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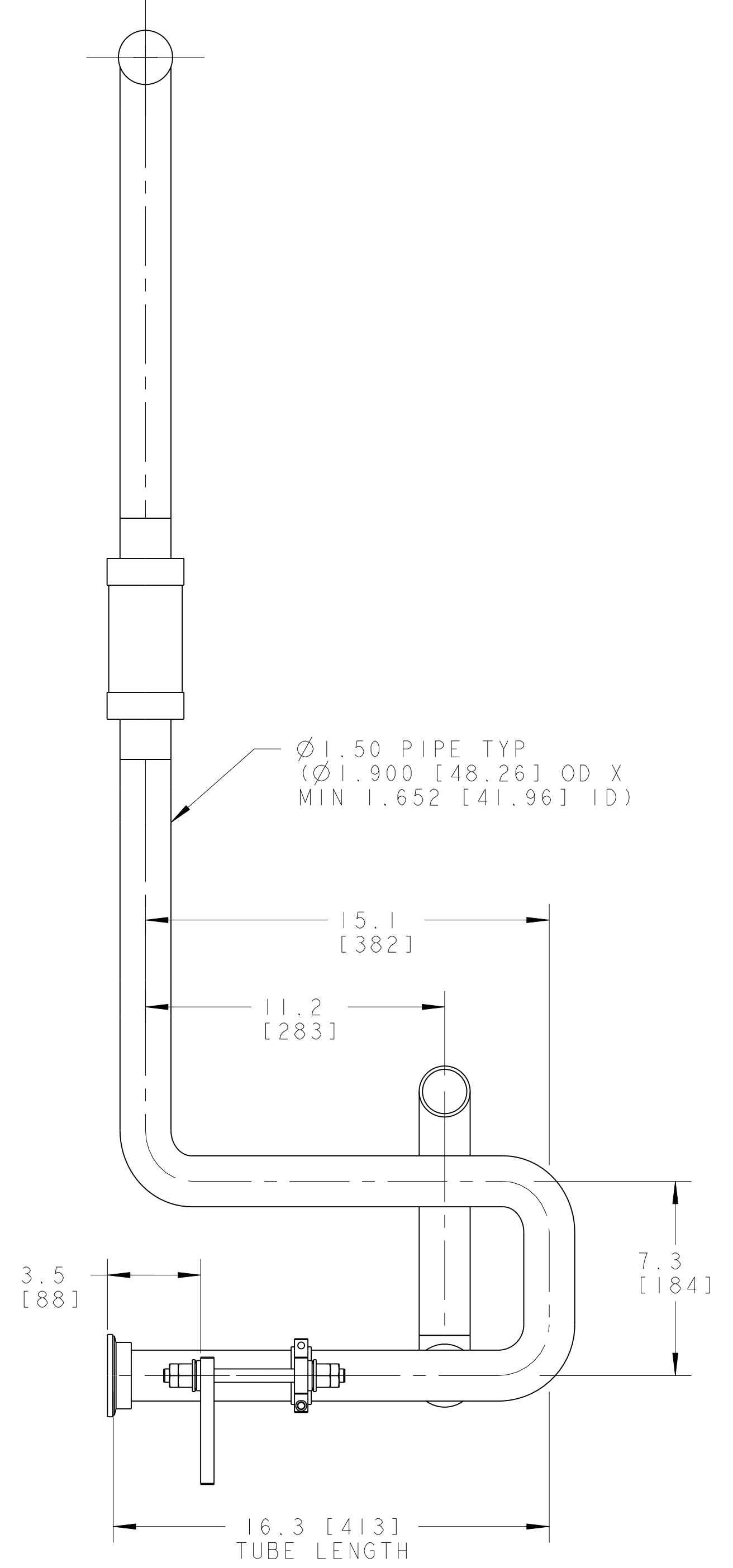
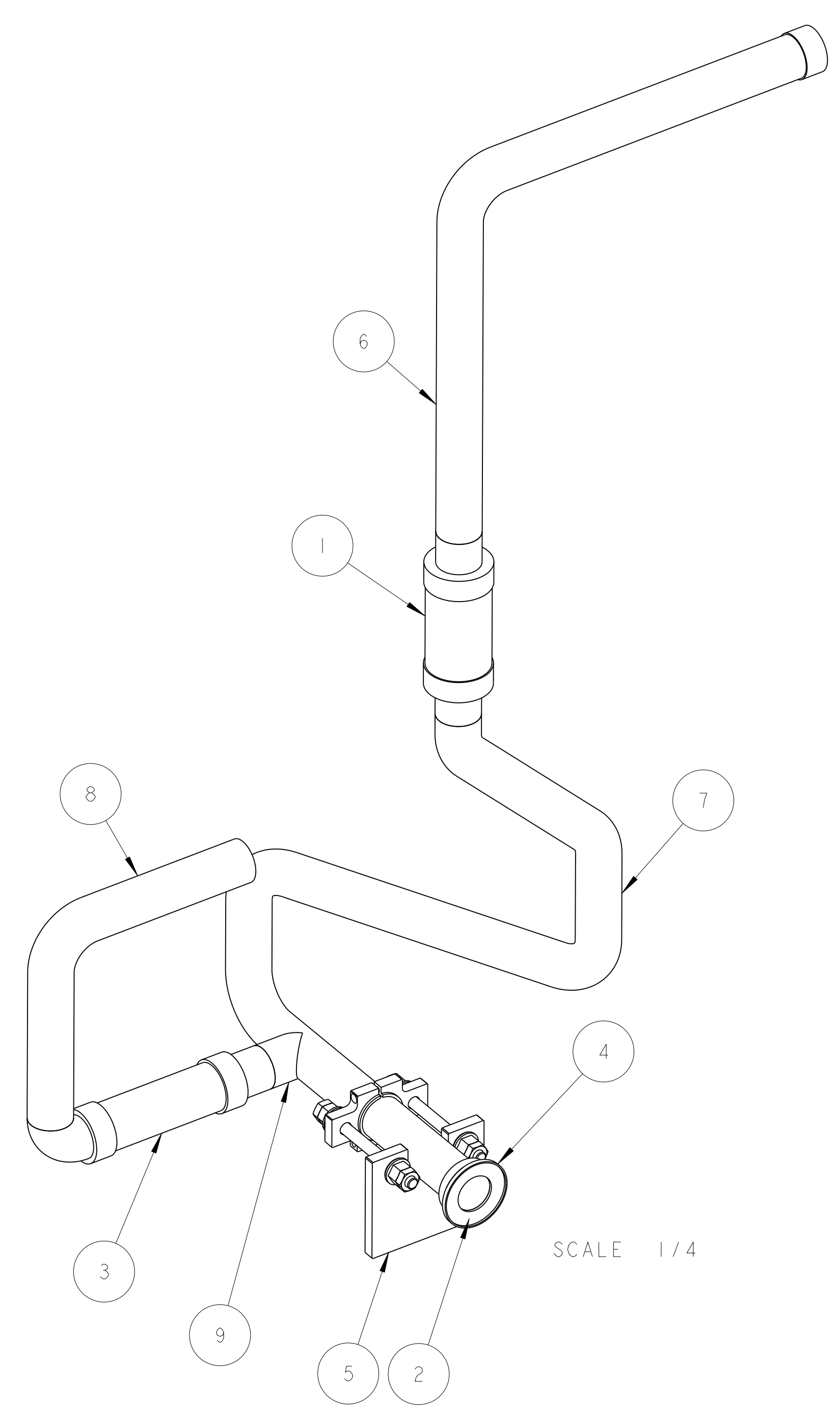
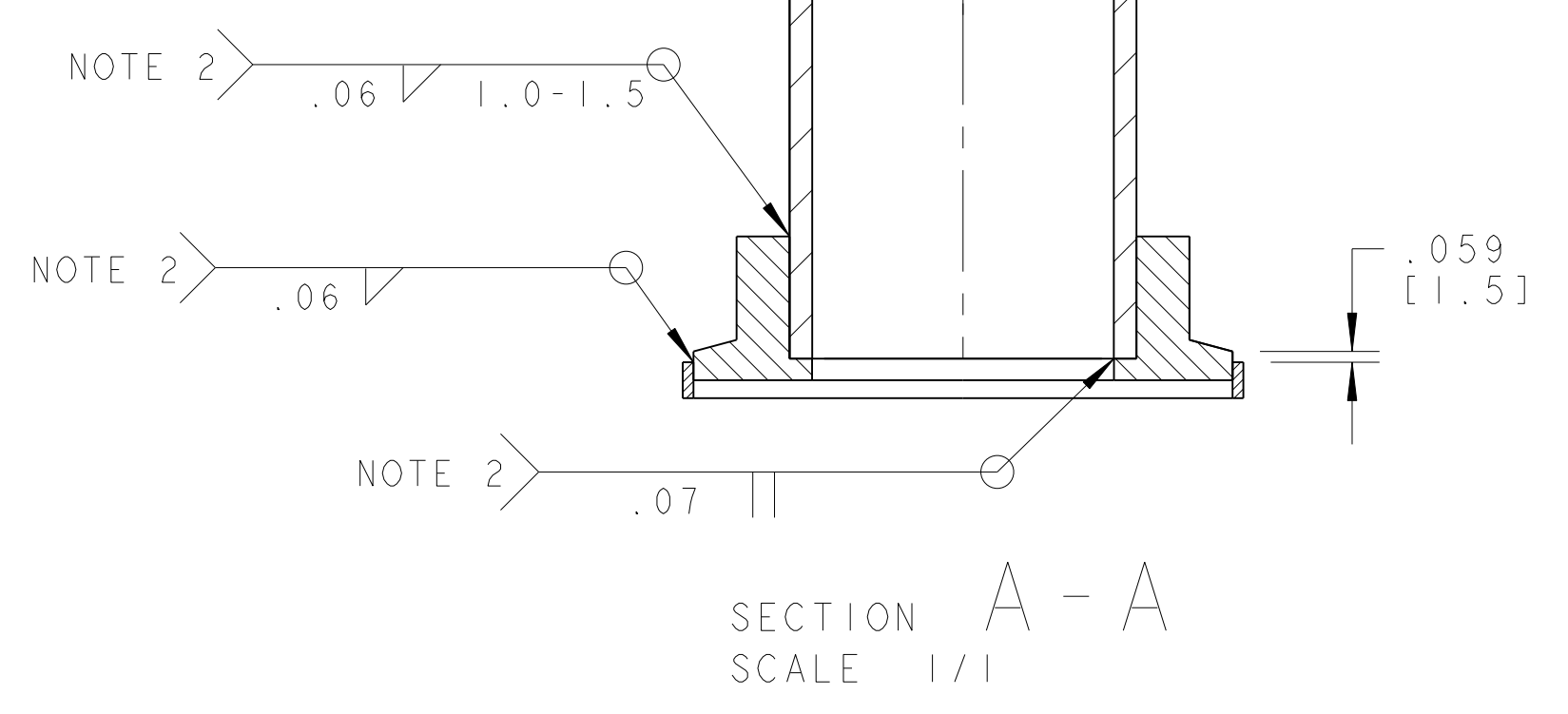
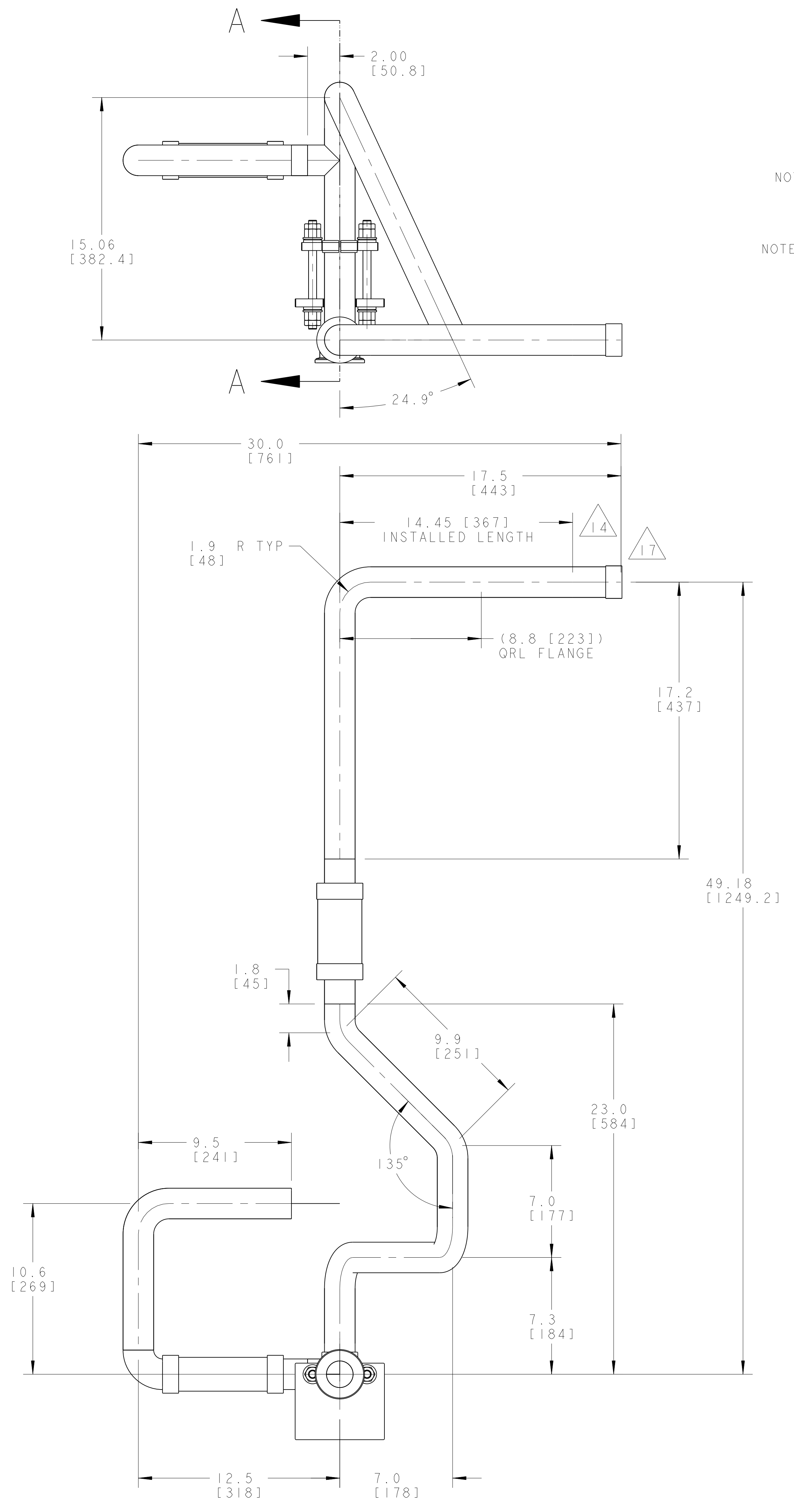
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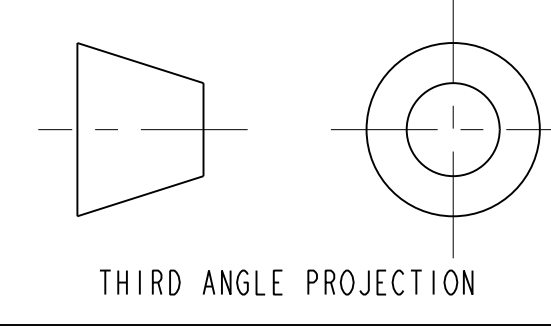
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NOTES: (UNLESS OTHERWISE SPECIFIED)

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

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°
 CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS
 BREAK EDGES .125 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.3M & B.01

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 309 SERIES
2	251307	1	FLANGE, FINAL# 5520-MB-390033	SS 309 SERIES
1	-	1	BRAIDED FLEX HOSE, 1 1/2" ID X 4' LL	SS 309 SERIES

SHOP ORDERS

ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY

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

DATE: 11-01-02
 DRAWN BY: S. YIROSTEK
 CHECKED BY: D. OSHATZ

SCALE: 1/4
 SHEET 1 OF 1
 25M9186 A

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NAME: ARHARRIS OBJECT: 25M918 DATE: 08-Nov-02 13:50:09

DRAWING NO: 25M9186 A 1