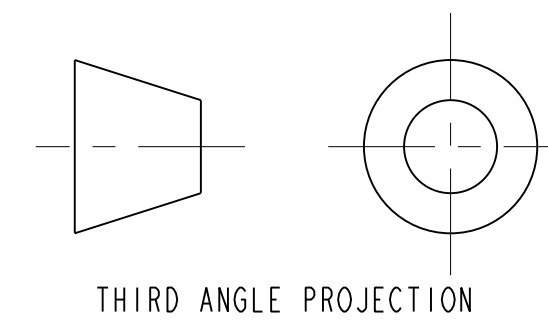
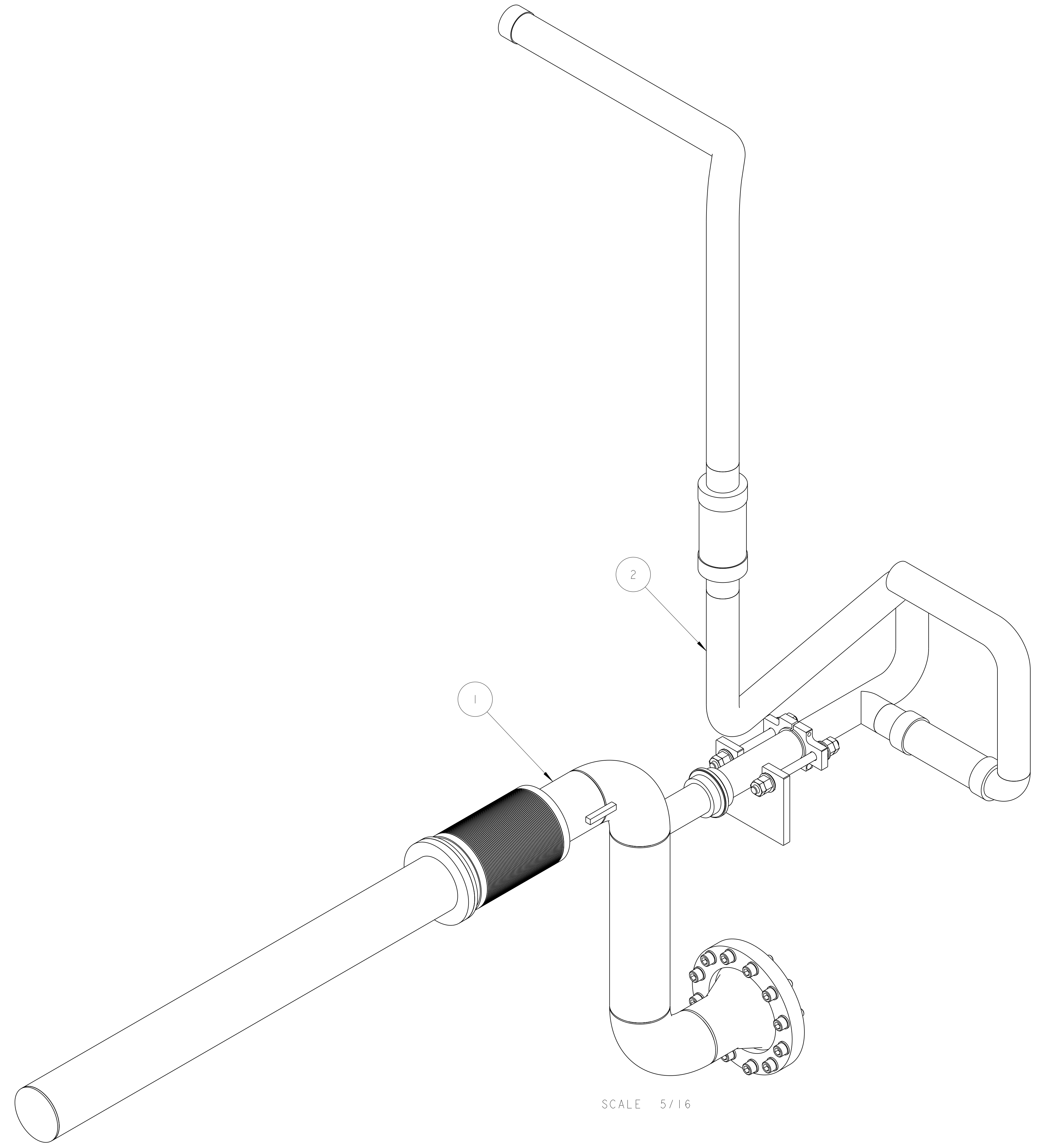
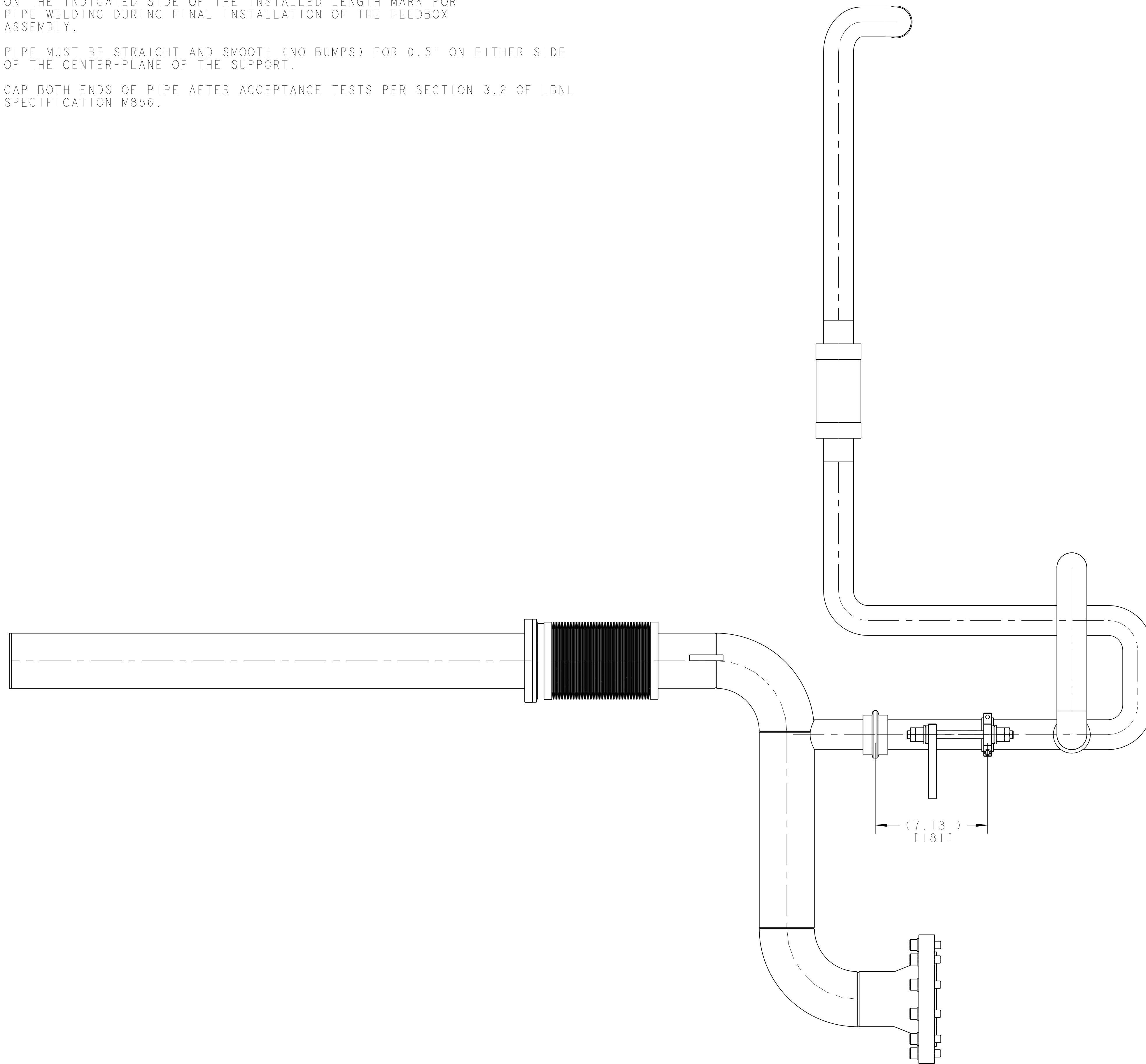


NOTES: (UNLESS OTHERWISE SPECIFIED)

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 $\pm 0.063"$.
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	DWG	CHK	ZONE	DATE	CHANGES
A	ARH	DPO		10-29-02	INITIAL RELEASE
					CHANGES

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
3	-	1	WELD RING, ID 75mm, FINAL SUPPLIED	SS 304L
2	25M920	1	PIPE WELDMENT, LD ORL / LD CROSSOVER	-
1	25M857	1	PIPE WELDMENT, MOKI	-

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	SEE
FINISHNESS	X.X ± 0.1	FRAC	± .1/64
ROUNDS	X.XX ± 0.03	ANGLE	± 1.00°
CHAMFER	X.XXX ± 0.010	FINISH	VD/25
DO NOT SCALE PRINT			
THICKEN AND CLASS 2			
CHAMFER ENDS OF ALL SCREEN THREADS 30°			
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS			
BREAK EDGES .516 MAX. ON MACHINED WORK			
REMOVE BURRS, WELD SPATTER & LOOSE SCALE			
IN ACCORDANCE WITH ASME B16.9 & B.8.1			

DATE	13-May-02	BY	Jan Zbasnik/D. OSWATZ
DATE	23-Oct-02	BY	Jan Zbasnik/D. OSWATZ
DATE	23-Oct-02	BY	Jan Zbasnik/D. OSWATZ

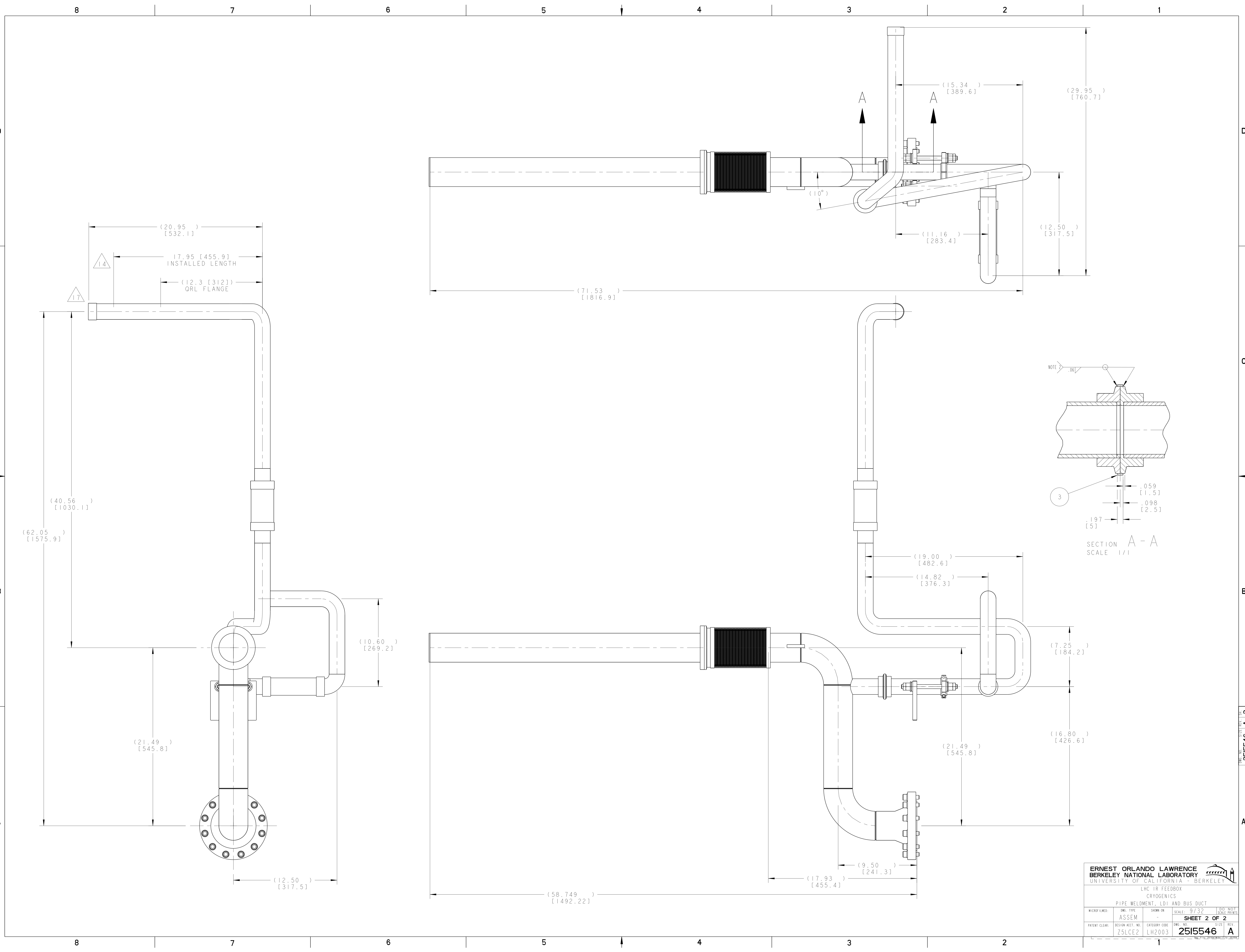
ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY		UNIVERSITY OF CALIFORNIA BERKELEY	
LHC IR FEEDBOX CRYOGENICS			
PIPE WELDMENT, LD1 AND BUS DUCT		SCALE: 9/32	
ASSEM		SHEET 1 OF 2	
PATENT CLEAR:	REVIEW ACCT. NO:	CATEGORY CODE:	DWG. NO.
	Z5LCE2	LH2003	2515546

NAME: ARHARRIS OBJECT: 251554_1 DATE: 08-Nov-02 13:27:58

2515546 A 1

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NAME: ARHARRIS OBJECT: 2515546 DATE: 08-Nov-02 13:25:00



ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 PIPE WELDMENT, LD1 AND BUS DUCT

MICROFILMED:	ENG. TYPE:	SHOW ON:	SCALE:	DO NOT:
	ASSEM		9/32	LOCK PRINTS
PATENT CLEAR:			REVISION NO.:	SIZE:
			Z5LCE2	LH2003
			2515546	A

SHEET 2 OF 2

2515546 A 2