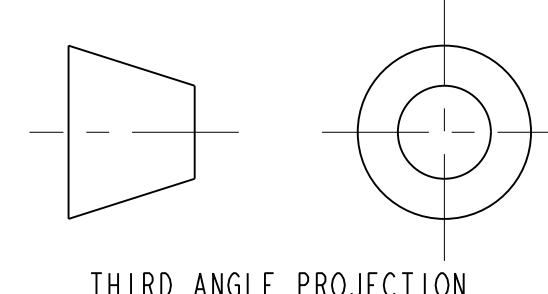


1ST WELDMENT STAGE

- NOTES: UNLESS OTHERWISE SPECIFIED,
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982 UNITS ARE IN INCHES 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.
  - CLEAN AFTER MACHINING PER VENDOR SPECIFICATION; SUBJECT TO LBNL APPROVAL.
  - VENDOR SUGGESTED CHANGES TO WELD PREPS: SUBJECT TO LBNL APPROVAL.
  - PROTECT FINISHED PART BY BAGGING OR SIMILAR METHOD TO PROTECT AND MAINTAIN CLEANLINESS DURING SHIPMENT AND STORAGE.
  - VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE ASSEMBLY; SUBJECT TO LBNL APPROVAL.
  - OPERATING CONDITIONS, 4.2k, 70 psig (4.4bar) TEST PRESSURE.
  - ESTIMATED WEIGHT: 768 LBS.
  - TACK WELD APPROPRIATE WELD BACKING STRIPS AROUND ENTIRE PERIMETER OF VESSEL OPENING. COVER SHOWN IN DRAWING Z5M8226 WILL BE WELDED INTO OPENING DURING A LATER STEP PER DRAWING Z4C3526.
  - TOOLING ITEM NOT SHOWN



UNLESS OTHERWISE SPECIFIED		LET	
X.X ± 0.1	FRACTION ± 1/64	NO	
X.XX ± 0.03	ANGLES ± 1.00°	DATE	
X.XXX ± 0.010	FINISH	REVISION	
DO NOT SCALE PRINT		PROJECT	
TOLERANCES UNLESS SPECIFIED		ISSUE	
CHAMFER ENDS OF ALL SCREW THREADS 30°		DATE	
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS		BY	
BREAK EDGES .156 MAX. ON MACHINED WORK		DATE	
REMOVE BURRS, WELD SPATTER & LOOSE SCALE		BY	
IN ACCORDANCE WITH ASME Y14.3M & B46.1		DATE	

ITEM	PART NO	QTY	DESCRIPTION	MATERIAL
32	251900	2	TANK SUPPORT BRACKET	SS 304L
31	251576	1	LIQUID HELIUM TANK, END PLATE	304L SS
30	251105	1	LIQUID HELIUM TANK, UPPER SHELL	304L SS
29	251667	1	PUSH BLOCK	ALUM 6061
28	-	4	SCW, MSX-B, 1/2LG, SILVER PLATED	SS 18-8
27	-	4	LOCK WASHER, MS	SS
26	251110	8	LIQUID HELIUM TANK, WELDMENT RING	304L SS
25	251115	1	LIQUID HELIUM TANK, END PLATE (1 PORT)	304L SS
24	25M813	1	CLAMP COVER 1"	OFHC, C101
23	251909	1	LIQUID HELIUM PORT STUB	304L SS
22	251908	1	CHECK VALVE STUB	304L SS
21	251907	1	RELIEF PORT PIPE STUB	304L SS
20	251899	2	PIPING SUPPORT PAD	SS 304L
19	251687	1	CABLE LOOM BASE-B ASSEMBLY	-
18	251457	2	HTS SOLDER JOINT ASSEMBLY-BA	-
17	251688	2	CABLE LOOM BASE ASSEMBLY	-
15	251689	2	HTS SOLDER JOINT ASSEMBLY-B	-
14	251689	3	CABLE LOOM BASE-A ASSEMBLY	-
13	251665	12	SOLDER BOX GUSSET	SS
12	25M900	1	TANK SUPPORT BOSS	CDA 101
11	25M860	4	LIQUID HELIUM TANK, HALF RIB, LOWER	304L SS
10	251109	4	LIQUID HELIUM TANK, FULL RIB	SS 304L
9	251108	4	LIQUID HELIUM TANK, HORIZONTAL LOWER RIB	SS 304L
8	251107	5	LIQUID HELIUM TANK, HORIZONTAL UPPER RIB	SS 304L
7	-	1	COPPER-BRAID, 1" X 1/8"	SS 304L
6	251104	1	LIQUID HELIUM TANK, PORT FRAME	SS 304L
5	251103	1	LIQUID HELIUM TANK, HORIZONTAL LOWER RIB	SS 304L
4	251102	1	LIQUID HELIUM TANK, HORIZONTAL UPPER RIB	SS 304L
2	251898	4	LIFTING PAD	SS 304L
1	251106	1	LIQUID HELIUM TANK, LOWER SHELL	304L SS

ERNEST ORLANDO LAWRENCE  
BERKELEY NATIONAL LABORATORY  
UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX  
CRYOGENICS

LIQUID HELIUM TANK - 8 PORT RIGHT

ASSEM

SCALE: 1/4

SHEET 1 OF 4

Z5LCE2 LH2003 2515746 A

NAME: ARHARRIS OBJECT: 251574\_1 DATE: 04-Dec-02 09:22:09

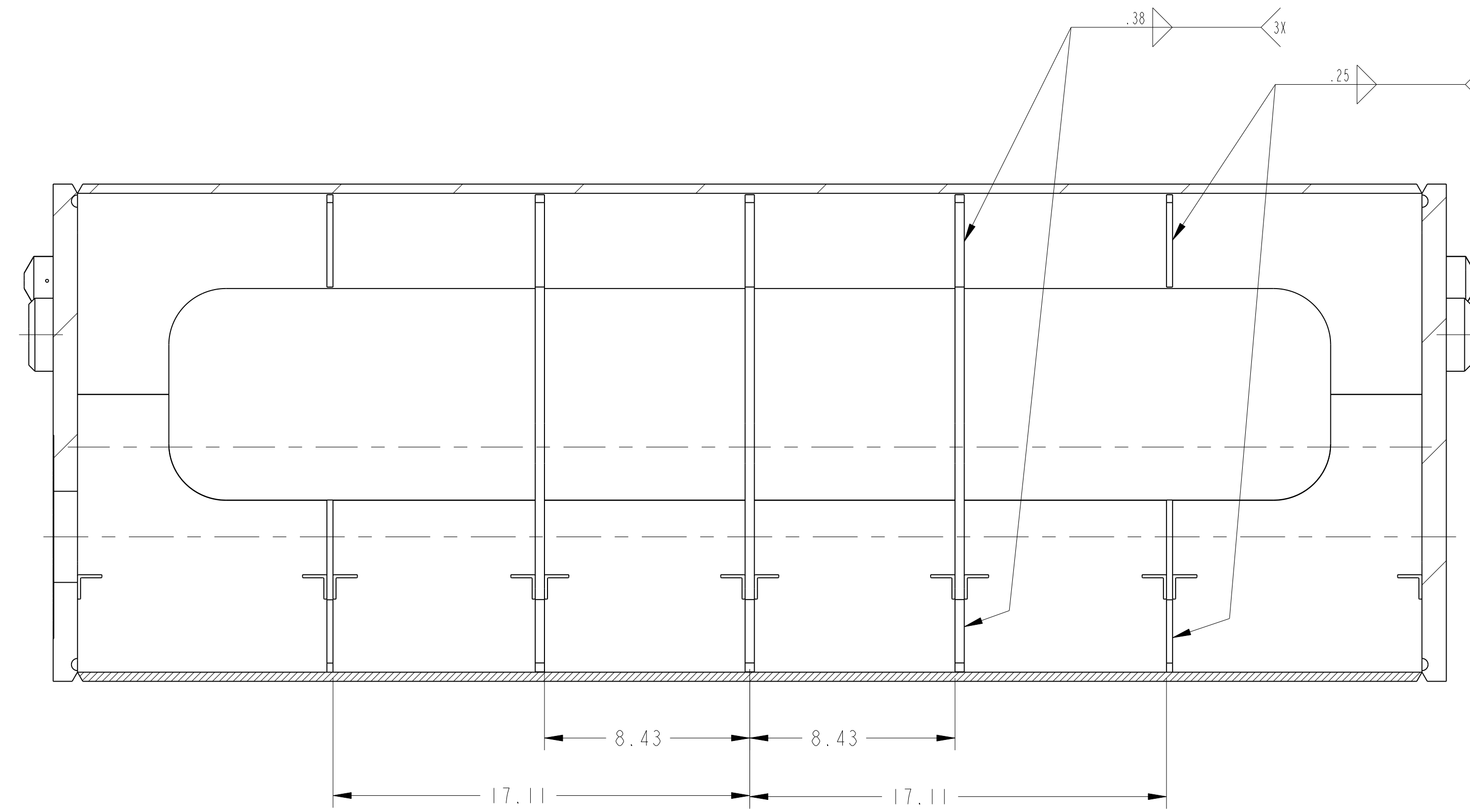
2515746 A 1

A

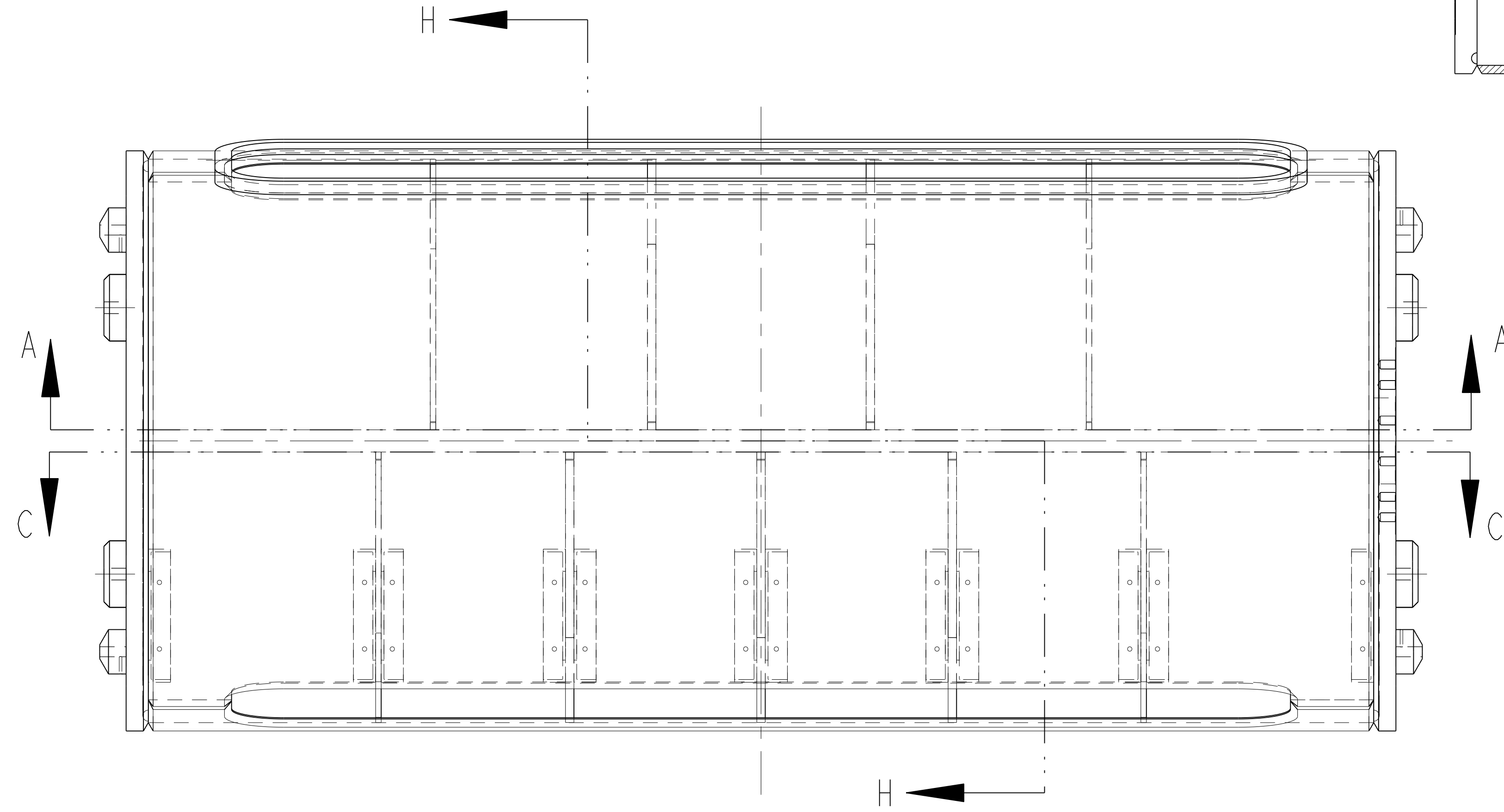
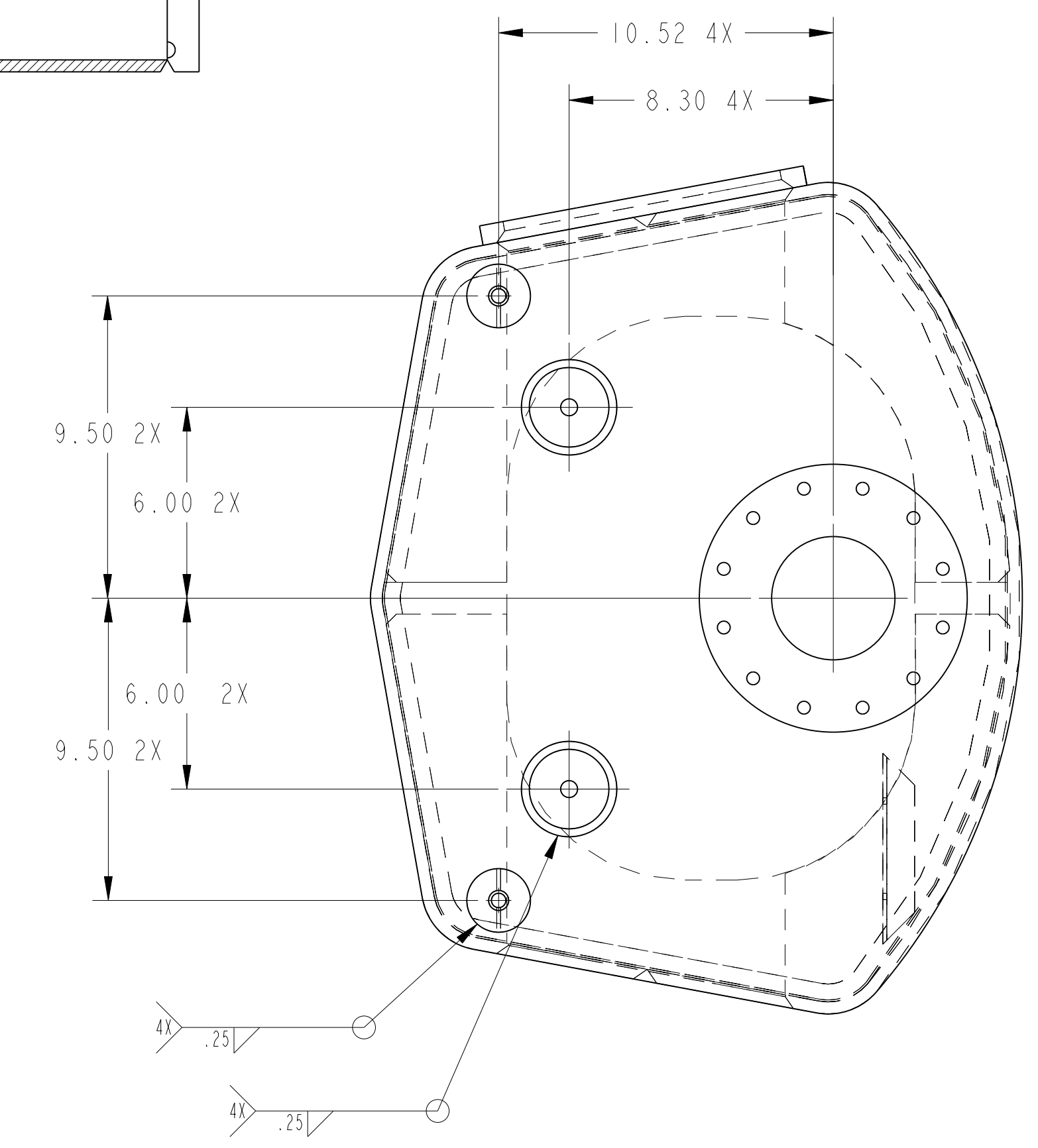
A

8 7 6 5 4 3 2 1

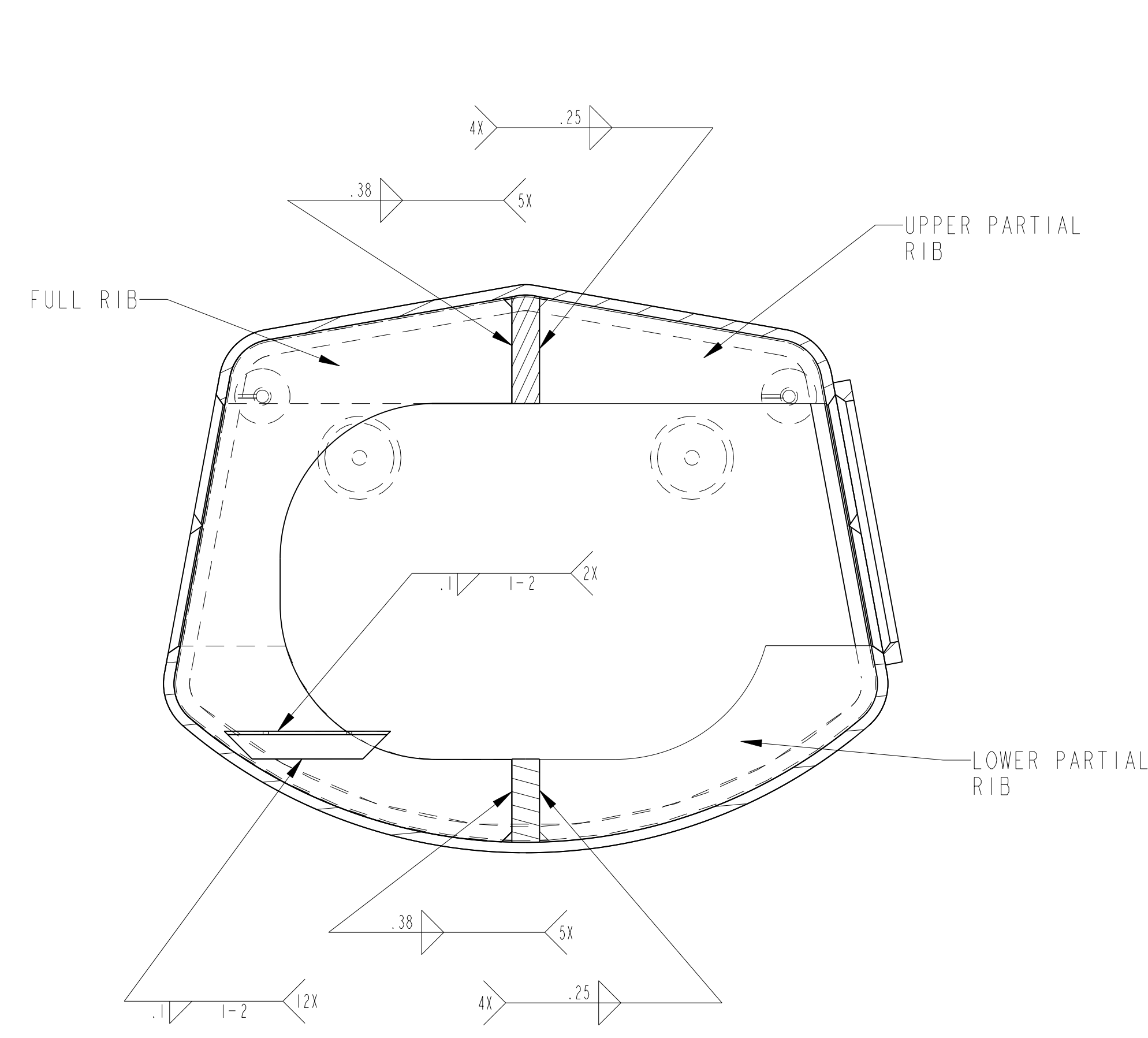
1ST WELDMENT STAGE



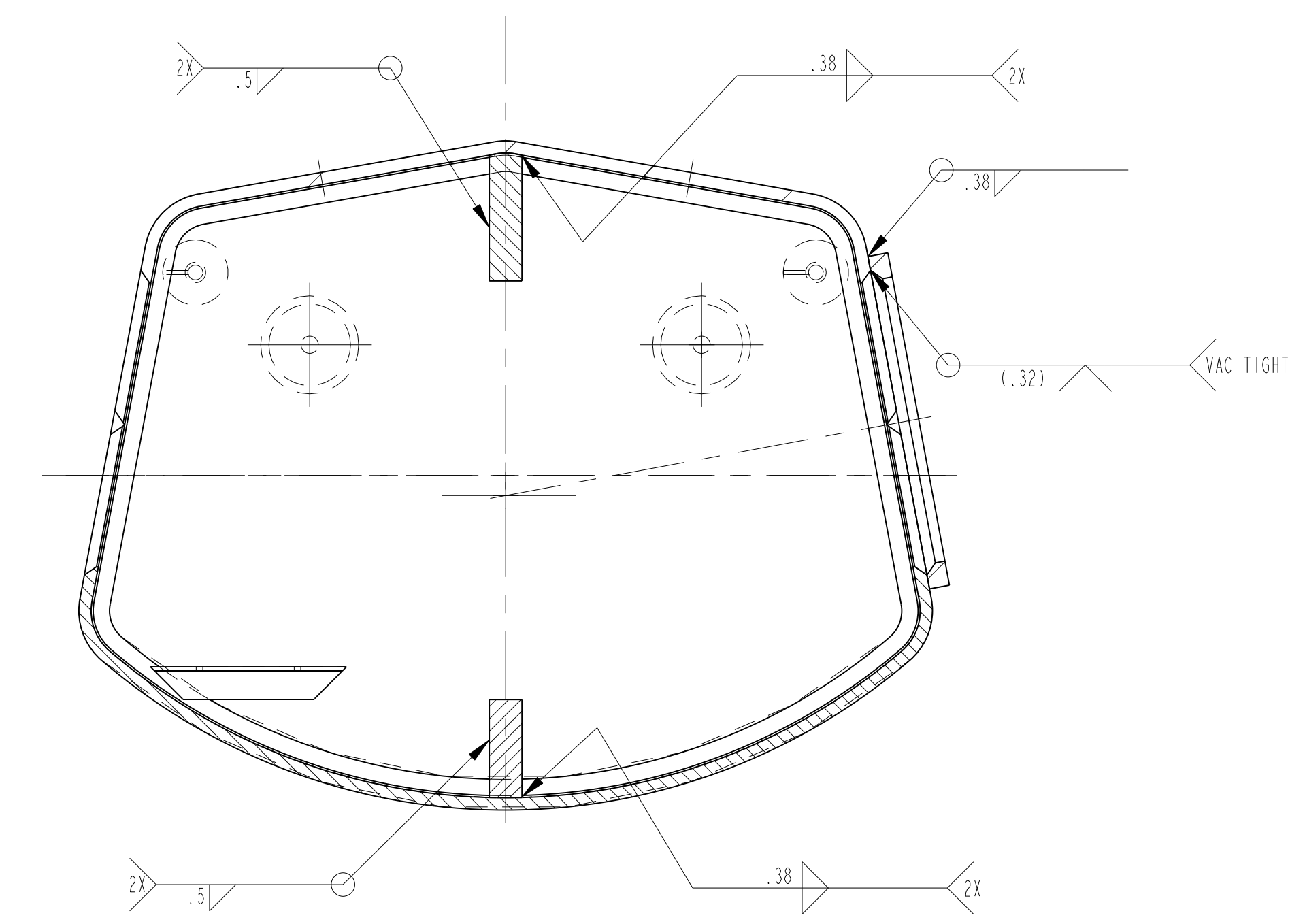
SECTION C-C  
SCALE 1/4  
VIEW ROTATED 180°



SECTION A-A

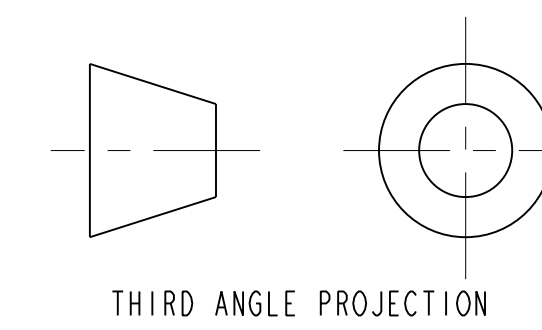


SECTION H-H



SECTION B-B

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY			
UNIVERSITY OF CALIFORNIA BERKELEY			
LHC IR FEEDBOX CRYOGENICS			
LIQUID HELIUM TANK - 8 PORT RIGHT			
MICROFILMED:	DWG. TYPE	SCALE	DO NOT LOCK PRINTS
	ASSEM	1/4	
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.
	Z5LCE2	LH2003	2515746
SHEET 2 OF 4		SIZE	REV
		A	A



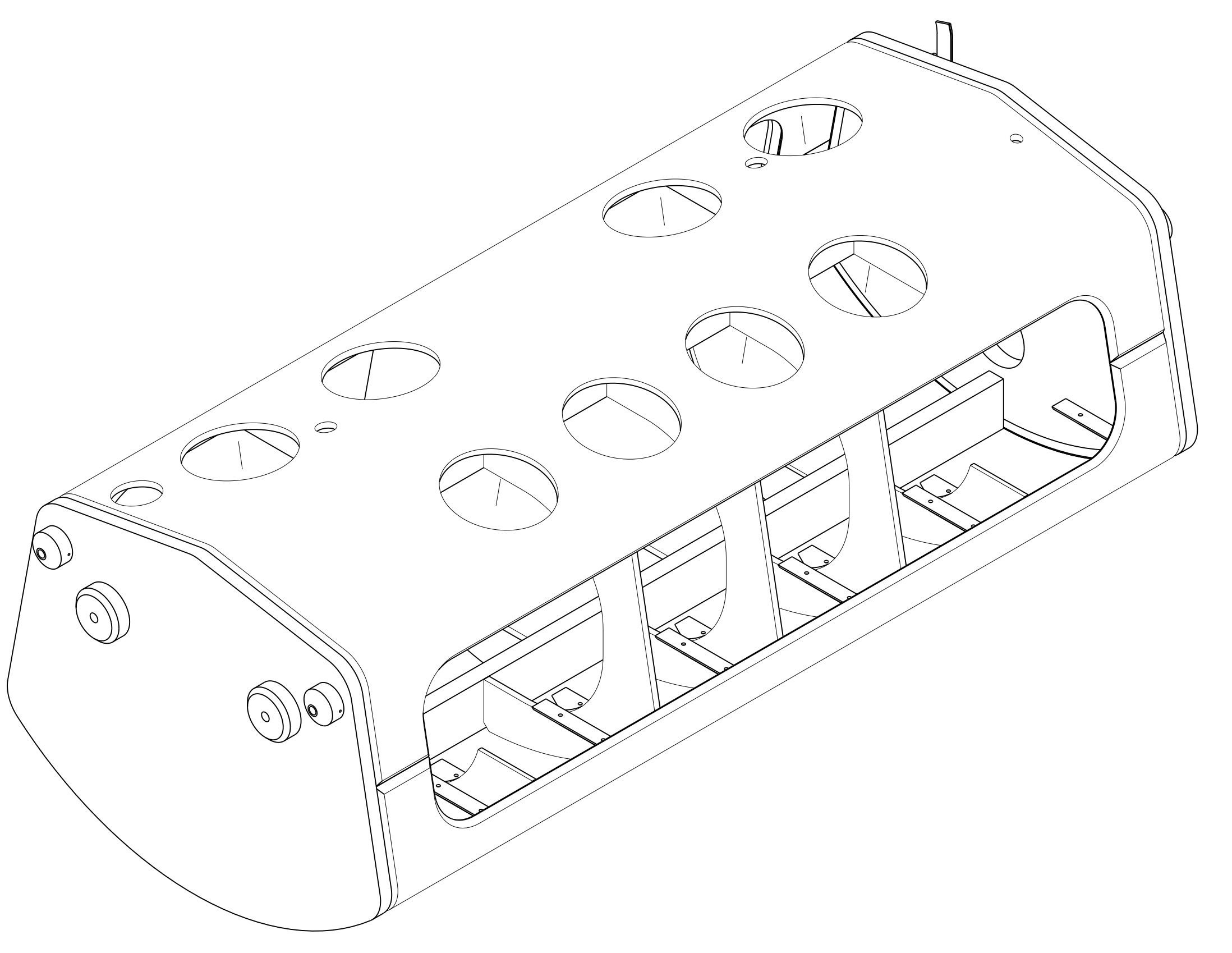
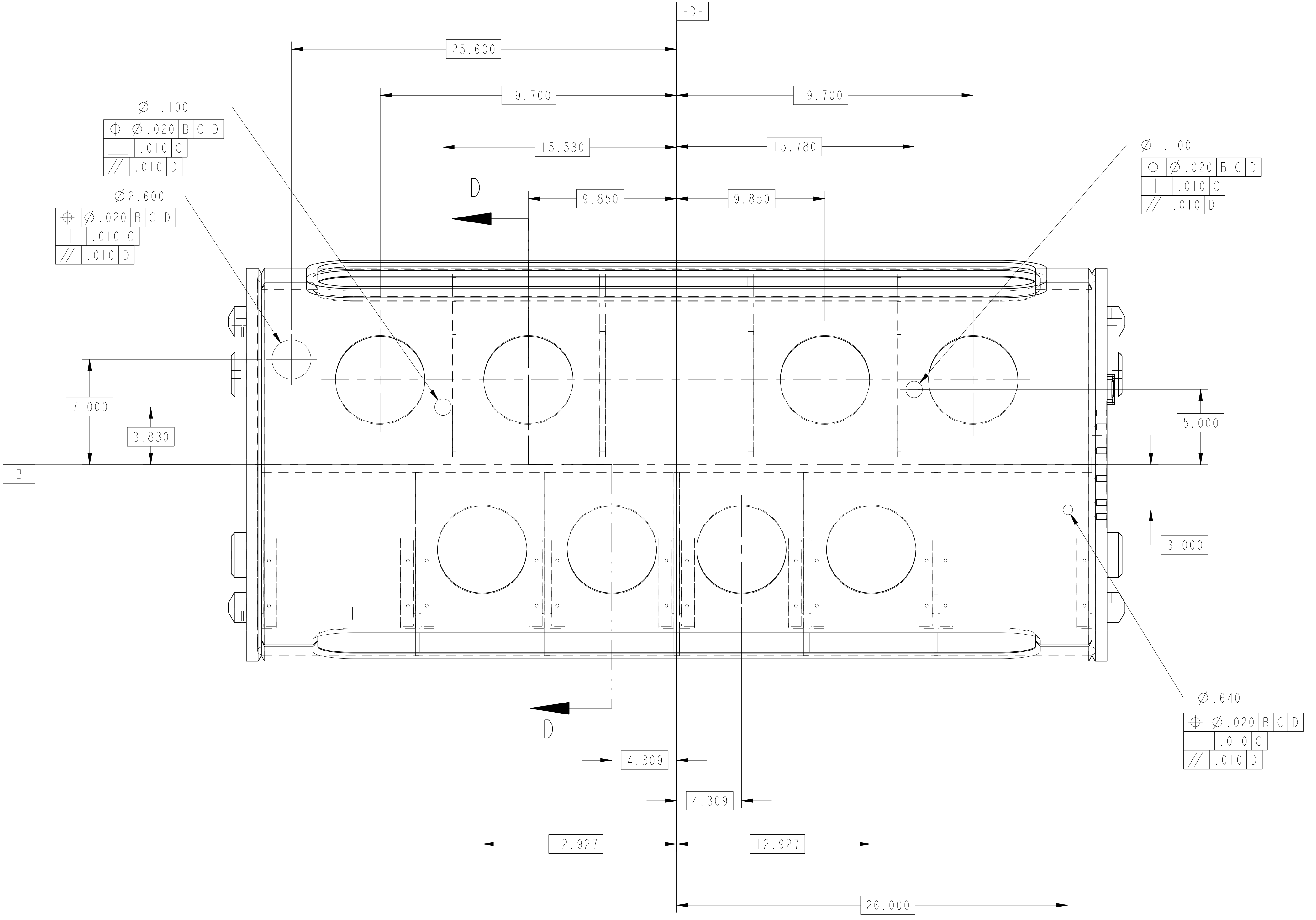
THIRD ANGLE PROJECTION

8 7 6 5 4 3 2 1

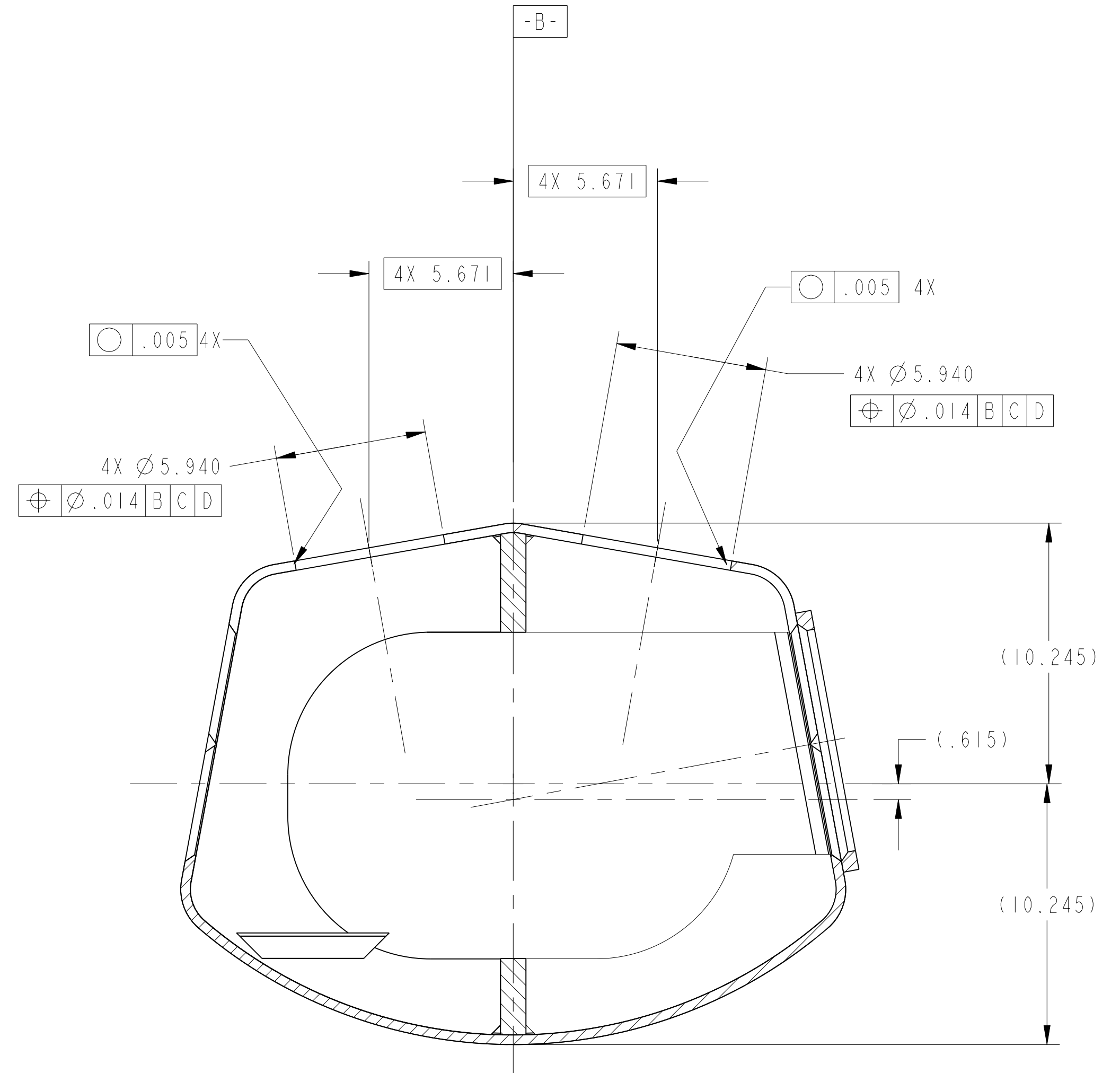
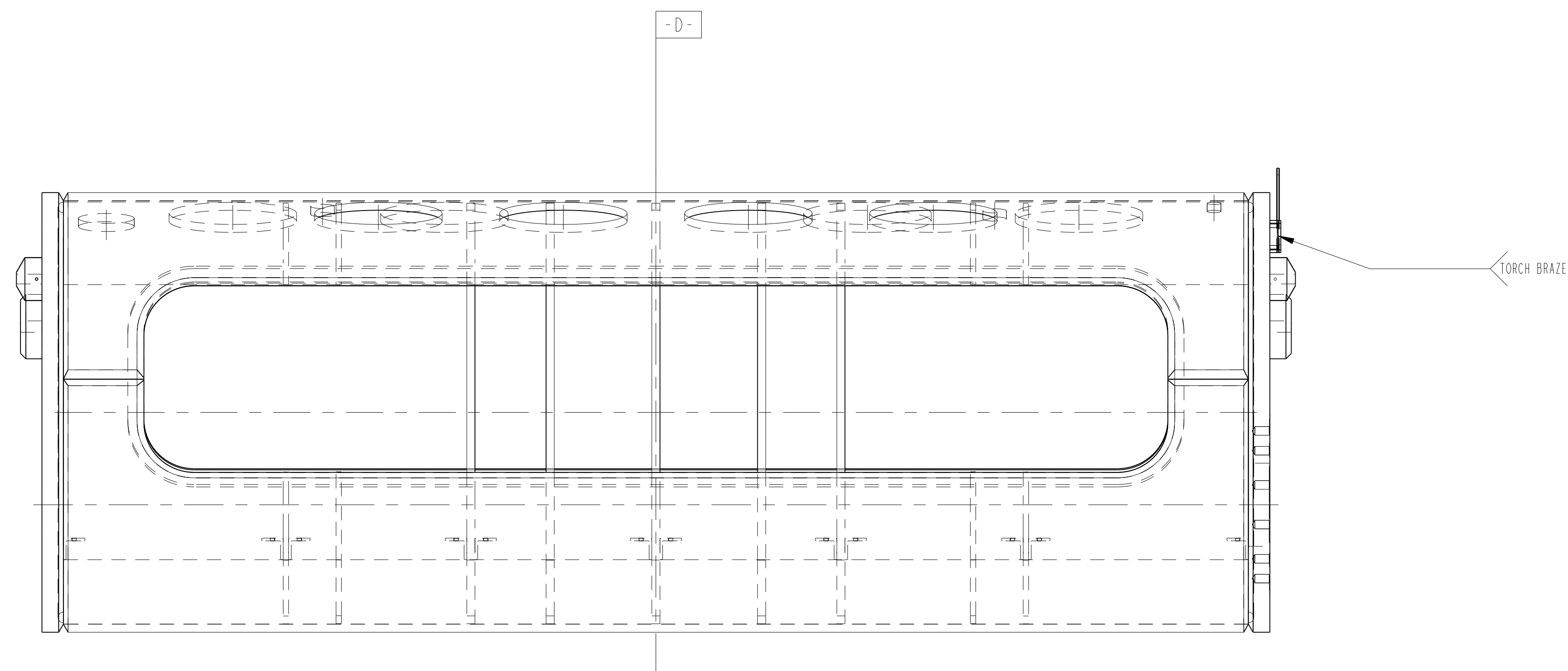
NAME: ARHARRIS OBJECT: 2515746 DATE: 04-Dec-02 09:22:12

2515746 A 2

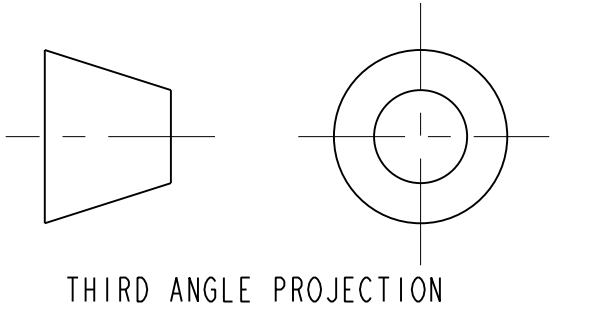
8 7 6 5 4 3 2 1



MACHINED STAGE



SECTION D-D



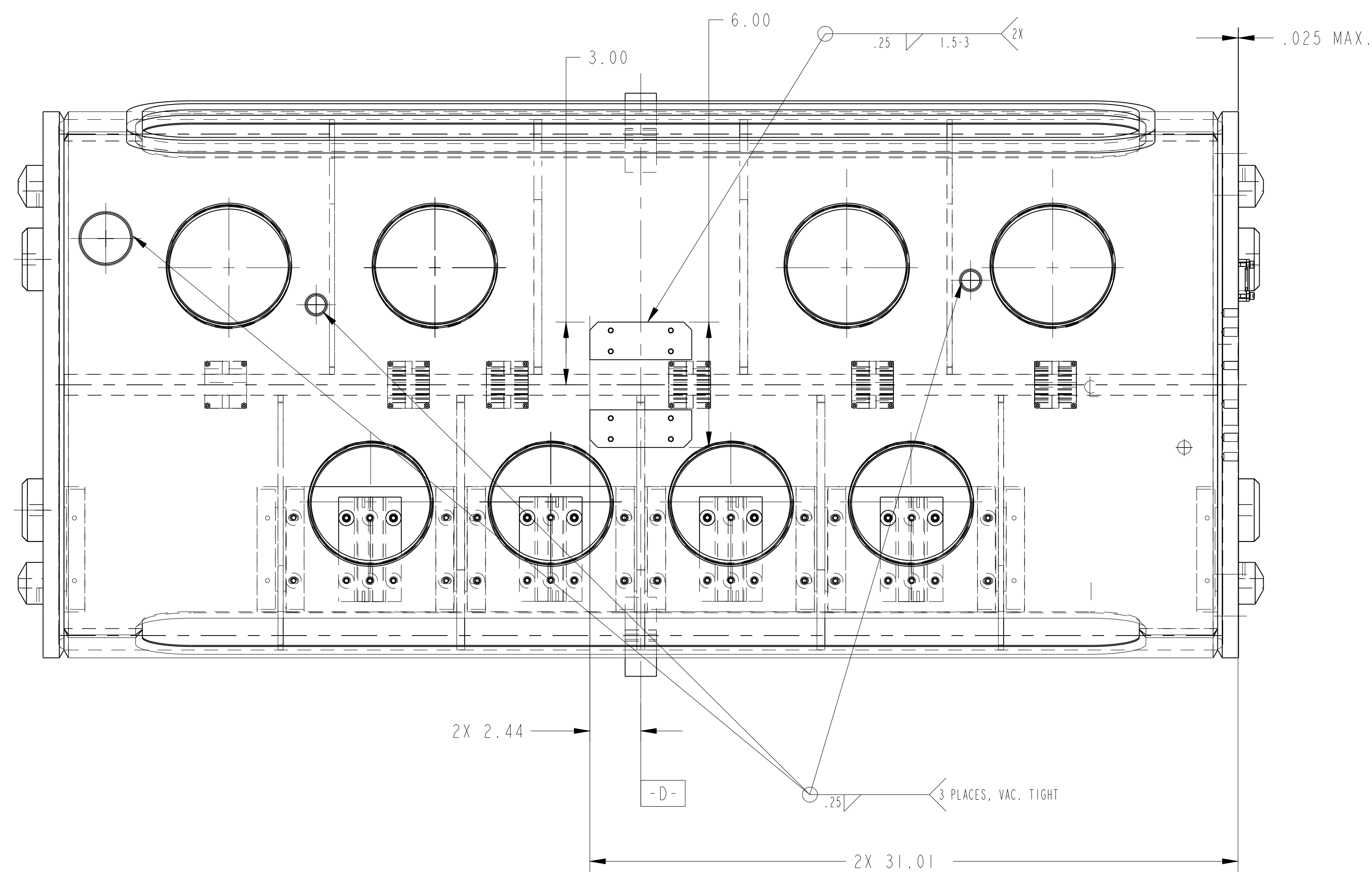
ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY			
UNIVERSITY OF CALIFORNIA BERKELEY			
LHC IR FEEDBOX CRYogenics			
LIQUID HELIUM TANK - 8 PORT RIGHT			
DESIGNED BY	SCALE	DATE	DO NOT SCALE PRINTS
ASSEM	1/4		
SHEET 3 OF 4		SIZE A	
PATENT CLEAR	REVISION NO.	CATEGORY CODE	DRWG. NO.
	Z5LCE2	LH2003	2515746

8 7 6 5 4 3 2 1

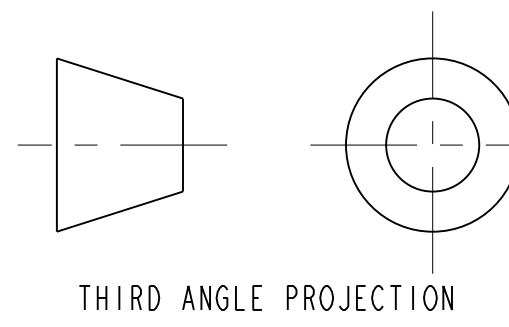
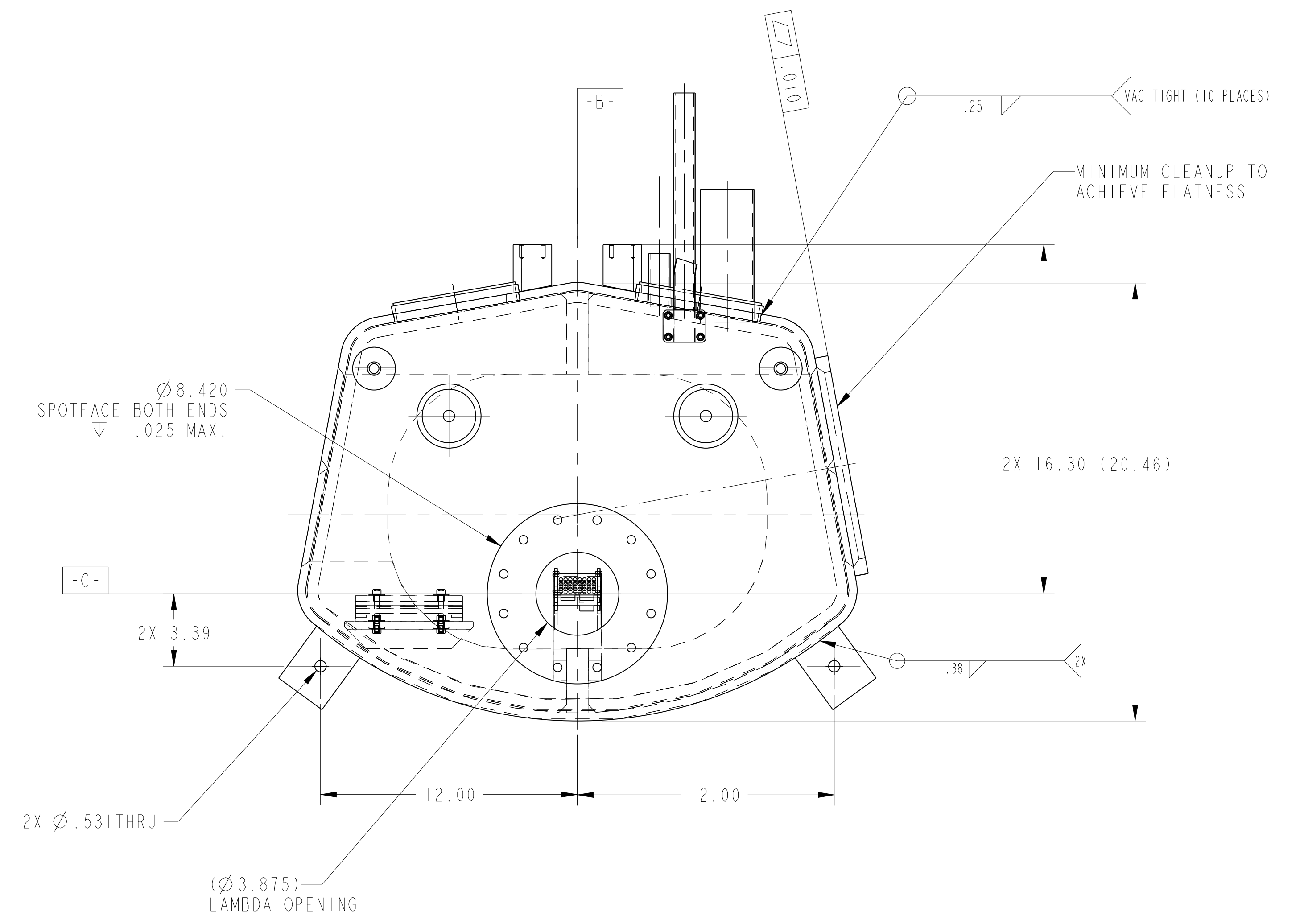
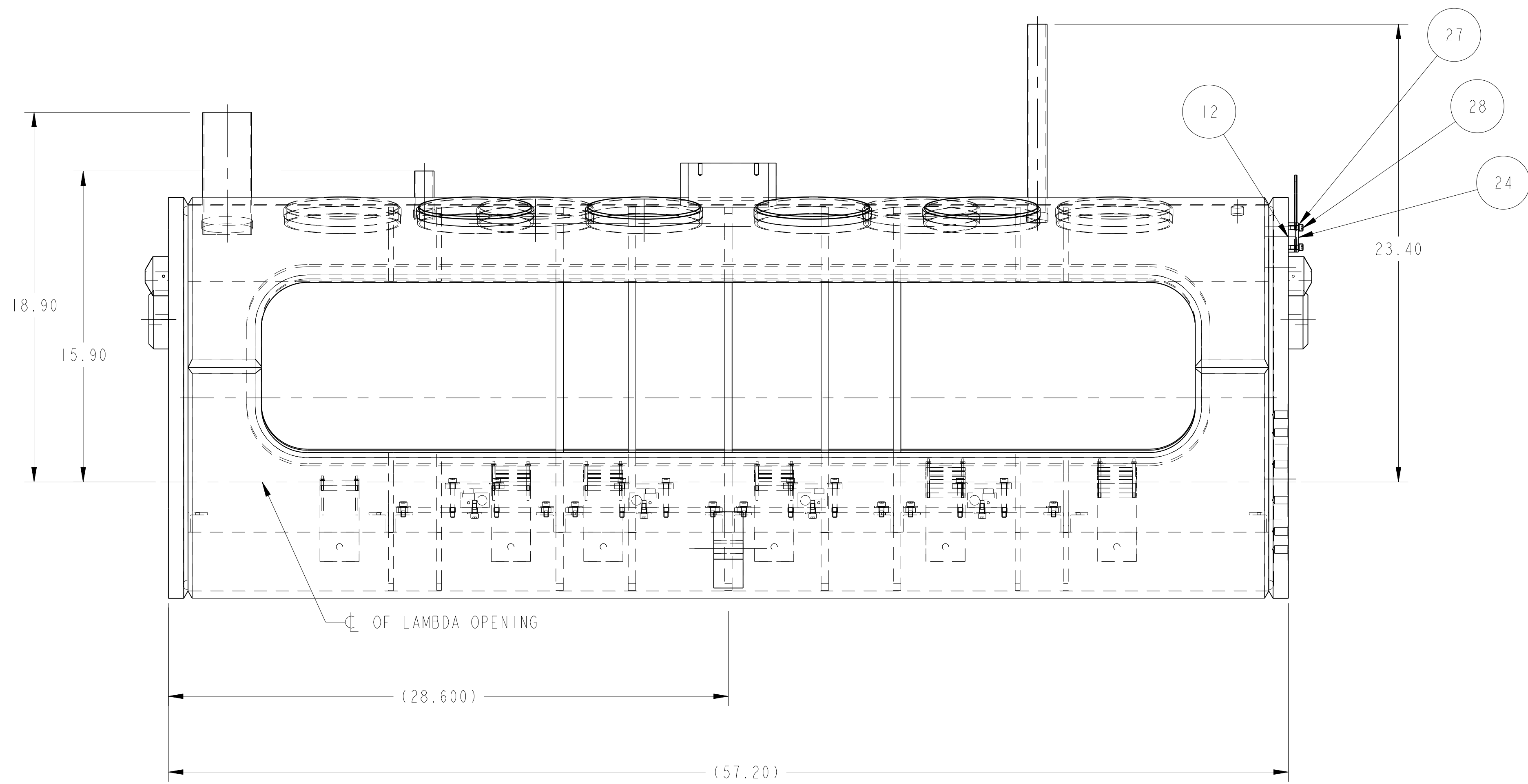
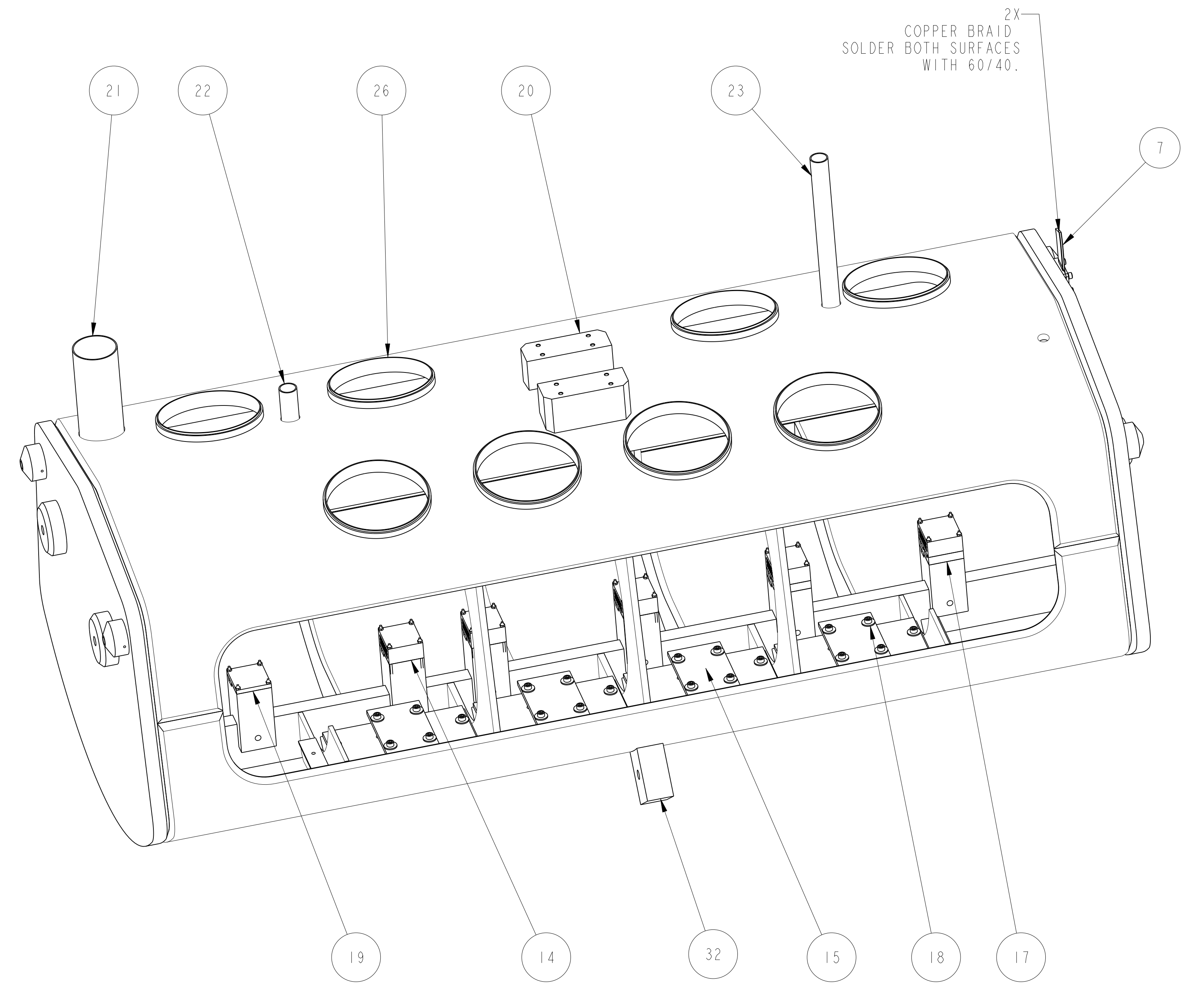
NAME: ARHARRIS OBJECT: 251574.3 DATE: 04-Dec-02 09:22:14

2515746 A 3

8 7 6 5 4 3 2 1



FINAL WELDMENT & ASSEMBLY STAGE



ERNEST ORLANDO LAWRENCE  
BERKELEY NATIONAL LABORATORY  
UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX  
CRYogenics  
LIQUID HELIUM TANK - 8 PORT RIGHT

WROUGHT: DWG. TYPE: SCALE: 1/4 (DO NOT  
ASSEM. LUCKY PRINTS)  
PATENT CLEAR: DESIGN ACCT. NO. Z5LCE2 CATEGORY CODE LH2003 DWG. NO. 2515746 SIZE: REV. 4 A

8 7 6 5 4 3 2 1

NAME: ARHARRIS OBJECT: 251574\_4 DATE: 04-Dec-02 09:22:16

2515746 A 4