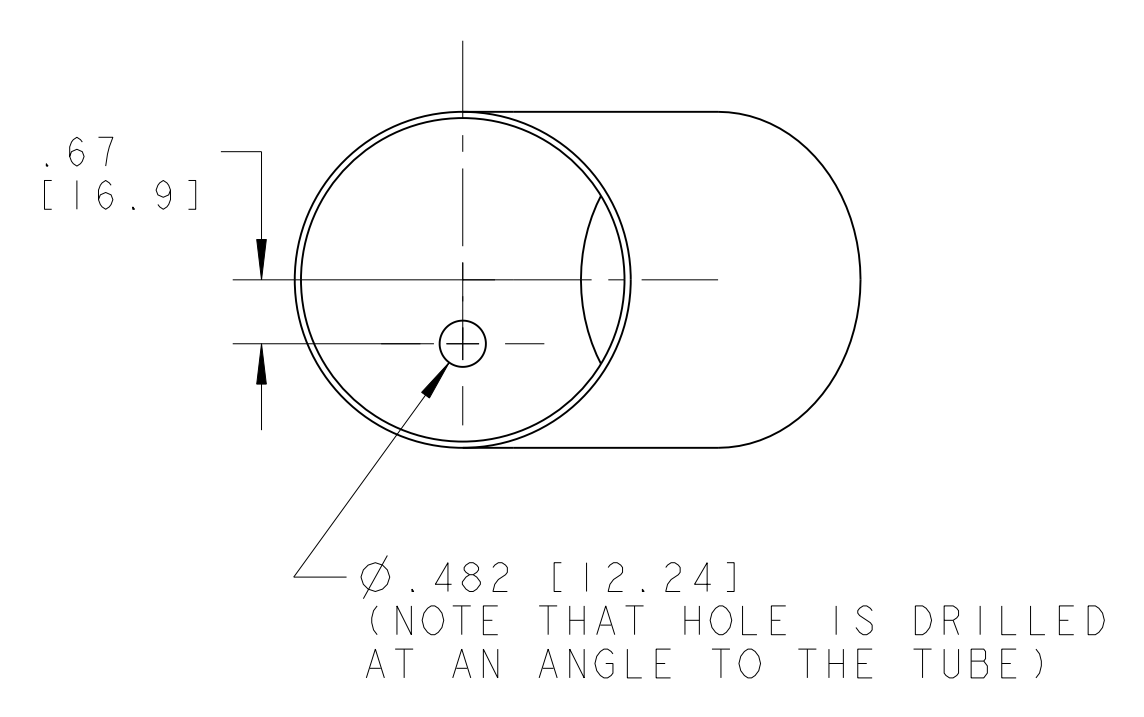
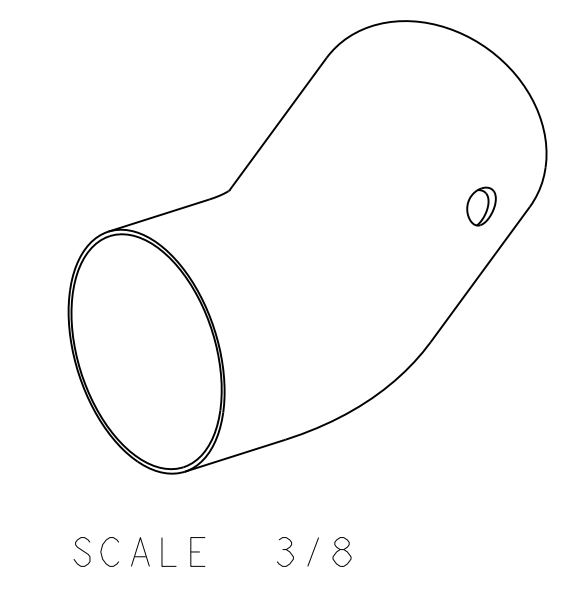
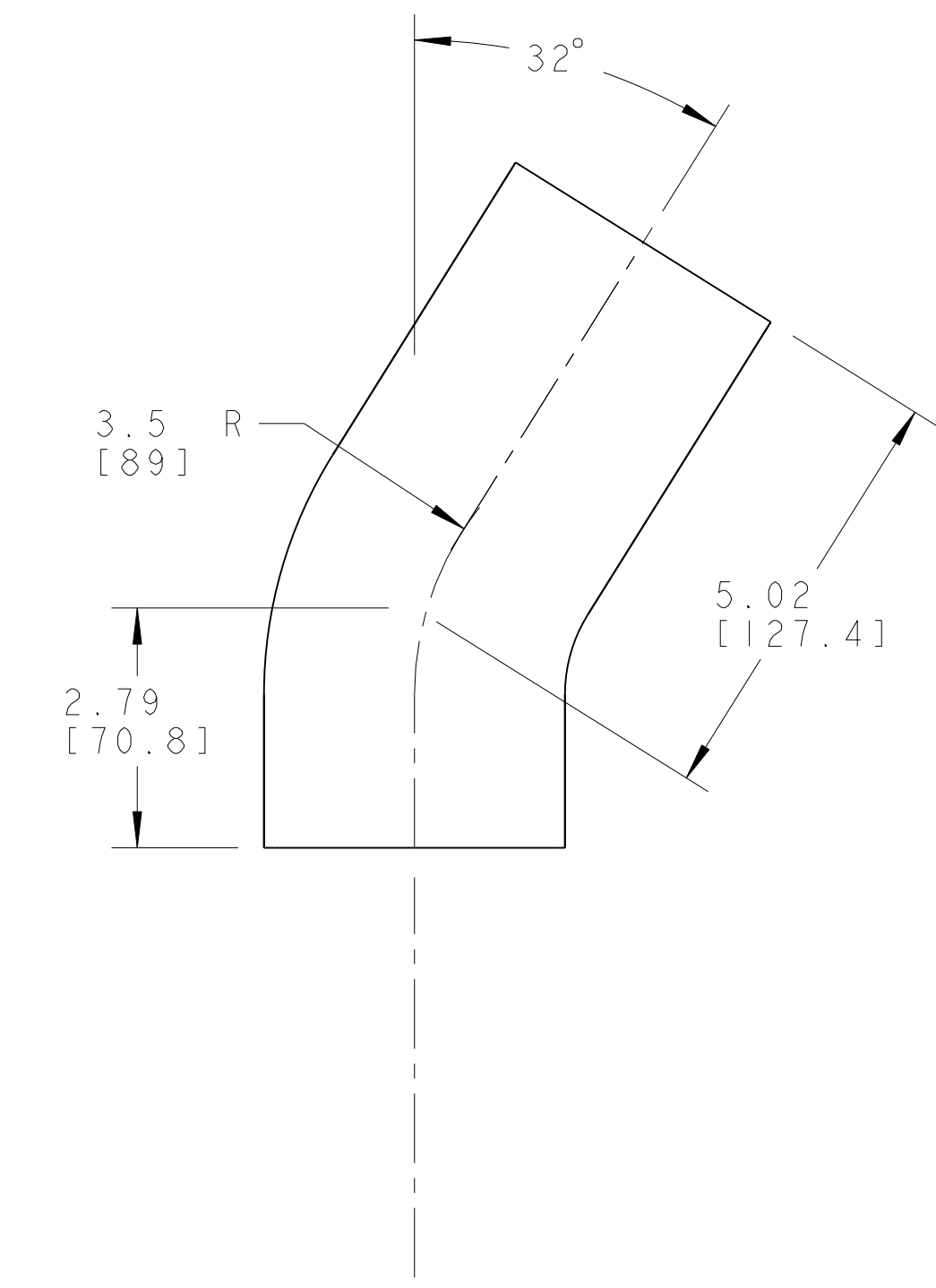


NAME: ARHARRIS OBJECT: 251550 DATE: 08-Nov-02 09:17:23

DWG. NO. 2515504	SIZE A	REV. 1	SH.
DESCRIPTION TUBE, PER ASTM A269		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.



TOLERANCES		UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY	
X.X ± 0.1	FRAC. ± 1/64	ACCT. NO.	NO. RECD.	NO.	DATE	LHC IR FEEDBOX CRYOGENICS PIPE, XB, SURGE TANK ATTACHMENT			
X.XX ± 0.03	Angles ± 1.00°	DEL. TO		DATE ISSD		MICROFILMED: DWG. TYPE PART			
X.XXX ± 0.010	FINISH 125√RMS	SURFACE TREATMT	TAG	DATE RECD		SCALE: 1/2 DO NOT SCALE PRINTS			
DO NOT SCALE PRINT		TOLERANCE METHOD		PROJECT NAME		SHEET 1 OF 1			
THREADS ARE CLASS 2		PROJECT NUMBER		PROJECT NAME		DWG. NO. 2515504			
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NAME		PROJECT NAME		SIZE REV. A			
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		PROJECT NAME		PROJECT NAME		DWG. NO. 2515504			
BREAK EDGES .016 MAX. ON MACHINED WORK		PROJECT NAME		PROJECT NAME		SIZE REV. A			
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		PROJECT NAME		PROJECT NAME		DWG. NO. 2515504			
IN ACCORDANCE WITH ASME Y14.5M & B46.1		PROJECT NAME		PROJECT NAME		SIZE REV. A			
REV. A		ARH SPV		11-01-02		INITIAL RELEASE		CHANGES	

D
C
B
A

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B
A

8 7 6 5 4 3 2 1