

FLANGE TO BE WELDED AFTER ASSEMBLY INTO TOP PLATE
 (3 EQUAL SPACE 25.85) [656.7]
 NOTE 2
 INTERMITTENT .06/.51
 .07

SECTION A-A
 SCALE 1/1

DETAIL C
 SCALE 3/4
 WELD STUB Ø.5 [13] TUBE X .065 [1.65] WALL NOT TO PROTRUDE INTO ID OF RECEIVING PIPE

19.8 [503]
 16.76 [425.6] INSTALLED LENGTH
 16.76 [425.6] ORL FLANGE
 14
 15
 33.91 [861.2]

DETAIL B
 SCALE 1/2

Ø.866 [22] TUBE X .039 [1] WALL

- 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.
 - 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".
 - 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.
 - PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
 - CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
 - INSTALL TEMPERATURE SENSOR PER LHC SPECIFICATION LHC-QIT-ES-0002. SENSOR TO BE PROVIDED BY LBNL.
 - ALL PIPES TO BE INSULATED PER MLI SPECIFICATION PROVIDED BY VENDOR AND SUBJECT TO LBNL APPROVAL. IN LOCATIONS WHERE PIPES PASS THROUGH SUPPORT ASSEMBLIES, INSULATION IS TO BE WRAPPED WITH KAPTON TAPE FOR PROTECTION FROM ABRASION DURING THERMAL CYCLING.

ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
20	-	4	TUBE, PER ASTM A269	SS 304L
19	-	1	TUBE, PER ASTM A269	SS 304L
18	25M856	1	PIPE HANGER	SS 304L
17	-	1	HTS MANIFOLD HEADER, SS TUBING	SS 304L
16	-	1	TUBE, PER ASTM A269	SS 304L
15	-	1	TUBE, PER ASTM A269	SS 304L
14	-	1	Ø 5/16" X 1/16" FLAT PLATE ORIFICE	SS 304L
13	-	3	TUBE, PER ASTM A269	SS 304L
11	-	1	HTS MANIFOLD PIPE CAP	SS 304L
9	-	4	BRAIDED FLEX HOSE, 1/2" ID X 2.3" LL	SS 300 SERIES
3	-	1	2-3/4 CONFLAT, MDC 110012	SS 304L
2	-	1	BRAIDED FLEX HOSE, 1" ID X 5" LL	SS 300 SERIES
1	-	1	CERNOX, TEMP SENSOR	

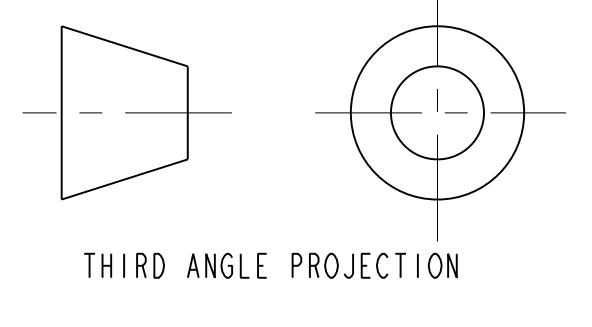
REV	DATE	BY	CHK	ZONE	DATE	CHANGES
A	11/18/02	JDR	SPV			INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED
 TOLERANCES: X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.0°
 X.XXX ± 0.010 FINISH: 125 µm
 DO NOT SCALE PRINT
 THREADS ARE CLASS 2
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 CUT ROUNDS, 1/8" THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES .016 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.5M-1994

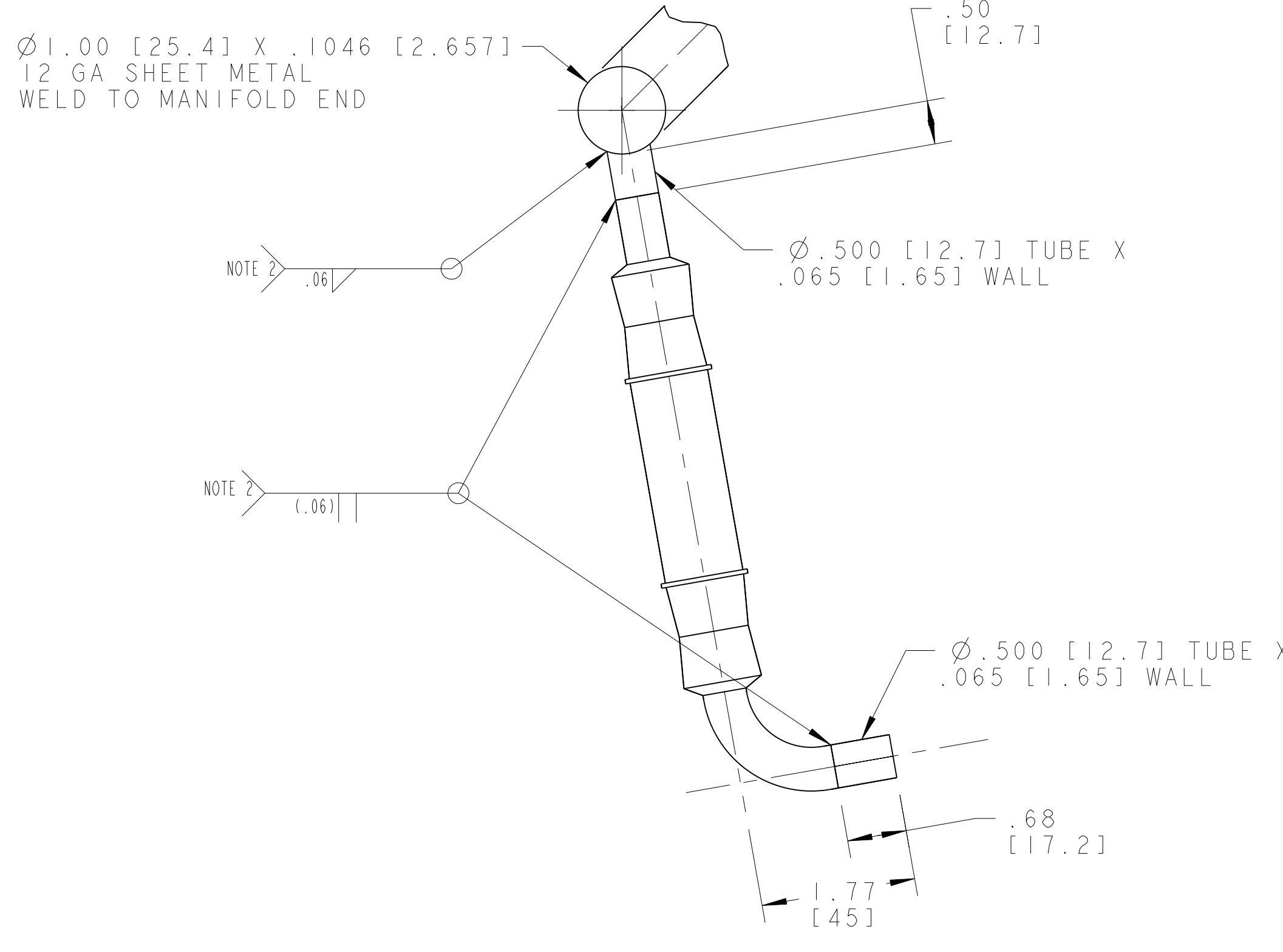
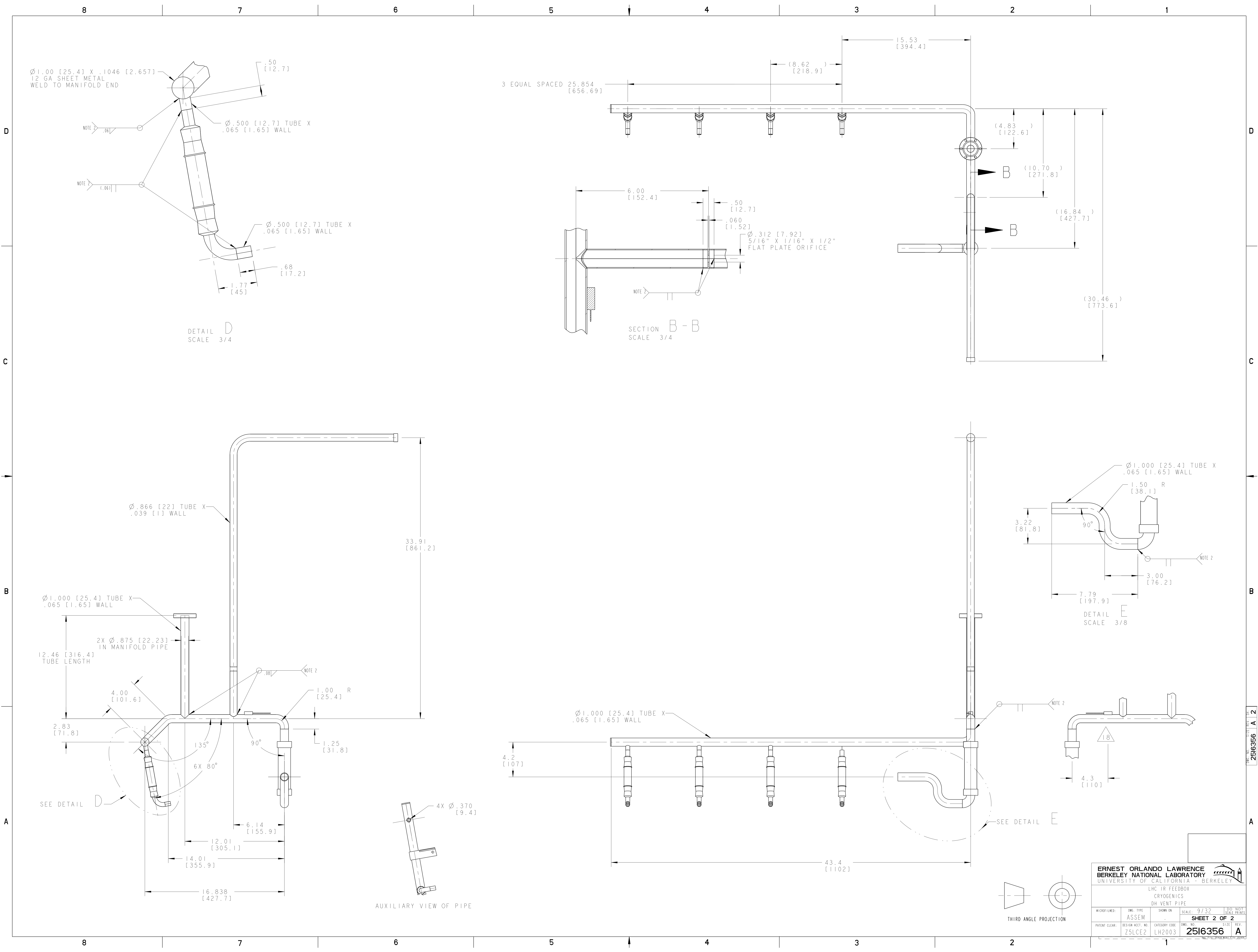
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 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 DH VENT PIPE

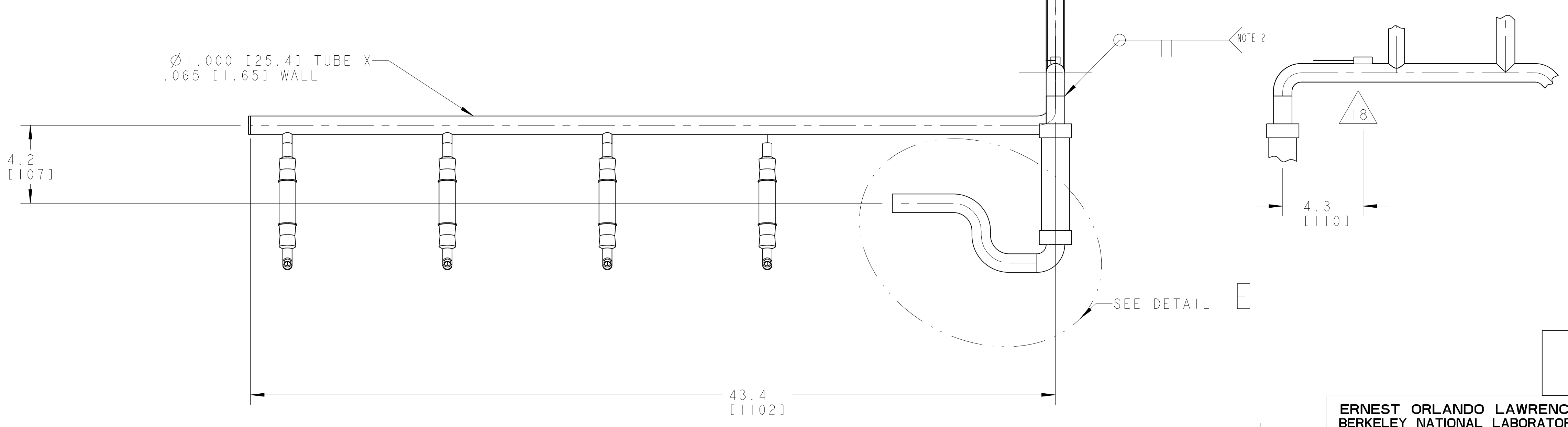
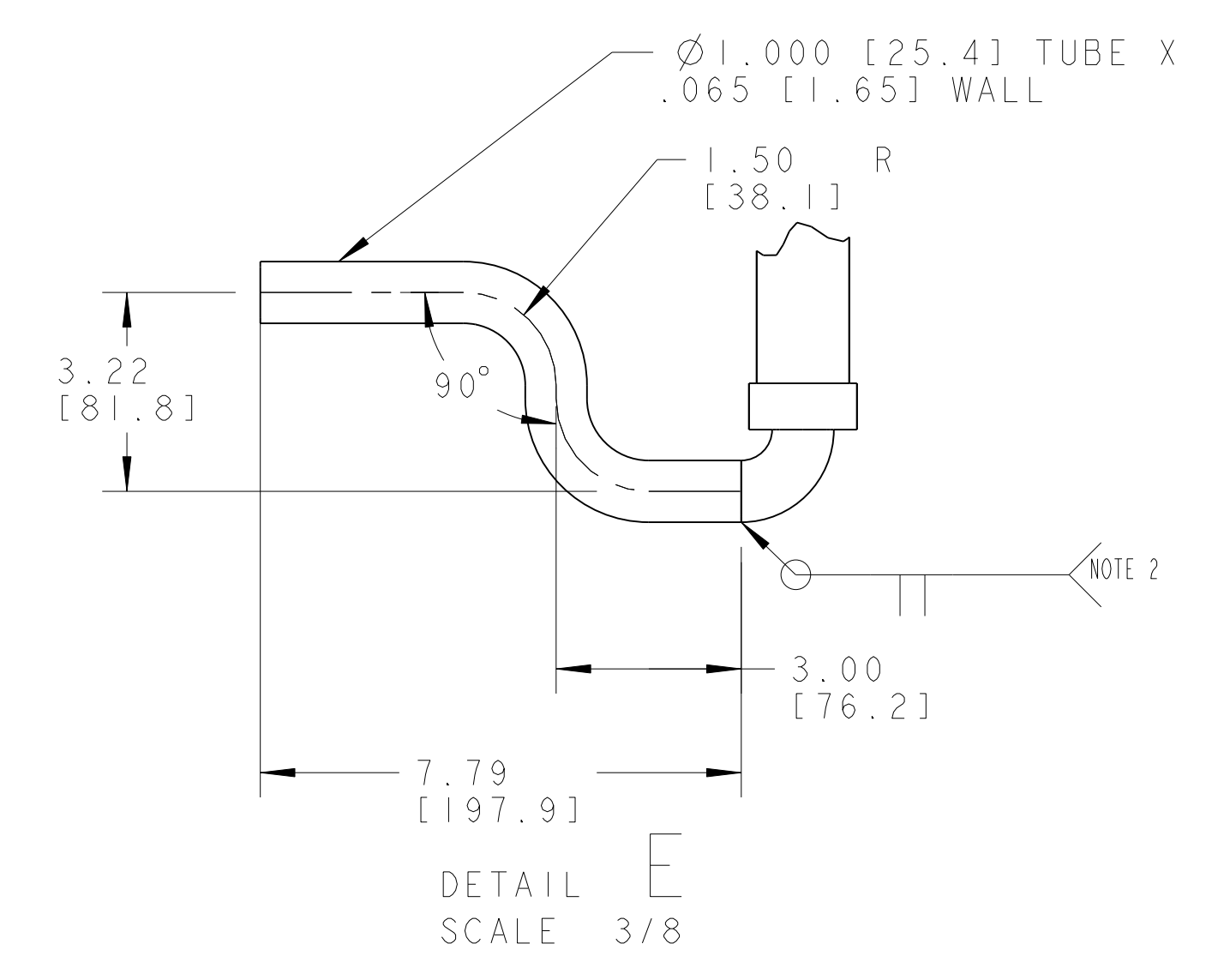
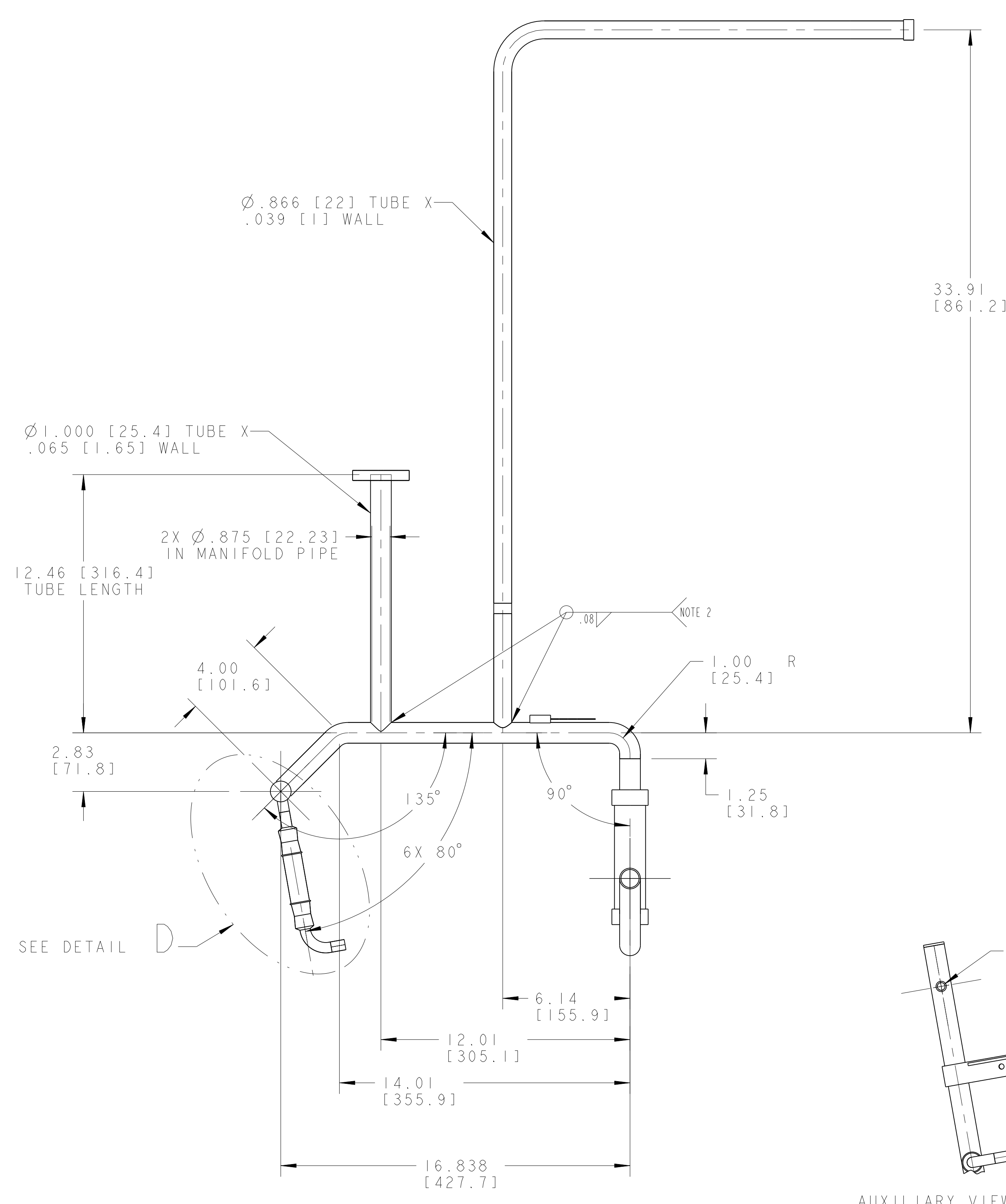
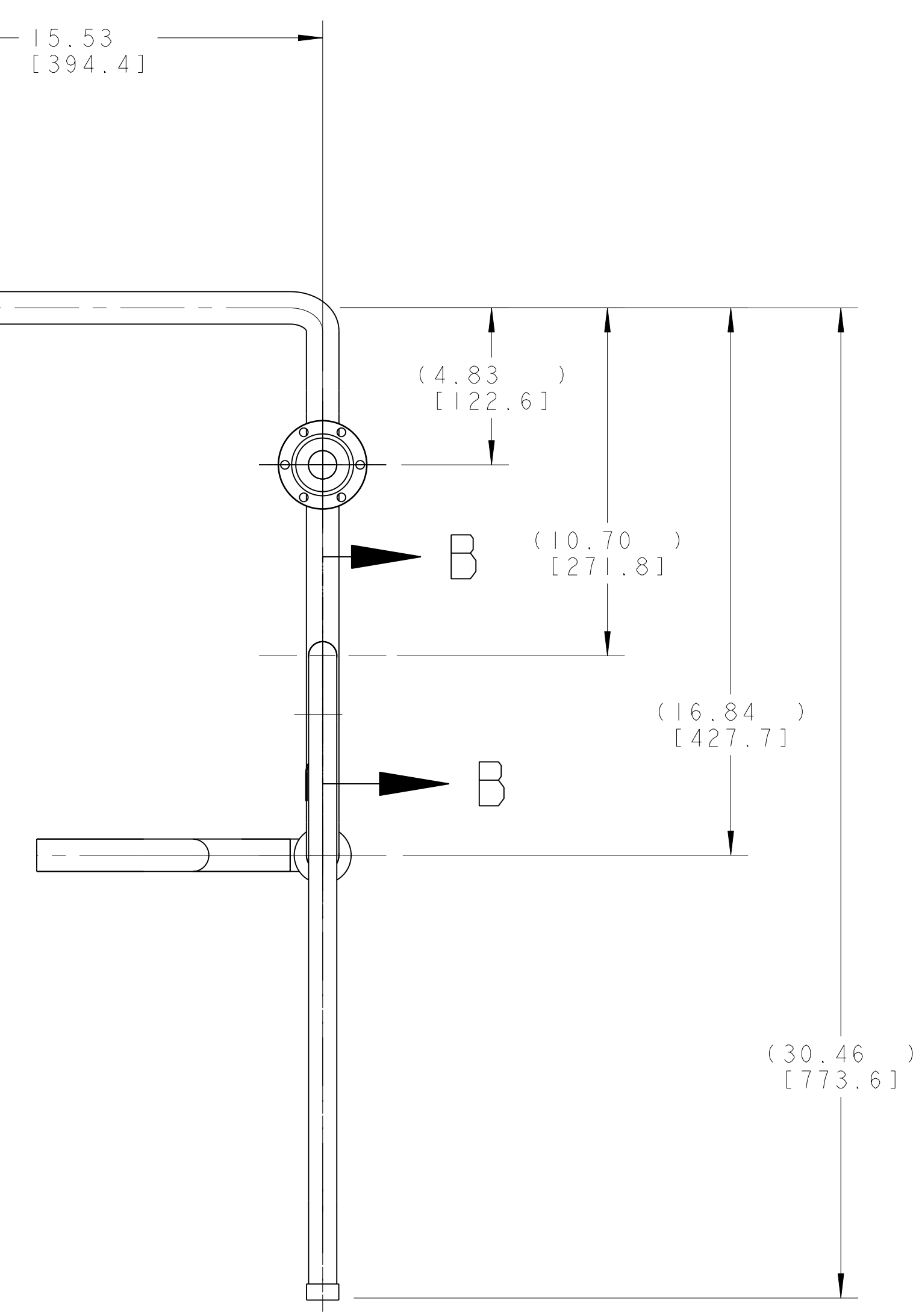
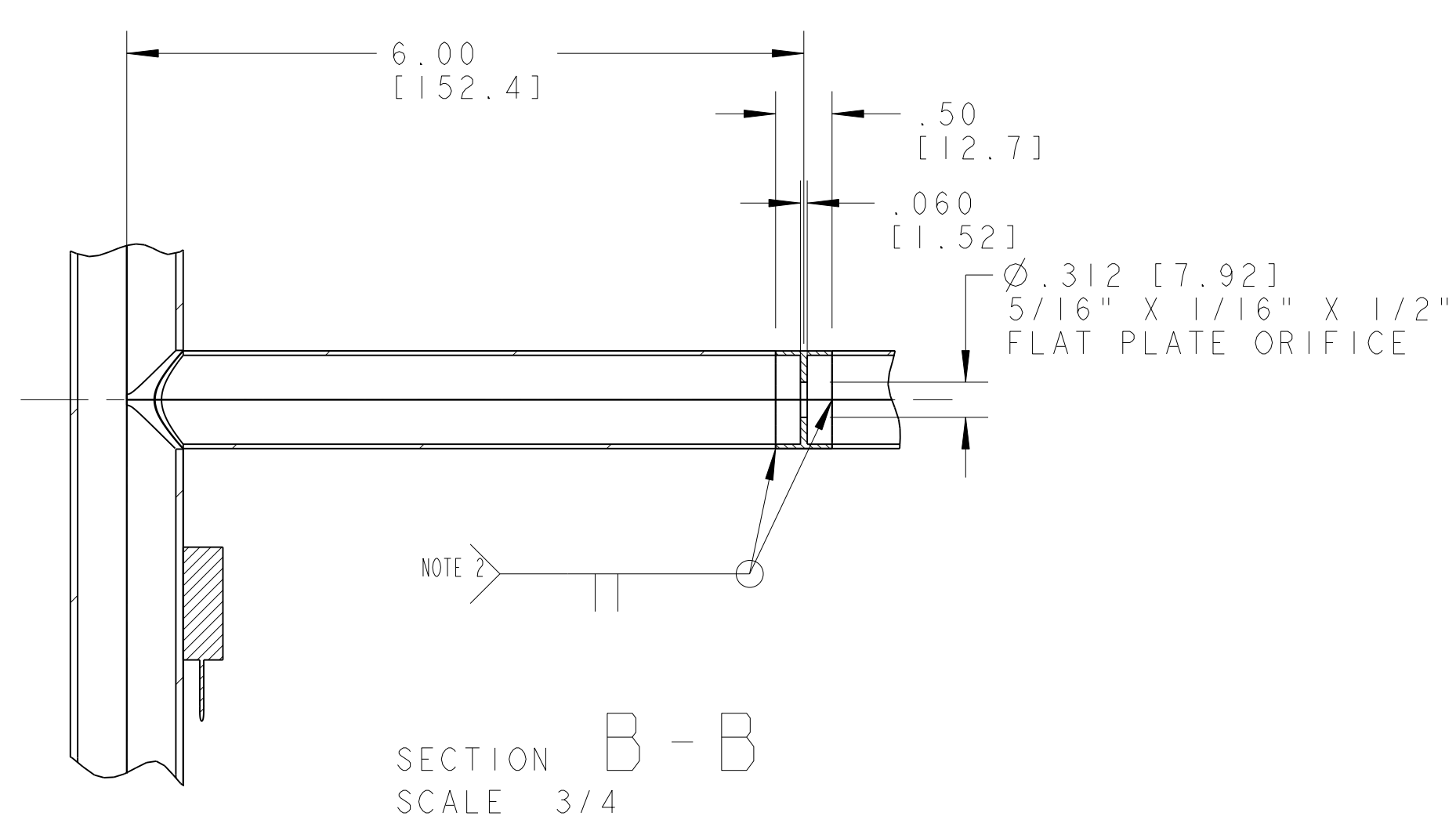
SCALE: 1/4
 SHEET 1 OF 2
 DWG. NO. 2516356
 DATE: 25-JUL-02



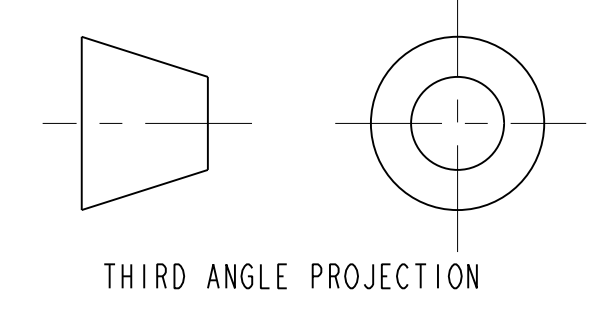
2516356 A 1



DETAIL D
 SCALE 3/4



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LHC IR FEEDBOX CRYOGENICS DH VENT PIPE			
MICROFILMED:	DWG. TYPE:	SHOWN ON:	SCALE:
	ASSEM		9/32
SHEET 2 OF 2			DO NOT SCALE PRINTS
PATENT CLEAR:	DESIGN ACCT. NO:	CATEGORY CODE:	DWG. NO.:
	ZSLCE2	LH2003	2516356
			SIZE: REV.:
			A



DWG. NO. 2516356