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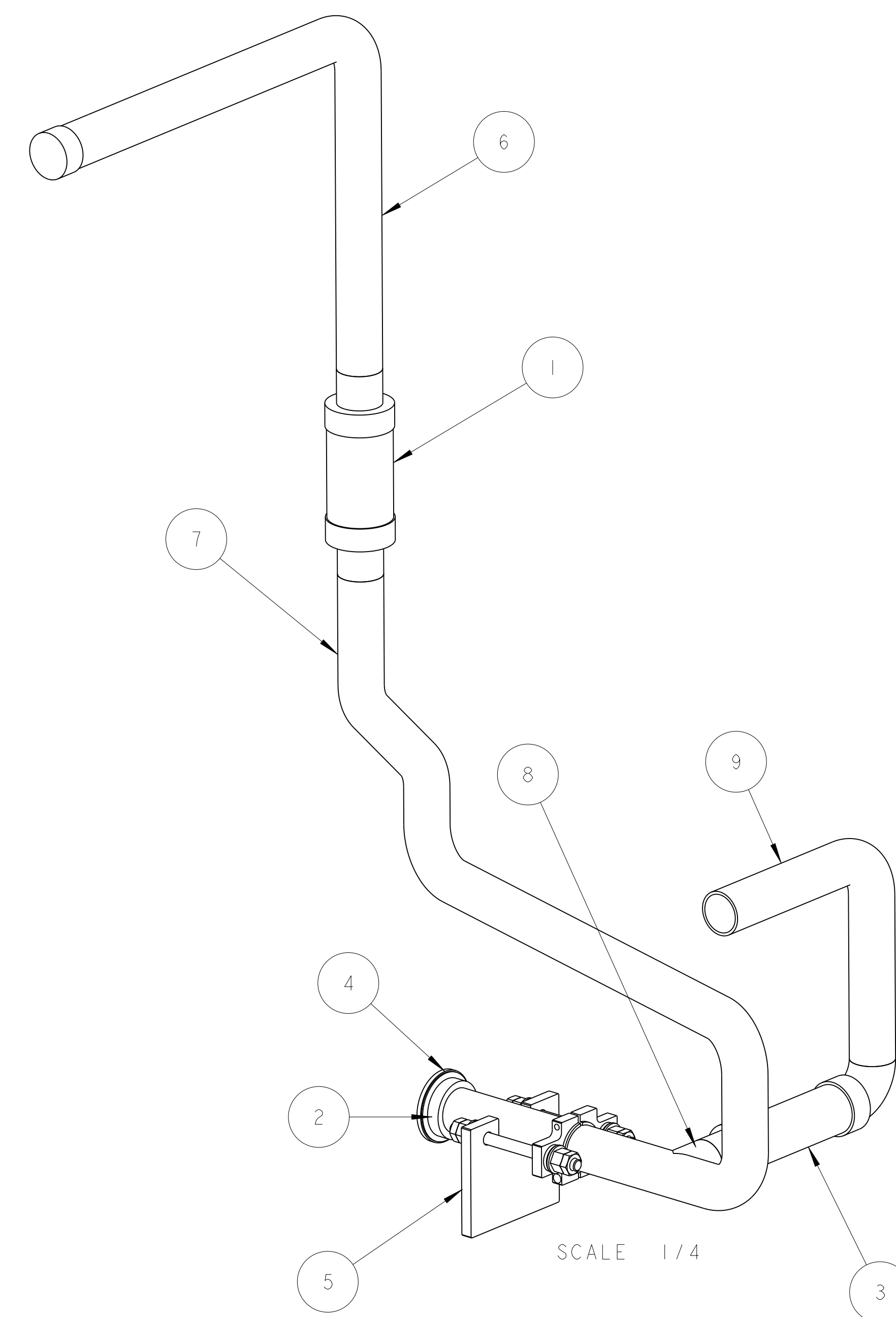
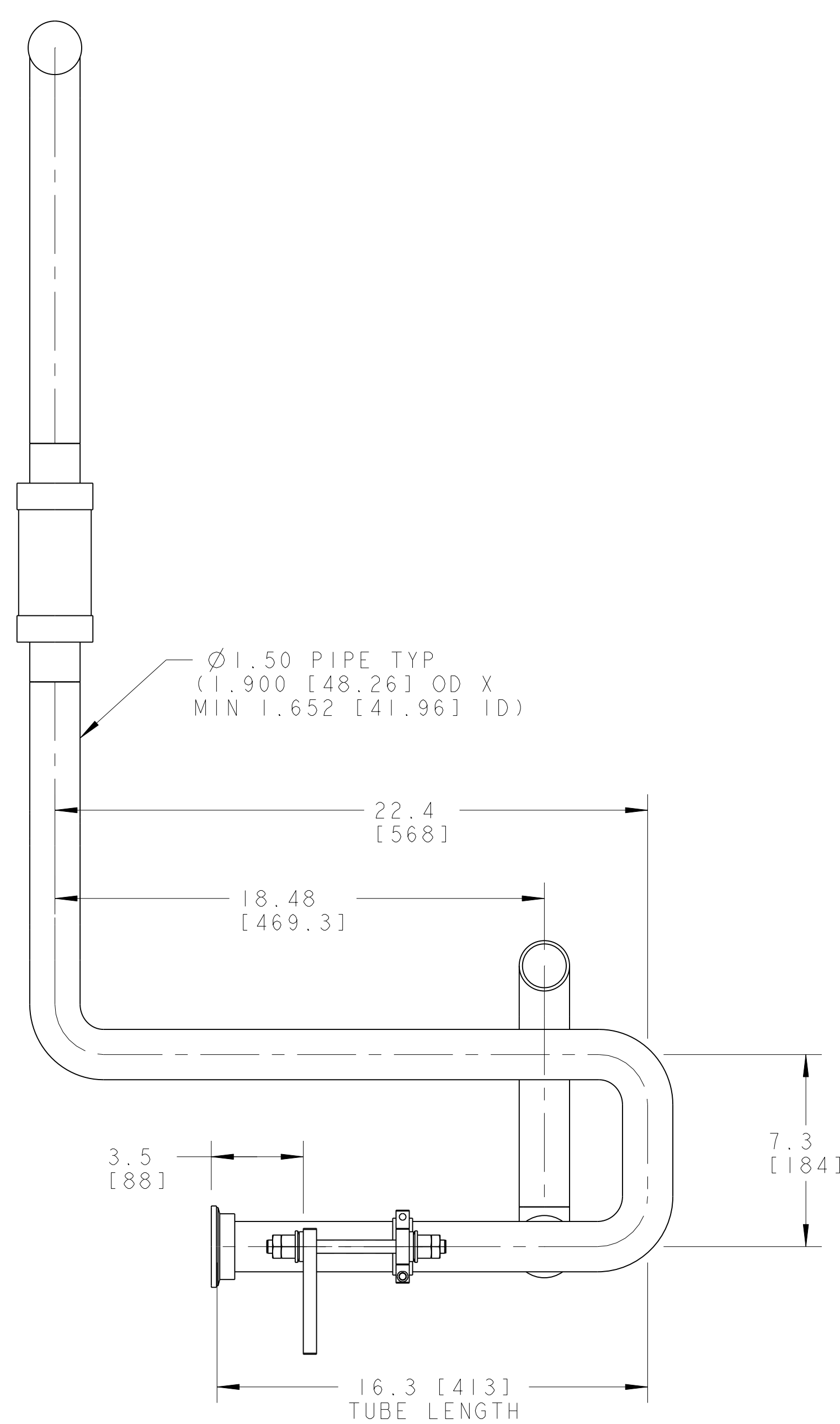
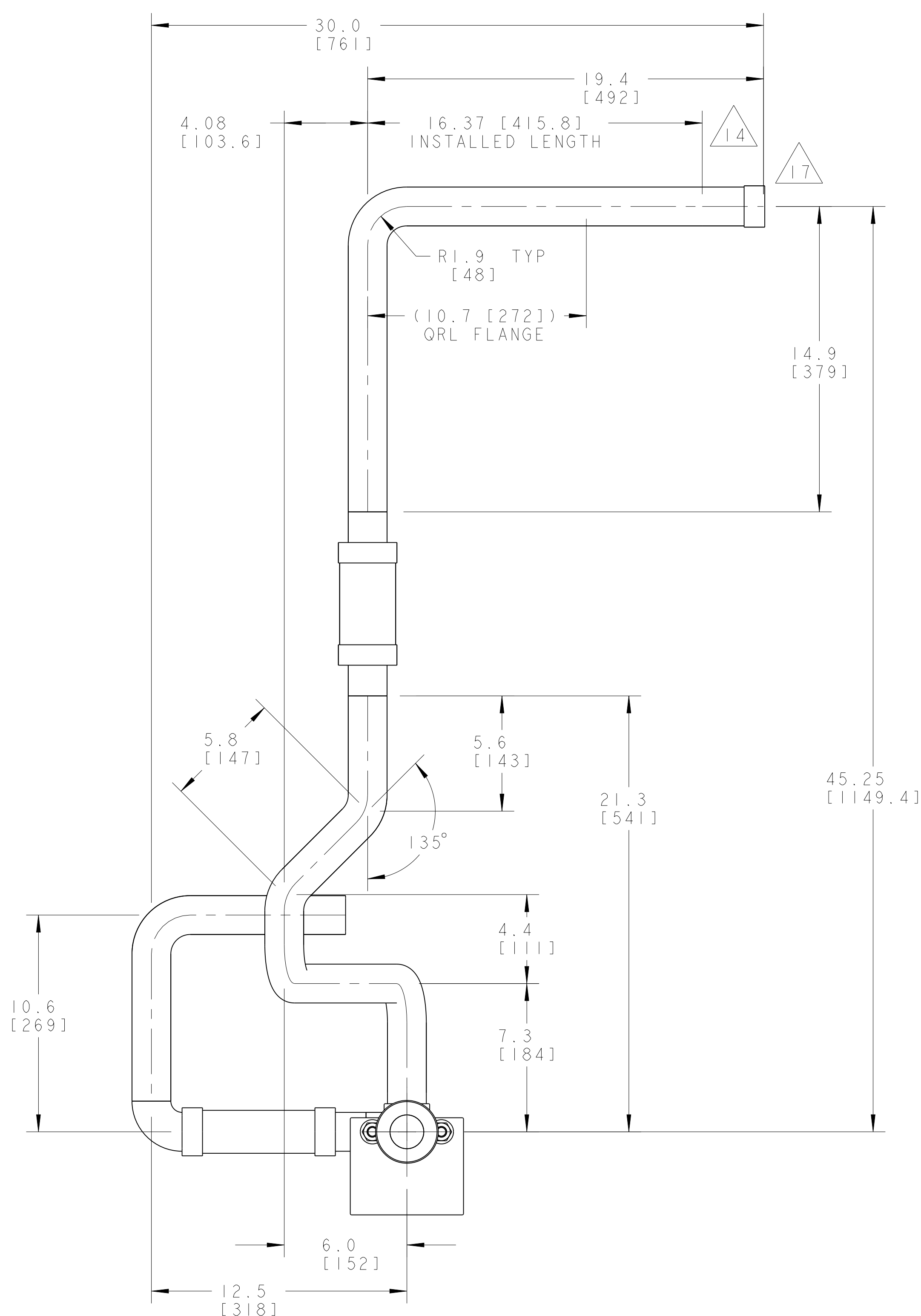
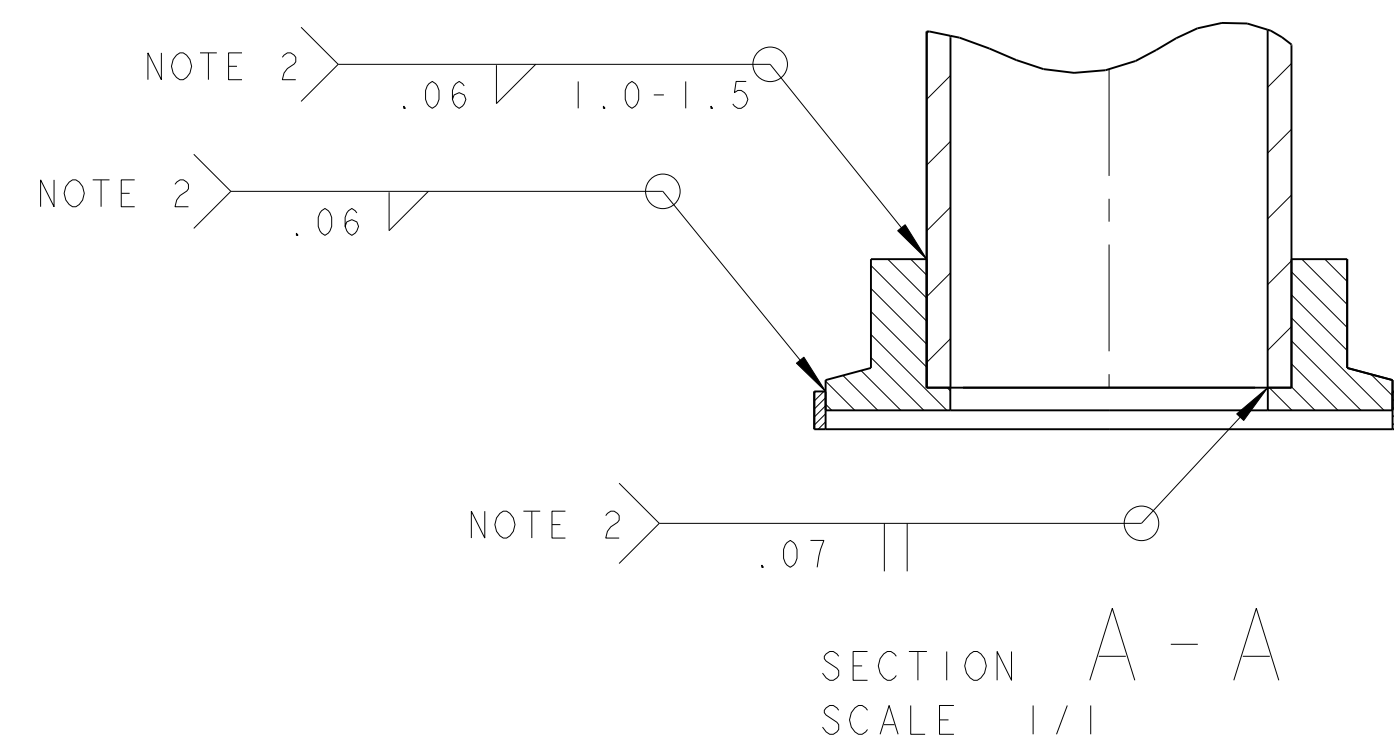
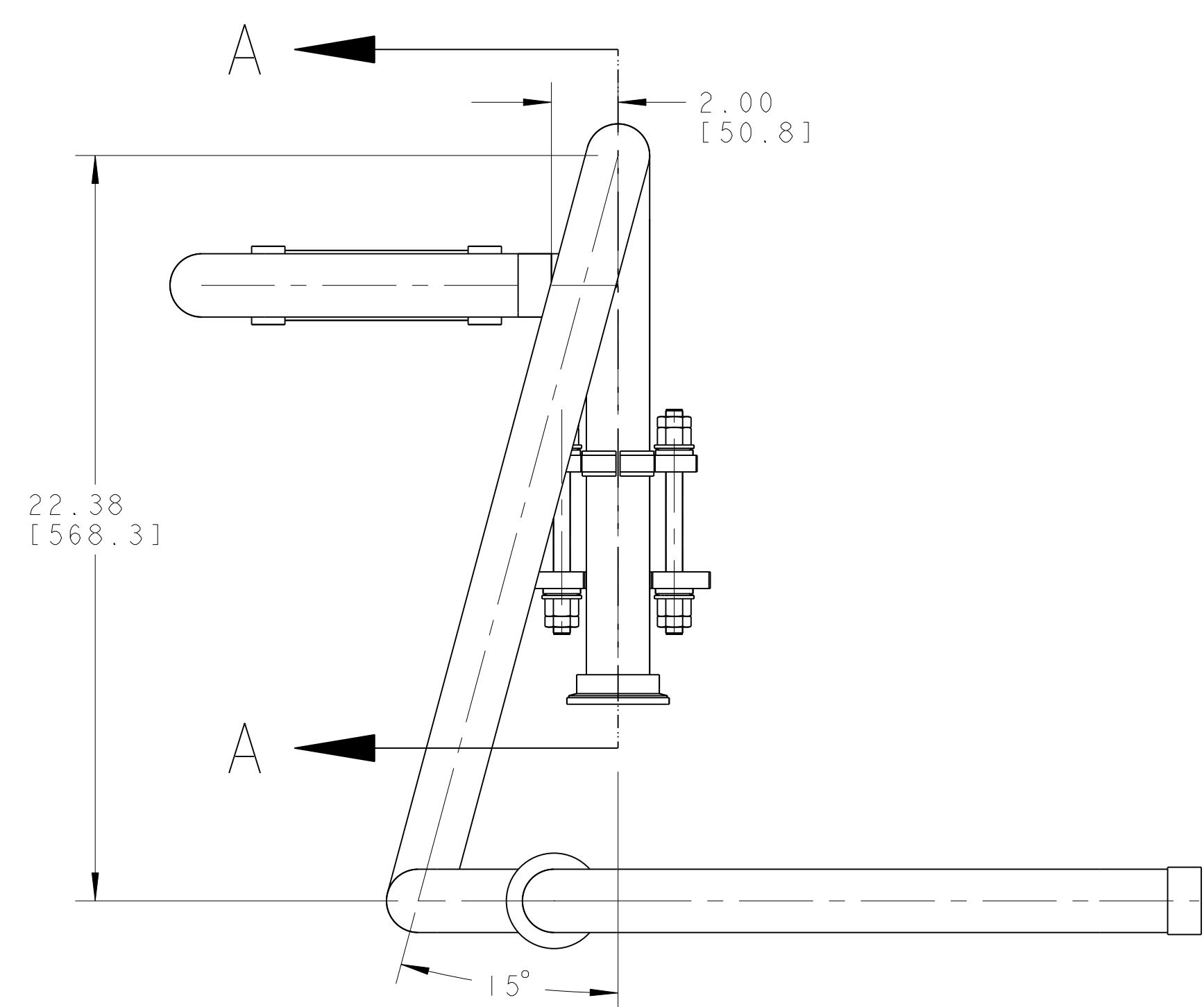
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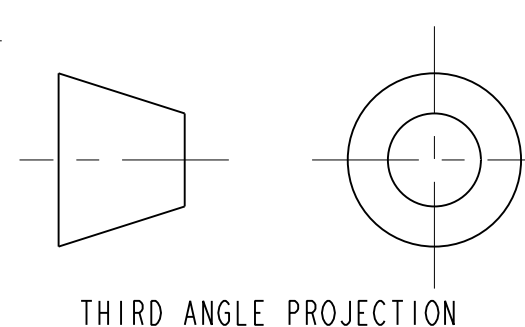
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NOTES: (UNLESS OTHERWISE SPECIFIED)

- 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.



REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE	CHANGES
A						

UNLESS OTHERWISE SPECIFIED
 X.X ± 0.1 FRACTION ± 1/64
 X.XX ± 0.03 ANGLES ± 1.00°
 X.XXX ± 0.010 FINISH 125
 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 .100 MAX. ON MACHINED WORK
 REMOVE BURRS, WELD SPATTER & LOOSE SCALE
 IN ACCORDANCE WITH ASME Y14.3M & B46.1

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 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
 SET -
 NO. -
 DATE -
 REGR -
 DATE -
 REGR -

ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY

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

DATE: 16-01-02
 DWG. NO. Z5LCE2
 ASSEM
 PATENT CLEAR: REVIEW ACCT. NO. LH2003
 CATEGORY CODE: Z5LCE2
 DWG. NO. 25M9196
 SHEET 1 OF 1
 SCALE: 1/4
 SIZE: 11x17
 REV. 1

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NAME: ARHARRIS OBJECT: 25M919 DATE: 08-Nov-02 14:52:59

25M9196 A 1

DO NOT SCALE PRINTS