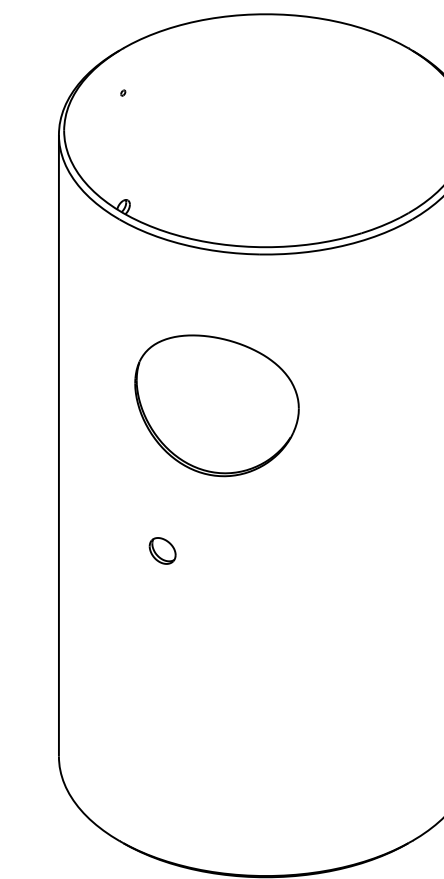
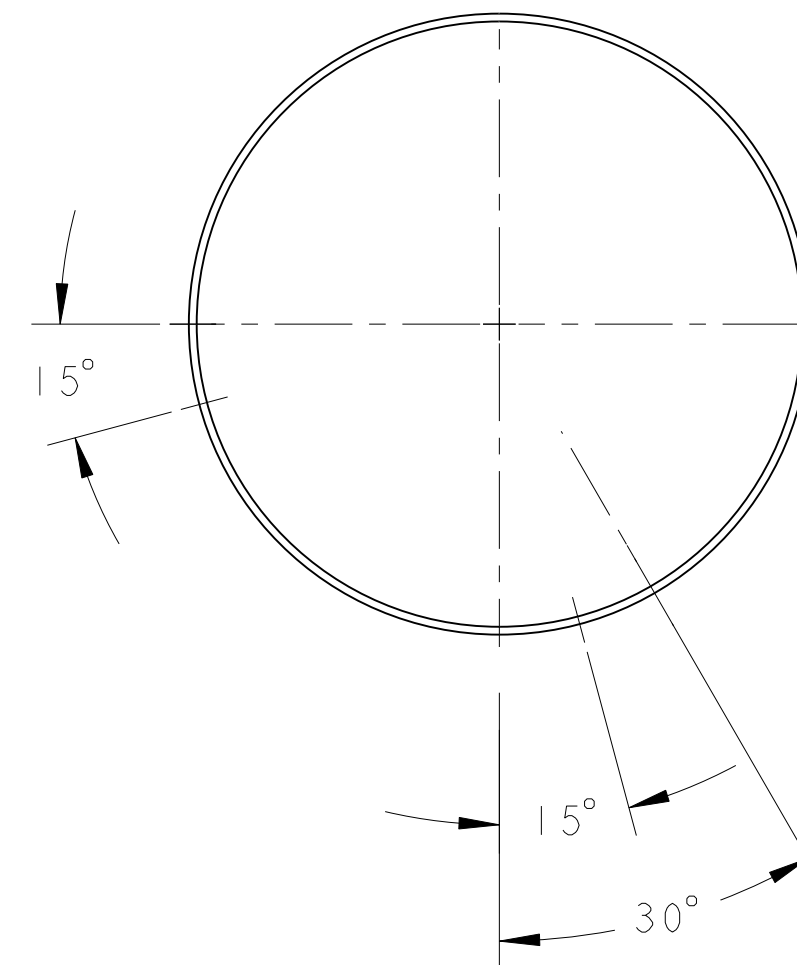


NAME: ARHARRIS OBJECT: 251572 DATE: 08-Nov-02 07:44:57

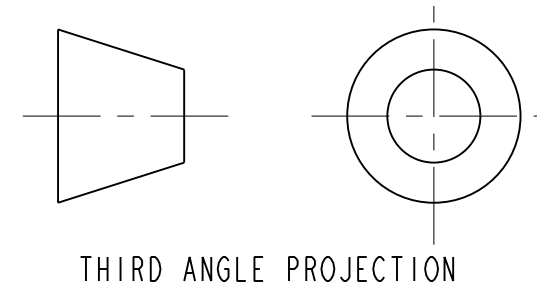
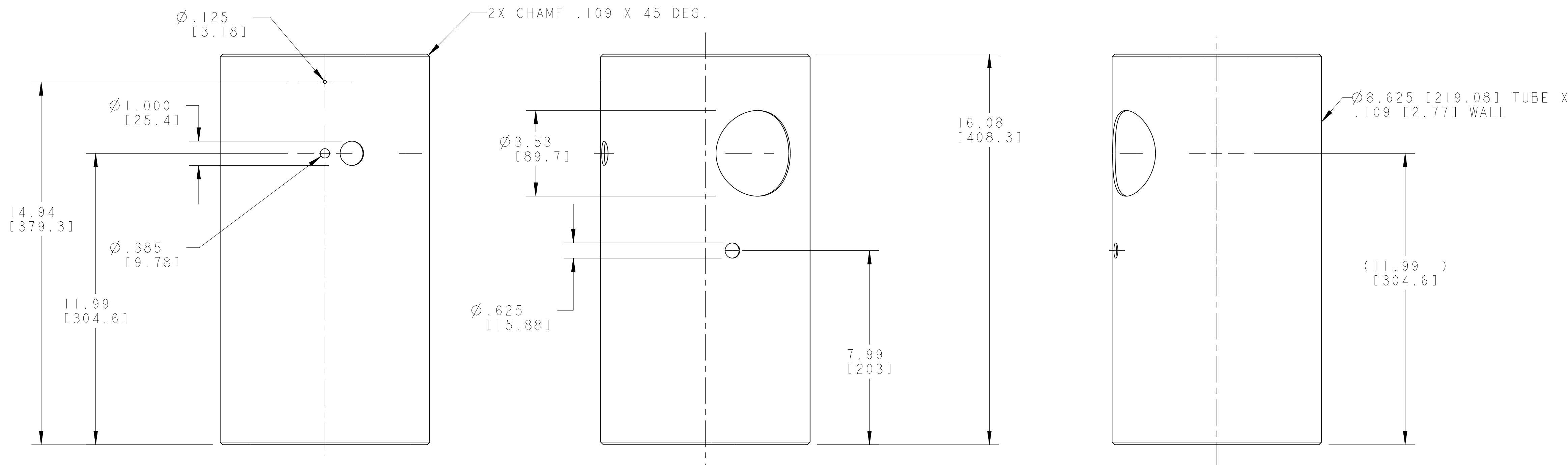
DWG. NO. 2515724	SIZE A	REV. 1	SH.
DESCRIPTION PIPE, SCHEDULE 5S, PER ASTM A312		MATERIAL SS 304L	MAT. LOCATION

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.



SCALE 1/4



REV	DWG	CHK	ZONE	DATE	CHANGES
A	ARH	DPO		9-17-02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER NO.	-
X.X ± 0.1	FRAC. ± 1/64	ACCT NO.	NO. RECD	DATE ISSD	-
X.XX ± 0.03	Angles ± 1.00°	DEL TO	DATE RECD		
X.XXX ± 0.010	FINISH 125 $\sqrt{R_{a}}$	SURFACE TREATMT			
DO NOT SCALE PRINT		TIDENT METHOD	TAG		
THREADS ARE CLASS 2		PROJECT NUMBER	N/A		
CHAMFER ENDS OF ALL SCREW THREADS 30°		PROJECT NAME	N/A		
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG BY	KNOLLS	DATE	27-Jul-02
BREAK EDGES .016 MAX. ON MACHINED WORK		CHK BY	30W120516K	DATE	25-OCT-02
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		APR BY	Jon Zbasnik/D.Oshatz	DATE	25-OCT-02
IN ACCORDANCE WITH ASME Y14.5M & B46.1					

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY			
LHC IR FEEDBOX CRYOGENICS SURGE TANK BODY			
MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 3/8
	PART		DO NOT SCALE PRINTS
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.
	Z5LCE2	LH2003	2515724
			REV. A

SHEET 1 OF 1

2515724 A