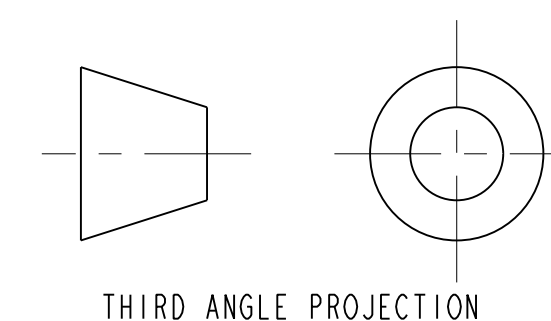
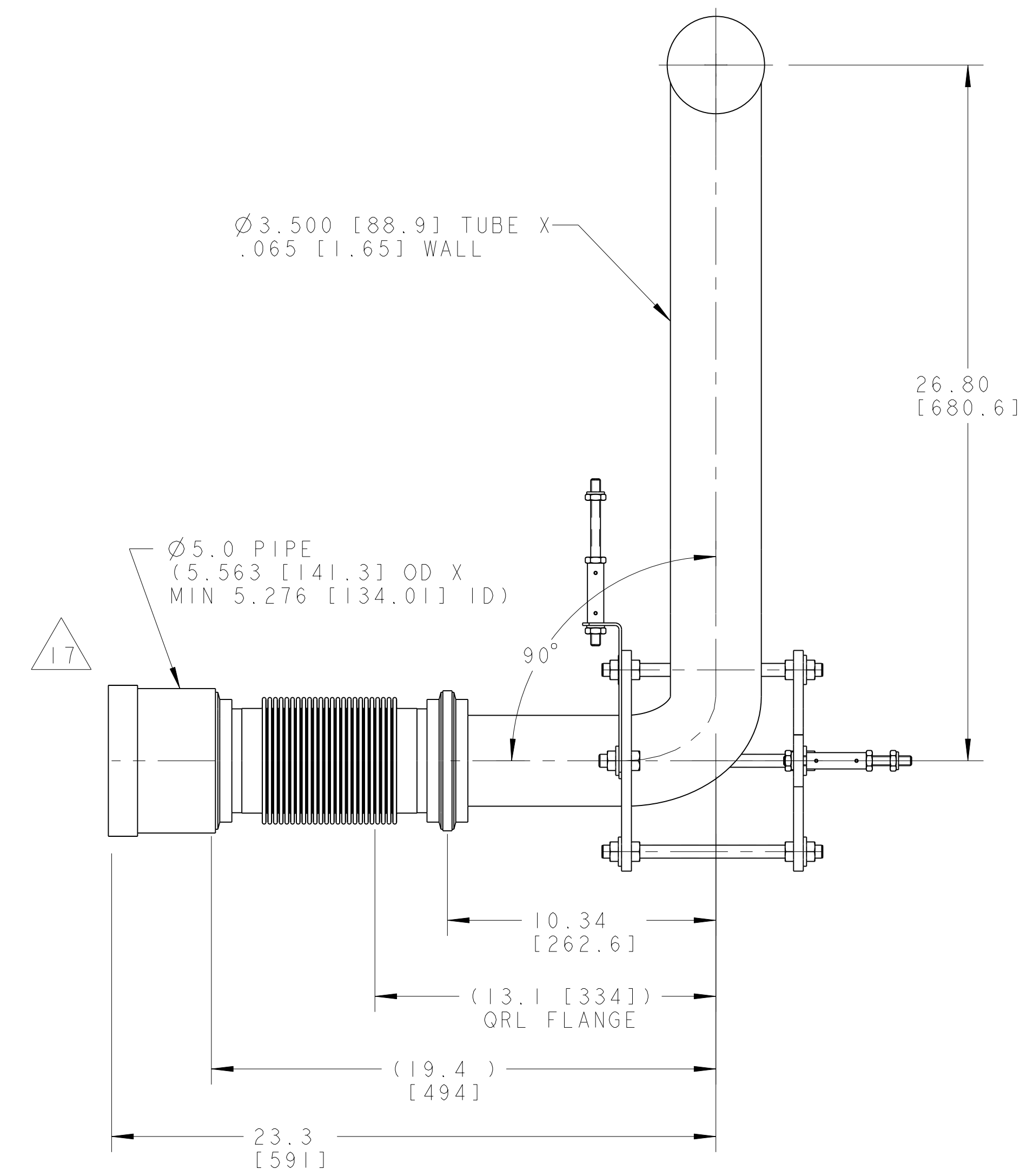
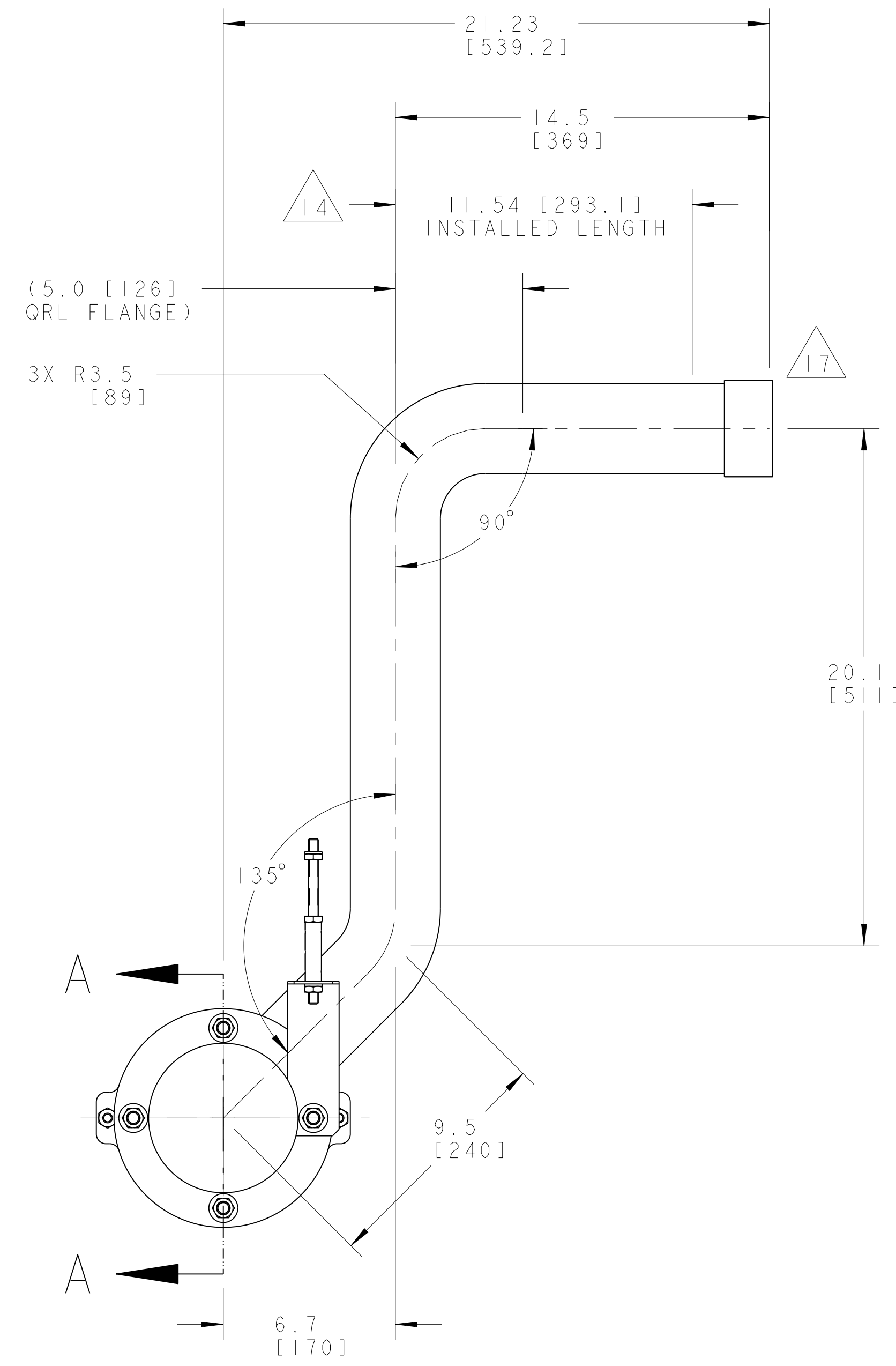
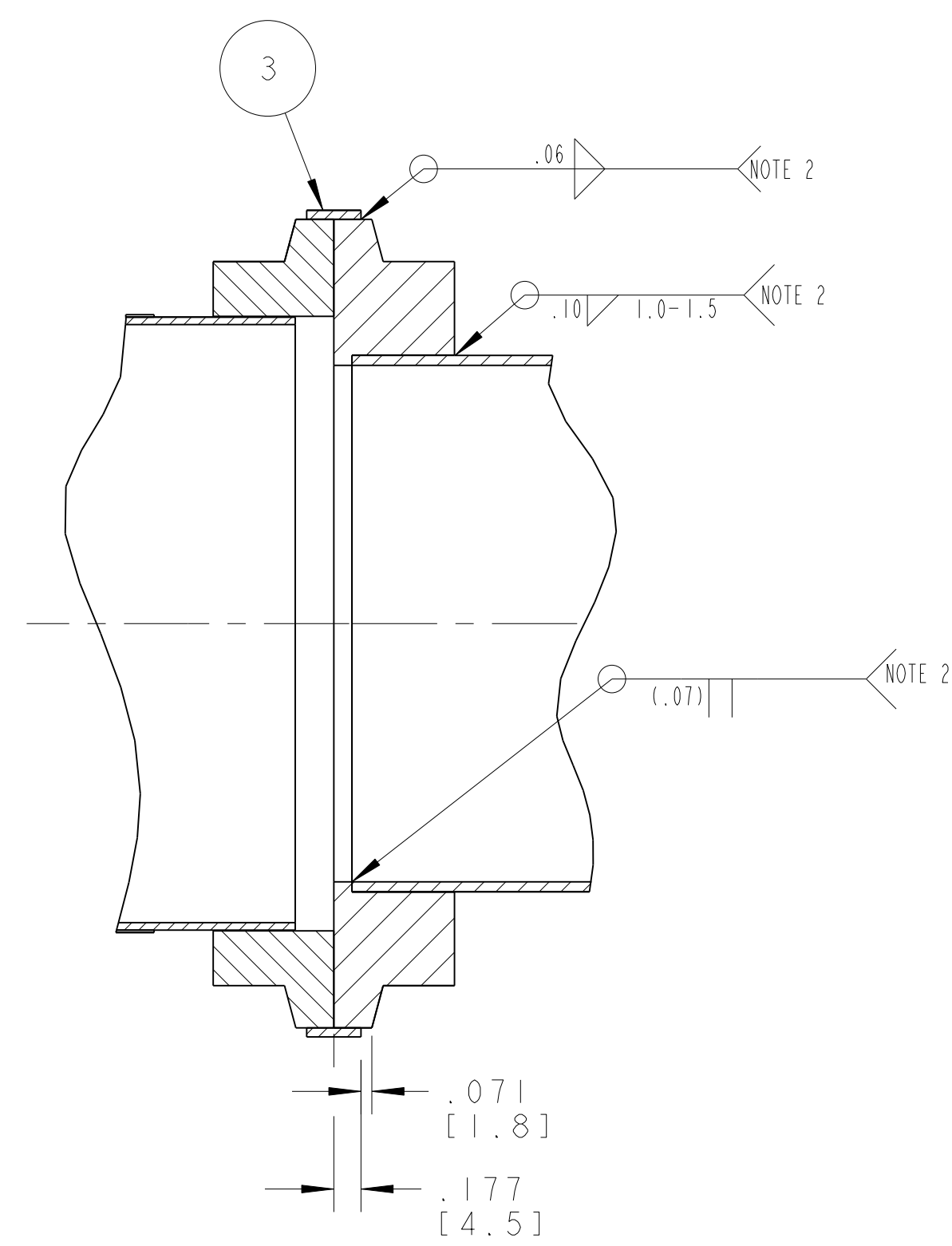
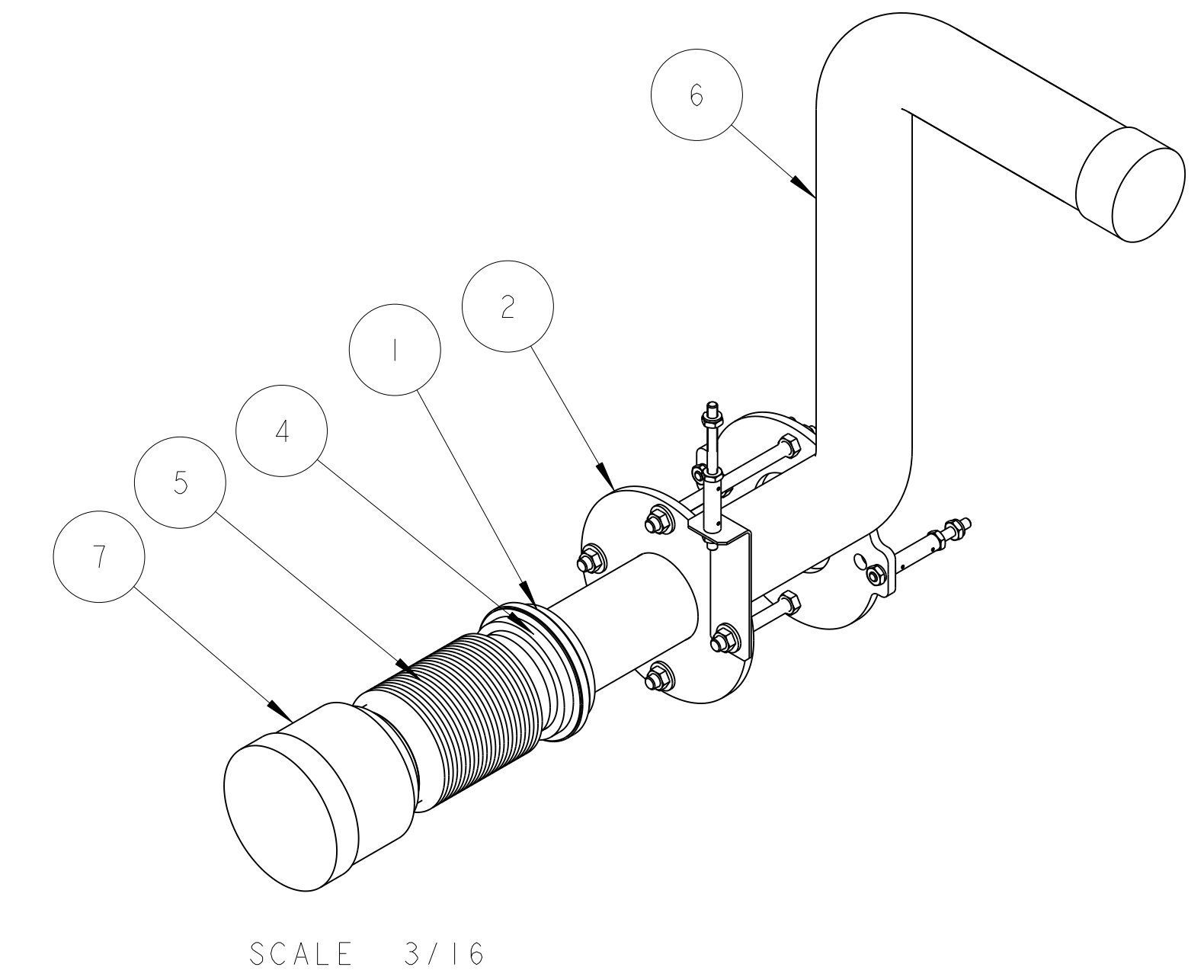
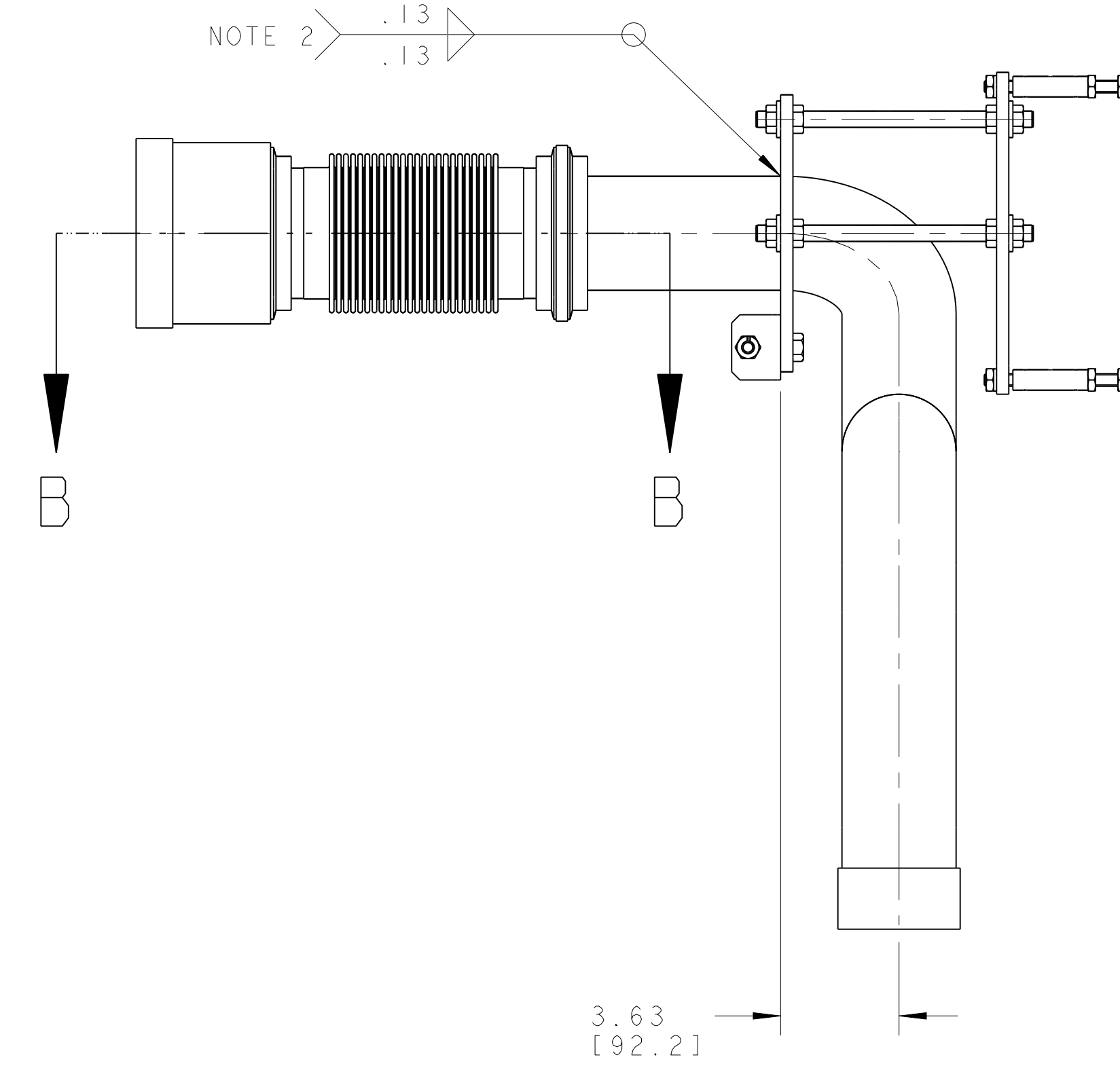
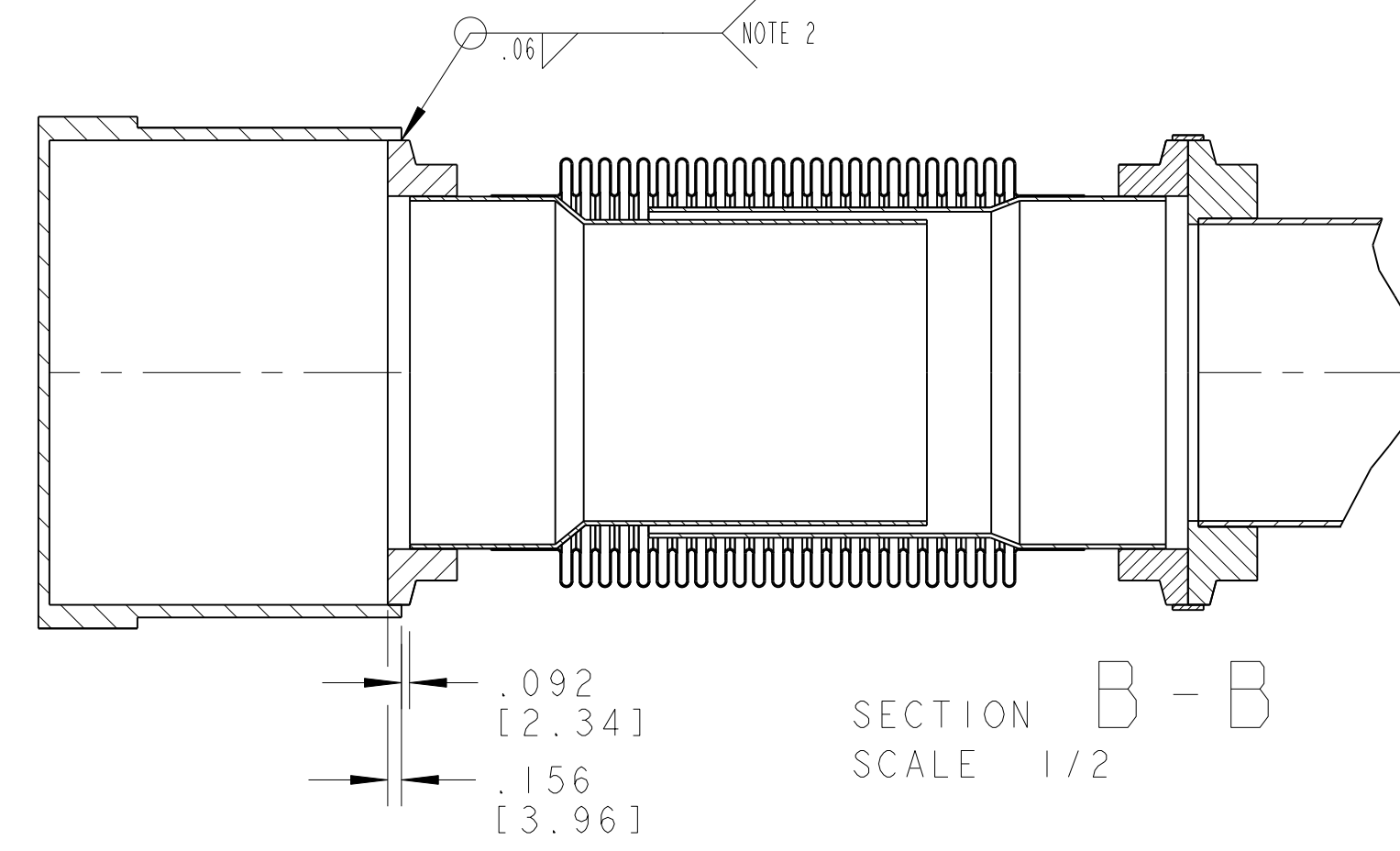


NOTES: (UNLESS OTHERWISE SPECIFIED)

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 FEEDBOX 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.



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

INITIAL RELEASE
CHANGES

UNLESS OTHERWISE SPECIFIED
 X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.0°
 X.XXX ± 0.010 FINISH
 DO NOT SCALE PRINT
 TOLERANCES ARE 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 SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME B16.9 & B31.1

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
7	-	1	PIPE, PER ASTM A312	SS 304L
6	-	1	TUBE, PER ASTM A269	SS 304L
5	251314	1	BELLOWS, FINAL# 5520-MD-390065	SS 309 SERIES
4	251306	1	FLANGE, FINAL# 5520-MC-390032	SS 309 SERIES
3	-	1	THREADED ROD	BMW STRN HRD. 316 SS
2	25M923	1	XB THRUST PLATE ASSY	-
1	-	1	WELD RING, ID 134mm, FINAL SUPPLIED	-

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
1	-	1	WELD RING, ID 134mm, FINAL SUPPLIED	-

SHOP ORDERS	SET	DATE
NO	-	-
ISSUE	-	-
REVISION	-	-

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY	UNIVERSITY OF CALIFORNIA BERKELEY
LHC IR FEEDBOX CRYOGENICS PIPE WELDMENT, XB	
DESIGNED BY: [Signature]	DATE: 13-May-02
CHECKED BY: S. WROSTEN	DATE: 25-Oct-02
APPROVED BY: Jan Zbasnik/D. OSWALD	DATE: 16-Oct-02

SCALE	1/4	DO NOT SCALE PRINTS
SCALE: 1/4	-	-

SHEET 1 OF 1	REV. 1
2515526	A

2515526 A 1

NAME: ARHARRIS OBJECT: 251552 DATE: 27-Nov-02 13:39:18