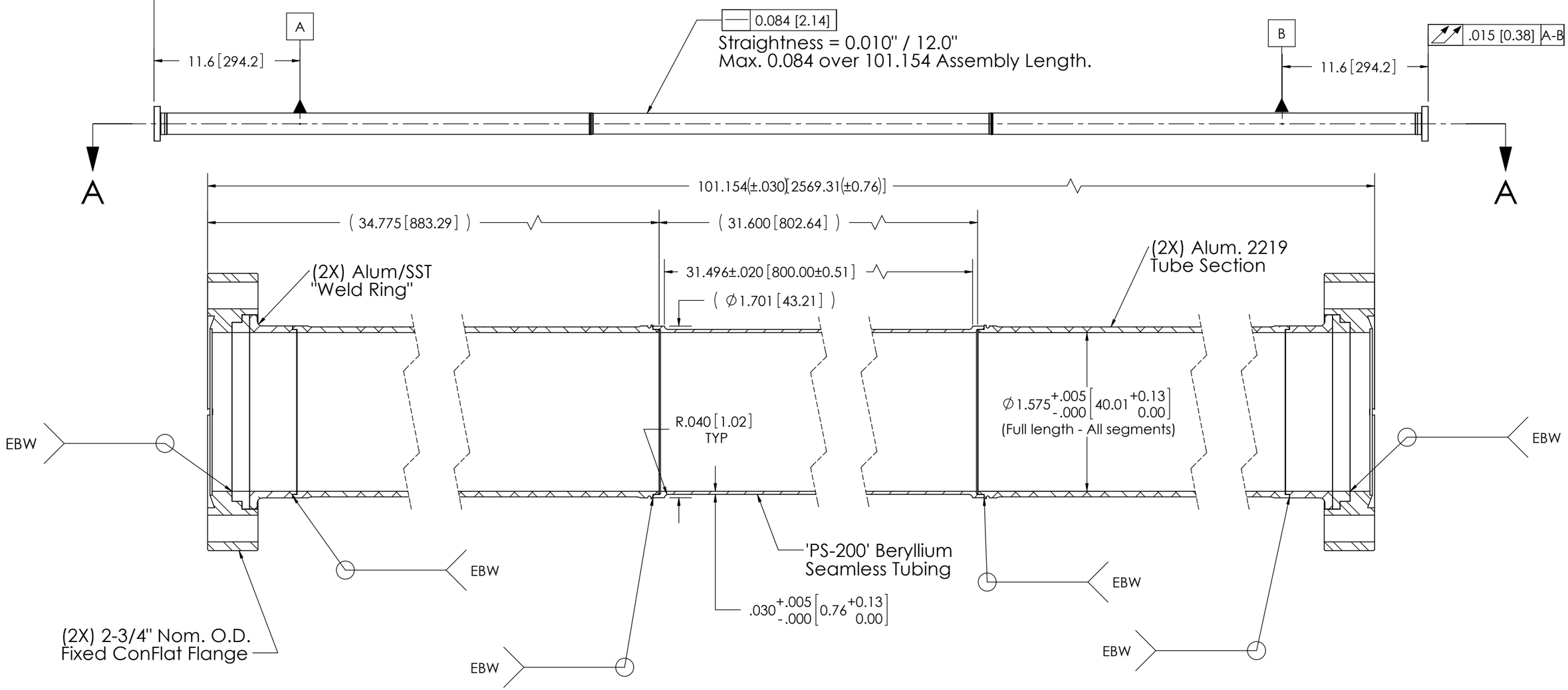
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
.	A	Initial release.	1/26/09	D. Harris
.	B	Redesign: Alum Tubing was SST; Weld Rings were at ends of Be Tube; Updated Notes.	3/05/09	D. Harris

Customer Approval:

(signature) (date)



SECTION A-A
SCALE 1 : 1

NOTES:

1. Material: Beryllium PS-200, 2219 Aluminum, Alum/SST Transition, & 304L Fixed ConFlat Flanges, as specified.
2. Assembly to be bakeable to 300° C.
3. Assembly to be vacuum tight; Mass Spec. Leak Rate not to exceed 1 E-10 Std cc/sec He.
4. Assembly I.D. to be NEG coated and bakeable to 250° C; B.N.L. responsible for interior coating.
5. Beryllium section O.D. to be coated with Berylcoat D and bakeable to 250° C; BW-EFP responsible for Be coating.
6. Detail design and fabrication procedure to be approved by B.N.L. after contract award.
7. Flange Runout and overall Straightness to be measured with assembly unrestrained and simply supported at datums A & B.

Interpret Drawing per ANSI Y14.5 M-1994.

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTION ±1/16
ANGLES ±0.5
.XX ±0.03
.XXX ±0.005

FINISH (Ra): 63

BW-ELECTROFUSION PROPRIETARY
Information included in this document not to be disseminated without prior written authorization.

	NAME	DATE
DRAWN	D. Harris	1/26/09
ENG APPR.	.	.

CUSTOMER
Brookhaven Nat'l Lab

MATERIAL
As noted.

BRUSH WELLMAN
ELECTROFUSION PRODUCTS

TITLE:
EB Weld Beam Pipe,
PHENIX

SIZE	DWG. NO.	REV
B	22906	B

SCALE: 1:12 DO NOT SCALE DRAWING SHEET 1 OF 1