

8

7

6

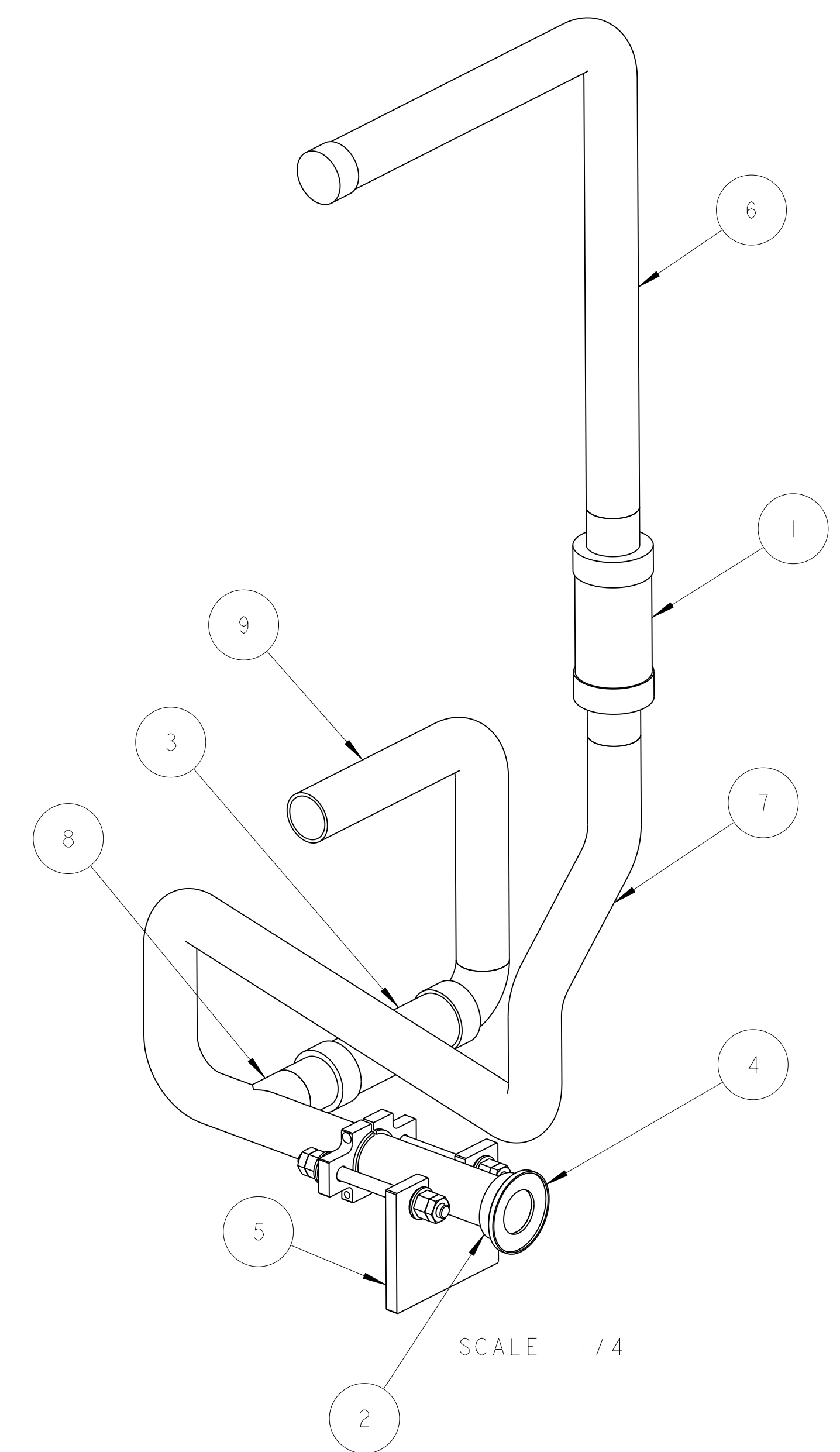
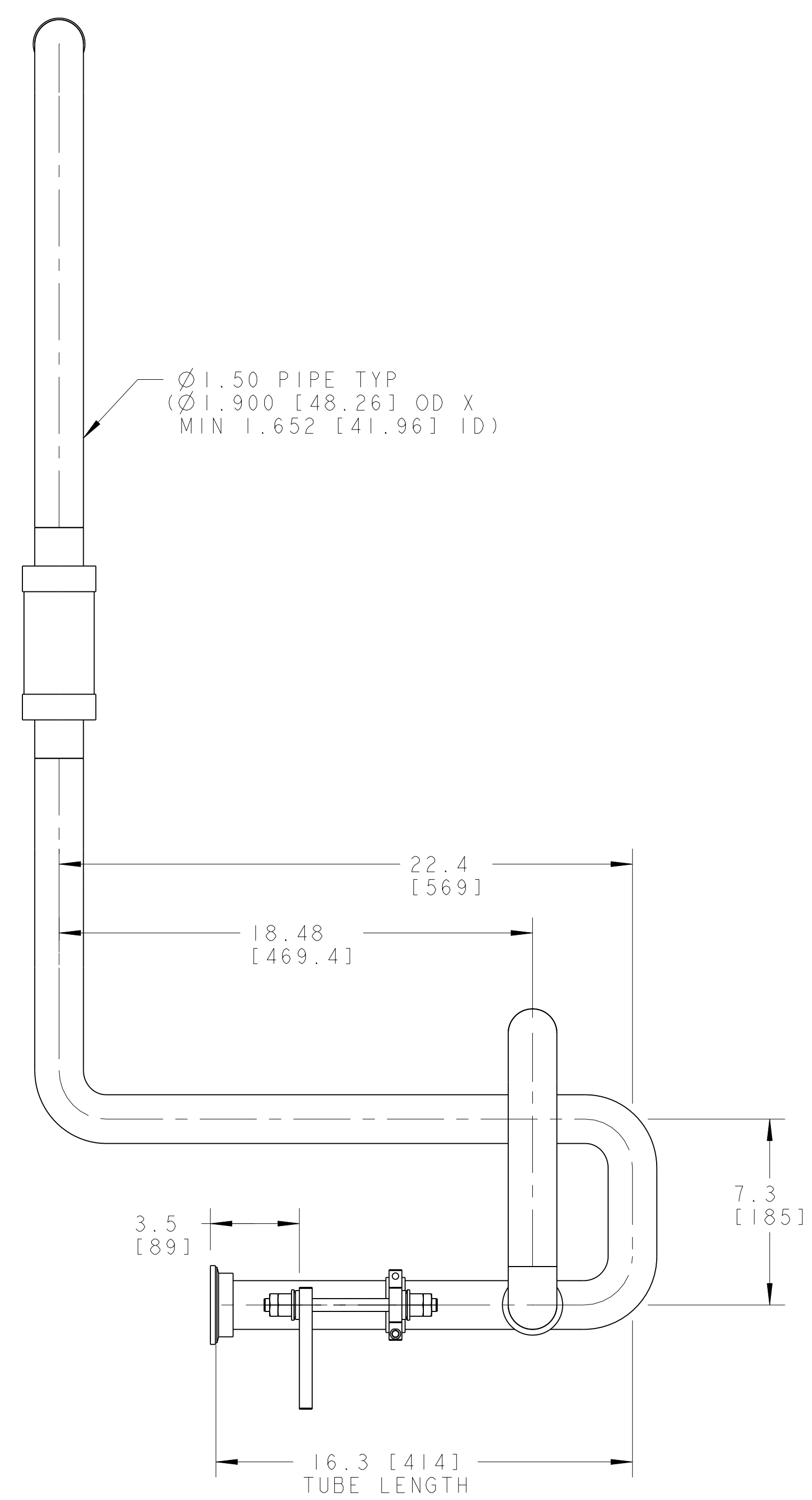
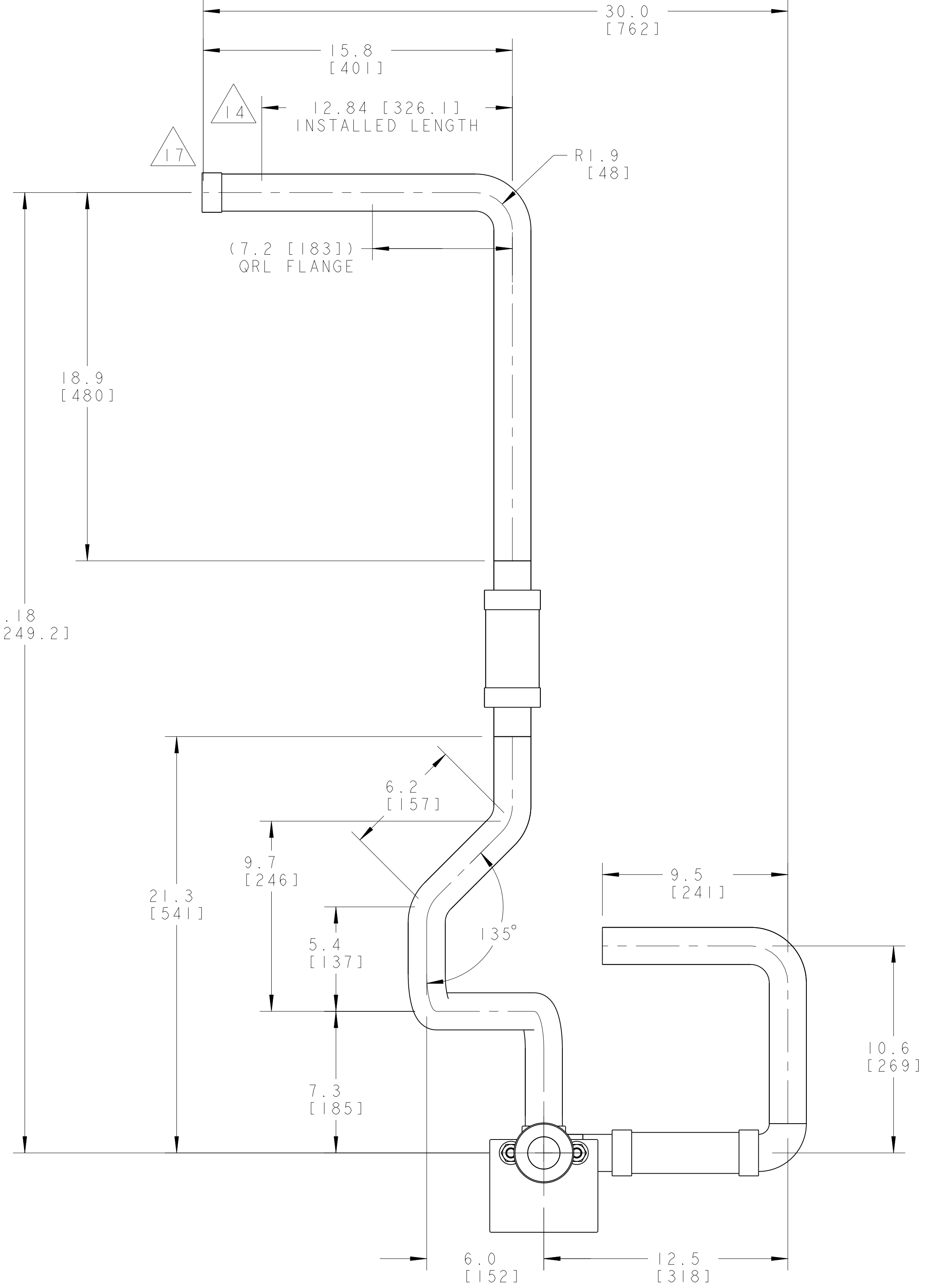
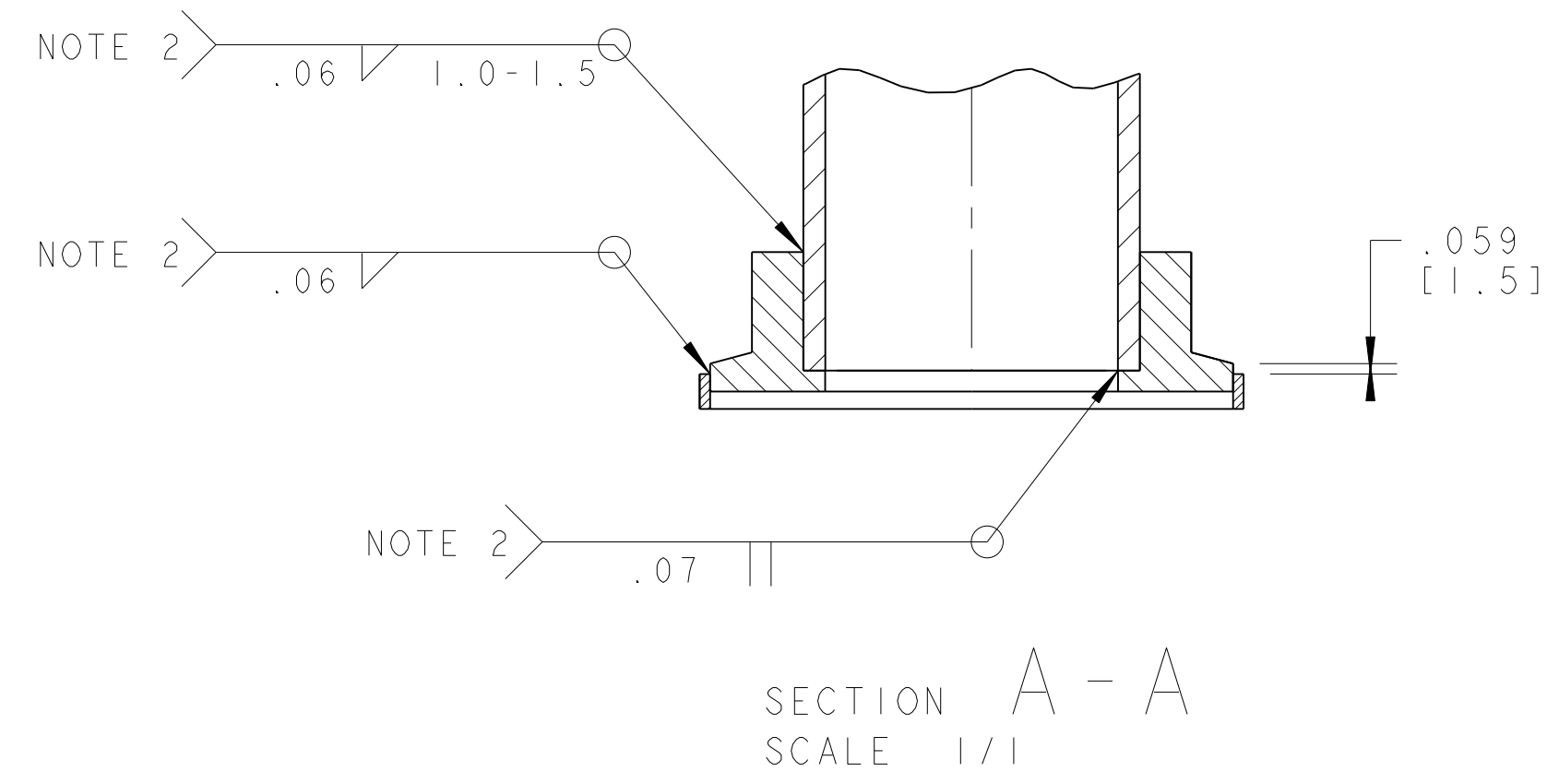
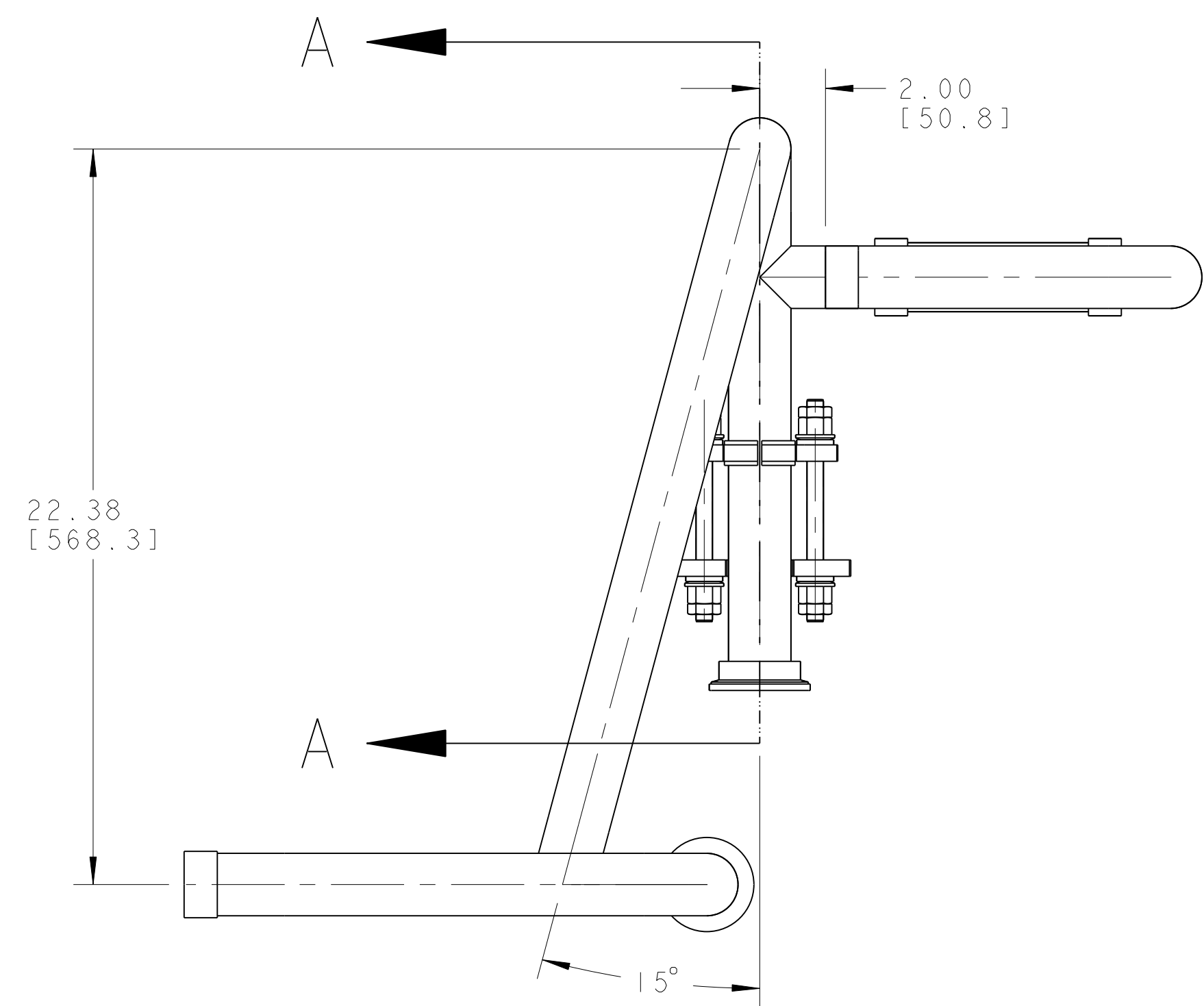
5

4

3

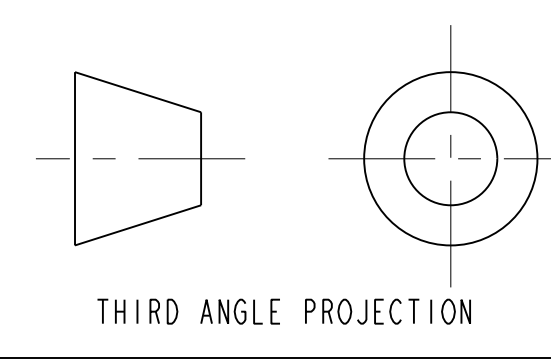
2

1



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.



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

INITIAL RELEASE 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 μm  
 DO NOT SCALE PRINT  
 DIMENSIONS ARE CLASS 2  
 CHAMFER ENDS OF ALL SCREEN THREADS 30°  
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS  
 BREAK EDGES .010 MAX. ON MACHINED WORK  
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE  
 IN ACCORDANCE WITH ASME B16.3 & B31.1

ITEM	PART NO.	REQD.	DESCRIPTION	MATERIAL
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	1	THRUST SUPPORT, BUS DUCT	SS 304L
4	-	1	WELD RING, ID 75mm, FINAL SUPPLIED	SS 304L
3	-	1	BRAIDED FLEX HOSE, 1 1/2" ID X 5.5" LL	SS 300 SERIES
2	251307	1	FLANGE, FINAL# 5520-MB-390033	SS 300 SERIES
1	-	1	BRAIDED FLEX HOSE, 1 1/2" ID X 4" LL	SS 300 SERIES

**ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY**  
 UNIVERSITY OF CALIFORNIA BERKELEY

LHC IR FEEDBOX CRYOGENICS  
 PIPE WELDMENT, LD ORL / LD CROSSOVER

ASSEM  
 PATENT CLEAR: REVIEW ACCT. NO. Z5LCE2  
 CATEGORY CODE LH2003

SCALE: 1/4  
 SHEET 1 OF 1  
 SIZE: A

NAME: ARHARRIS OBJECT: 25M917 DATE: 08-Nov-02 14:09:34

25M9176 A 1