

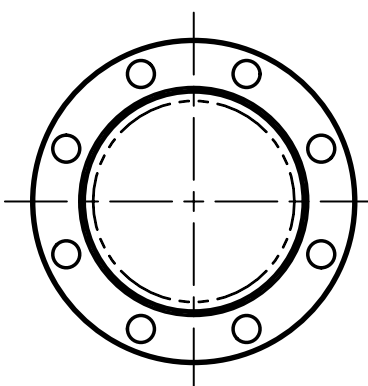
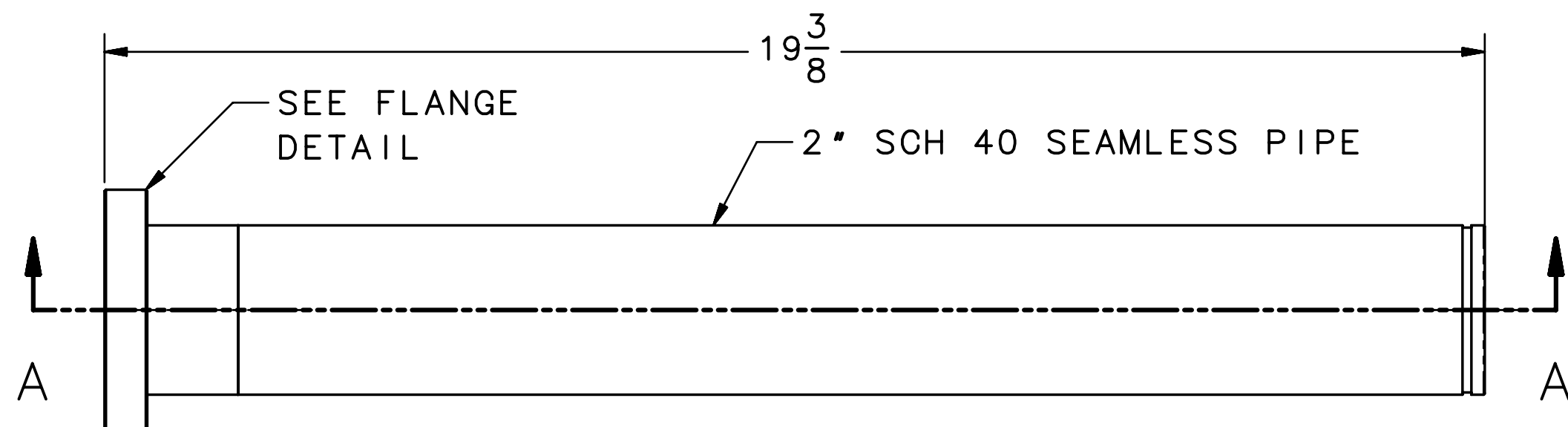
4

3

2

1

REVISION HISTORY				
ZONE	REV	DESCRIPTION		DATE/REVISER
-	A	DESIGN CHANGE, UPDATED DRAWING		5/9/18
-	B	ADDED NOTE 3		5/22/18 BCM
-	C	CHANGED WINDOW RADIUS SIZE		6/29/18 BCM

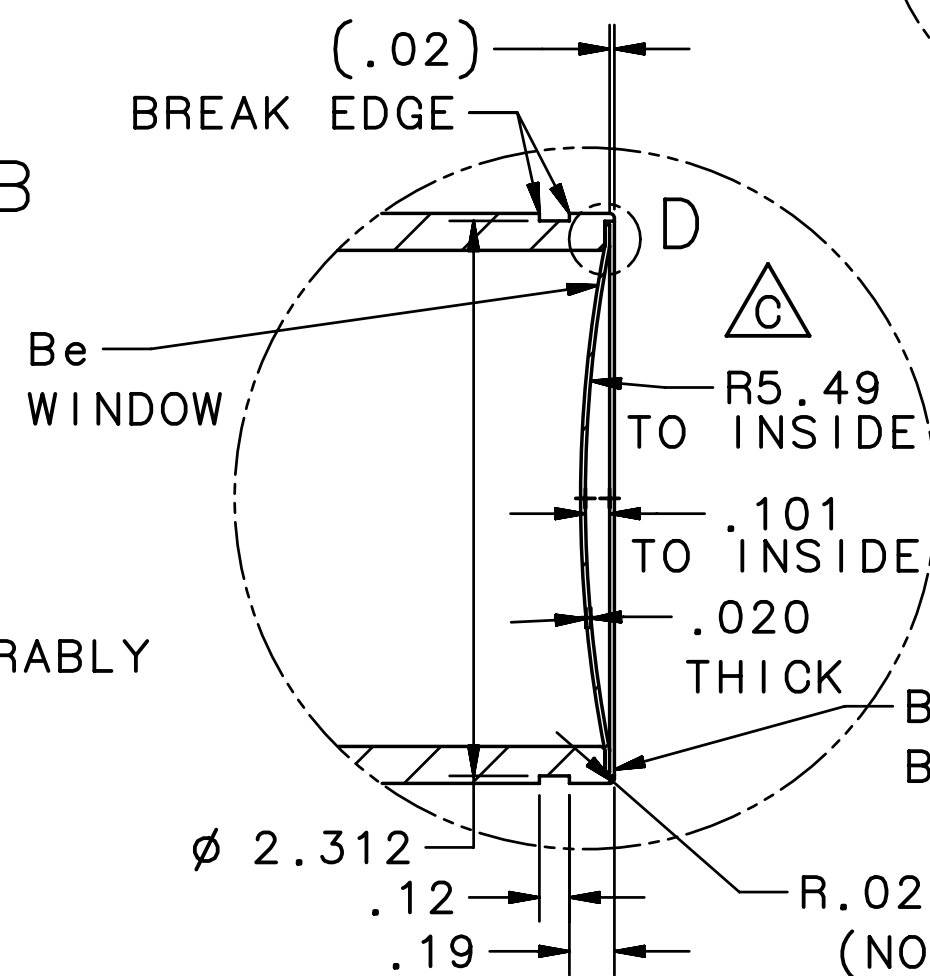


R.020
R.030
TUBE
RADIUS

FULL
PENETRATION
WELD

DETAIL D

WINDOW RADIUS TO MATCH
TUBE ID AND RADIUS
WHEN FORMING



1

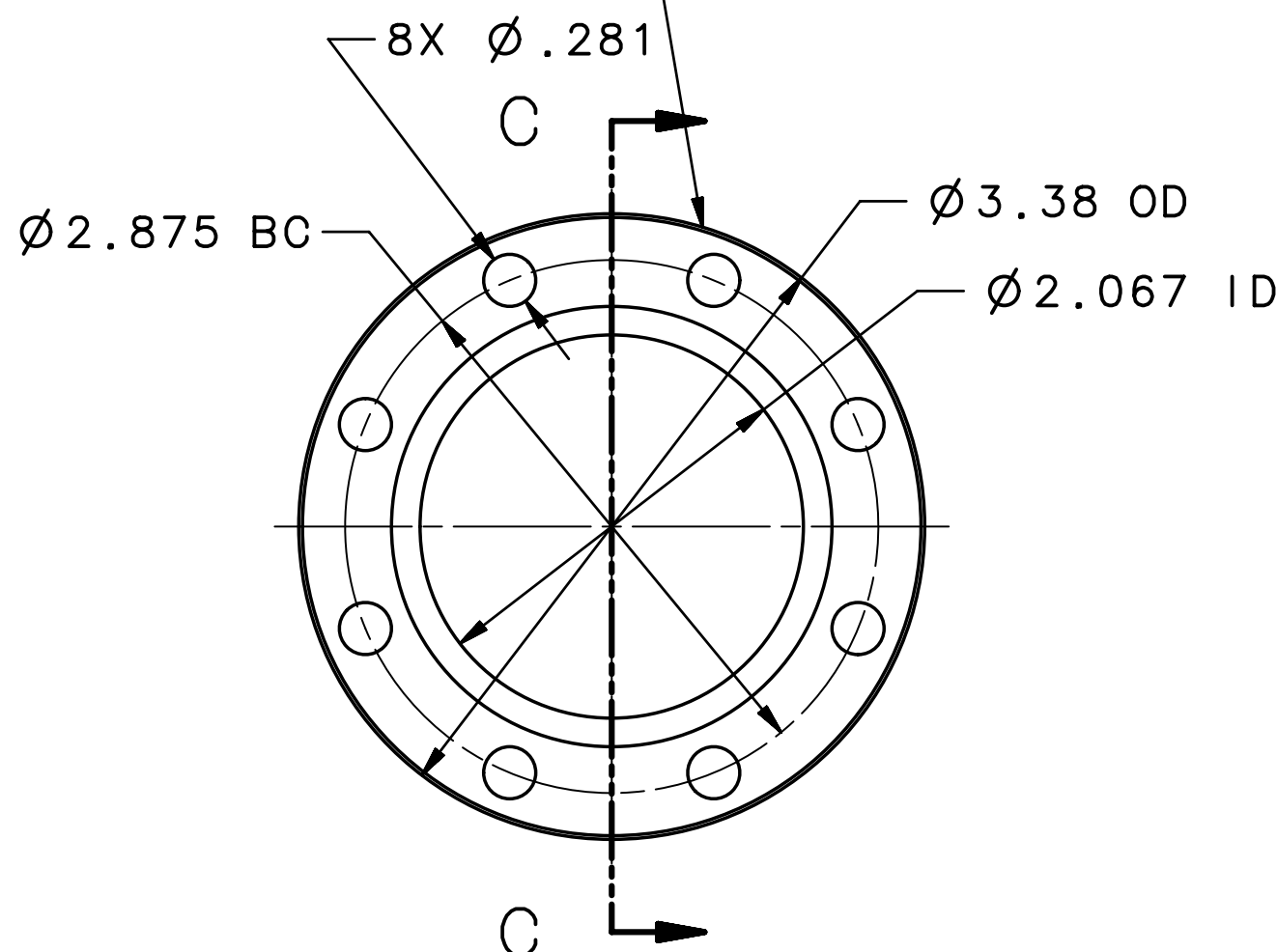
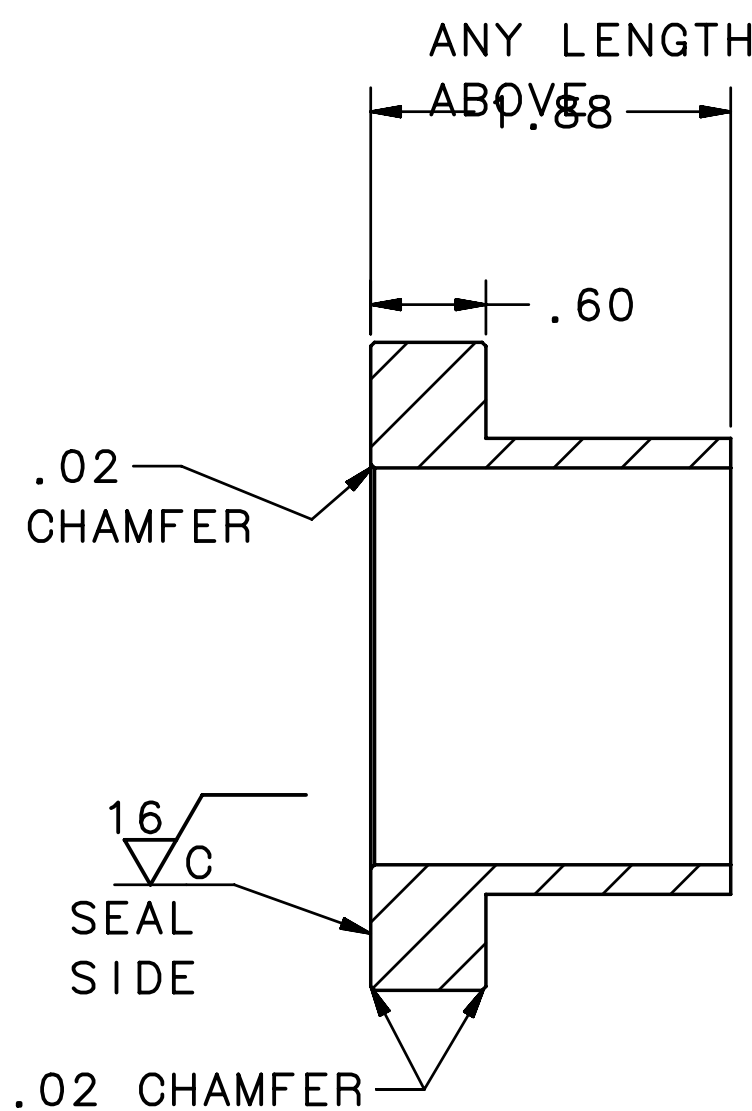
DETAIL B

Be WINDOW AND WELD MUST BE
BELOW TUBE SURFACE

SECTION A-A

PROTECT FLANGE SURFACE
FROM TEMP ABOVE 150F

ALUMINUM 5083-H PREFERABLY
ALUMINUM 5086-H
(NOT O DESIGNATION)



NOTES

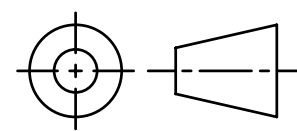
1. Be WINDOW MATERIAL TO BE PS-200
BOTH SIDES COATED WITH BR-127.

2. VACUUM TEST BEAMPIPE ASSY AFTER WELD
TO 1x10E-9 STD ATM CCH_e/SEC IN.

3. FLANGE TO BE VACUUM SEALED FOR STORAGE
PURGE WITH N₂ GAS FOLLOWED BY
IMMEDIATE VACUUM SEAL.

DIM & TOL PER ASME Y14.5 2009
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS DECIMAL ANGLES
± 1/16 .XX ± .01 ± .50°
.XXX ± .005

THIRD ANGLE PROJECTION



MATERIAL
ALUMINUM 5083-H
PREFERABLY
ALUMINUM 5086-H
NOT O DESIGNATION

FINISH 125 UNLESS
MACHINED SURFACES OTHERWISE
DEBURR & BREAK ALL SHARP EDGES

DO NOT SCALE DRAWING

DRAWN
METZGER

DATE
8/10/17

United States
Department
of Energy

Jefferson Lab
Ottomans Jefferson National Accelerator Facility

Newport News
Virginia

HALL C
3He
Be WINDOW BEAMPIPE WELDMENT

SIZE	DWG. NO.	REV.
C	67507-00022	C
SCALE	N/A	USED ON ASSY NO. 67507-00014
SHEET 1 OF 1		