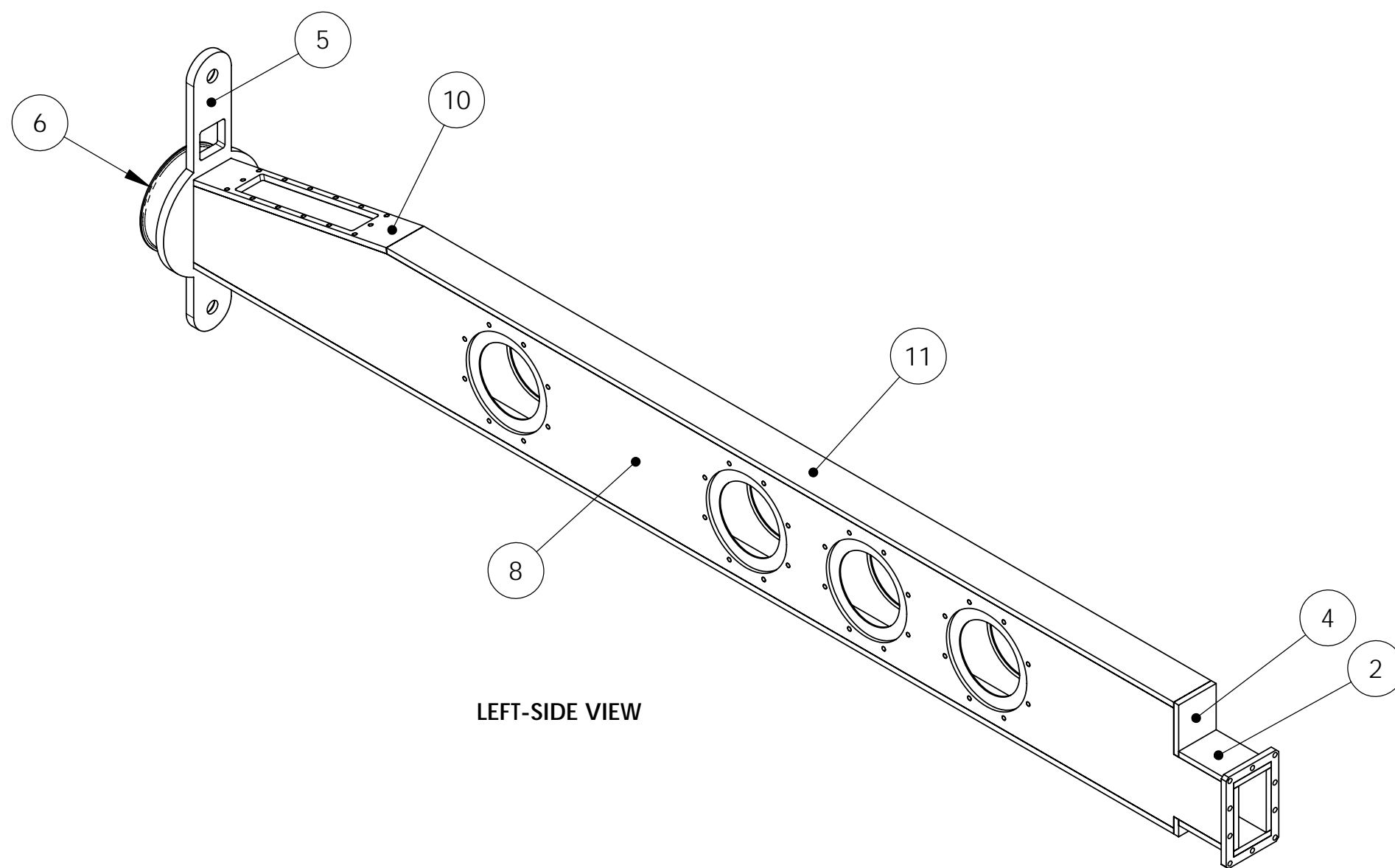
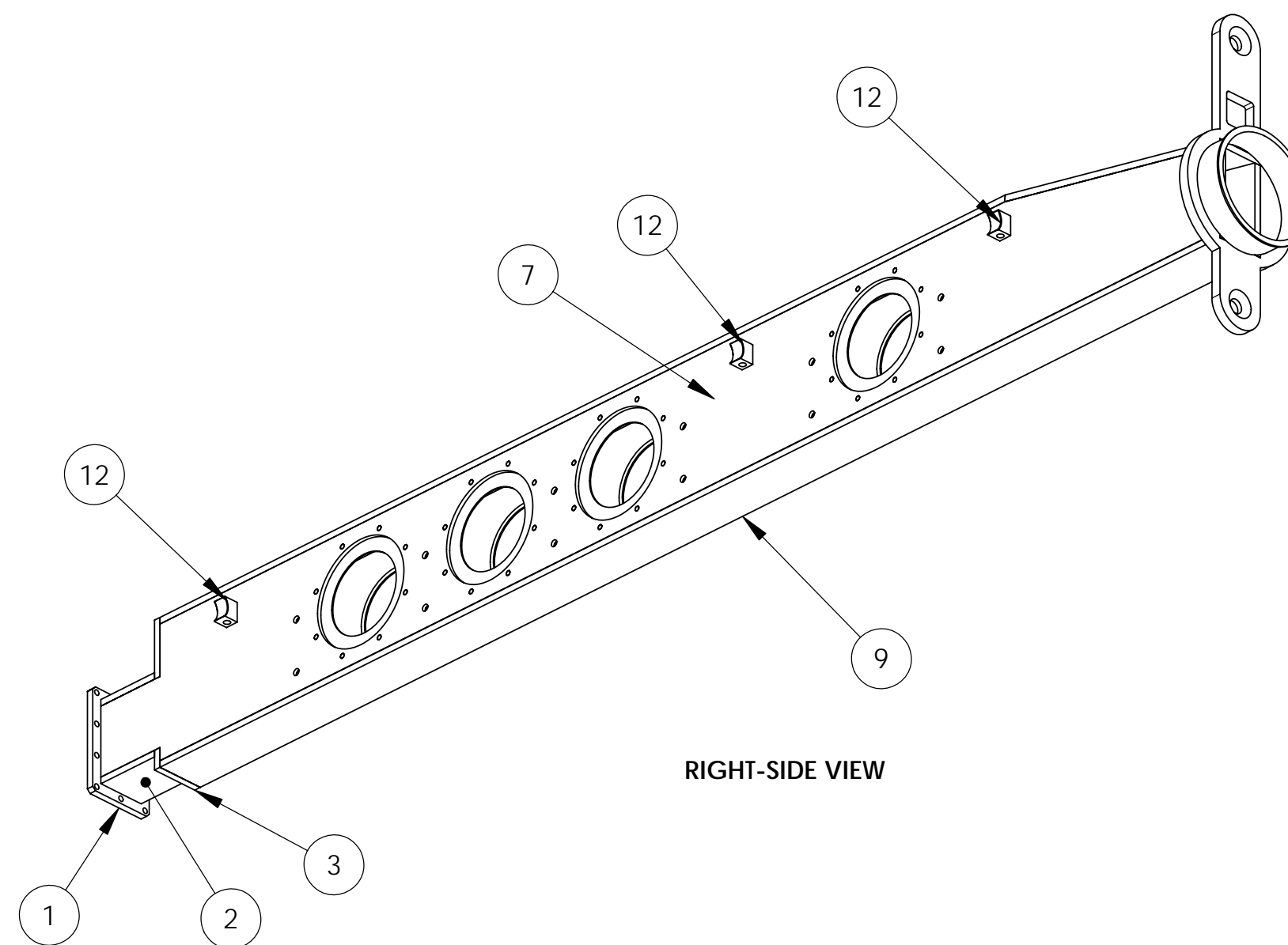


NOTES

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3. MATERIAL CERTIFICATIONS REQUIRED.



LEFT-SIDE VIEW



RIGHT-SIDE VIEW

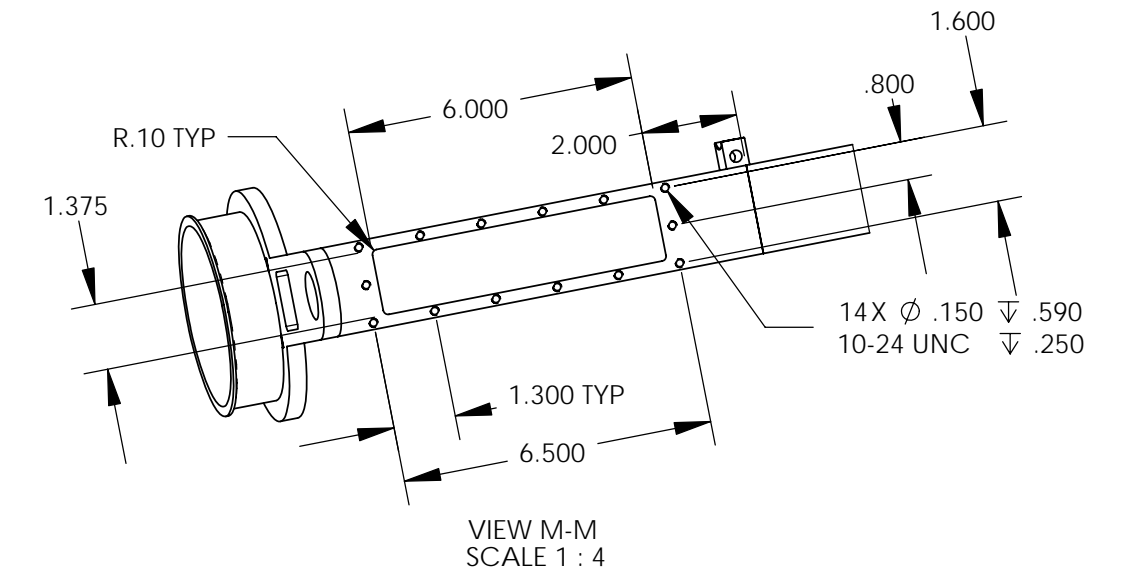
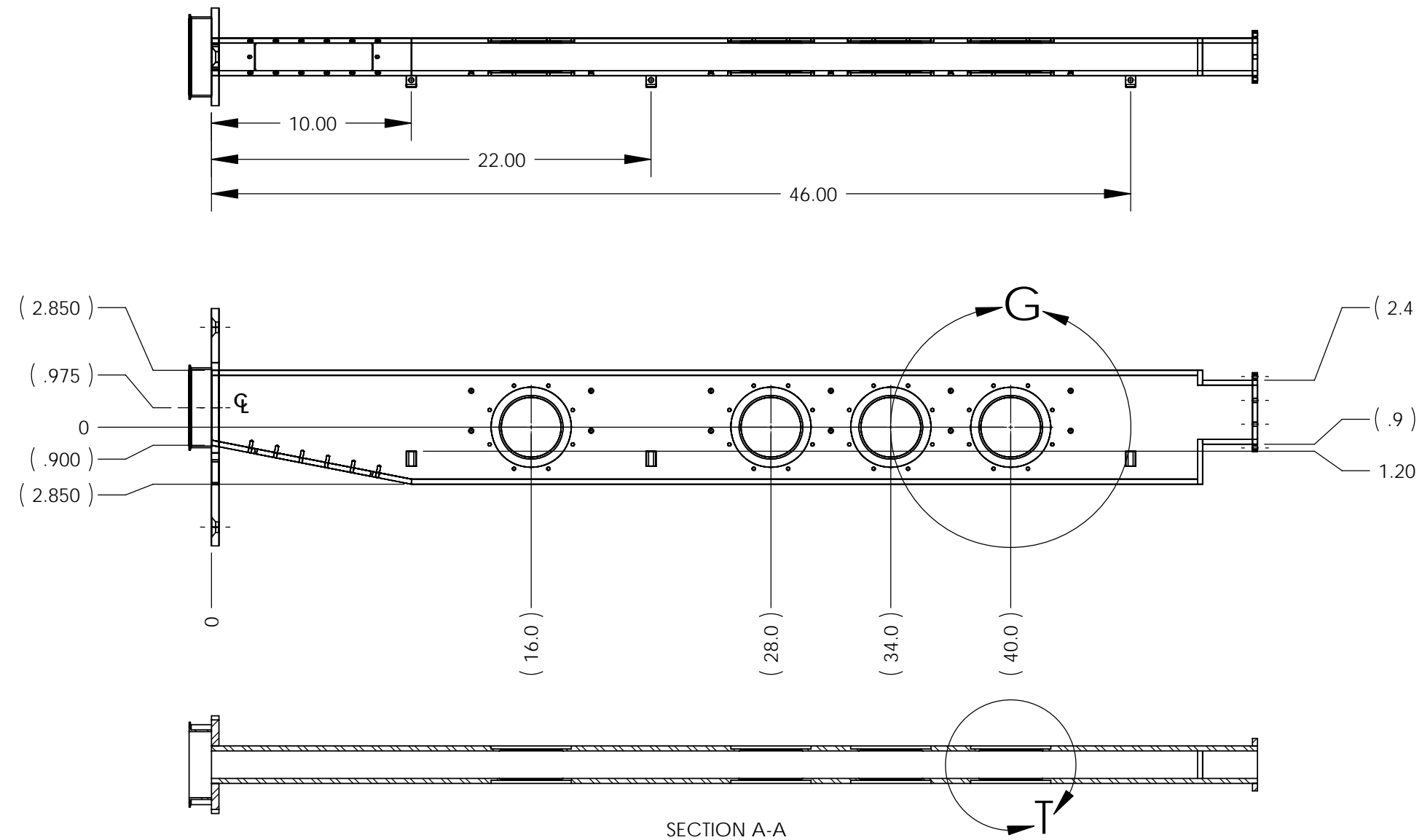
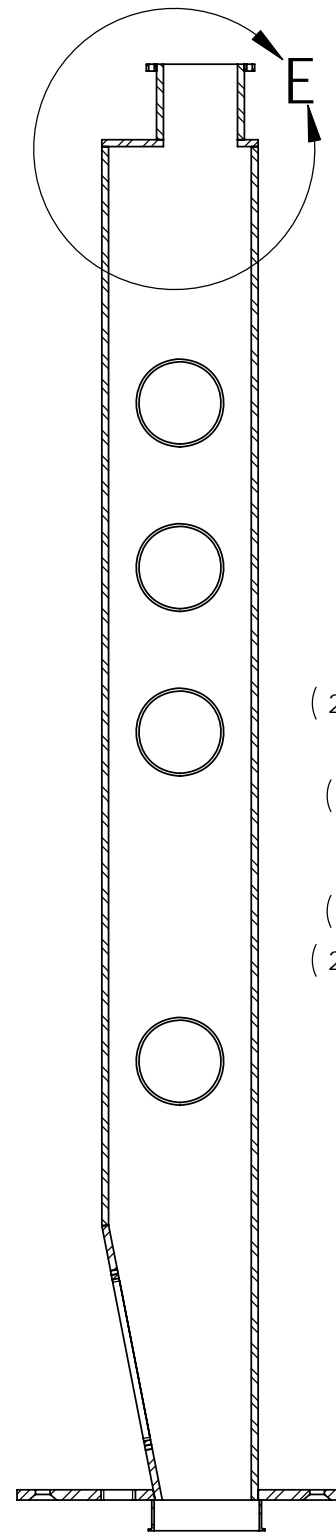
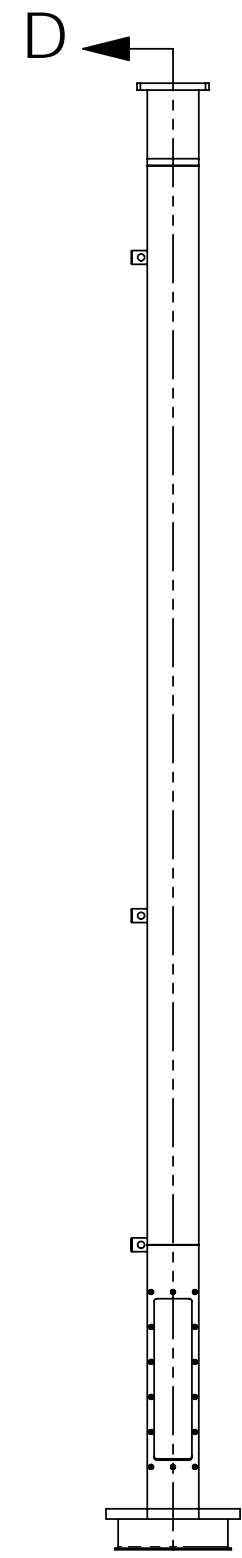
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
12	3	BAR, .50 x .75 x .75	SS - 316L, ASTM A276	.75
11	1	PLATE, 39.33 x 1.88 x .25	SS - 316L, ASTM A240	39.33
10	1	PLATE, 10.21 x 1.88 x .25	SS - 316L, ASTM A240	10.21
9	1	PLATE, 49.35 x 1.88 x .25	SS - 316L, ASTM A240	49.35
8	1	PLATE, 5.20 x 52.35 x .25	SS - 316L, ASTM A240	52.35
7	1	PLATE, 52.35 x 5.20 x .25	SS - 316L, ASTM A240	52.35
6	1	SWAGELOK 4.00" BUTT WELD FERRULE JC14AM7	SS	N/A
5	1	PLATE, 4.89 x 11.88 x .38	SS - 316L, ASTM A240	11.88
4	1	PLATE, 2.25 x 1.88 x .25	SS - 316L, ASTM A240	2.25
3	1	PLATE, .75 x 1.88 x .25	SS - 316L, ASTM A240	.75
2	2	PLATE, 1.88 x 2.75 x .25	SS - 316L, ASTM A240	2.75
1	1	PLATE, 2.63 x 3.95 x .25	SS - 316L, ASTM A240	3.95

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DES	V GRAVES	06/05/2005	<p>MERIT EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT</p>			
DRW	T OQUIN	06/05/2005				
CHK	P SPAMPINATO	03/07/2006				
ENG	V GRAVES	06/05/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			PRI TUBE WELDMENT HJT	203-HJT-0610	1:5	1 of 5
			SIZE	DWG NO.		REV
			C	203-HJT-0611		0
DRAWING APPROVALS		DATE				

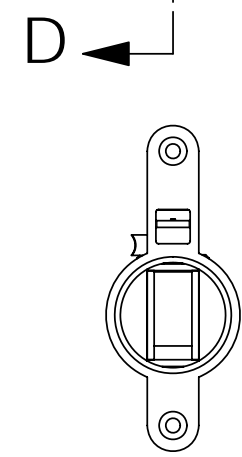
S THIS DRAWING PRODUCED ON SOLIDWORKS

NOTES

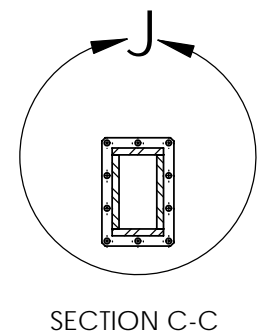
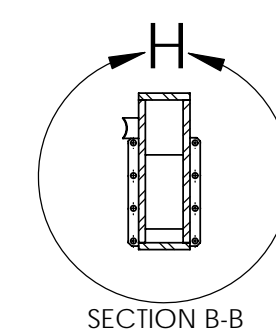
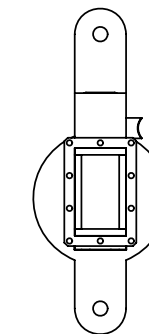
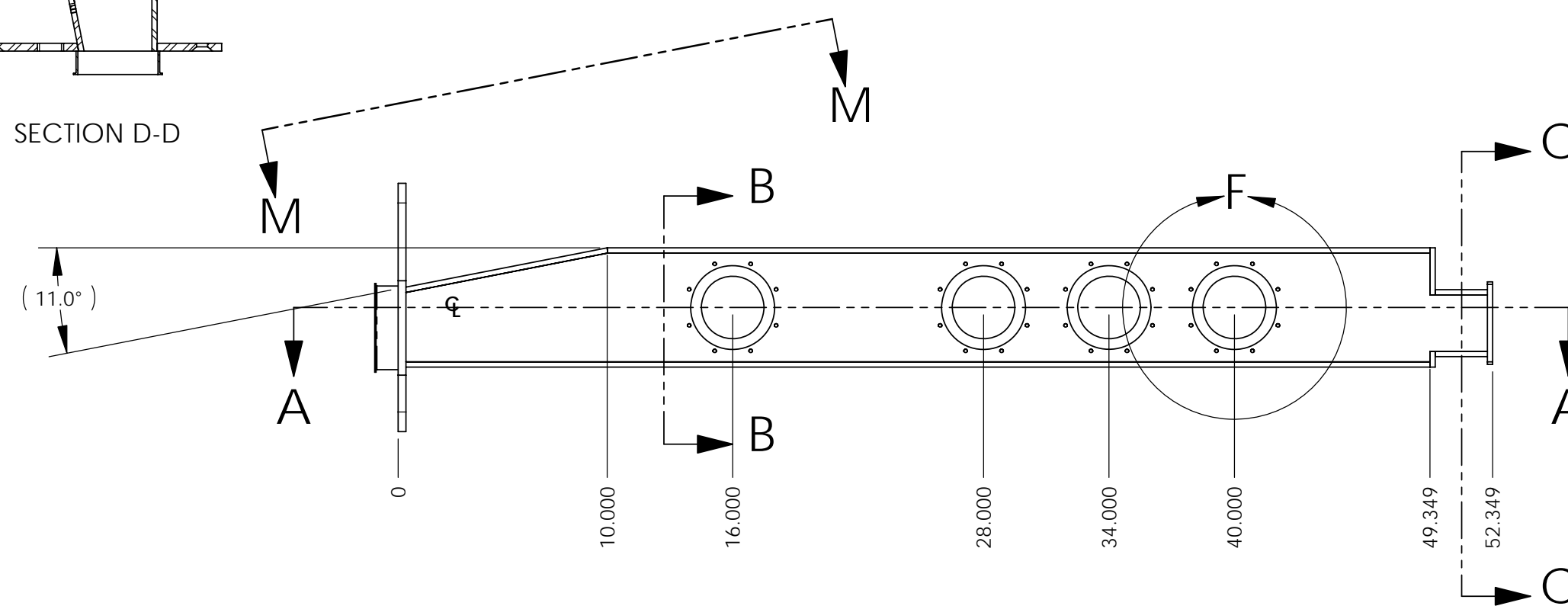
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DETAIL VIEWS ON SHEET 3



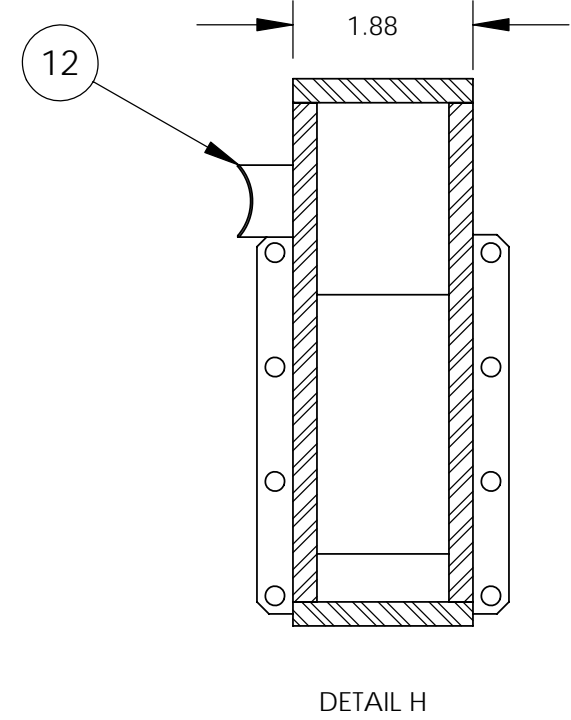
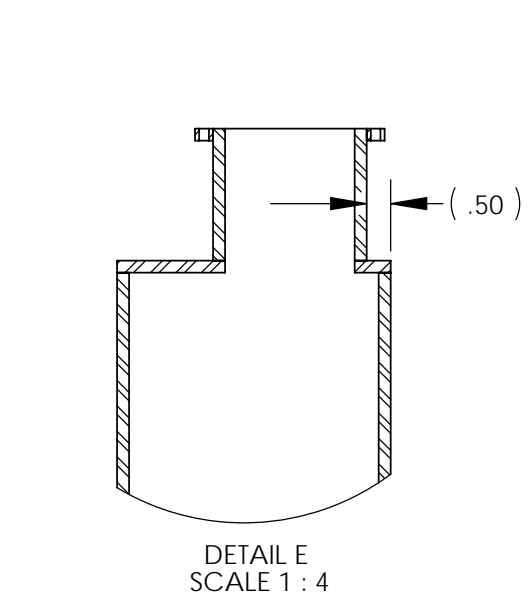
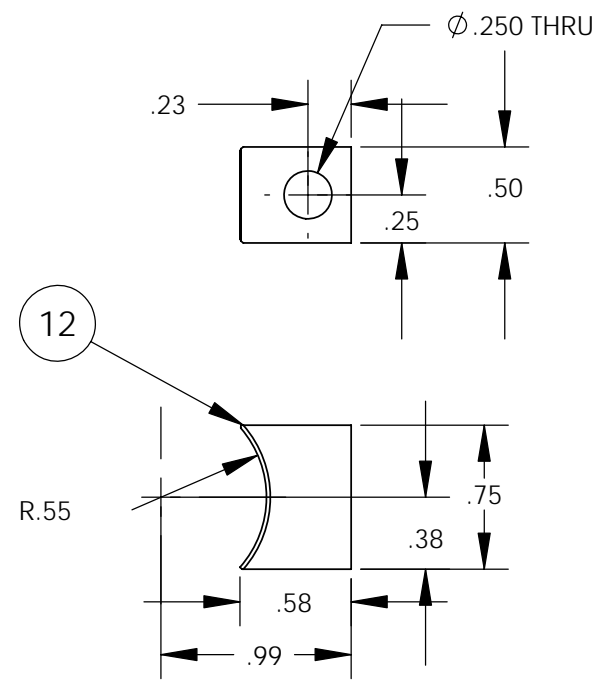
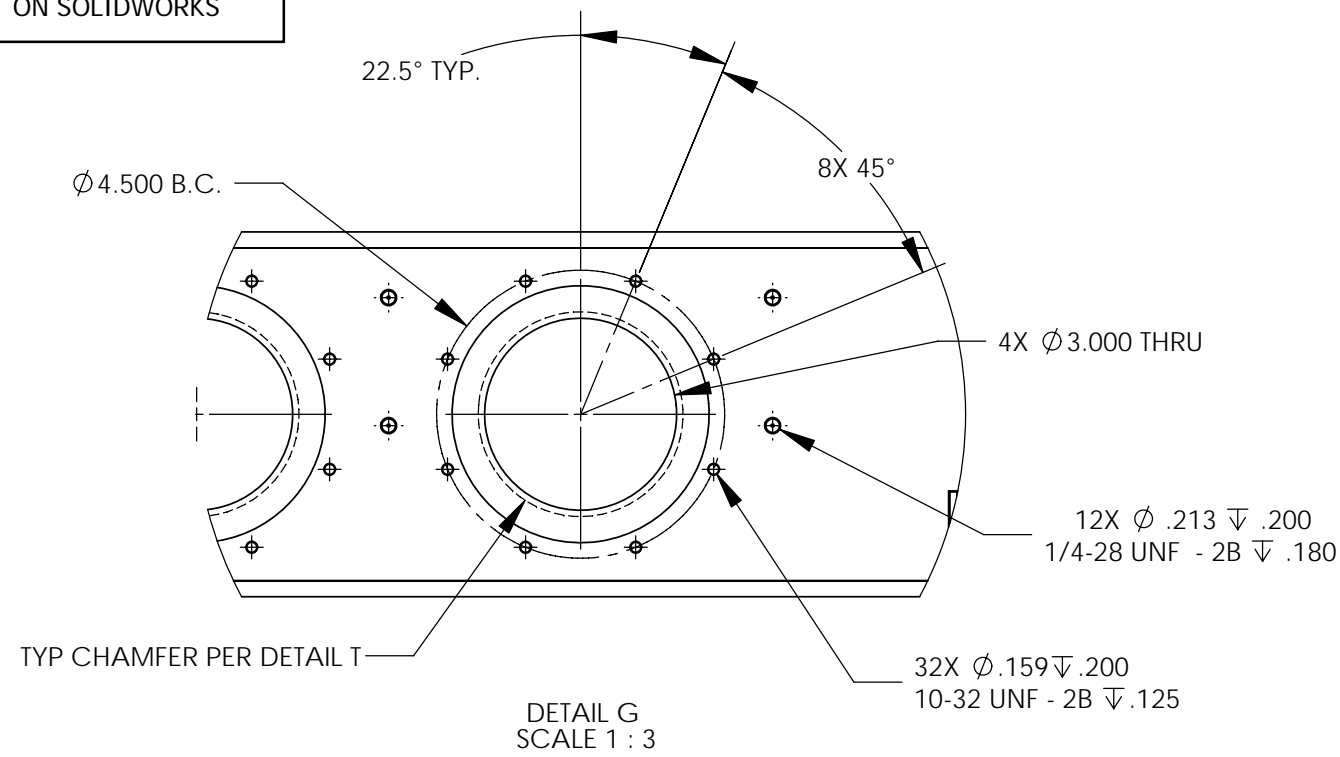
SEE DETAIL "X"



<p>THIRD-ANGLE PROJECTION</p>	<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>			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>																
	<p>UNLESS OTHERWISE NOTED</p> <ol style="list-style-type: none"> 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 ±1/2° 6. FORMED ANGLES ±1° 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS ±1/16 9. X DECIMALS ±.030 10. XX DECIMALS ±.010 11. XXX DECIMALS ±.005 			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>																
<table border="1"> <tr> <td>DES</td> <td>V GRAVES</td> <td>06/05/2005</td> </tr> <tr> <td>DRW</td> <td>T OQUIN</td> <td>06/05/2005</td> </tr> <tr> <td>CHK</td> <td>P SPAMPINATO</td> <td>03/07/2006</td> </tr> <tr> <td>ENG</td> <td>V GRAVES</td> <td>06/05/2005</td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> </table>			DES	V GRAVES	06/05/2005	DRW	T OQUIN	06/05/2005	CHK	P SPAMPINATO	03/07/2006	ENG	V GRAVES	06/05/2005	QA			<p>MERIT EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT</p>		
DES	V GRAVES	06/05/2005																		
DRW	T OQUIN	06/05/2005																		
CHK	P SPAMPINATO	03/07/2006																		
ENG	V GRAVES	06/05/2005																		
QA																				
<p>DRAWING APPROVALS DATE</p>																				
<p>CAD FILE: PRI TUBE WELDMENT HJT PREV ASSY: 203-HJT-0610 SCALE: 1:7 SHEET: 2 of 5</p>			<p>SIZE: DWG NO. 203-HJT-0611 REV: 0</p>																	

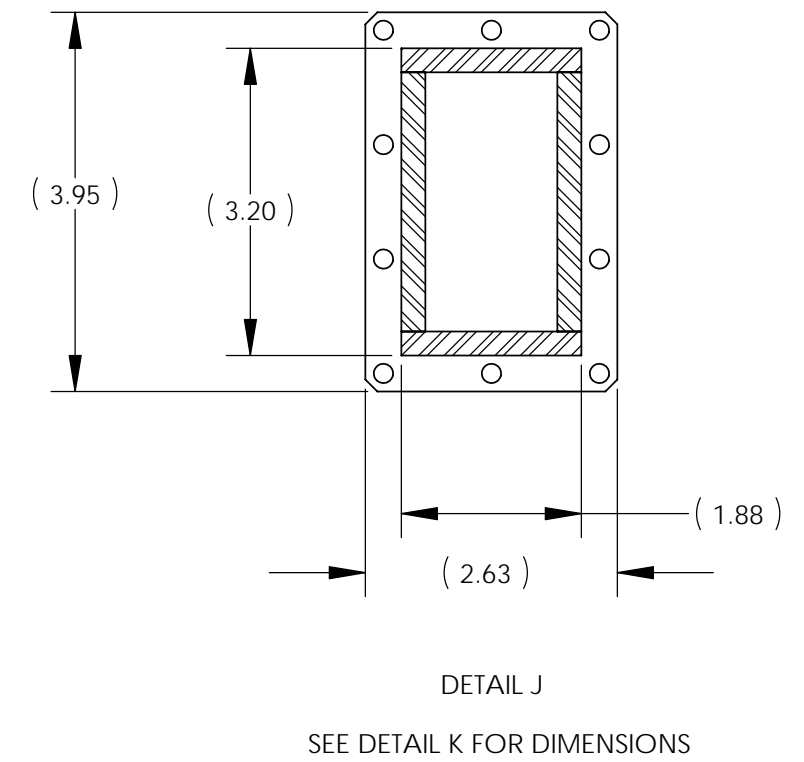
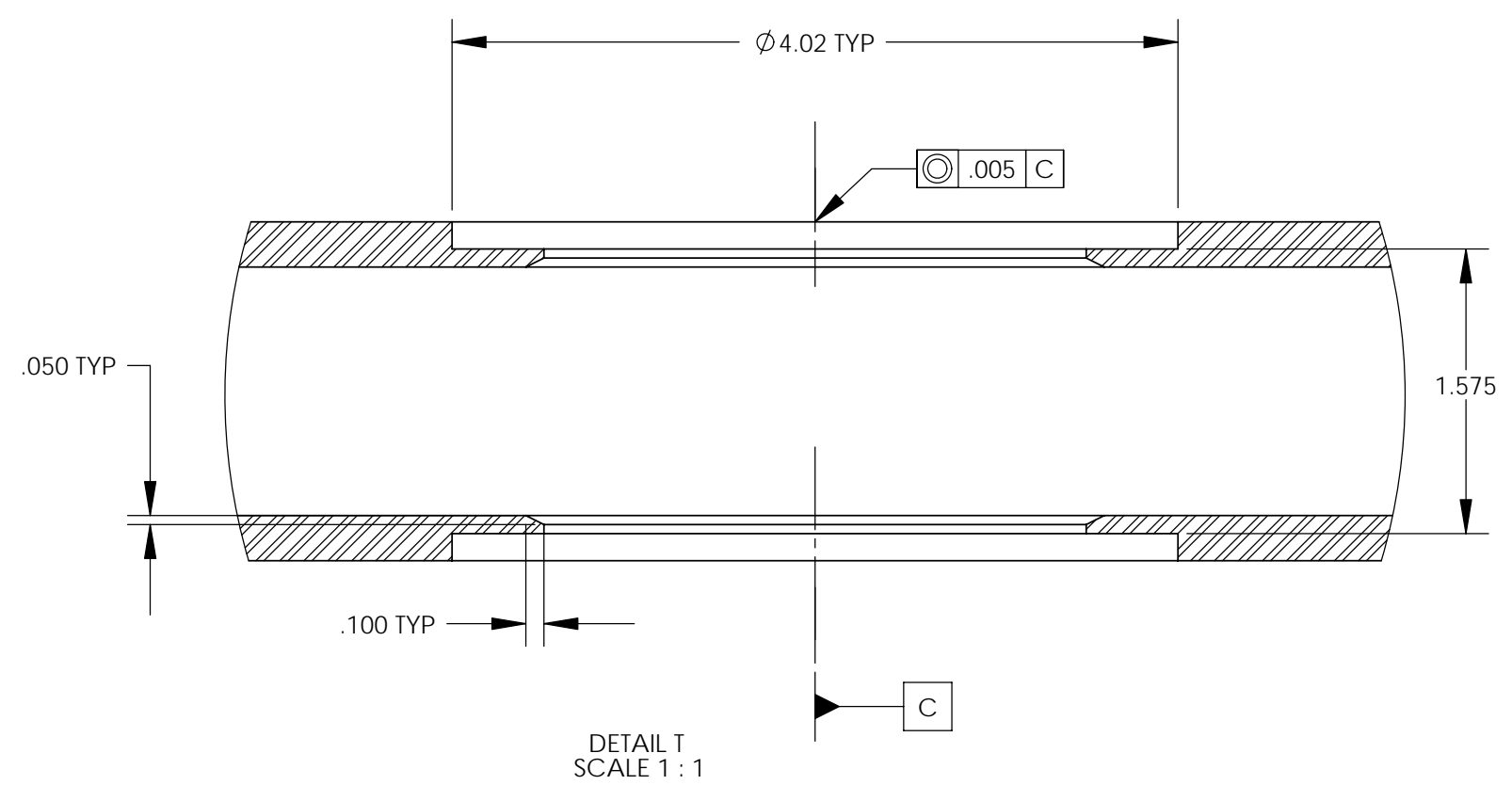
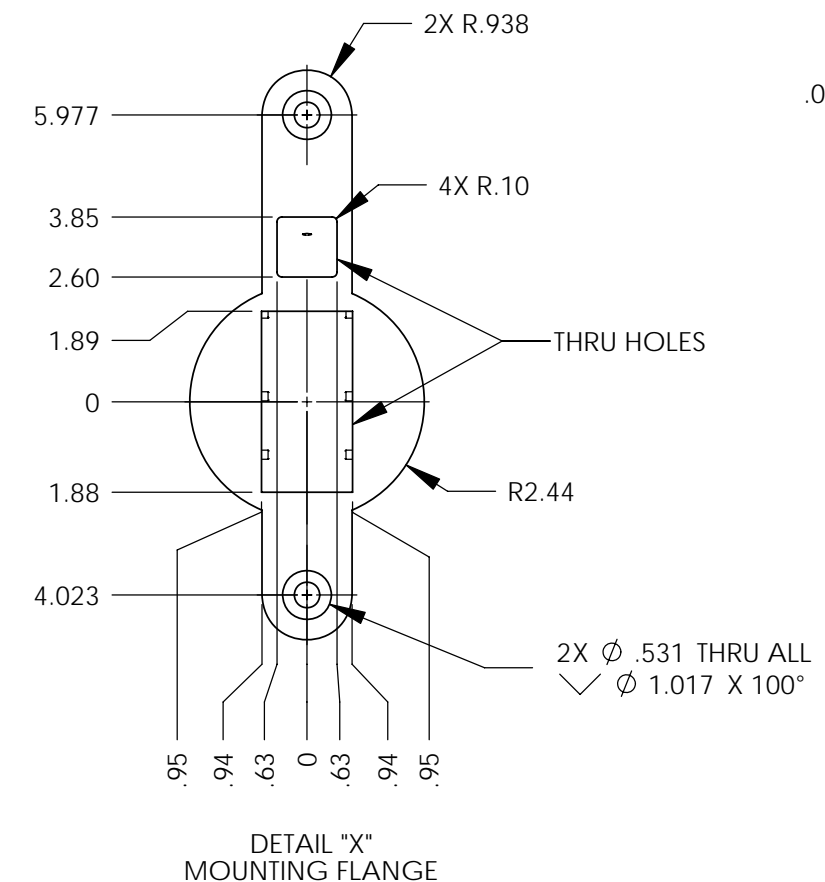
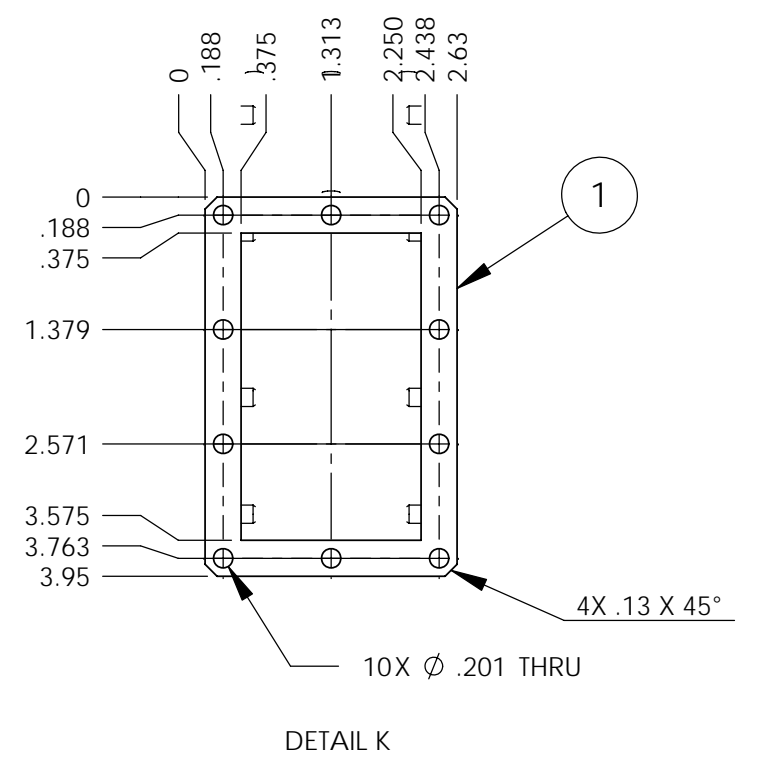
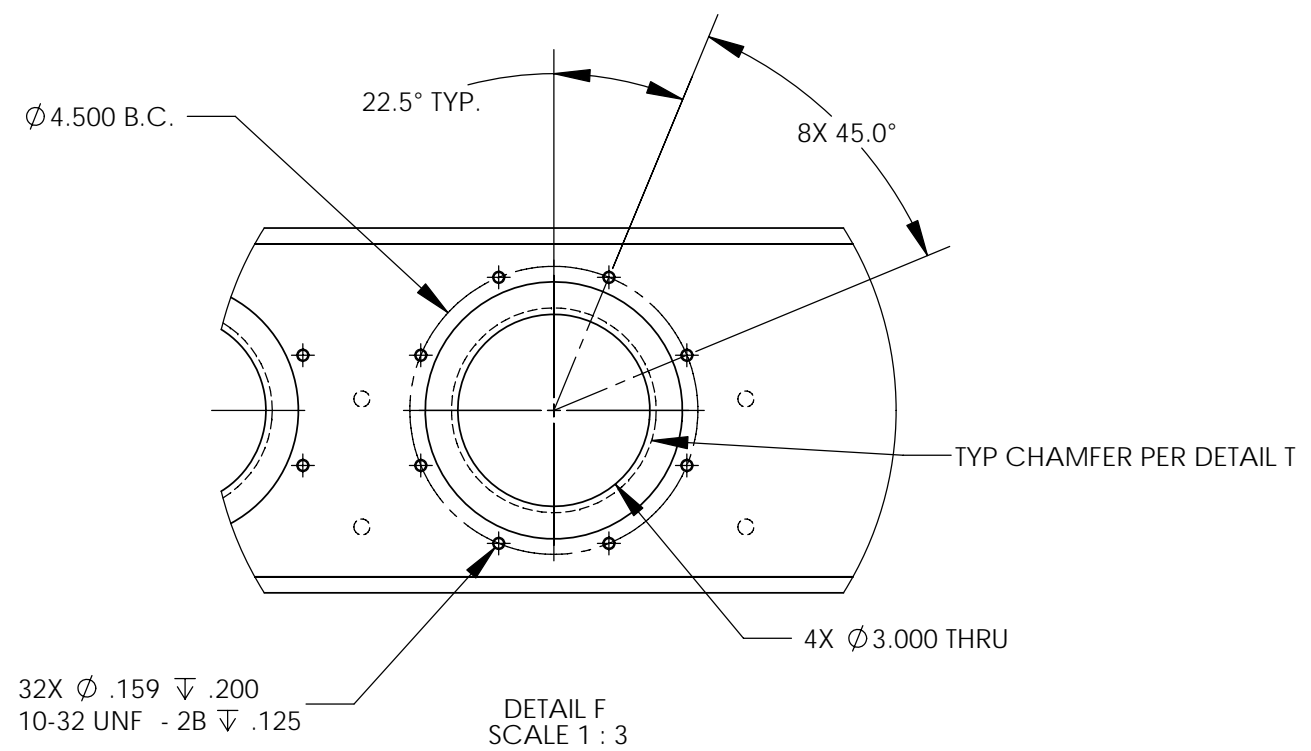
DWG NO. 203-HJT-0611

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

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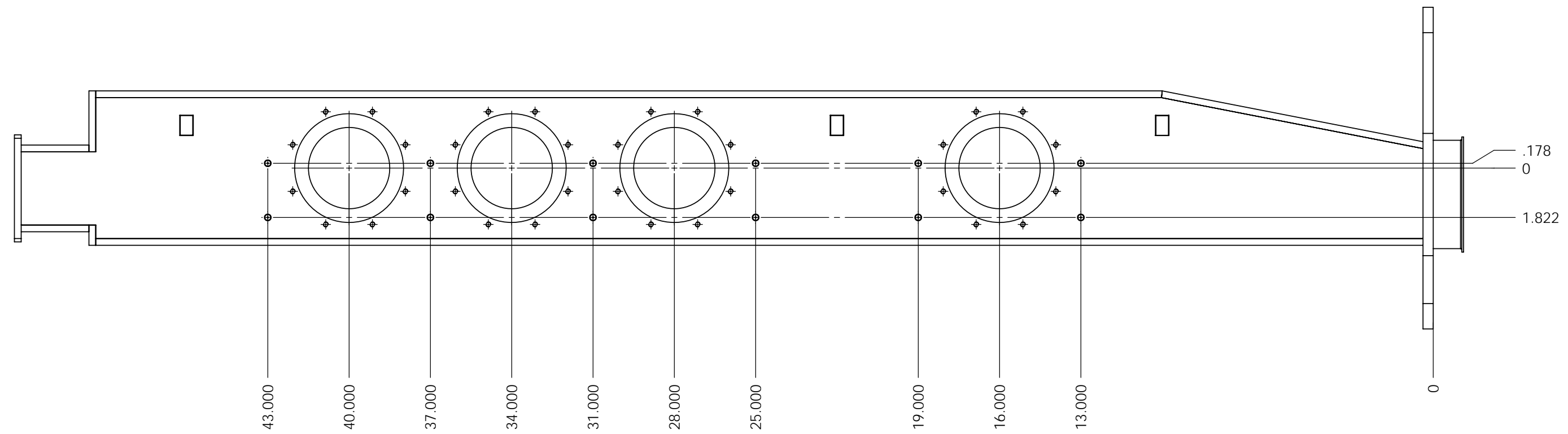


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QA																			
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>CAD FILE PRI TUBE WELDMENT HJT</p>	<p>PREV ASSY 203-HJT-0610</p>	<p>SCALE 1:2</p>	<p>SHEET 3 of 5</p>													
<p>SIZE</p>		<p>DWG NO.</p>	<p>203-HJT-0611</p>		<p>REV 0</p>														

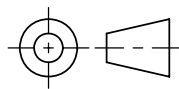


DWG NO. 203-HJT-0611

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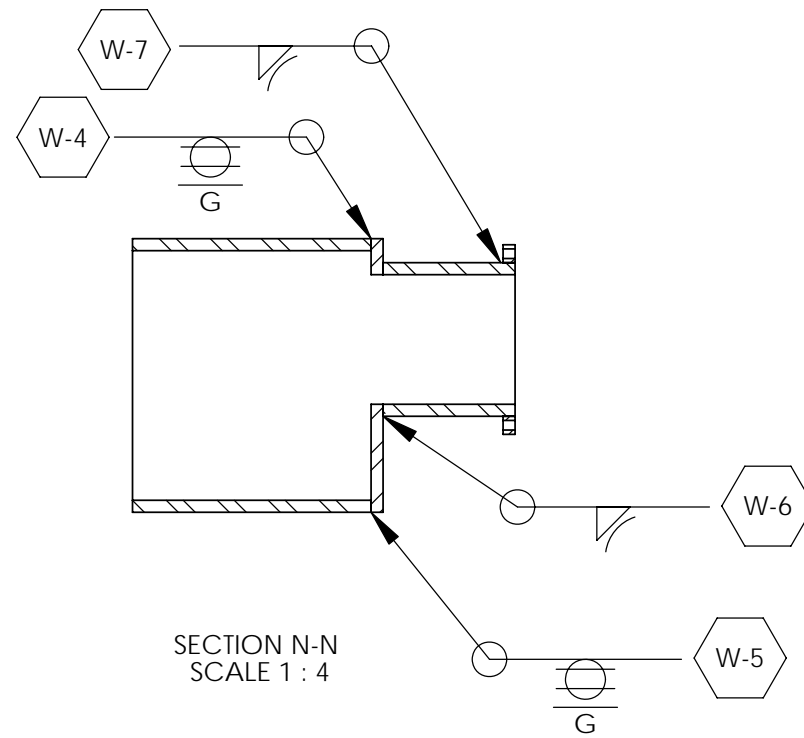
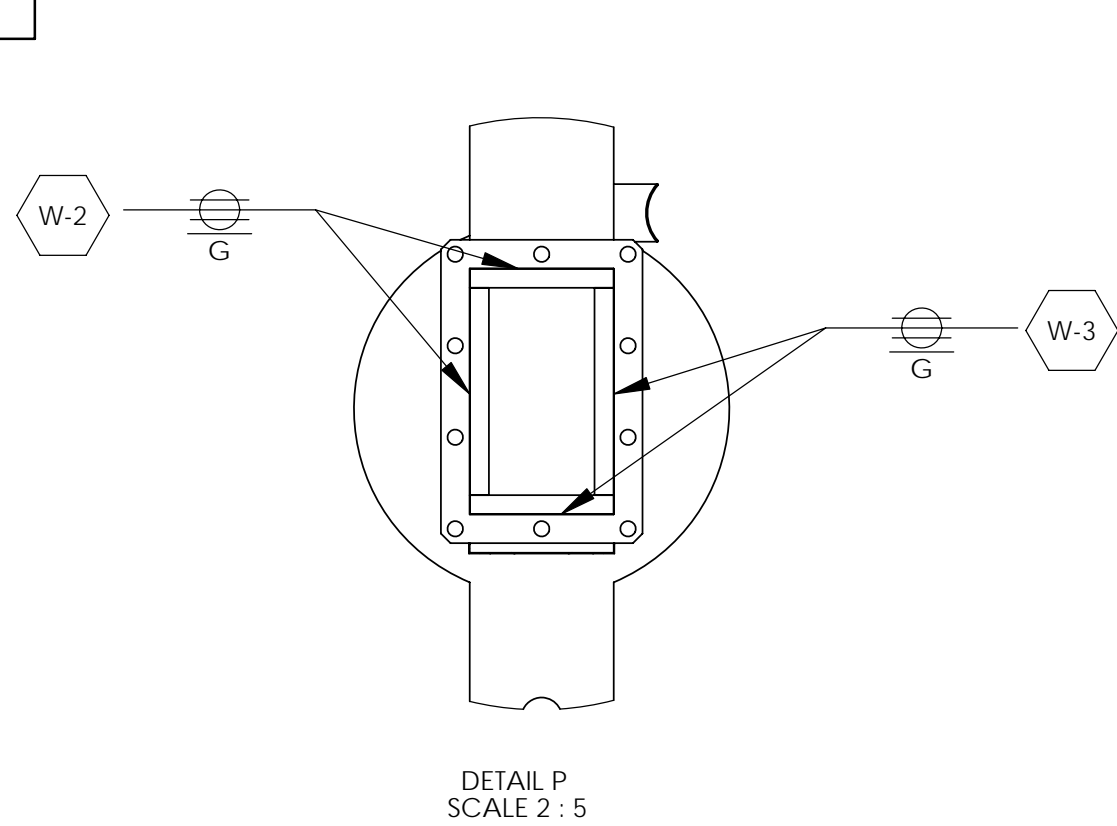
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RIGHT SIDE VIEW

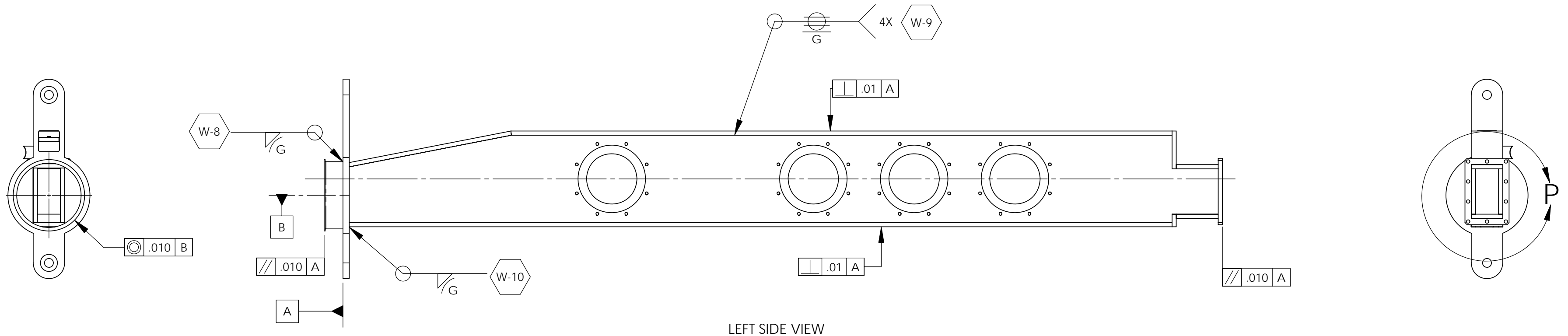
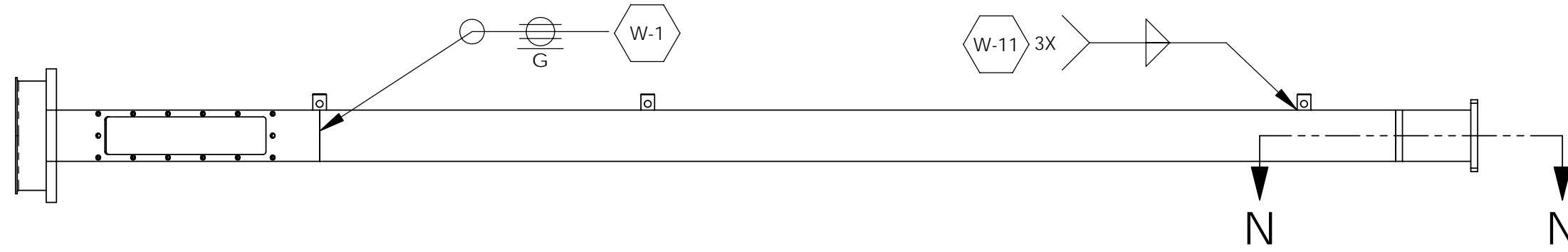
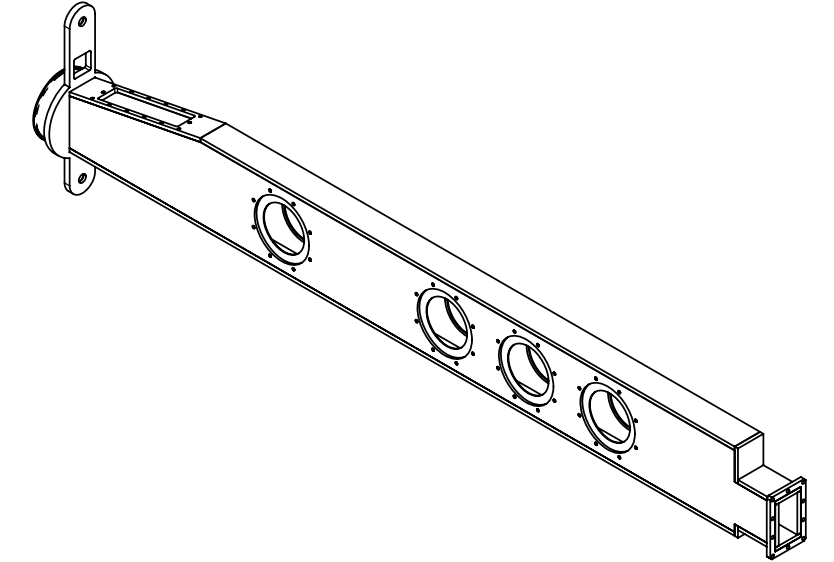
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DRW	T OQUIN	06/05/2005				
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ENG	V GRAVES	06/05/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			PRI TUBE WELDMENT HJT	203-HJT-0610	1:4	4 of 5
DRAWING APPROVALS		DATE	SIZE	DWG NO.		REV
			C	203-HJT-0611		0

S THIS DRAWING PRODUCED ON SOLIDWORKS



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LEFT SIDE VIEW

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<p>CAD FILE PRI TUBE WELDMENT HJT</p>		<p>PREV ASSY 203-HJT-0610</p>	<p>SCALE 1:5</p>	<p>SHEET 5 of 5</p>															
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>SIZE C</p>	<p>DWG NO. 203-HJT-0611</p>															
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DWG NO. 203-HJT-0611