

NOTES

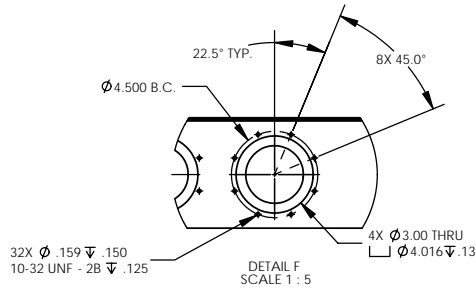
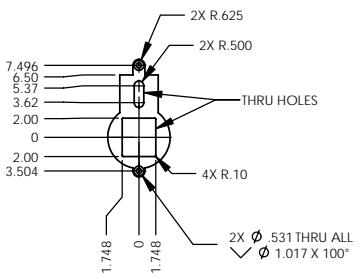
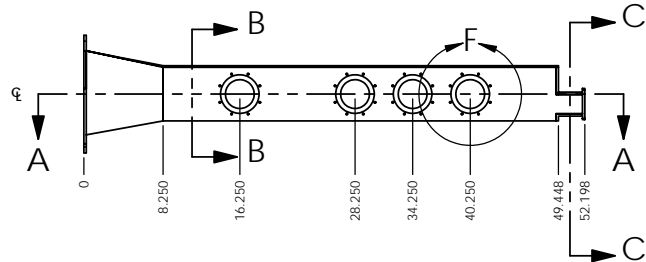
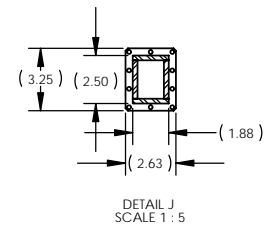
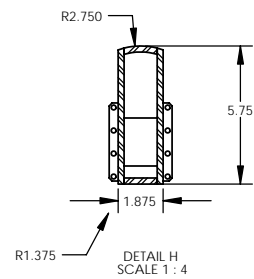
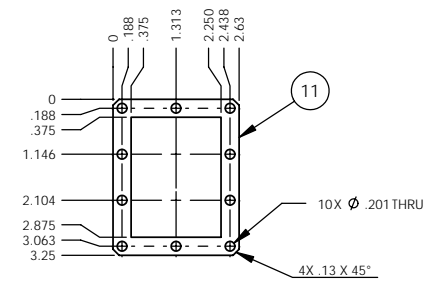
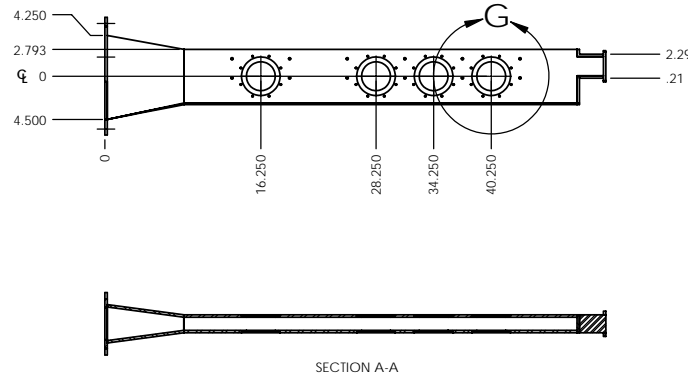
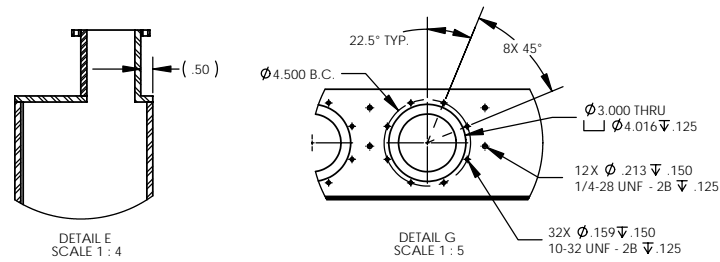
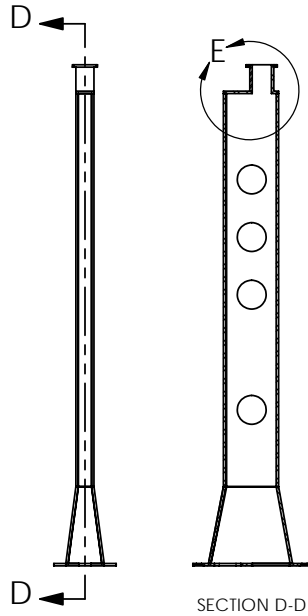
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
12	1	PLATE, 43.95 x 1.38 x .25	SS - 304, ASTM A479	43.95
11	1	PLATE, 2.63 x 3.25 x .25	SS - 304, ASTM A479	3.25
10	1	PLATE, 1.88 x 3.00 x .25	SS - 304, ASTM A479	3.00
9	1	PLATE, 1.88 x 2.75 x .25	SS - 304, ASTM A479	2.75
8	1	PLATE, 1.88 x 3.00 x .25	SS - 304, ASTM A479	3.00
7	1	PLATE - 1.38" X 43.79" X .25" THK	SS - 304, ASTM A479	
6	1	PLATE - 3.50" X 8.25" X .25" THK	SS - 304, ASTM A479	
5	1	PLATE - 3.50" X 8.25" X .25" THK	SS - 304, ASTM A479	
4	1	PLATE - 5.57" X 43.79" X .25" THK	SS - 304, ASTM A479	
3	1	PLATE - 5.57" X 43.79" X .25" THK	SS - 304, ASTM A479	
2	2	PLATE - 8.25" X 9.50" X .25" THK	SS - 304, ASTM A479	
1	1	PLATE - 6.50 x 12.25 x .25	SS - 304, ASTM A479	12.25

<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	UNLESS OTHERWISE NOTED 1. ALL DIMENSIONS ARE IN INCHES 2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M 3. MACHINED FINISH 125 MICRO-INCHES RMS 4. CONCENTRICITY .010 TIR 5. MACHINED ANGLES FORMED ANGLES ±1/2° 6. BREAK SHARP CORNERS AND REMOVE ALL BURRS 7. WHOLE NUMBERS AND FRACTIONS ±1/16 8. X DECIMALS ±.030 9. XX DECIMALS ±.010 10. XXX DECIMALS ±.005		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>			
DES	V GRAVES	06/05/2005	<p align="center">NUFACT HG JET EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT</p>			
DRW	T OQUIN	06/05/2005				
CHK						
ENG	V GRAVES	06/05/2005				
QA			CAD FILE PRI TUBE WELDMENT HJT	PREV ASSY 203-HJT-0610	SCALE 1:5	SHEET 1 of 4
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0611	REV 3	

NOTES

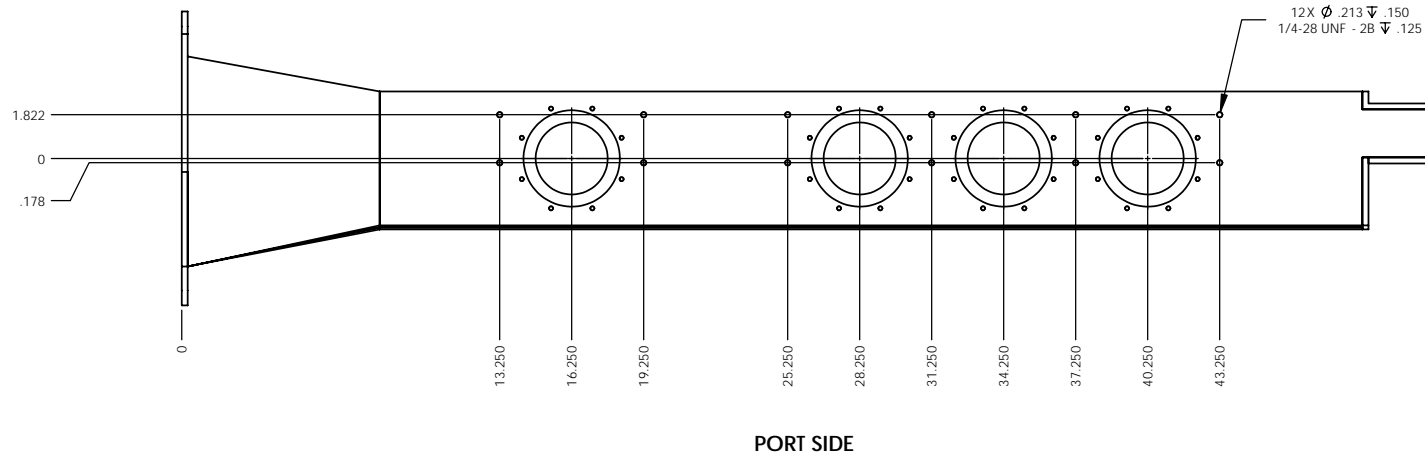
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DRW	T OQUIN	06/05/2005				
CHK						
ENG	V GRAVES	06/05/2005				
QA			CAD FILE PRI TUBE WELDMENT HJT	PREV ASSY 203-HJT-0610	SCALE 1:10	SHEET 2 of 4
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0611	REV 3	

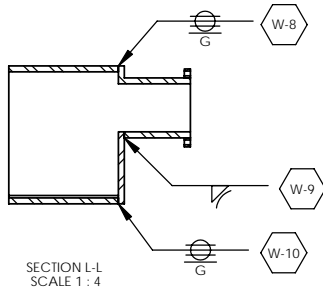
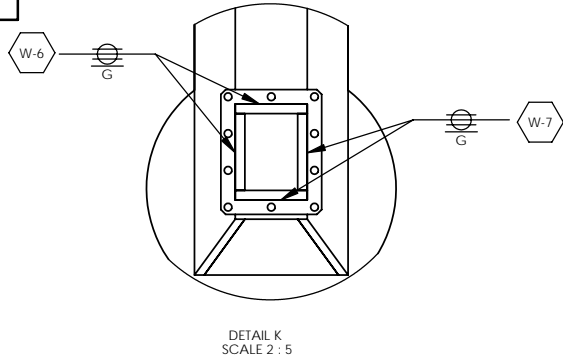
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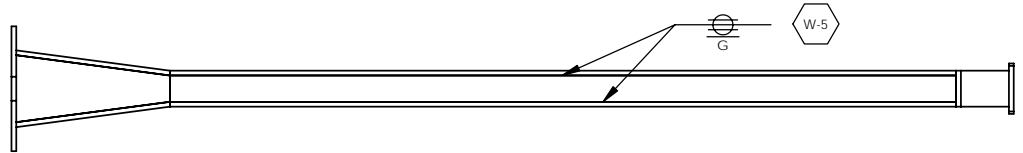
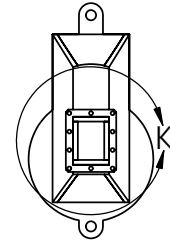
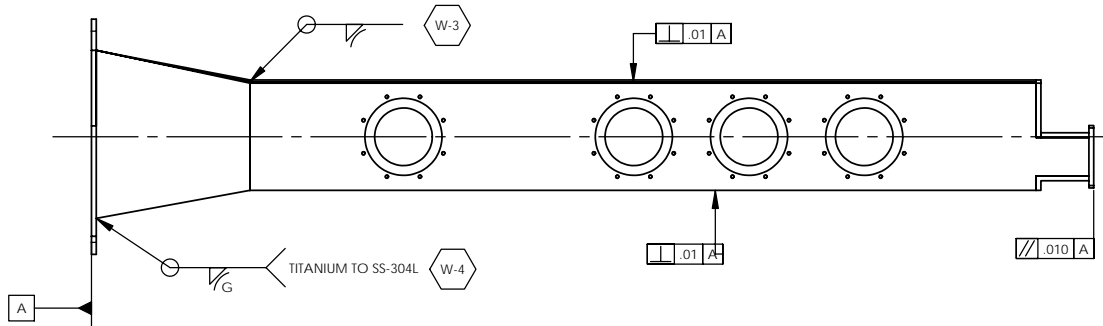
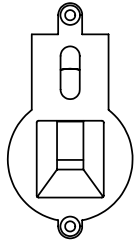
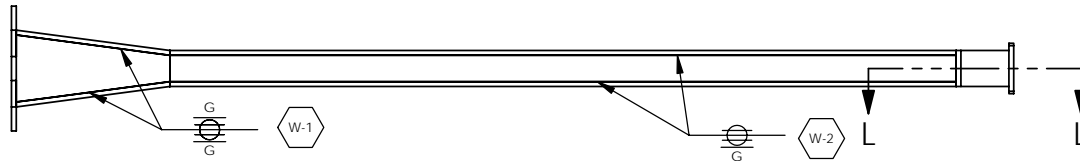
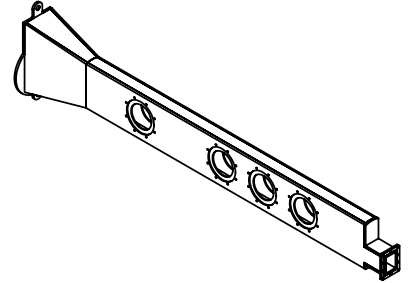
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DES V GRAVES 06/05/2005 DRW T OQUIN 06/05/2005 CHK ENG V GRAVES 06/05/2005 QA			<p>NUFACT HG JET EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT</p>		
DRAWING APPROVALS DATE			CAD FILE PRI TUBE WELDMENT HJT	PREV ASSY 203-HJT-0610	SCALE 1:4
SIZE DWG NO. C			SHEET 3 of 4		
DATE			REV 3		
203-HJT-0611			203-HJT-0611		

S THIS DRAWING PRODUCED ON SOLIDWORKS



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<p>DRAWING APPROVALS</p> <p>DATE</p>		<p>NUFACT HG JET EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT</p>		<p>CAD FILE PRI TUBE WELDMENT HJT</p> <p>PREV ASSY 203-HJT-0610</p> <p>SCALE 1:5</p> <p>SHEET 4 of 4</p>
<p>SIZE DWG NO. C</p>		<p>203-HJT-0611</p>		<p>REV 3</p>

DWG NO. 203-HJT-0611