

8

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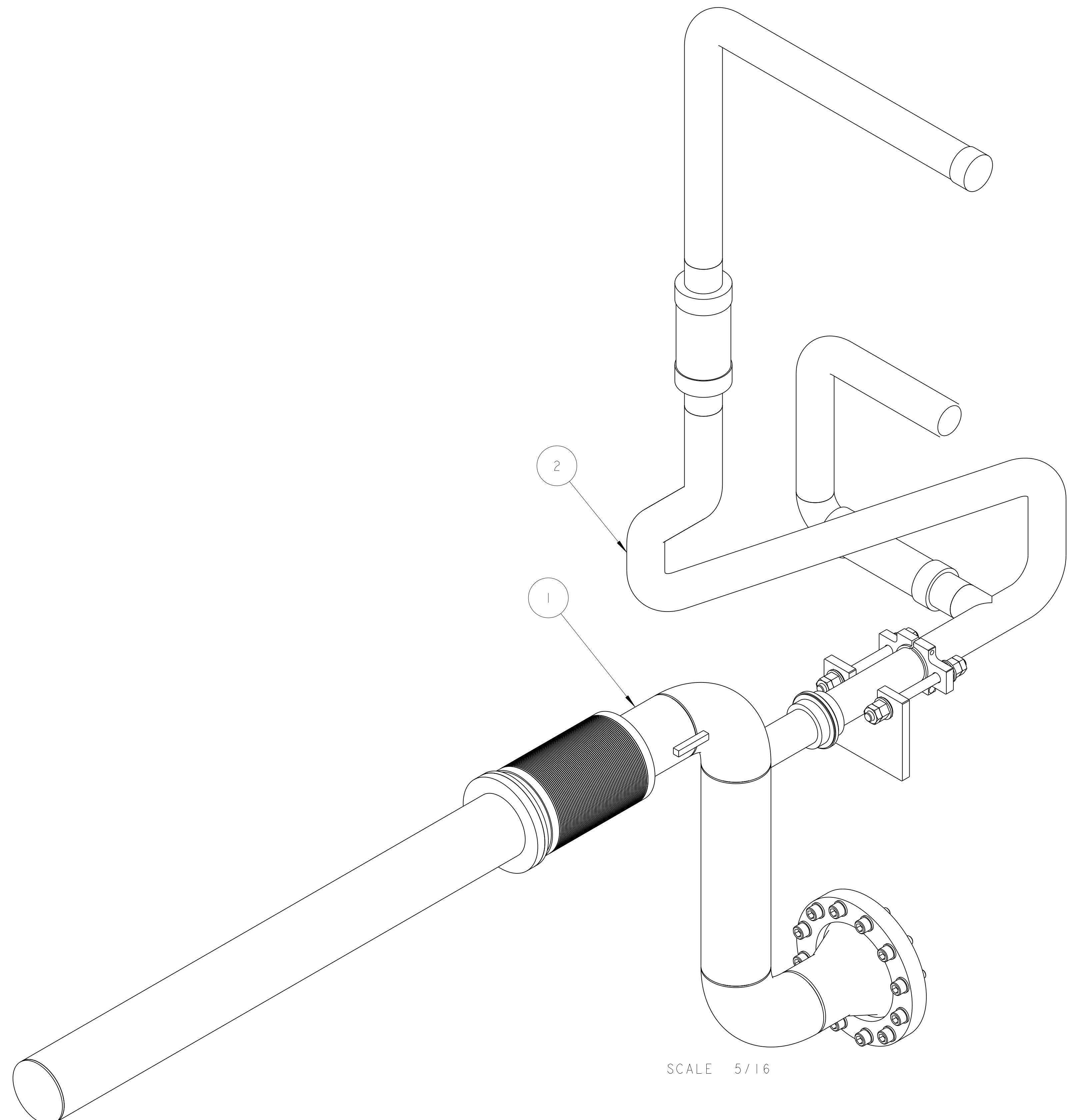
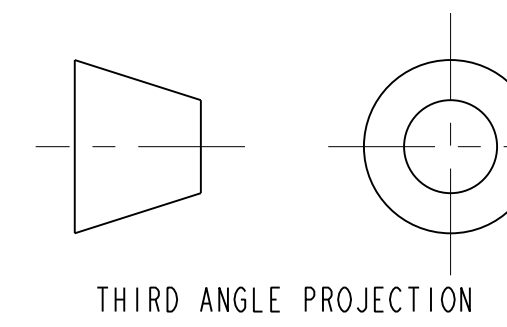
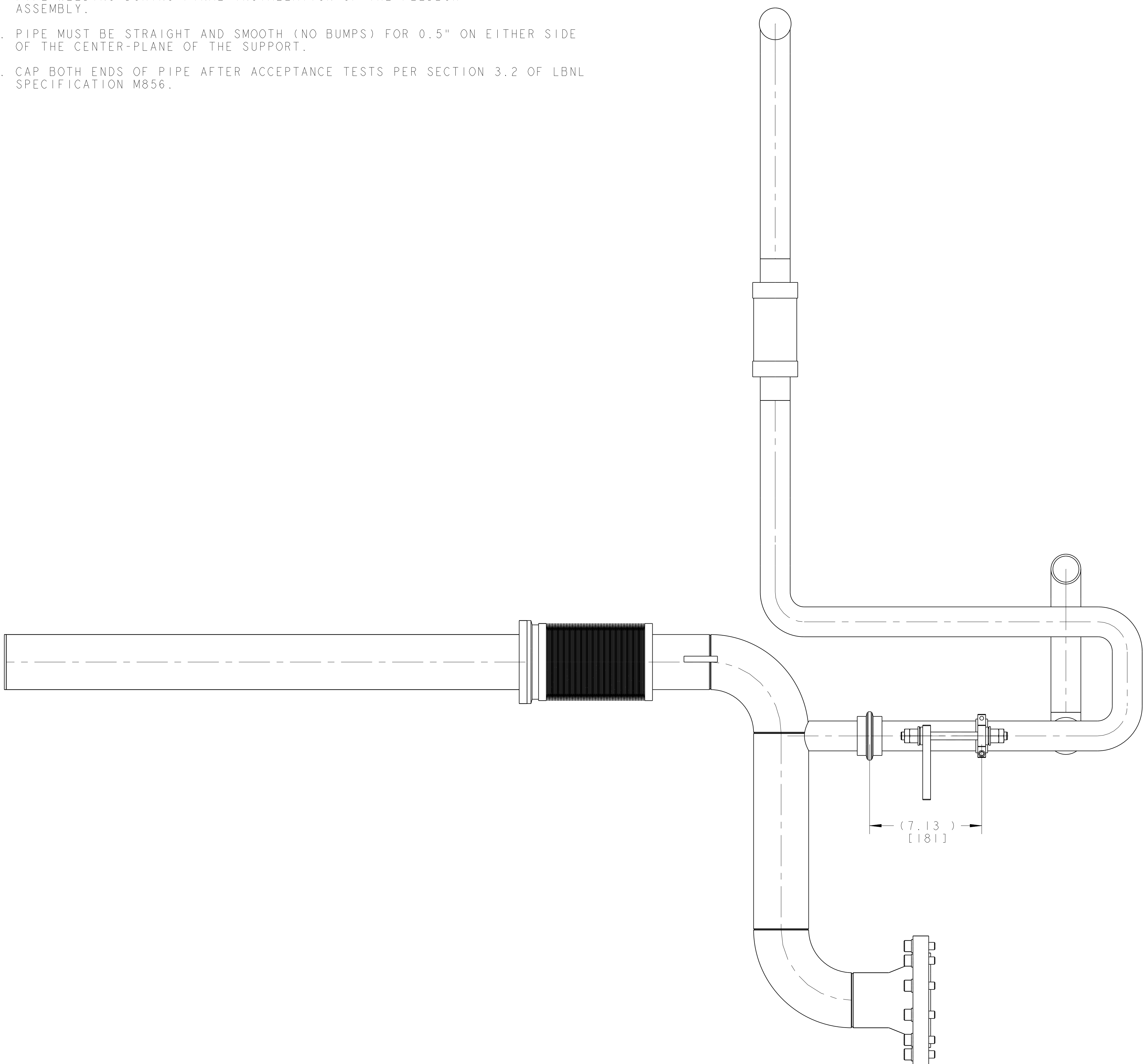
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NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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.

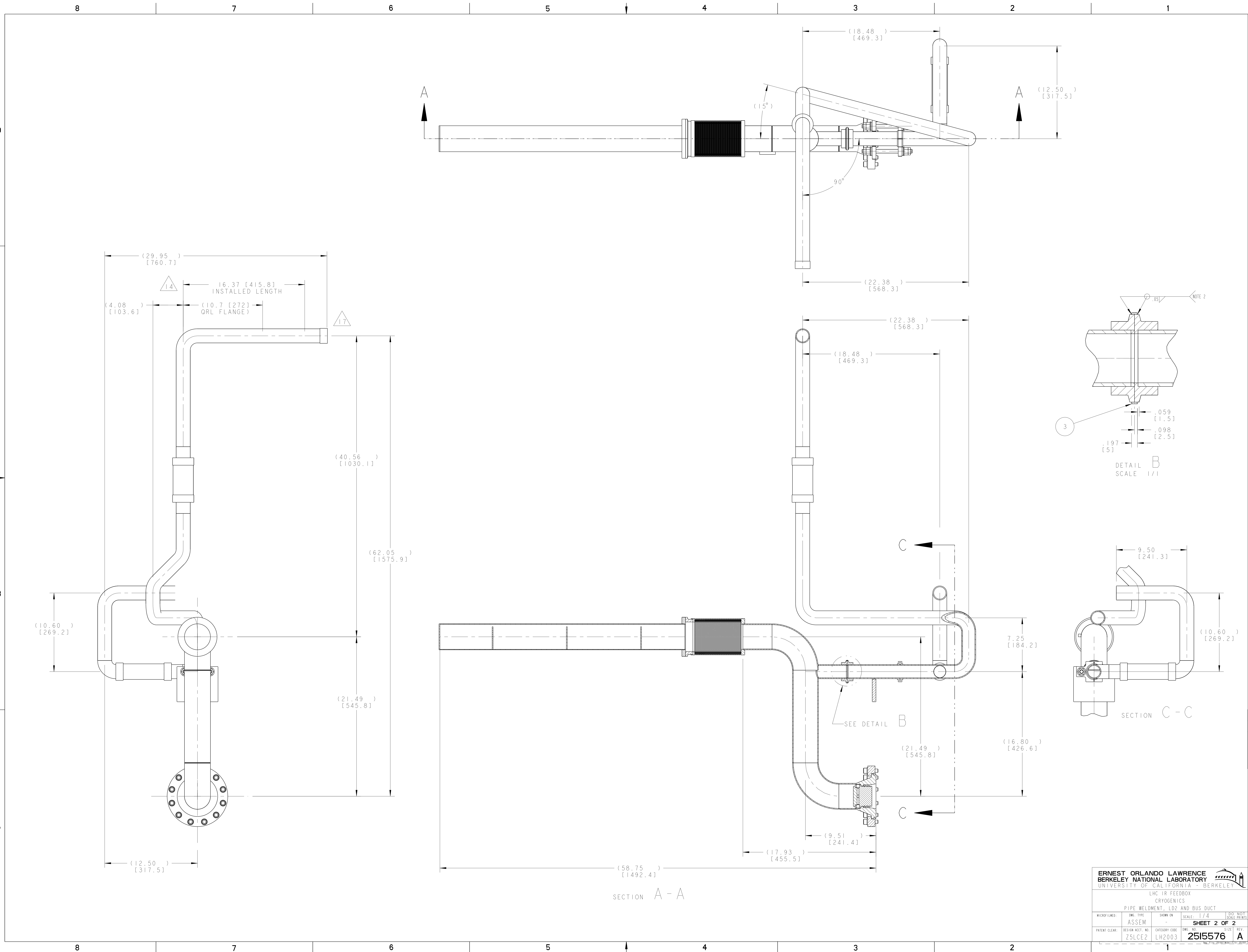


3	-	1	WELD RING, ID 75mm, FINAL SUPPLIED	SS 304L
2	25M019	1	PIPE WELDMENT, LD ORL / LD CROSSOVER	-
1	25M057	1	PIPE WELDMENT, MOKI	-
ITEM	PART NO.	QTY	DESCRIPTION	MATERIAL
SHOP ORDERS UNLESS OTHERWISE SPECIFIED TOLERANCES: X.X ± 0.1 FRACTION ± 1/64 DECIMAL ± 0.03 ANGLES ± 1.0° SURFACE FINISH: X.XXX ± 0.010 DO NOT SCALE PRINT THREADS ARE CLASS 2 CHAMFER ENDS OF ALL SCREW THREADS 30° CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS BREAK EDGES .125 MAX. ON MACHINED WORK REMOVE BURRS, WELD SPLICED & LOOSE SCALE IN ACCORDANCE WITH SEMI E14.3M & B&E.1				
ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA BERKELEY LHC IR FEEDBOX CRYOGENICS PIPE WELDMENT, LD2 AND BUS DUCT ASSEM DWG. NO. Z5LCE2 DATE: 04-04-02 SHEET 1 OF 2 SCALE: 9/32 DESIGNED BY: D. OSHATZ DATE: 04-04-02 CHECKED BY: D. OSHATZ DATE: 04-04-02 PATENT CLEAR: REVIEW ACCT. NO. Z5LCE2 CATEGORY CODE LH2003 DWG. NO. 2515576 SIZE: A				

ARH	SPY	10-29-01	INITIAL RELEASE
REV	DWG	CHK	ZONE
DATE	DATE	CHANGES	

NAME: ARHARRIS OBJECT: 251557_1 DATE: 08-Nov-02 10:45:35
 SHEET 1 OF 2
 SCALE: 9/32
 SIZE: A

NAME: ARHARRIS OBJECT: 2515576 DATE: 08-Nov-02 10:45:37



ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY <small>UNIVERSITY OF CALIFORNIA BERKELEY</small>			
LHC IR FEEDBOX CRYOGENICS PIPE WELDMENT, LD2 AND BUS DUCT			
MICROFILMED:	DWG. TYPE:	SHOW ON:	SCALE: 1/4
	ASSEM		DO NOT CHECK PRINTS
PATENT CLEAR:	DESIGN ACCT. NO:	CATEGORY CODE:	DWG. NO. REV.:
	Z5LCE2	LH2003	2515576 A
			SHEET 2 OF 2 SIZE: A

2515576 A 2