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STATEMENT OF WORK
for the
Forward Hadronic Calorimeter Absorber Structure

Quality Classification: A-3

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REVISION HISTORY

Revision #	Effective Date	Summary of Change
00	12/5/2024	Initial Release
01	1/15/2025	Revised Section 6 Schedule
02	4/7/2025	Included production units as options contingent on BSA-approval of five (5) pre-production units
03	6/3/2025	Revised Section 3.2.2 to indicate testing of first articles will occur at ORNL, removed approval by BSA Technical Representative from Section 3.3.5 and Section 3.4.2, revised Section 4.6.3 to include written approval by the BSA Technical Representative and BSA Contract Specialist, revised Section 5 Deliverables
04	7/15/2025	Section 6 Schedule updated to indicate production units as an option, removed third party testing from Section 4.6.2
05	1/09/2026	Revised to include initial 645 8M module production units as part of the base contract, BNL-QA-101 Clause 4.24 added to Section 4.1, noted that records will be maintained by the Contractor in Section 4.2
06	3/09/2026	Updated requirements for magnetic properties
07	6/18/2026	Updated requirements for laser welding, nickel-plating, and GD&T for pre-production modules

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LIST OF ACRONYMS

ATP	Acceptance Test Procedure
BNL	Brookhaven National Laboratory
BSA	Brookhaven Science Associates
DOE	Department of Energy
EIC	Electron-Ion Collider
Fe/Sc	Iron-Scintillator
GD&T	Geometric Dimensioning and Tolerancing
IP-6	Experimental Hall of the EIC Detector
ISO	International Organization for Standardization
LFHCal	Longitudinally segmented Forward Hadronic Calorimeter
MRP	Material Requirements Planning
M&TE	Measuring and Test Equipment
NIST	National Institute of Standards and Technology
ORNL	Oak Ridge National Laboratory
PO	Purchase Order
QA	Quality Assurance
SOW	Statement of Work

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Statement of Work for the Forward Hadronic Calorimeter Absorber Structure

1 SCOPE

This Statement of Work (SOW) will be the basis for the procurement of the Absorber Structure for the Longitudinally segmented Forward Hadronic Calorimeter (LFHCal) of the Electron-Ion Collider (EIC) General Purpose detector to be built in the EIC interaction region IP-6 (Experimental Hall of the EIC Detector) at Brookhaven National Laboratory (BNL) managed by Brookhaven Science Associates (BSA). This document outlines the Contractor's responsibilities and obligations necessary for completing the requirements as set forth herein.

1.1 Background

The EIC Project will design, build, and install the accelerator hardware for a new electron storage ring, an electron injector, and modifications to the hadron ring required to produce an electron-ion collider and its infrastructure. It will include one interaction region, with an allowance for a second, and one detector. The facility is designed to meet requirements to ensure high reliability and availability for the user program.

The detector in IP-6 will provide an almost 4π coverage in tracking, particle identification, electromagnetic and hadronic calorimetry. The hadronic calorimeter in the forward (hadron-going) endcap is of a particular importance, to measure highly energetic particle jets with a sufficient energy resolution, isolate the jet neutral components (neutrons and K_L particles), complement tracking and electromagnetic calorimetry in particle flow algorithms, and be an integral part of the detector solenoid magnetic field flux return.

The LFHCal is an Iron-Scintillator (Fe/Sc) sampling sandwich calorimeter, where 16 mm thick steel plates are alternated with 4 mm thick scintillator plates (for a total of 60 layers each) with a depth of around 1.32 meters. All absorber layers will be made of a magnetic carbon steel because they are part of the EIC detector solenoid magnetic flux return. The full LFHCal is comprised of 1138 modules; 1066 are of the 8M layout and 72 are of the 4M layout. The 8M modules have a transverse size of about 200 mm (width) by 100 mm (height) and the 4M modules are one half of an 8M module in transverse size (100 mm x 100 mm). In addition, there are two insert modules (insert left and insert right) which have a combined transverse size of 600 mm x 600 mm with a conical opening to allow for the beampipe to pass through. The steel pieces are laser beam welded to one module. Nickel-plating of each full weldment to prevent corrosion shall be included as an option to this contract. The total scope of this Statement of Work is for an initial five (5) pre-production steel absorber modules of type 8M, with follow-on production of 845 8M modules (subject to acceptance of the 5 pre-production units) an option for 216 8M modules and 72 4M modules, and an option for nickel-plating of all units (pre-production and production)

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Early start of procurement of these Absorber Steel Structures is of a paramount importance for EIC, since it allows one to start the calorimeter module assembly shortly after the Department of Energy (DOE) CD-3 approval, and therefore finish the assembly and installation in IP-6 in 2031, on time for the solenoid acceptance tests.

2 APPLICABLE DOCUMENTS

In the event of a conflict between the Technical Documentation and this SOW, the Contractor shall immediately notify the BSA Contractual Representative who will in each instance determine which document takes precedence and advise the Contractor accordingly. Failure to notify BSA of a document conflict shall not relieve the Contractor's responsibility to ensure full compliance to all requirements.

The following documents are an integral part of the SOW; the applicable revision level will be the latest that is in effect at the time of award:

Document Number	Document Title
EIC-DET-SPC-021	Technical Specification for the Forward Hadronic Calorimeter Absorber Structure
BNL-QA-101	Brookhaven National Laboratory Supplier Quality Assurance Requirements
EPC-FWD-HCL-DET-ASM-100	A full set of engineering drawings for 8M modules
EPC-FWD-HCL-DET-ASM-200	A full set of engineering drawings for 4M modules

3 REQUIREMENTS

In accordance with the applicable specifications, referenced documents, and instructions as defined in this Statement of Work, the Contractor shall be responsible for the following.

3.1 Contractor Responsibilities

3.1.1 Technical Performance

In accordance with this SOW, BSA technical specification EIC-DET-SPC-021, and all referenced documents, the Contractor shall furnish all equipment, materials, tools, facilities, and labor to perform the work necessary to manufacture and test the Absorber Steel Structure on time, in the required quantity. The Contractor shall ensure that the finished product meets the performance parameters and criteria in accordance with BSA specification EIC-DET-SPC-021 and all other referenced documents. Failure to provide

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Steel Absorber Structures that satisfy the technical specifications outlined in EIC-DET-SPC-021 and all referenced documents will result in replacement of Steel Absorber Structure at the cost of the Contractor.

3.1.2 Tooling/Fixtures/Test Equipment

The Contractor shall be responsible for supplying all materials, including (but not limited to) the construction of all tools, jigs, fixtures, and test equipment required to meet the requirements of this SOW and technical specification.

3.1.3 Materials

The Contractor shall have an effective storage and age control system for items where acceptability is limited by the age or manner of storage of the item. Storage in a dry area and shipment in weatherproof containers are required.

3.2 Manufacturing Requirements

3.2.1 Detailed Analysis Requirements

The Contractor shall describe the methods and equipment to be used to control the dimensions of all parts and the assembled (laser beam welded) steel absorber module. This includes the application of an optional coating of electroless nickel-plating.

3.2.2 Approval to Proceed

The approval to proceed shall be granted in writing by BSA, based on the results of the tests with first article modules, carried out at Oak Ridge National Laboratory (ORNL). For this purpose, five (5) steel absorber modules of type 8M shall be provided to ORNL.

3.2.3 Manufacturing, Inspection and Test Requirements

All absorber plates and casing parts shall be manufactured according to geometric tolerances in the technical drawings EPC-FWD-HCL-DET-ASM-100 and EPC-FWD-HCL-DET-ASM-200. The material chemical composition shall match the technical specification EIC-DET-SPC-021 and material properties shall be documented. The fully laser beam welded modules shall be tested for dimensions and tolerance compliance (full Geometric Dimensioning and Tolerancing (GD&T) for the five pre-production modules and a limited number of dimensions for the remaining production units). Refer to Technical Specification EIC-DET-SPC-021 for requirements for number of dimensions.

3.2.4 Acceptance Test Procedures (ATP)

The Contractor shall provide an ATP that is in accordance with this SOW, the specification, and all reference documents noted herein. The ATP must be approved in writing by BSA prior to use. The ATP shall ensure that all test requirements as defined in the specification are achieved.

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Site acceptance testing at ORNL will include a complete characterization according to the ATP of all delivered complete modules. Modules which fail the requirements as specified in EIC-DET-SPC-021 will be returned to the Contractor for replacement.

3.3 Management

3.3.1 Program Plan

Within four (4) weeks after award of Contract, the Contractor shall deliver a detailed program plan which includes a milestone schedule defining the manufacturing, inspection, and testing phases in sufficient detail to allow regularly scheduled progress monitoring.

3.3.2 Progress Communications

Within four (4) weeks after award of Contract, bi-weekly program technical and progress telecommunications and/or meetings between the Contractor and BSA shall be held at a mutually scheduled time. The discussions shall include the Contractor's progress, technical and contractual questions, presentations of analysis or testing results, design reviews, value engineering, troubleshooting, material status, tooling status, resources, and manufacturing issues.

3.3.3 Manufacturing/Inspection/Test Plan

A Manufacturing/Inspection/Test plan shall be developed which identifies the manufacturing processes required to complete all efforts as identified in this SOW. The plan shall be submitted for review and approval by BSA within four (4) weeks after award of Contract. The plan shall include manufacturing, inspection, and test steps.

The plan may be a single document or may make use of existing travelers or other suitable planning and control documents. It shall address the Material Requirements Planning (MRP), and at a minimum include manufacturing, inspection, and test steps including identification of critical manufacturing operations and parts/subassemblies showing integrated flow into the end item(s).

If the Contractor does not have an MRP system in place, then details for purchasing all raw materials, shop loading (by work center), and a schedule for manufacturing all components and assemblies through packaging and shipping shall be provided by the Contractor.

3.3.4 Performance Reporting

Throughout the life of the Contract, the Contractor shall supply a written report by the fifth of every month to the BSA Technical Representative and Contractual Representative clearly detailing progress through the prior month with respect to the program. This shall include milestone charts, detailed progress, open items, problems, recommended solutions, and risk mitigation.

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3.3.5 "Witness" Points

BSA reserves the right, after review of the Contractor Manufacturing/Inspection/Test Plan, to designate selected manufacturing, inspection, and/or test operations as "witness" points. The Contractor shall provide BSA with ten (10) working days' notice in advance of such witness points during the manufacturing and test cycle.

3.4 Documentation and Data Management

3.4.1 Report/Documentation Format

a. All reports submitted shall include an introduction, body of the documents, and a conclusion. Large documents shall include a table of contents. For calculations, equations shall be shown with values defined for each variable so the analysis can be reviewed. Diagrams shall be included for clarity and labels shall be consistent with design drawings for specific items.

b. All documentation provided by the Contractor shall be in English.

c. The Contractor shall provide an electronic copy (BSA-identified FTP, DVD or USB data storage device) of all documentation required by this SOW. Contractor manufacturing Computer-Aided Design files of all components and assemblies shall be in one of these formats: STP, SAT, IGES, IAM, or IPT.

3.4.2 End Item Documentation Package

The Contractor shall provide with the End Item documentation package an electronic copy as well as three (3) physical copies of the following documentation in accordance with the schedule set forth in this SOW. The End Item documentation package shall consist of all documentation identified in this SOW and include the following:

a. Manufacturing Travelers: Manufacturing Travelers that include documentation of visual and dimensional inspections, materials, cleaning procedures, vacuum bake-outs, etc. shall be provided.

b. Final Inspection and Test Reports: Final test reports of all required or necessary inspections, examinations, and tests, properly validated by the Contractor's authorized personnel shall be recorded and compiled in a measurement and test report and be supplied to BSA.

c. A listing of the delivered items, using a unique parts list or other such means of positive identification.

d. Material Certificates: Copies of material test reports for specified materials, showing physical and chemical properties.

e. Copies of permeability measurements of the magnetic steel.

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f. Nonconformance Reports: Nonconformance reports identified as "rework / repair" or "use-as-is" shall be provided.

g. Certificate of Conformance

The Contractor shall provide a Certificate of Conformance that certifies the following:

- Materials used are those which have been specified by BSA, and the items delivered were produced from materials for which the Contractor has on file, reports of chemical or physical analysis, or any other equivalent evidence of conformance.
- Processes used in the fabrication of items delivered were in compliance with the SOW or BSA-approved procedures or specifications.
- The items as delivered comply with all applicable specifications, and other requirements of the procurement documentation.

3.4.3 Records

The Contractor shall retain objective evidence, including records, of the inspections and tests performed in the course of manufacturing, testing, inspecting, preserving, packaging, and preparation for shipment of procured items. These records shall be made available to BSA for review upon request. These records shall be maintained for a minimum of three (3) years, unless otherwise specified in the procurement documentation, after the completion of the Purchase Order (PO)/Contract.

3.5 Marking and Serialization

Where labeling is required, the position of serialization and/or labeling of the identification number/nameplate shall be agreed upon between the Contractor and BSA prior to acceptance of the final design. All completed modules shall have identifiable unique labeling to ease tracking of components.

4 QUALITY ASSURANCE

4.1 Quality System and Facility Access

The Contractor shall maintain and apply an effective and documented quality assurance system for the design, manufacture, and testing of all equipment provided. The system shall meet the requirements of the ISO-9001 Standard, "Quality Management Systems Requirements", and shall provide the processes to ensure that each component produced for acceptance conforms to the requirements of this document and the applicable technical documentation. The Contractor shall supply the necessary documentation to demonstrate this compliance. Post-award surveys may be required and shall be supported by the Contractor. In addition, BSA representatives will have access to the Contractor's facility during agreed-upon fabrication, inspection and testing processes. The Contractor shall provide ten (10) working days' notice in advanced of the agreed-upon witness points.

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As set forth in BSA Form BNL-QA-101, "Brookhaven National Laboratory Supplier Quality Assurance Requirements," as amended herein, forms a part of this statement of work. Specifically, this includes the following sections:

1, 2, 3, 3.1, 3.1.2, 3.2 to 3.22, 4.0, 4.1, 4.2, 4.3 ,4.4 as modified below, 4.4.1, 4.4.2, 4.4.3, 4.5 as modified below, 4.6, 4.7, 4.7.1, 4.7.3, 4.10, 4.10.1, 4.10.2, 4.10.3 4.10.4, 4.11, 4.13, 4.14, 4.15, 4.16, 4.18, 4.18,2, 4.18.3, 4.18.4, 4.19, 4.21, 4.22, 4.23, 4.24, and 4.39. With each Component delivered, the Contractor shall supply to BSA a Certificate of Conformance, in accordance with section 4.16 of BNL-QA-101.

> *Clause 4.4: Manufacturing / Inspection / Test Plan is modified as follows:* Four weeks after receipt of order the supplier shall submit for the Buyer's approval a Manufacturing / Inspection / Test Plan for the item(s) to be produced.
>
> *Clause 4.5: "Witness" Points, is modified as follows*: The supplier shall provide BNL with ten (10) days' notice in advance of reaching such witness points during the manufacturing and test cycle of each item.

4.2 Configuration Management

The Contractor shall establish and maintain a configuration control system to ensure that all end items (LFHCal 8M and 4M modules) are of the proper configuration. The Contractor shall immediately notify the BSA Contractual Representative of any significant changes (those that may affect form, fit, function, reliability, safety, or interchangeability) in design, fabrication methods, material (including magnetic properties) or processing. Records verifying the configuration of each item shall be maintained by the Contractor for a minimum of five (5) years from the date of acceptance of the equipment by BSA.

For changes in configuration, a request for change approval shall be submitted to BSA for consideration. Changes in configuration may be made by the Contractor only with the written approval of BSA.

4.3 Responsibility for Subcontractor

It is the responsibility of the Contractor to flow down and impose applicable technical and quality assurance requirements upon their contractors and subcontractors. BSA reserves the right to disapprove, in writing, any contractor or subcontractor.

4.4 Responsibility for Conformance

The Contractor is responsible to provide items which conform to the requirements of the PO/Contract regardless of any assessments, surveillances, inspections and/or tests by BSA or its representatives at either the Contractor's or BSA's facility. The Contractor is responsible for notifying the BSA Contractual Representative of any recalls or alerts associated with this PO/Contract.

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4.5 Measuring and Test Equipment (M&TE) Calibration

The Contractor shall calibrate any M&TE used in the fulfillment of the PO/Contract requirements against certified standards that are traceable to national standards such as the National Institute of Standards and Technology (NIST), or an international standard, or a physical constant. The Contractor shall notify BSA of any condition found during the calibration, servicing or repair of measuring and test equipment that can affect the end item requirements.

4.6 Inspections and Test Requirements

Unless otherwise specified in the PO/Contract, the Contractor shall be responsible for the performance of all inspections and tests specified herein. Except as otherwise specified in the PO/Contract, the Contractor shall utilize facilities suitable for the performance of the inspection and test requirements, specified herein, which are acceptable to BSA. BSA reserves the right to re-perform any of the inspections and/or tests set forth in this document or referenced specifications where deemed necessary to ensure that Equipment conforms to prescribed requirements at no cost to the Contractor. BSA and/or their representative shall have the option to witness all of the tests defined in this SOW.

4.6.1 Acceptance Testing

The modules shall be tested by the Contractor at the Contractor's facility, the Contractor's subcontractor's facility, or a pre-approved BSA collaborator prior to shipment, using an ATP (as noted in Section 3.2.2) generated by the Contractor and approved in writing by BSA. BSA or its designee retains the right to witness all testing. Final acceptance of the units shall take place following the successful completion of final testing at ORNL. The time period for the final testing at ORNL shall be within 90 days after receipt of the units at ORNL.

4.6.2 Pre-Production Unit Acceptance

The Contractor shall provide pre-production units built to the specification for evaluation and testing at ORNL. BSA's acceptance of pre-production unit(s) is required prior to the production run. The pre-production unit(s) shall be identified as such, including the PO number/Contract, part number, and part name.

4.6.3 Approval for Production

After the BSA Technical Representative's acceptance of the pre-production unit(s), all of the remaining units required by the PO/Contract shall be produced by the Contractor and the Contractor's suppliers using the same design, materials, processes, methods and tooling that were used to manufacture the approved pre-production unit(s). Any changes must have prior written approval from BSA Technical Representative and BSA Contract Specialist and may require a contractual modification. The Contractor should incorporate all of the costs related to design of the complete LFHCal modules, design and production planning, and production tooling and facilities into the pre-production unit cost. If production of the LFHCal modules is not approved by BSA, there shall be no further cost to BSA.

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4.7 Repairs

If failures occur or repairs are required to an assembly or any component during manufacturing or testing that affects form, fit, function, reliability, safety, or interchangeability the process shall stop and BSA shall be immediately notified. Failure to provide complete LFHCal modules that satisfy the technical specifications outlined in EIC-DET-SPC-021 and all referenced documents will result in replacement of modules at the cost of the Contractor. BSA at their discretion may ask for retesting, additional review and evaluation to determine root causes, analyses of failure modes(s) or proposals for repair. Proposals for repair shall include adequate information for evaluating the repair, testing the effectiveness of the repair, and methods to prevent damage to the existing work. No proposed repair shall be initiated without approval of BSA. No repair shall be considered successfully accomplished without inspection and written approval by BSA. All repairs shall be at the expense of the Contractor. In addition, the Contractor shall not use nonconforming materials via use-as-is disposition without written approval of BSA.

4.8 Failure Reporting, Analysis and Corrective Action

The Contractor shall maintain a failure reporting, analysis, and corrective action system which shall, at a minimum, evaluate, analyze, and correct failures occurring during end-item acceptance testing and inspection. The results of all failure evaluations and analyses shall be documented and available for review by the BSA Contractual Representative.

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5 DELIVERABLES

The Contractor shall supply the following:

Item	Deliverable	Due	BSA Approval
1	Program Plan	Four (4) weeks after award of Contract	Yes
2	Manufacturing/Inspection/Test Plan	Four (4) weeks after award of Contract	Yes
3	Acceptance Test Procedure (ATP)	Prior to first use	Yes
4	Delivery of Pre-Production Units	As set forth in schedule, Section 6	Yes
5	Pre-Production Units End-Item Documentation	As set forth in schedule, Section 6	Yes
6	Delivery of LFHCal modules	As set forth in schedule, Section 6	Yes
7	End Item Documentation	As set forth in schedule, Section 6	Yes

6 SCHEDULE

The following schedule is for planning purposes only. Schedule requirements set forth in the Contract will take precedence.

Milestone	Calendar weeks (maximum) after award
Delivery of five (5) pre-production units	10
End item documentation, pre-production units	10
BSA Evaluation of pre-production units	16
Delivery of 8M modules (batch 1, 845 8M modules)	78
End item documentation (batch 1)	78
Delivery of 8M&4M modules (batch 2, 216 8M modules, 72 4M modules, Option)	130
End item documentation (batch 2, Option)	130

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7 VALUE ENGINEERING

The Contractor is encouraged to make recommendations for changes that might lead to an improvement in performance, reliability, quality, safety, or reduction in cost. Simplicity in operation, ease of maintenance, and an improvement in the performance and reliability of the specific functions beyond the requirements of this specification are objectives which shall be considered in the production. Where it appears a substantial improvement in simplicity of design, performance, ease of maintenance or reliability will result from the use of materials, parts and processes other than those specified, it is desirable that their use be investigated. When investigations point to advantages that may be realized, the recommendation for change shall be presented to BSA for review.

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