

8

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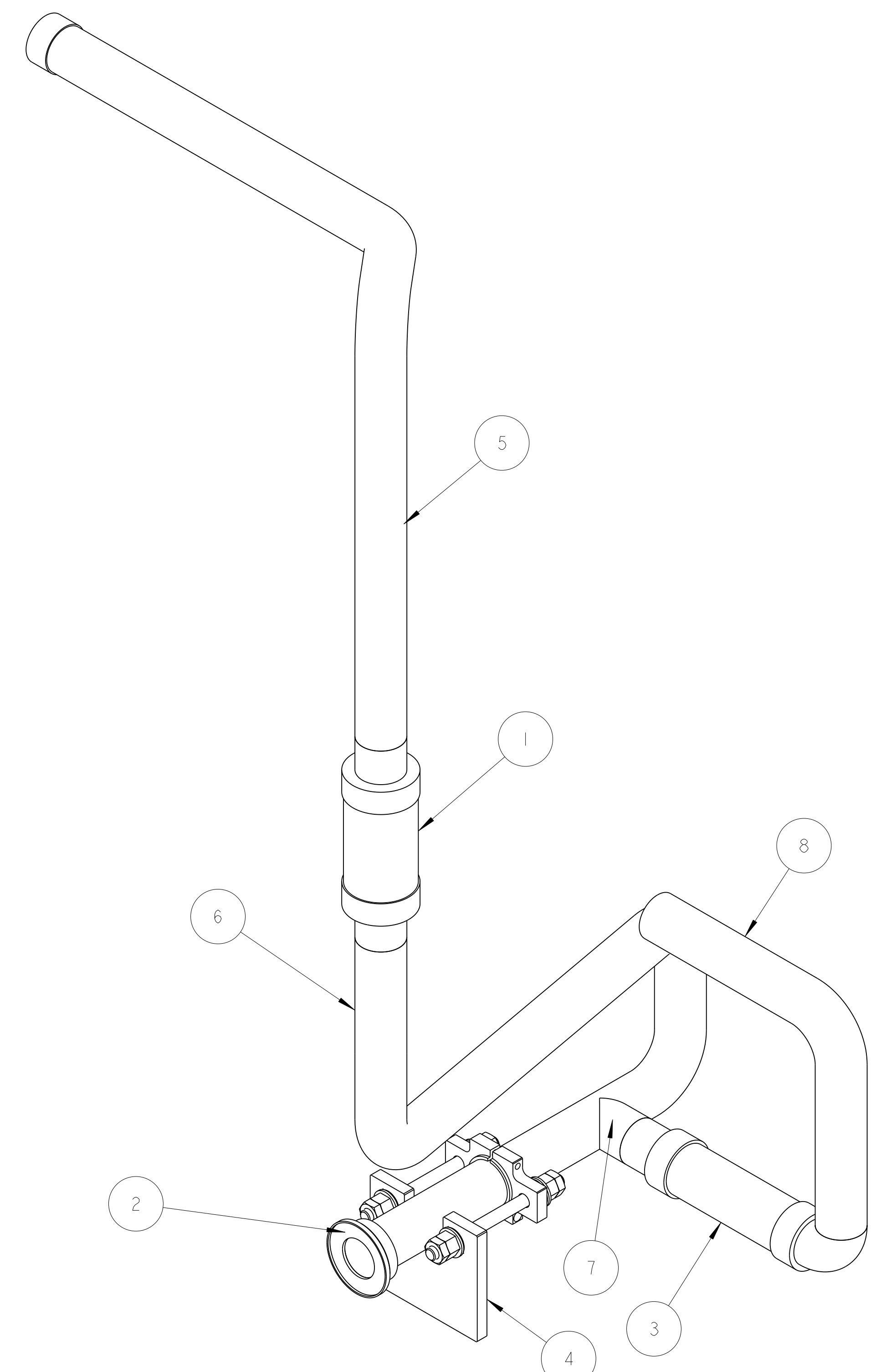
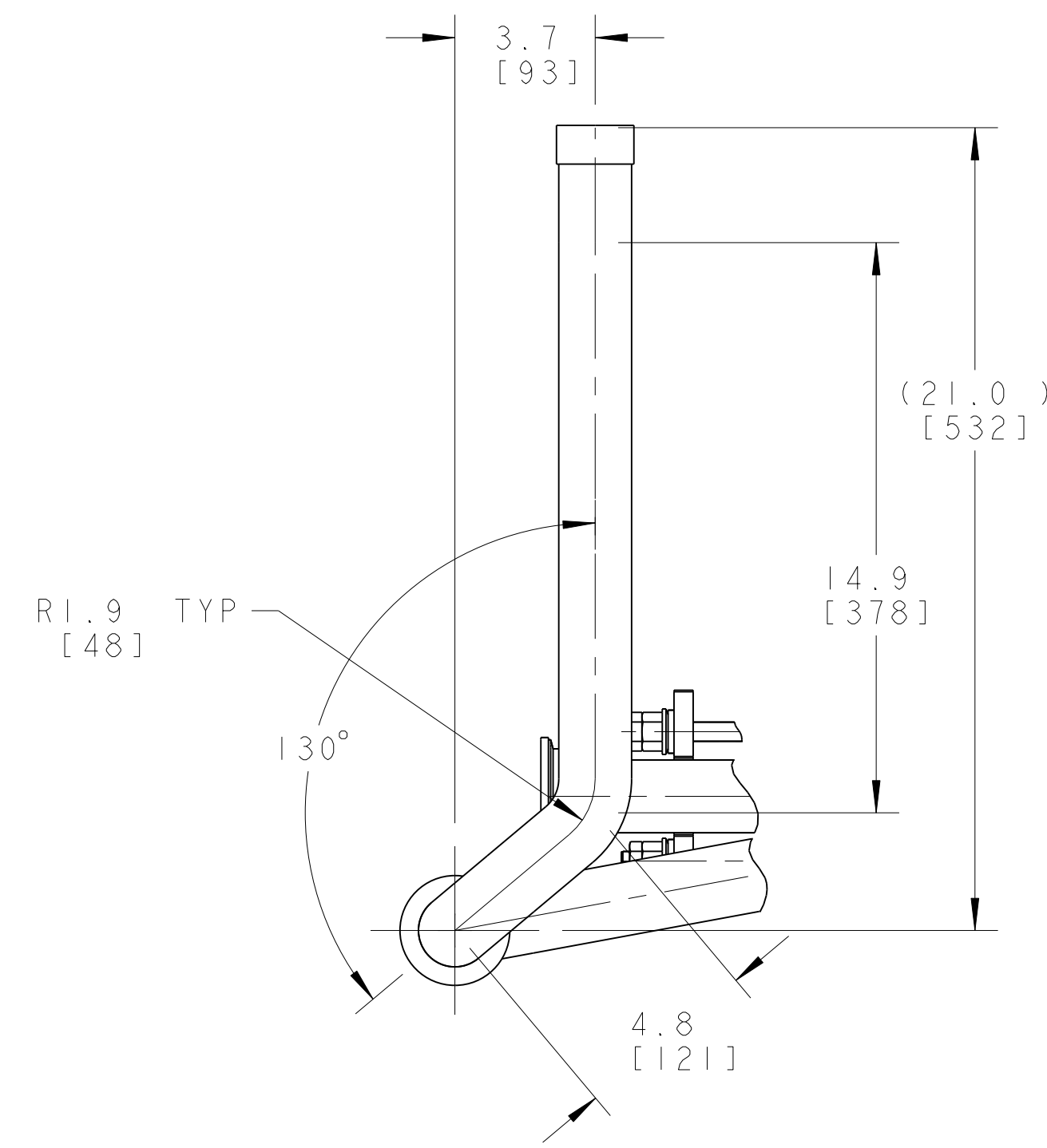
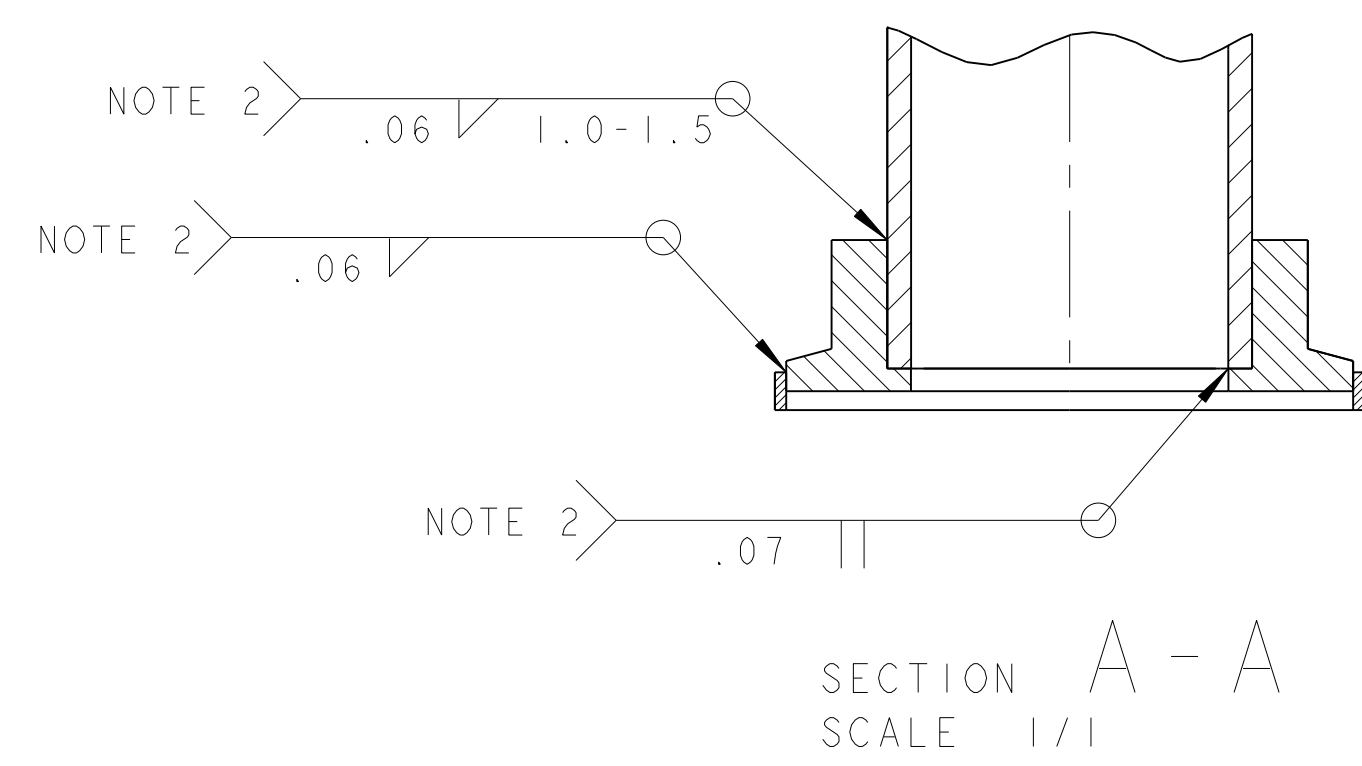
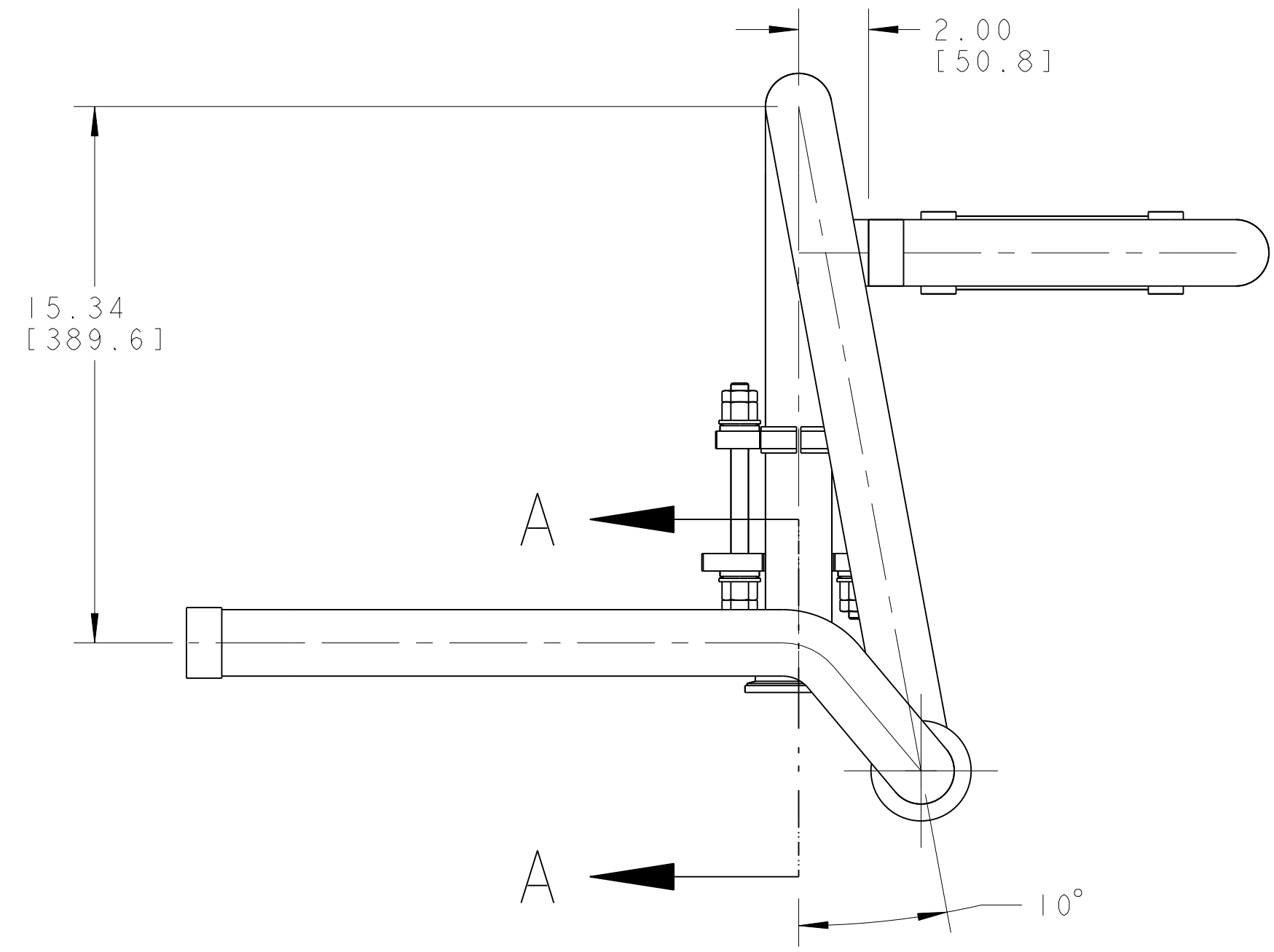
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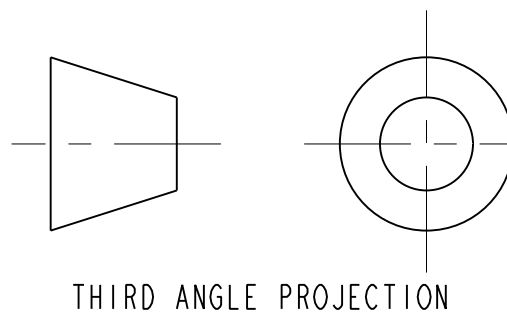
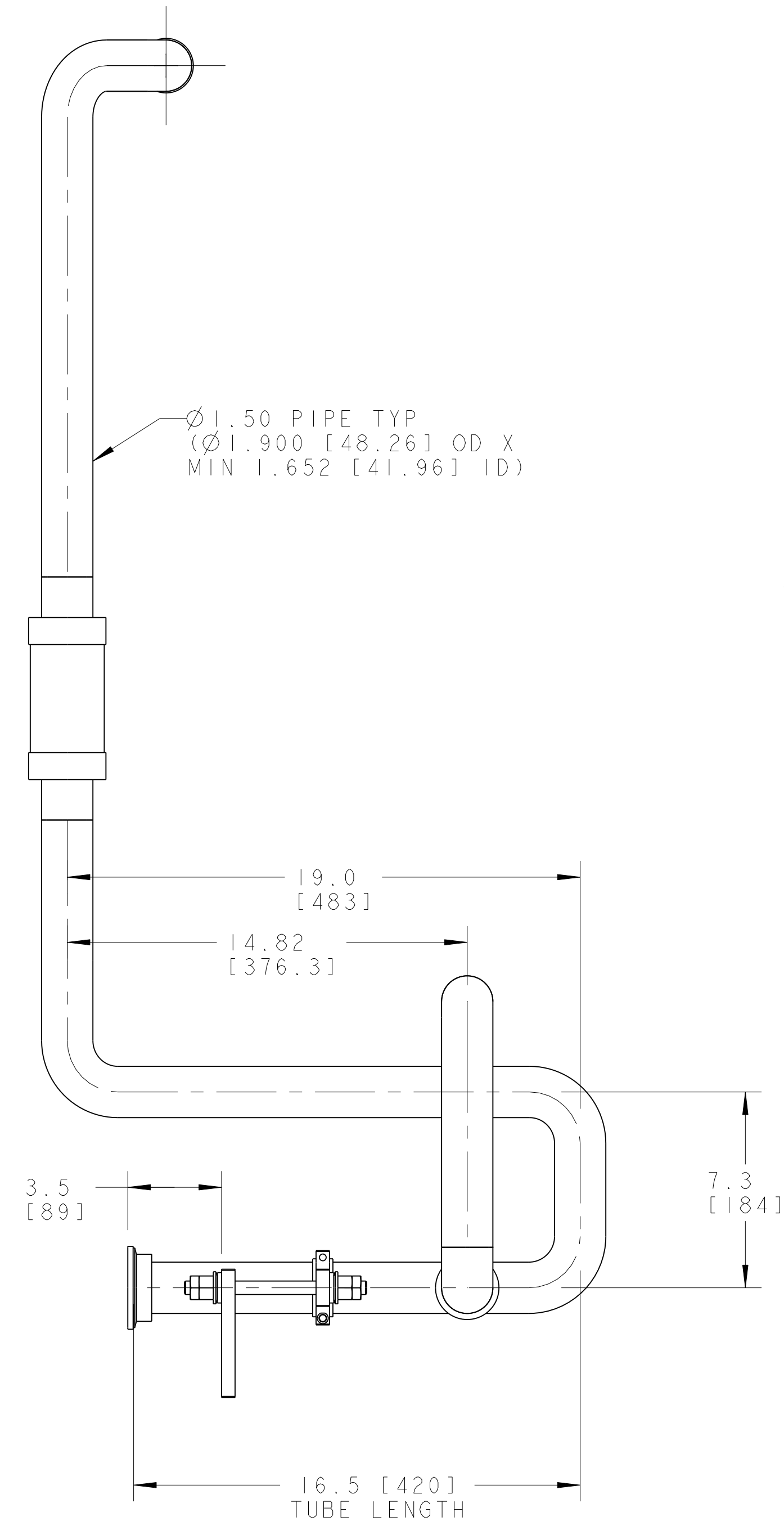
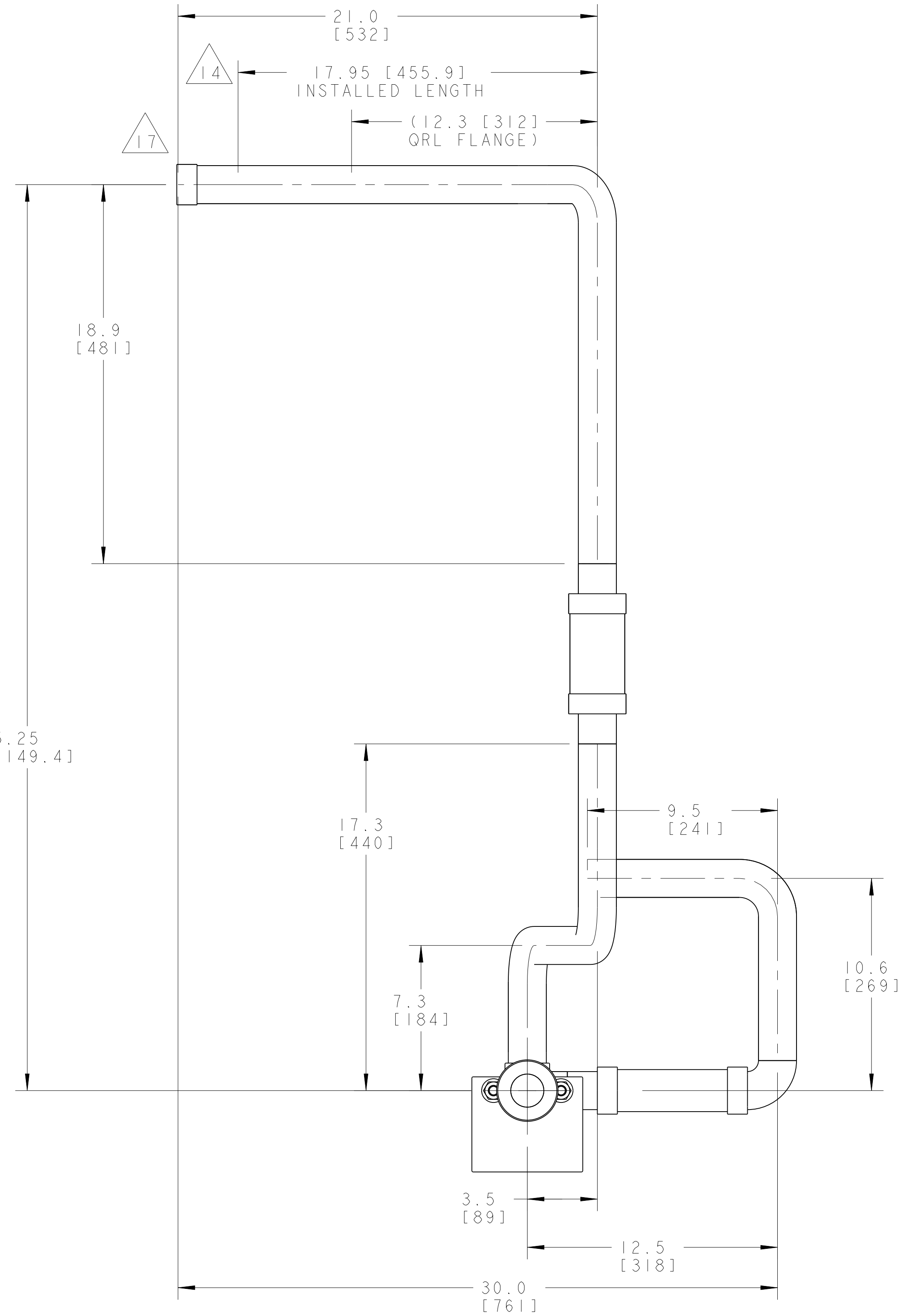
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SCALE 5/16



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	DESCRIPTION
A	ARH	SPV		10-29-02	INITIAL RELEASE
					CHANGES

ITEM	PART NO	REQD	DESCRIPTION	MATERIAL
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	-	1	PIPE, PER ASTM A312	SS 304L
4	25H406	1	THRUST SUPPORT, BUS DUCT	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

ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA BERKELEY
 LHC IR FEEDBOX CRYOGENICS
 PIPE WELDMENT, LD ORL / LD CROSSOVER
 ASSEM
 SHEET 1 OF 1
 SCALE: 1/4
 DATE: 05-Apr-02
 DRAWN BY: S. WYROSZKA
 CHECKED BY: D. OSHATZ
 DATE: 29-Oct-02
 DATE: 05-Nov-02
 PATENT CLEAR: REVIEW ACCT. NO. Z5LCE2
 CATEGORY CODE: LH2003
 DWG. NO.: 25M9206
 SIZE: A

NAME: ARHARRIS OBJECT: 25M920 DATE: 06-Nov-02 15:21:37

25M9206 A 1

DO NOT SCALE PRINTS