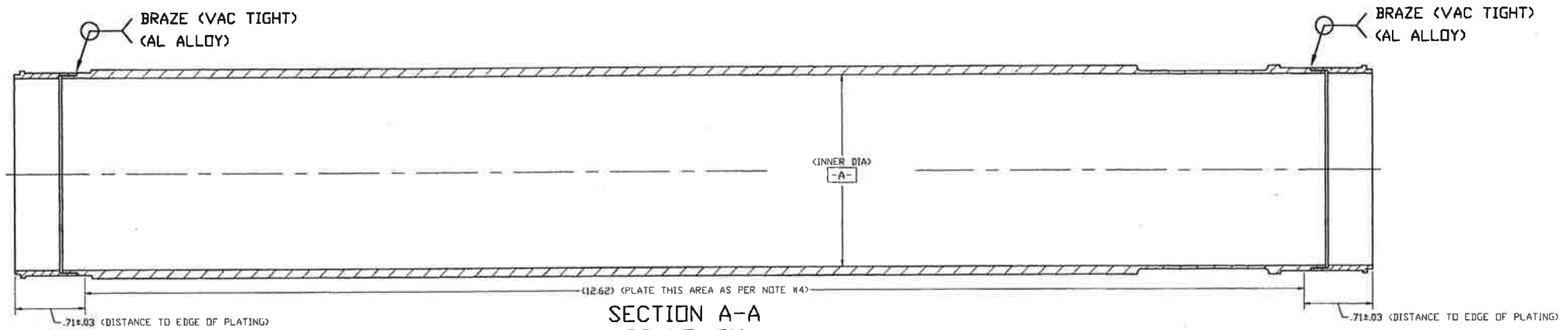
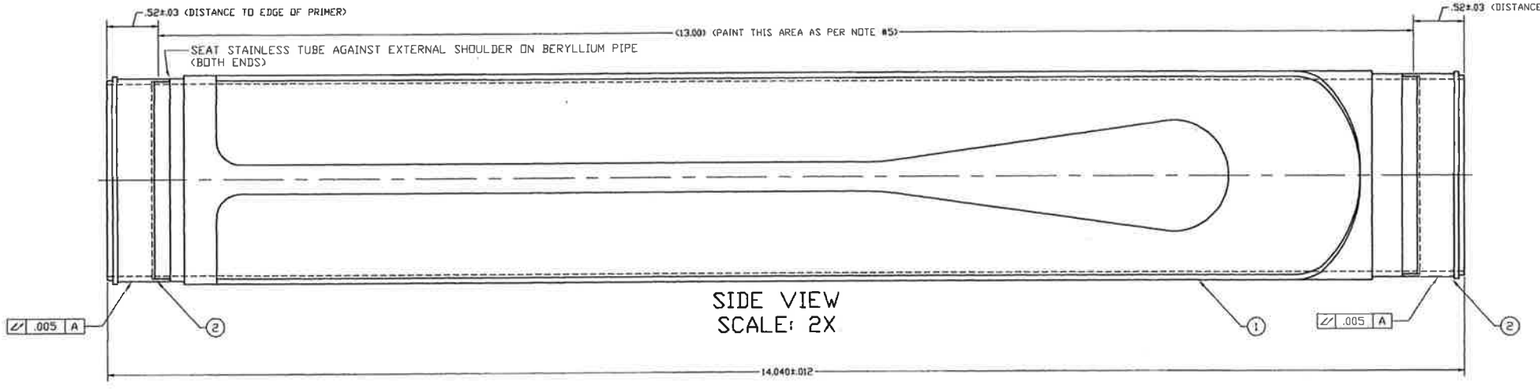
PROJECTION

REV	DESCRIPTION	DRN	CHK	APP	DATE
1	REVISED PER VENDOR INPUT	KSV			4-5-07

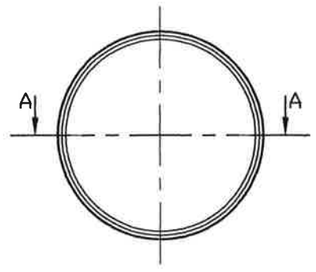
NOTES:
1. BRAZE MATERIAL MUST REMAIN WITHIN .25" OF EACH BRAZE LONGITUDINALLY.
   BRAZE MATERIAL MUST REMAIN WITHIN .006" OF BRAZE RADIALLY.
   VERIFY FLUX REMOVAL WITH SILVER NITRATE TEST AFTER BRAZING.
2. THIS PIPE MUST BE LEAKTIGHT WHEN TESTED ON A MASS SPECTROMETER HELIUM LEAK DETECTOR. ANY LEAKAGE 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. LEAK TESTING IS DONE BEFORE COATINGS ARE APPLIED.
3. THE FINAL PART MUST BE DELIVERED TO SLAC DIMENSIONALLY CORRECT IN A STRESS FREE CONDITION. (STRESS RELIEVE AS REQUIRED.)
4. PLATE AREA SHOWN ON OUTSIDE SURFACE OF BERYLLIUM TUBE WITH 7±1 MICRONS OF ELECTROLESS NICKEL.
   POLYMER BASED LIQUID MASKS ARE NOT PERMITTED INSIDE THE PIPE FOR VACUUM REASONS.
   LIQUID MASKS MAY BE USED ON THE OUTSIDE SURFACES OF THE PIPE. DRY RUBBER STOPPERS AND / OR O-RINGS MAY ALSO BE USED. PLATING PROCEDURE / MASKING METHOD TO BE APPROVED BY SLAC.
5. APPLY BR154 EPOXY PRIMER TO LOCATION SHOWN ON EXTERIOR OF PIPE.
   PAINT APPLICATION PROCEDURE TO BE APPROVED BY SLAC.
   KEEP ENDS PLUGGED WHILE WORKING ON PIPE TO AVOID INTERNAL CONTAMINATION.
   PURGE PIPE WITH DRY NITROGEN WHILE BAKING PAINT.
   (THIS PIPE IS TO BE WATER COOLED AFTER ASSEMBLY. THE PURPOSE OF THE PAINT AND PLATING IS CORROSION RESISTANCE.)
6. THE FINAL SUB ASSSEMBLY MUST BE CLEANED FOR UHV AND STORED IN A DRY, SEALED CONTAINER
7. FABRICATE AS PER SLAC SPECIFICATION PS-343-410-40



SECTION A-A
SCALE: 2X

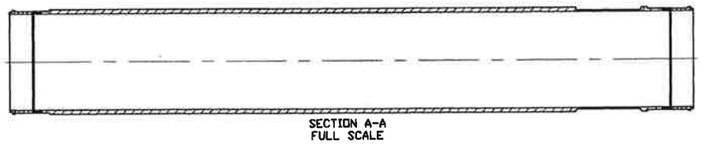


SIDE VIEW
SCALE: 2X

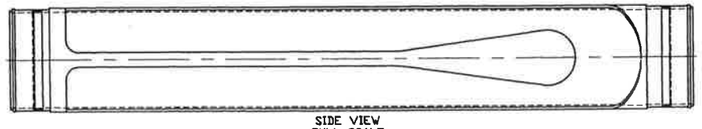


END VIEW
SCALE: 2X

ULTRA HIGH VAC PART
FABRICATE PER PS-343-410-40

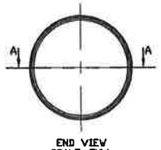


SECTION A-A
FULL SCALE



SIDE VIEW
FULL SCALE

SCALE:
INCHES 0 1 2 3
CM 0 5 10



END VIEW
SCALE: FULL

ITEM NO	PREF	BASE	SUFF	STOCK OR PART NO	TITLE OR DESCRIPTION	QTY
2		PF-343-410-04			BEAM PIPE EXTENSION	2
1		PF-343-410-03			Be BEAM PIPE	1

DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ANSI Y14.5M-1982.
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES:
BREAK EDGES .005
INTERNAL CORNERS .005 R MAX
FRACTIONS ± 1/64
.XX ± .01
.XXX ± .004
ANGLES ± 1/2 ALL RAWS 63

SCALE: PER VIEW
DO NOT SCALE DRAWING
NEXT ASSEMBLY: SA-343-410-01

STANFORD LINEAR ACCELERATOR CENTER
US DEPARTMENT OF ENERGY
STANFORD UNIVERSITY STANFORD, CALIFORNIA

DRN KNUT SKARPAAS 2-5-07
APPROVALS
KNUT SKARPAAS
MARTIN NORBY
NANCY PALMER

PEP-II IR VACUUM
BEAM PIPE ASSY
BEAM PIPE BRAZEMENT

SA-343-410-02 A1 E

SHT 1 OF 1

PEP II IR VAC BP BRAZEMENT

SA-343-410-02-A1