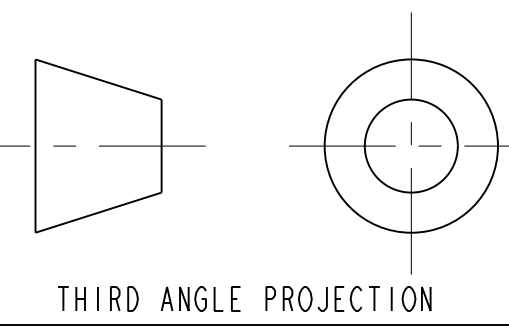


- NOTES: (UNLESS OTHERWISE SPECIFIED)
- THIS IS A CRYOGENIC VACUUM COMPONENT.
 - WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
 - CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
 - PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL 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 DEEDBOX 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.



REV	DATE	BY	CHK	ZONE	DATE	INITIAL RELEASE
A	10-29-02	ARH	SPV			CHANGES

UNLESS OTHERWISE SPECIFIED
 X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.00°
 X.XXX ± 0.010 FINISH 12.5
 DO NOT SCALE PRINT
 TOLERANCES AND CLASS 2
 CHAMFER ENDS OF ALL SCREW THREADS 30°
 BREAK EDGES - 1/16 MAX. ON MACHINED PARTS
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.3M & B.01

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
11	-	1	PIPE, PER ASTM A312	SS 304L
10	-	1	PIPE, PER ASTM A312	SS 304L
9	-	1	PIPE, PER ASTM A312	SS 304L
8	-	1	PIPE, PER ASTM A312	SS 304L
7	-	1	PIPE, PER ASTM A312	SS 304L
6	-	1	PIPE, PER ASTM A312	SS 304L
5	25H406	2	THRUST SUPPORT, BUS DUCT	SS 304L
4	-	2	WELD RING, 1D 75mm, FINAL SUPPLIED	SS 304L
3	-	1	BRAIDED FLEX HOSE, 1 1/2" ID X 5.5" LL	SS 300 SERIES
2	251307	4	FLANGE, FINALW 5520-MB-390033	SS 300 SERIES
1	-	4	BRAIDED FLEX HOSE, 1 1/2" ID X 4" LL	SS 300 SERIES

SHOP ORDERS

ITEM	DATE	BY	DESCRIPTION
1	24-01-02	ARH	PIPE WELDMENT, LD OQL / LD CROSSOVER
2	29-01-02	SPV	ASSEM
3	24-01-02	ARH	PIPE WELDMENT, LD OQL / LD CROSSOVER

ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX
 CRYOGENICS

PIPE WELDMENT, LD OQL / LD CROSSOVER

SCALE: 1/4

SHEET 1 OF 1

25M9166 A

NAME: ARH:ARIS OBJECT: 25M916 DATE: 26-Nov-02 01:07:12

25M9166 A 1