

FLANGE TO BE WELDED AFTER ASSEMBLY INTO TOP PLATE

INTERMITTENT .06 / .5-1

.07

NOTE 2

SECTION A-A
SCALE 1/1

WELD STUB Ø.5 [13] TUBE X .065 [1.65] WALL NOT TO PROTRUDE INTO ID OF RECEIVING PIPE

DETAIL C
SCALE 3/4

19.8 [503]

16.76 [425.6] INSTALLED LENGTH

16.76 [425.6] ORL FLANGE

(33.91) [861.2]

DETAIL B
SCALE 1/2

Ø.866 [22] TUBE X .039 [1] WALL

SEE DETAIL B

NOTES: (UNLESS OTHERWISE SPECIFIED)

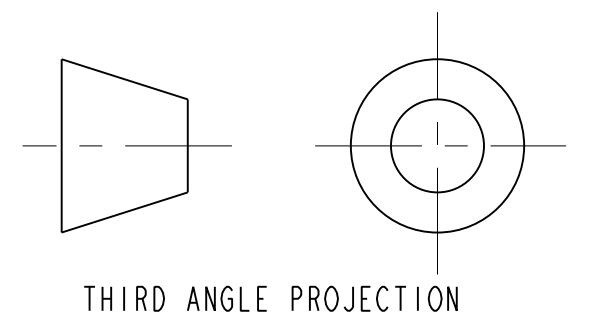
1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING 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.
18. INSTALL TEMPERATURE SENSOR PER LHC SPECIFICATION LHC-QIT-ES-0002. SENSOR TO BE PROVIDED BY LBNL.
19. 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	Ø5/16" 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	

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	DESCRIPTION	MATERIAL
TOLERANCES: X.X ± 0.1 FRACTION ± 1/64	NO		
X.XX ± 0.03 ANGLES ± 1.0°	NO		
X.XXX ± 0.010 FINISH: 125/32	NO		
DO NOT SCALE PRINT	NO		
THREADS: ALL CLASS 2	NO		
CHAMFER ENDS OF ALL SCREW THREADS: 30°	NO		
BREAK EDGES: 0.16 MAX. ON MACHINED WORK	NO		
REMOVE BURRS, WELD SPATTER & LOOSE SCALE	NO		
IN ACCORDANCE WITH ASME Y14.5M-1982	NO		

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

DATE	BY	DESCRIPTION
12-MAY-02	ASSEM	ASSEMBLY
8-NOV-02	ASSEM	ASSEMBLY
25-JUL-02	ASSEM	ASSEMBLY

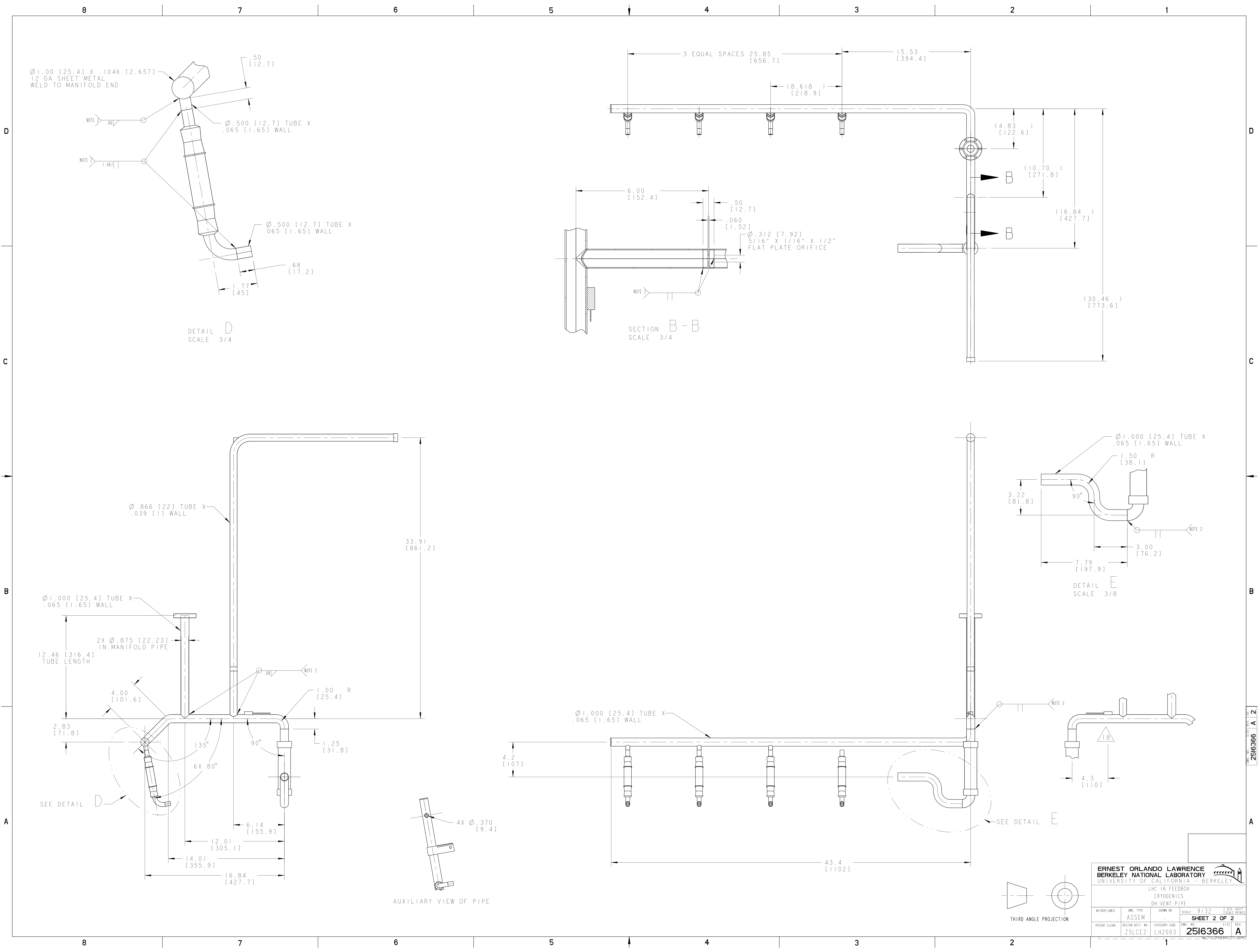


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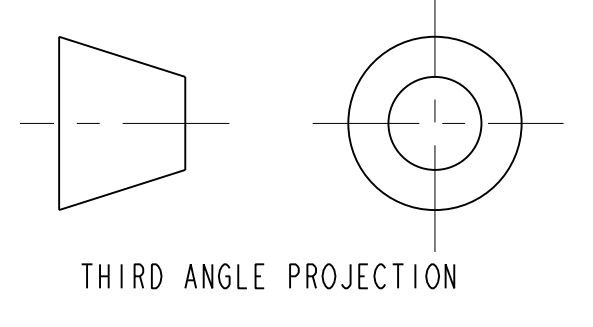
ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
CRYOGENICS
DH VENT PIPE

SCALE: 1/4
SHEET 1 OF 2
DWG. NO. 2516366
REV. A



ERNEST ORLANDO LAWRENCE UNIVERSITY OF CALIFORNIA - BERKELEY			
LHC IR FEEDBOX CRYOGENICS DH VENT PIPE			
MICROFILMED:	DWG. TYPE:	SHOWN ON:	SCALE:
	ASSEM		9/32
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE:	DWG. NO.
	ZSLCE2	LH2003	2516366
			DO NOT ENL. PRINTS
SHEET 2 OF 2			SIZE: REV.
			A



DWG. NO. 2516366 A 2