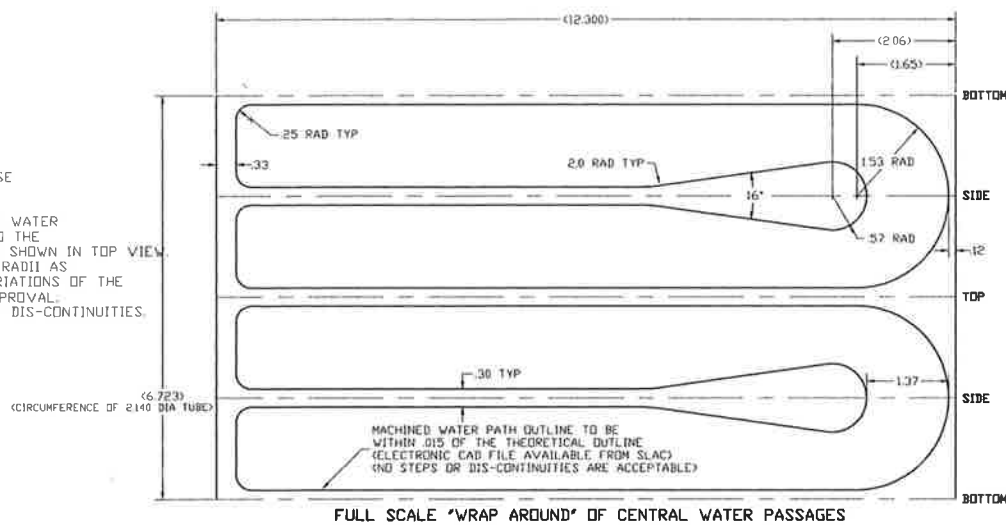
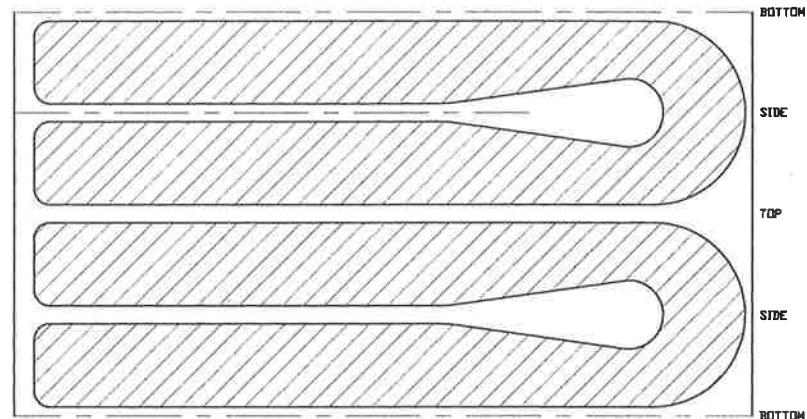
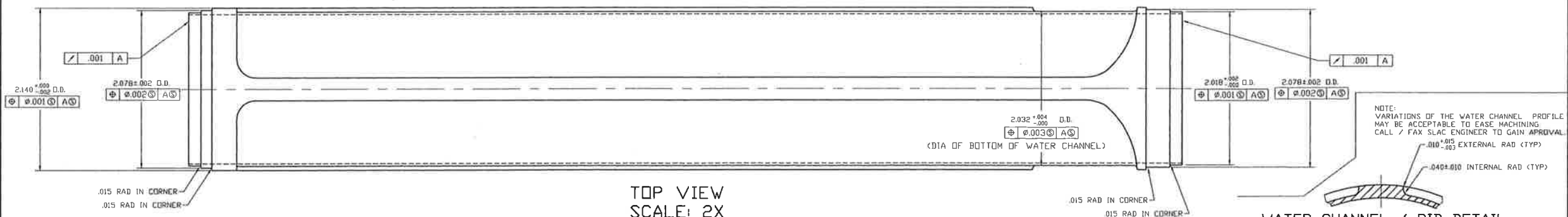
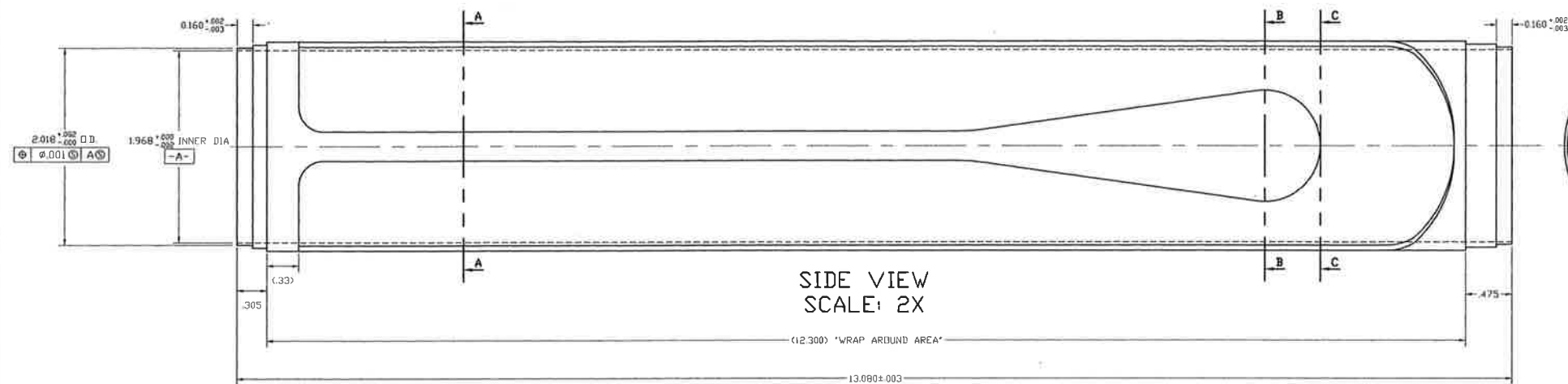
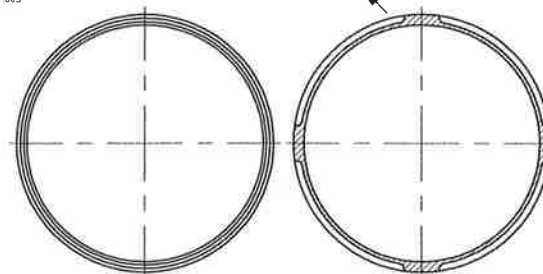
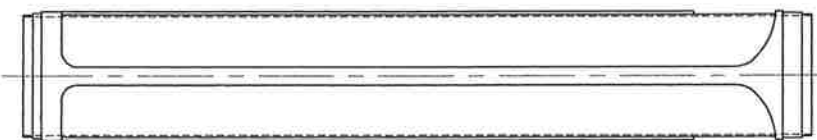
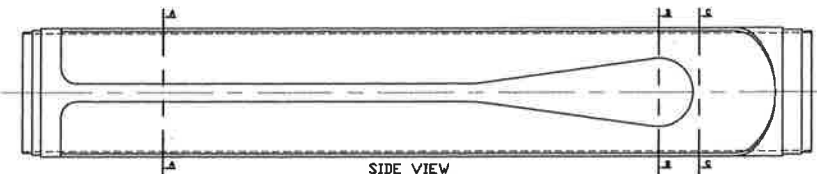


REV	DESCRIPTION	DRN	CHK	APP	DATE
1	REVISED PER VENDOR INPUT	KSVU	20	20	1-10-91

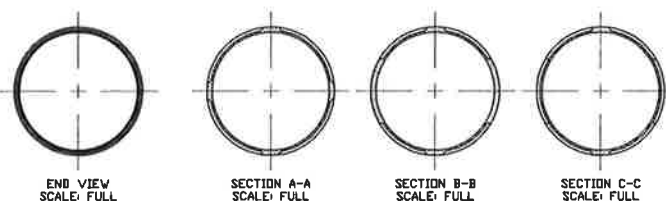
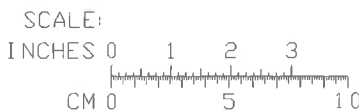
- NOTES:
1. BERYLLIUM TUBE IS TO BE MACHINED FROM SOLID TUBE OR BAR STOCK.
 2. THIS BEAMPIPE MUST BE LEAKTIGHT WHEN TESTED ON A MASS SPECTROMETER HELIUM LEAK DETECTOR. ANY LEAKAGE WHEN TESTED WITH A MINIMUM LEAK DETECTOR SENSITIVITY OF 2×10^{-10} STD CC/SEC PER LEAK RATE METER DIVISION WILL BE CAUSE FOR REJECTION.
 3. ALL SURFACES WHICH HAVE BEEN EDM'ED MUST BE POST MACHINED TO EASE CLEANING FOR UHV.
 4. FABRICATE AS PER SLAC SPECIFICATION PS-343-410-40.
 5. THE FULL SCALE "WRAP AROUND" VIEW REPRESENTS THE OUTLINE OF THE WATER PASSAGES CUT INTO THE BEAM PIPE. THE PATTERN IS AS PROJECTED TO THE SURFACE OF THE PART ($\phi 2.140$) WITHOUT RADII CUT PATTERN TO DEPTH SHOWN IN TOP VIEW. THE COMPLETE OUTLINE OF THE WATER PATH WILL HAVE FILLETS AND RADII AS SHOWN IN THE "WATER CHANNEL / RIB DETAIL". AS SHOWN, SLIGHT VARIATIONS OF THE PROFILE MAY BE ACCEPTABLE TO EASE MACHINING WITH PRIOR SLAC APPROVAL. ALL SURFACES WITHIN THE WATER PATH WILL BE SMOOTH AND FREE OF DISCONTINUITIES.



FULL SCALE "WRAP AROUND" OF CENTRAL WATER PASSAGES

FULL SCALE "WRAP AROUND" OF CENTRAL WATER PASSAGES
(WATER PASSAGES SHOWN HATCHED)TOP VIEW
SCALE: 2XSIDE VIEW
SCALE: 2XWATER CHANNEL / RIB DETAIL
SCALE: 4XEND VIEW
SCALE: 2XSECTION A-A
SCALE: 2XTOP VIEW
FULL SCALESIDE VIEW
FULL SCALE

DO NOT SCALE WATER PATH FROM SIDE, TOP, OR END VIEWS (USE ROLL UP VIEW)

END VIEW
SCALE: FULLSECTION A-A
SCALE: FULLSECTION B-B
SCALE: FULLSECTION C-C
SCALE: FULLULTRA HIGH
VAC PART
FABRICATE PER
PS-343-410-40

MATERIAL IS STRUCTURAL BERYLLIUM BLOCK (S-65 SCREENED FOR LOW CARBON CONTENT)

ITEM NO	PREP	BASE	SUFF	TITLE OR DESCRIPTION	QTY
1				PEP-II IR VACUUM BEAM PIPE BRAZEMENT BEAM PIPE	
STANFORD LINEAR ACCELERATOR CENTER US DEPARTMENT OF ENERGY STANFORD UNIVERSITY STANFORD, CALIFORNIA					
NEXT ASSEMBLY: SA-343-410-02					
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES: BREAK EDGES .005. INTERNAL CORNERS .005 R MAX. FINISHES: ± 1/64. DEC. 31. JET 2. 01. 3000 ± .014. ANALYST: J. A. B. 63.					
SCALE: PER VIEW. DO NOT SCALE DRAWING.					
PROPERTY OF STANFORD UNIVERSITY AND/OR U.S. DEPARTMENT OF ENERGY. RECIPIENT SHALL NOT PUBLISH THE INFORMATION HEREIN WITHOUT SPECIFIC PERMISSION OF STANFORD UNIVERSITY.					
APPROVALS: DRN: J. A. B. CHK: J. A. B. APP: J. A. B. DATE: 1-10-91.					
MATERIAL IS STRUCTURAL BERYLLIUM BLOCK (S-65 SCREENED FOR LOW CARBON CONTENT)					
PEP-II IR VACUUM BEAM PIPE BRAZEMENT					
PF-343-410-03 A1 E					