

REVISIONS			
REV	ZONE	EGN. NO.	DESCRIPTION
A			INITIAL RELEASE
B		00341, 342	AS PER ECNS

NOTES:

1. BEAMPIPE ASSEMBLY & ALL SUB-ASSEMBLIES, WELDED JOINTS, AND BRAZE JOINTS TO CONFORM TO SPECIFICATION RHIC-CR-E-4403-112.

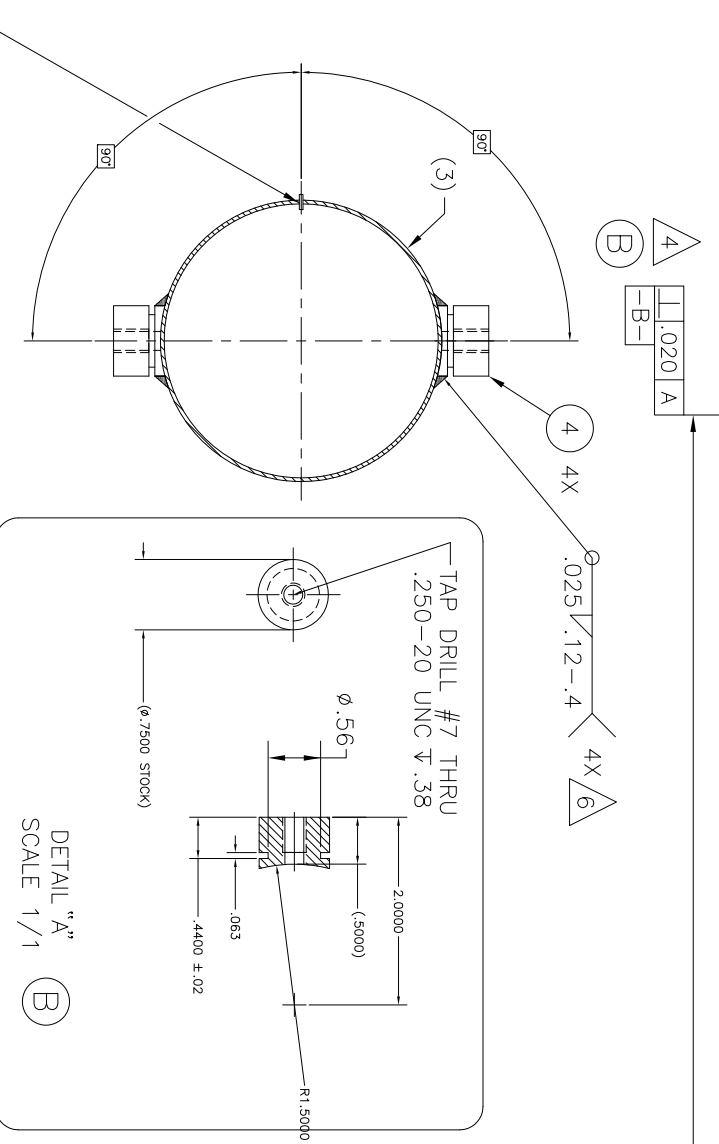
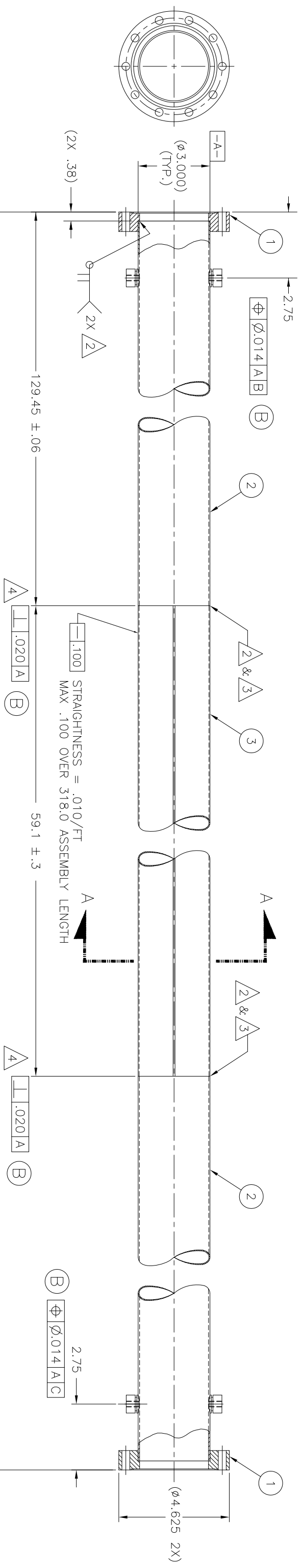
2. BEAM TUBE ASSEMBLIES, INCLUDING ALL WELDS & BRAZE JOINTS SHALL BE LEAK TIGHT EQUAL TO OR LESS THAN 1 x 10<sup>-10</sup> STD cc He/Sec.

3. BERYLLIUM TO ALUMINUM JOINTS TO BE MADE AS SHOWN ON DRAWING 44035010. SEE DETAIL "B".

4. PERPENDICULARITY IS TYPICAL FOR BOTH ENDS FOR THE LAST 12" OF TUBE ENDS.

5. TAG IN ACCORDANCE WITH MIL-STD-130.

6. DEPTH OF PENETRATION LIMITED. DO NOT MELT THROUGH ITEM 2.



ORIENT BRAZE JOINT ON ITEM 3 AS SHOWN

2X SECTION A-A SCALE 1/1

# ORIGINAL STAR BEAMPIPE

QUANTITY	ITEM NO.	PART NUMBER	DESCRIPTION	REMARKS
4	4		ALUMINUM, ROUND, 6061-T6, Ø.75 STOCK	SEE DETAIL "A"
1	3		BERYLLIUM TUBE, Ø3.000 O.D. X .040 ±.005 WALL THK.	
2	2		ALUMINUM, TUBE, 6061-T6, Ø3.000 O.D. X .049 ±.005 WALL THK.	
2	1		FLANGE, NON-ROTATABLE, Ø4.625 (OR EQUIV.) ALUMINUM(6061-T6) TO STAINLESS STEEL(316L) ATLAS TECH INC, MUST BE DIMENSIONALLY THE SAME AS CONFLAT SST FLANGE	

BILL OF MATERIALS			
OUTSTANDING	INTERPRET IN GENERAL	DATE	BY
NUMBERS	ASME Y14.24M-1989		
	UNLESS OTHERWISE SPECIFIED		
	DIMENSIONS ARE IN INCHES		
	DECIMALS		
	XX ± .02		
	XX ± .01		
	ANGULAR TOLERANCE ± 1°		
	FINISH		
	NA		
	BREAK SHARP EDGES		
	MAX .03 MIN. .015		

RHIC		BROOKHAVEN NATIONAL LABORATORY	
PERSONAL	DATE	PERSONAL	DATE
BY P.A. HELIG	02/09/98	BY P.A. HELIG	02/09/98
CHECKED BY J.T. KOEHLER	02/25/98	CHECKED BY J.T. KOEHLER	02/25/98
APPROVED BY A. ARNO III	02/25/98	APPROVED BY A. ARNO III	02/25/98
APPROVED BY W. EDWARDS	02/27/98	APPROVED BY W. EDWARDS	02/27/98
APPROVED BY D. HSEUH	02/27/98	APPROVED BY D. HSEUH	02/27/98
APPROVED BY I.R. MULLER	02/27/98	APPROVED BY I.R. MULLER	02/27/98
APPROVED BY S. KANE	02/27/98	APPROVED BY S. KANE	02/27/98

TITLE:	STAR BEAMPIPE
UPTON, N.Y. 11973	
DRAWING NUMBER:	44035009
SCALE:	1/2
WEIGHT:	NA
SHEET:	1 OF 1