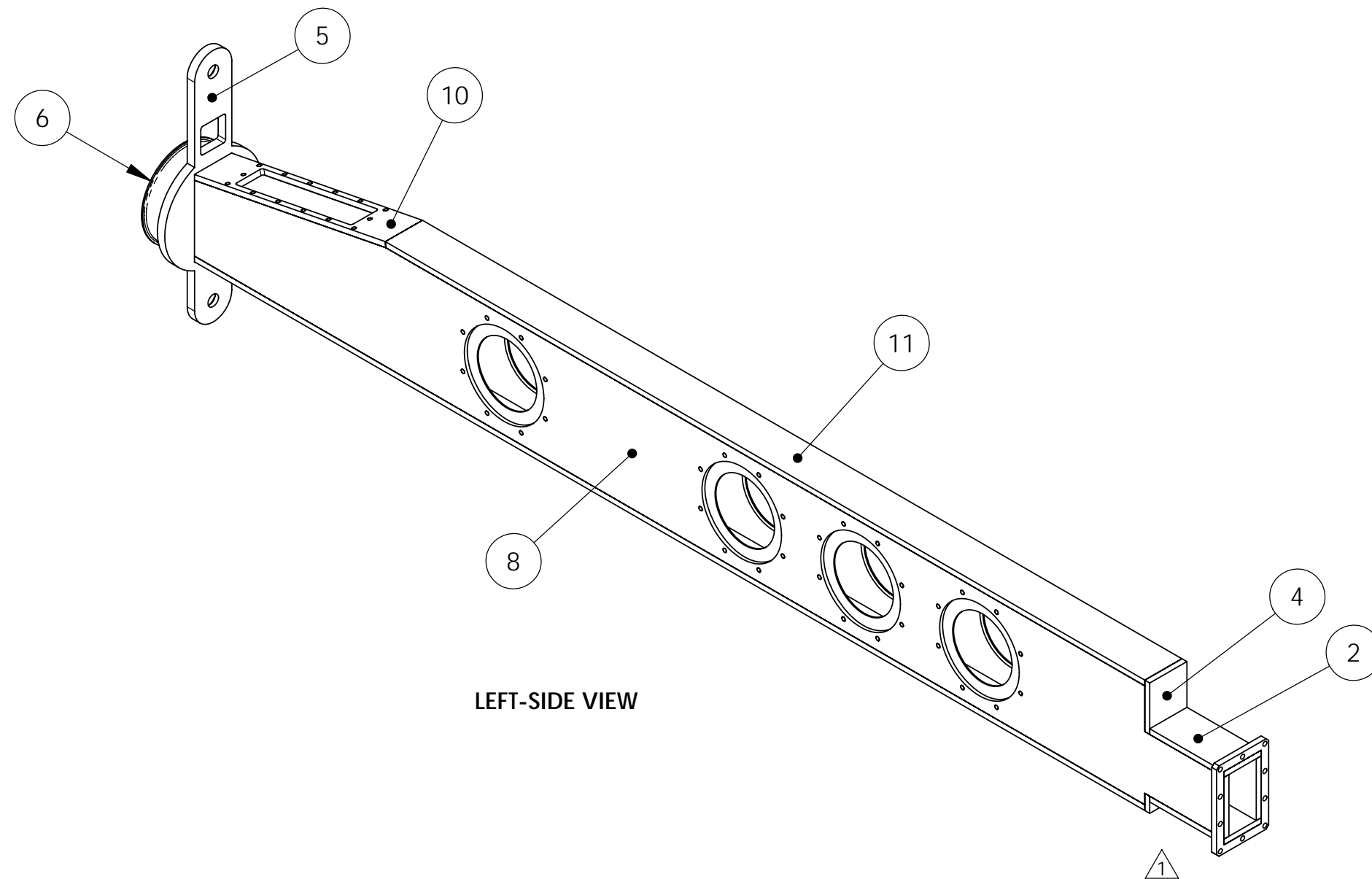
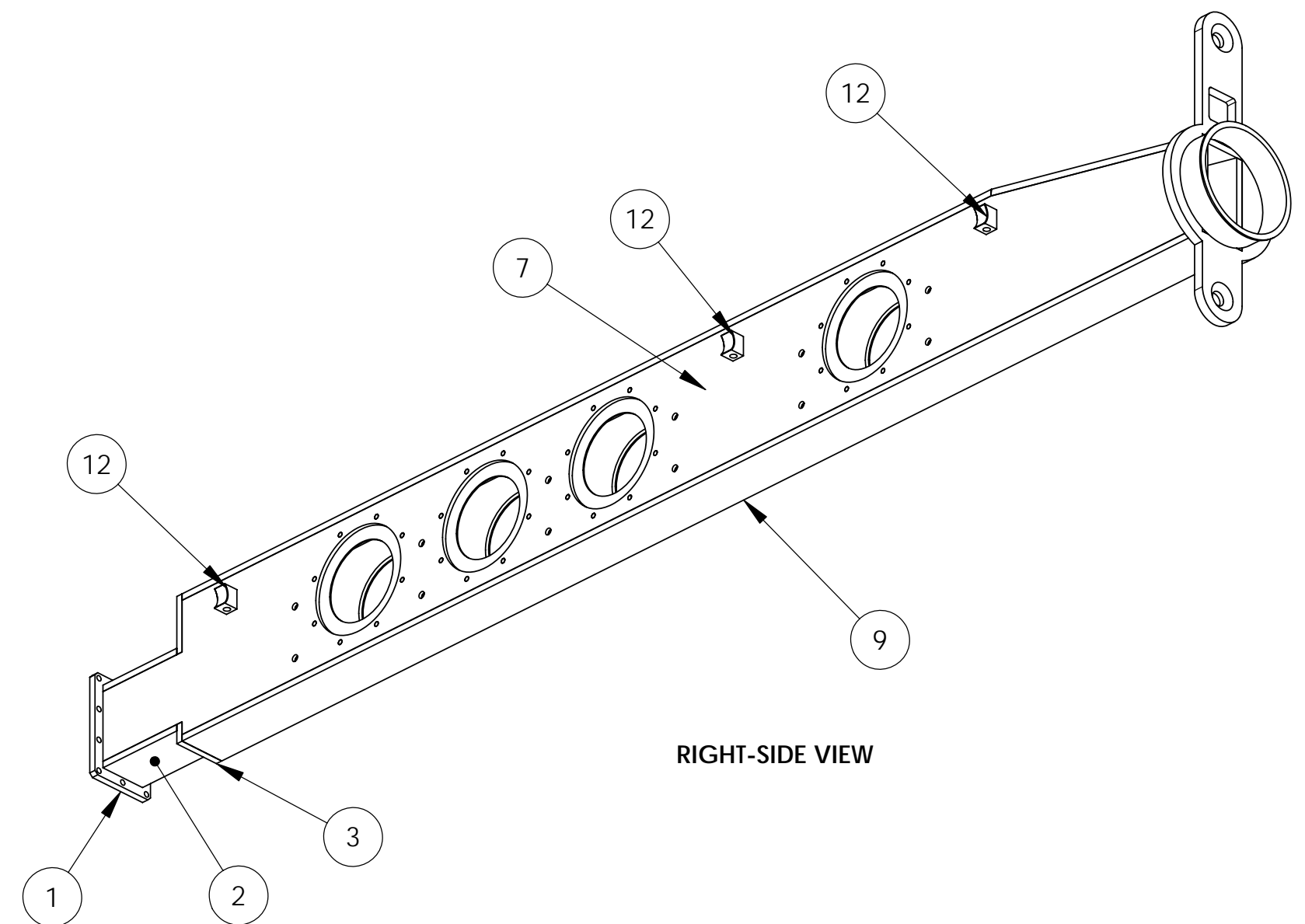


NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NO RADIOGRAPHY REQUIRED. ALL WELDS SHALL BE DYE PENETRANT INSPECTED.
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, 38.33 x 1.88 x .25	SS - 316L, ASTM A240	38.33
10	1	PLATE, 10.21 x 1.88 x .25	SS - 316L, ASTM A240	10.21
9	1	PLATE, 48.35 x 1.88 x .25	SS - 316L, ASTM A240	48.35
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 3.75 x .25	SS - 316L, ASTM A240	3.75
1	1	PLATE, 2.63 x 3.95 x .25	SS - 316L, ASTM A240	3.95



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 ±1/2°
6. FORMED ANGLES ±1°
7. BREAK SHARP CORNERS AND REMOVE ALL BURRS
8. X DECIMALS ±.030
9. XX DECIMALS ±.010
10. XXX DECIMALS ±.005

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.



OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN



REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

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		

**MERIT EXPERIMENT
PRIMARY TUBE ASSY
PRIMARY TUBE WELDMENT**

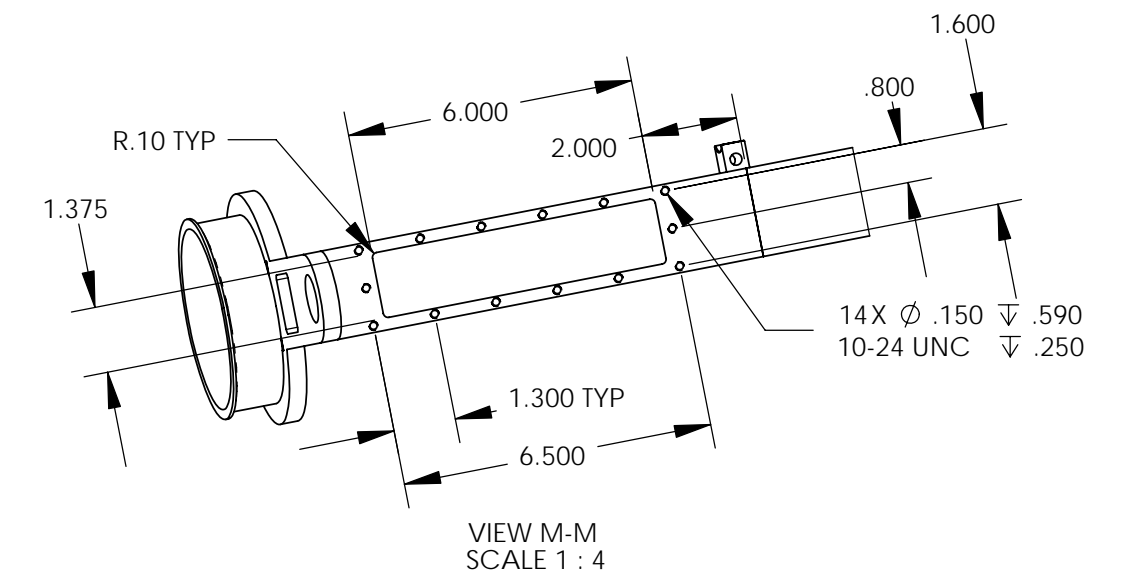
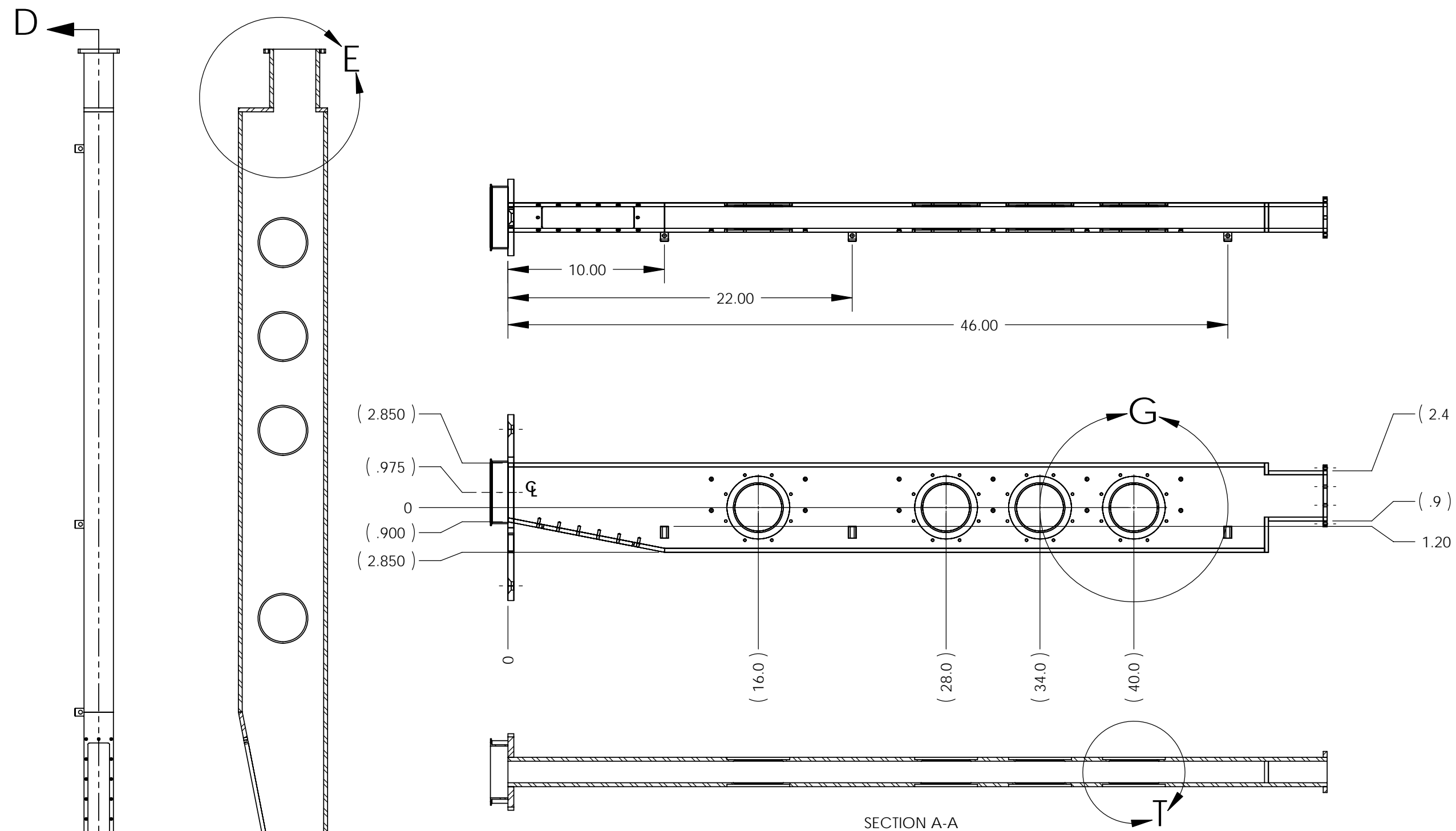
1	CHANGED LENGTH OF RECESS	4/25/2006	VBG	VBG
REV	DESCRIPTION	DATE	BY	APPROVED

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	1	

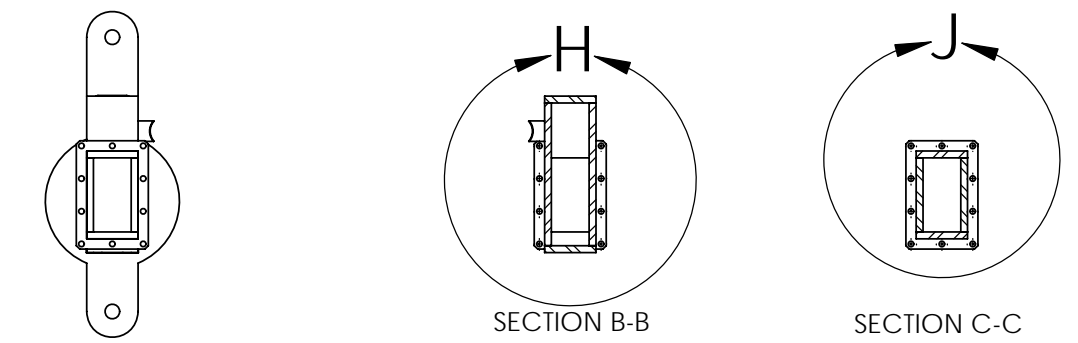
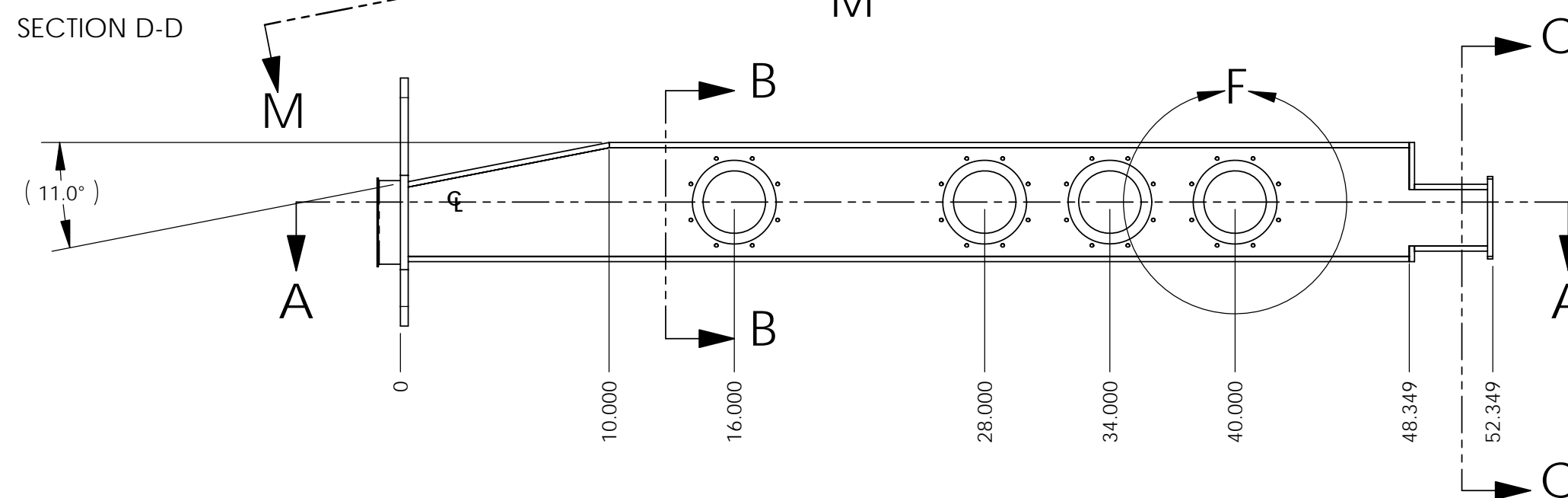
S THIS DRAWING PRODUCED ON SOLIDWORKS

NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NO RADIOGRAPHY REQUIRED. ALL WELDS SHALL BE DYE PENETRANT INSPECTED.
3. MATERIAL CERTIFICATIONS REQUIRED.



DETAIL VIEWS ON SHEET 3

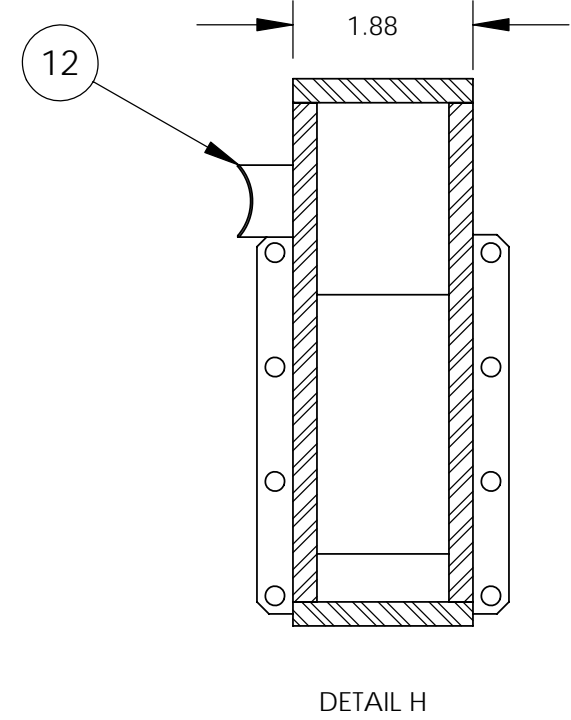
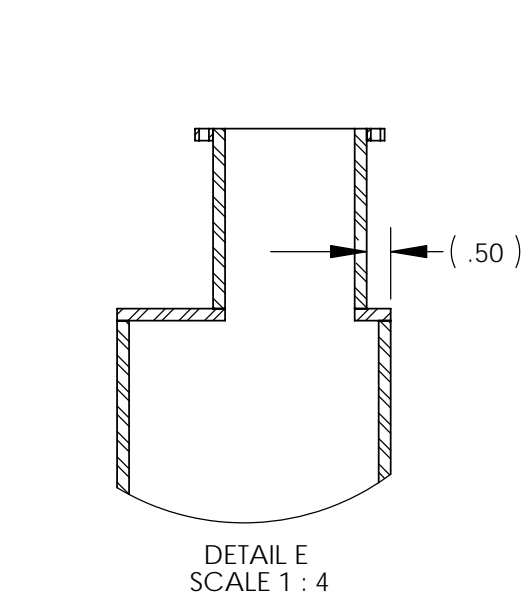
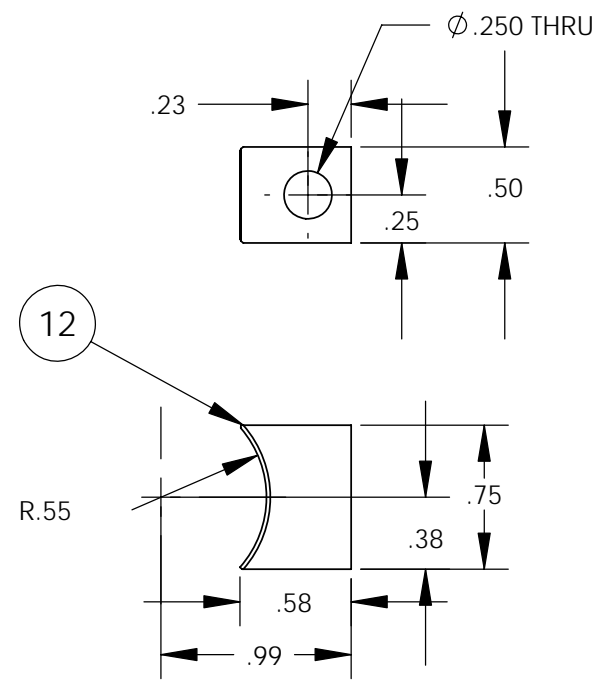
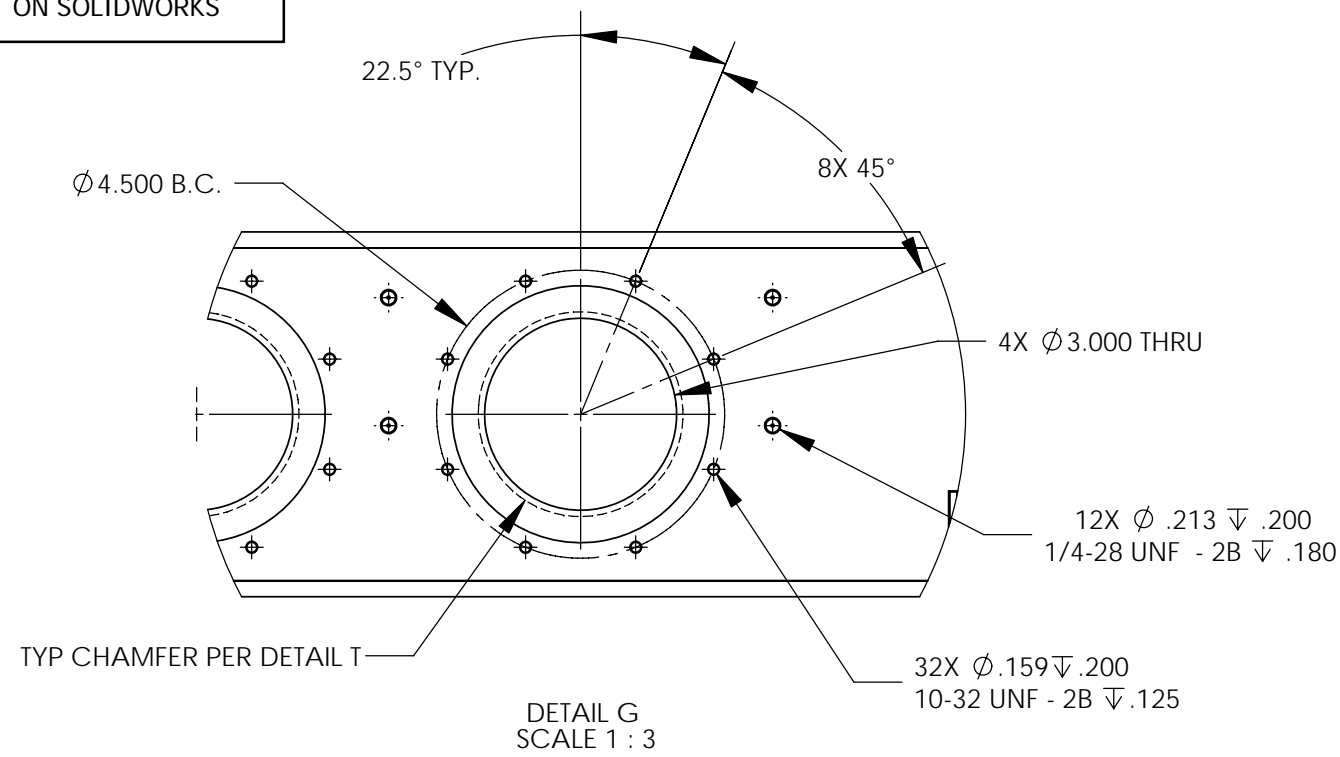


SEE DETAIL "X"

<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 $\pm 1/2^\circ$ 6. FORMED ANGLES $\pm 1^\circ$ 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS $\pm 1/16$ 9. X DECIMALS $\pm .030$ 10. XX DECIMALS $\pm .010$ 11. XXX DECIMALS $\pm .005$ 			<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>CAD FILE: PRI TUBE WELDMENT HJT PREV ASSY: 203-HJT-0610 SCALE: 1:7 SHEET: 2 of 5</p>																				
<p>DRAWING APPROVALS: [Signature] DATE: [Date]</p>			<p>SIZE: C DWG NO.: 203-HJT-0611 REV: 1</p>																	

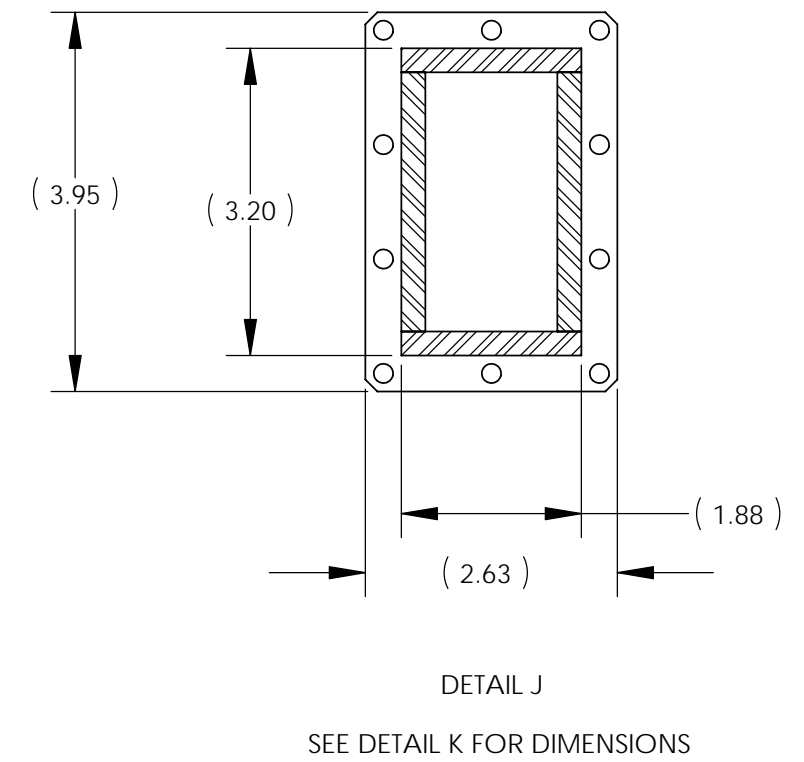
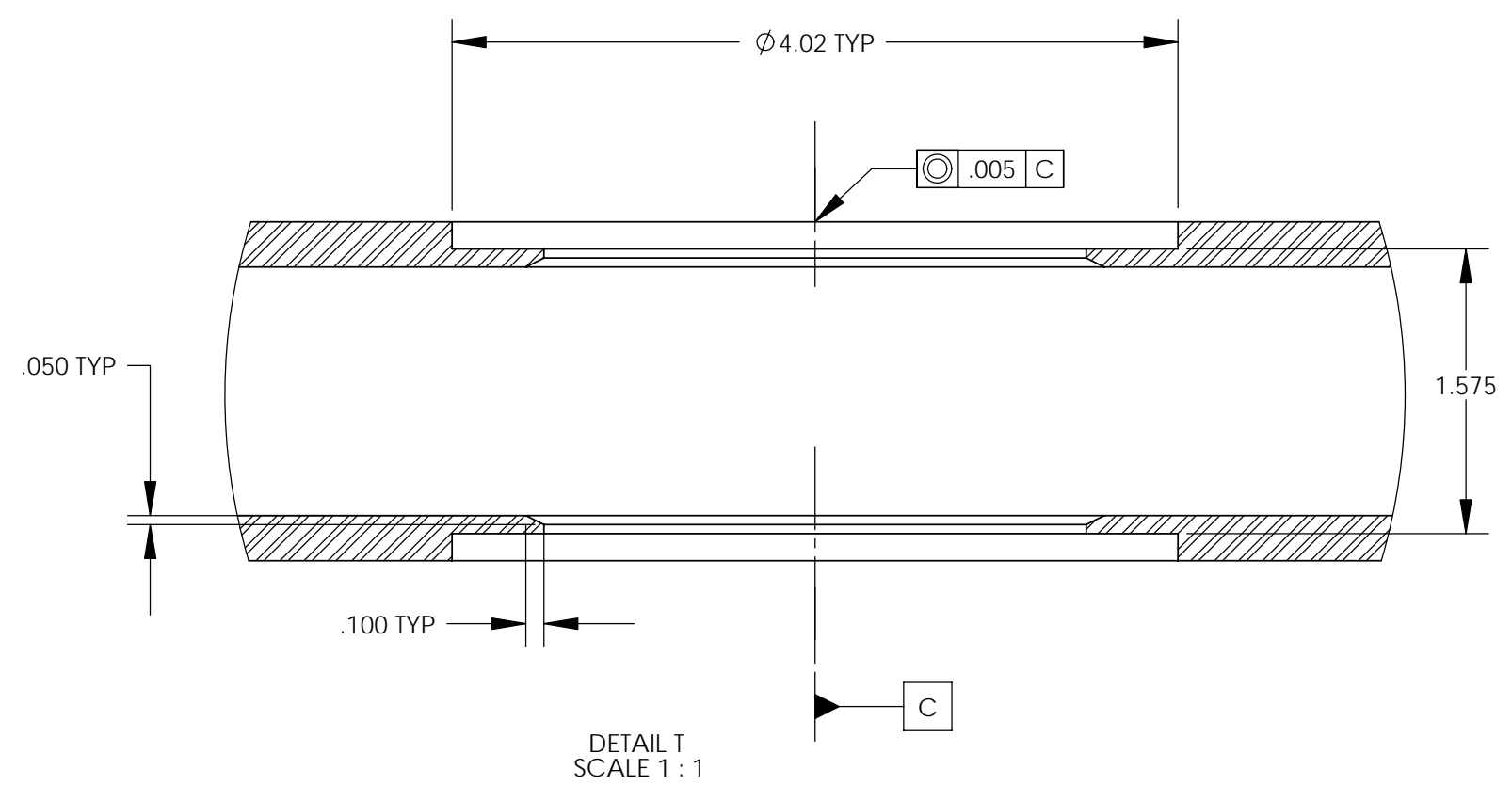
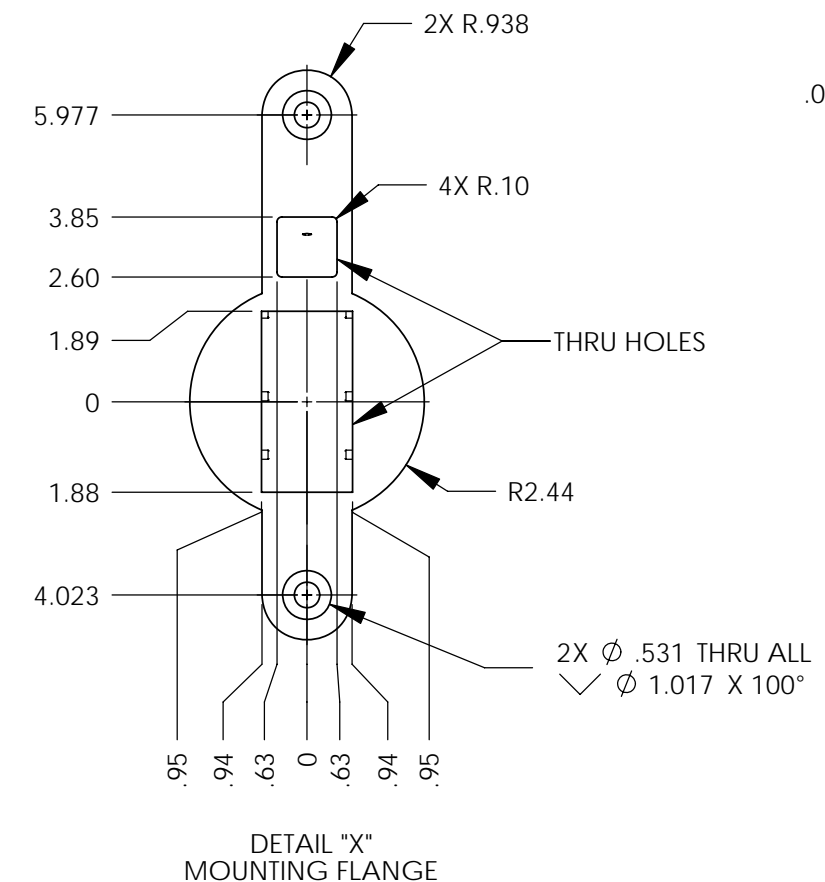
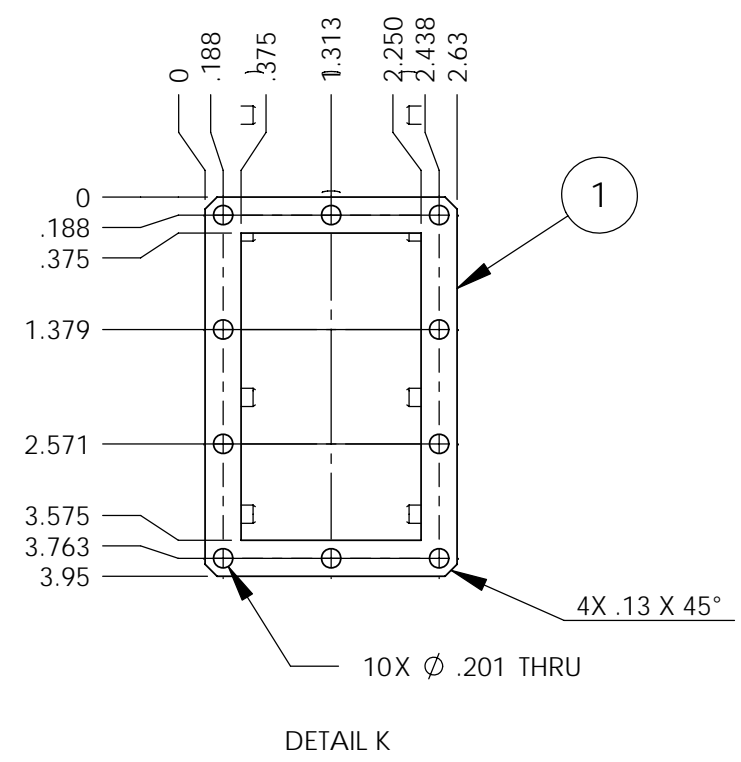
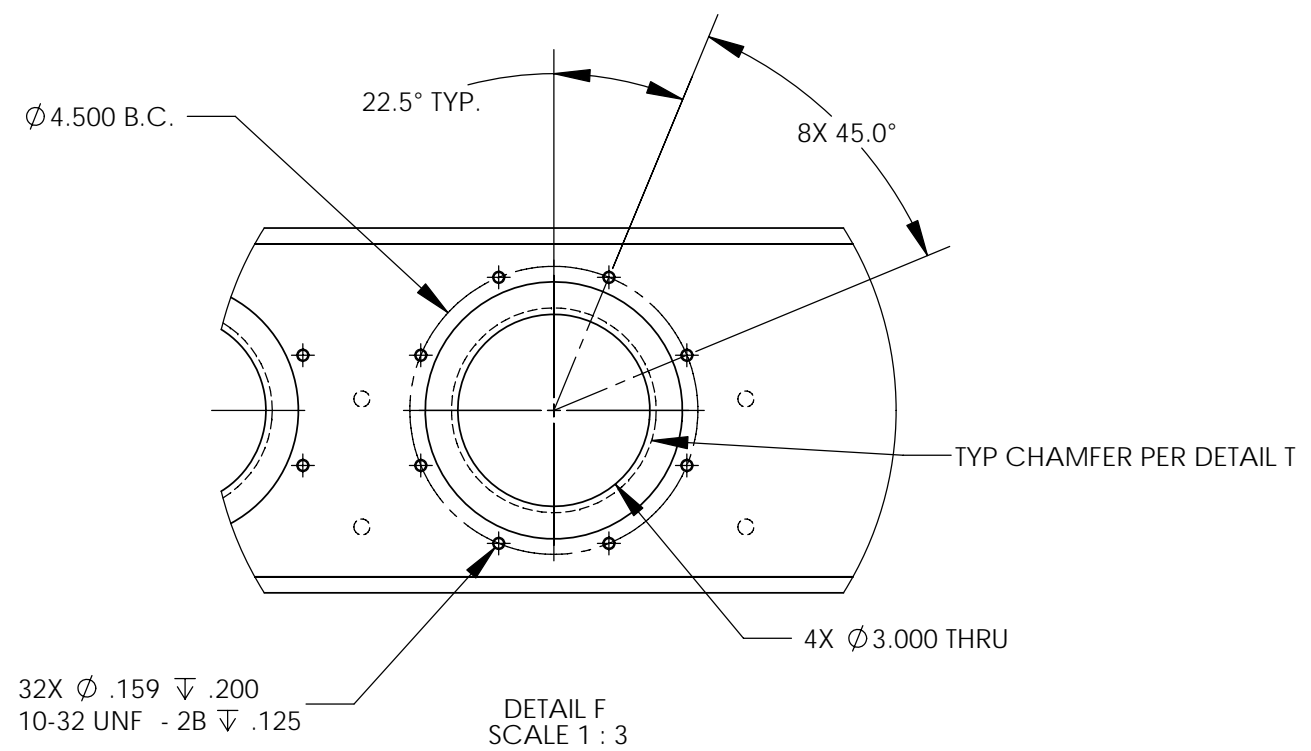
DWG NO. 203-HJT-0611

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NO RADIOGRAPHY REQUIRED. ALL WELDS SHALL BE DYE PENETRANT INSPECTED.
3. MATERIAL CERTIFICATIONS REQUIRED.

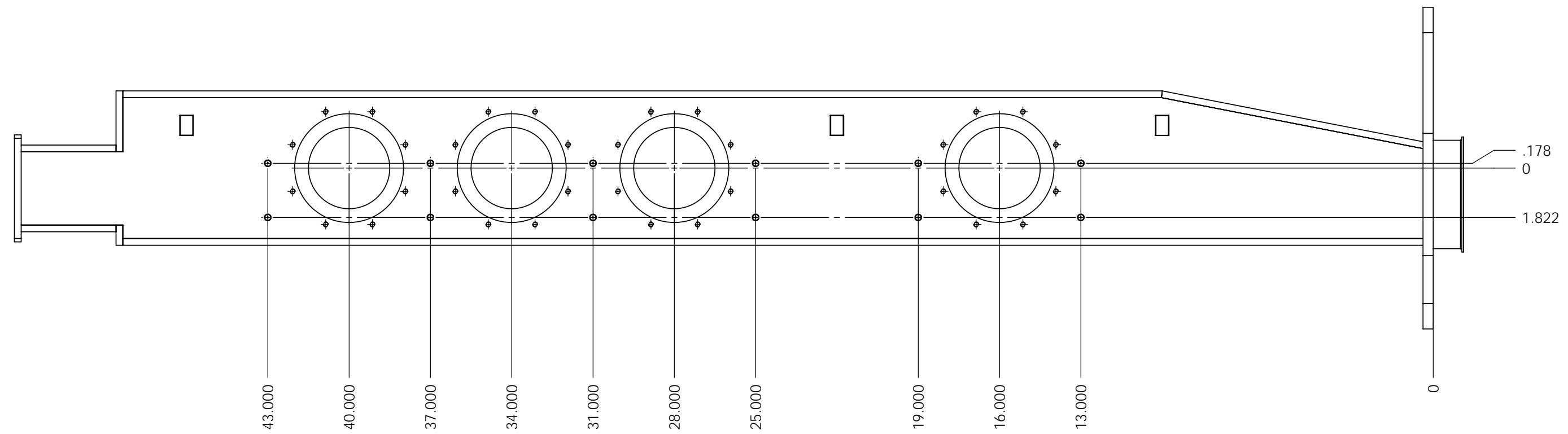


<p>THIRD-ANGLE PROJECTION</p>	<p>This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be 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° FORMED ANGLES ±1° 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>																
<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</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 1</p>														

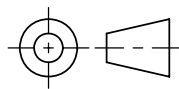


DWG NO. 203-HJT-0611

NOTES

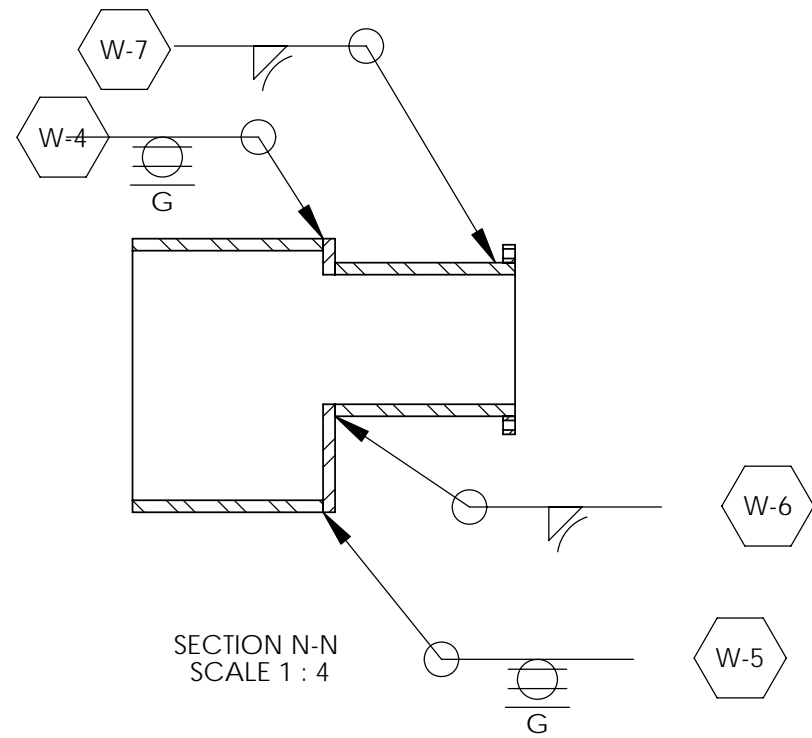
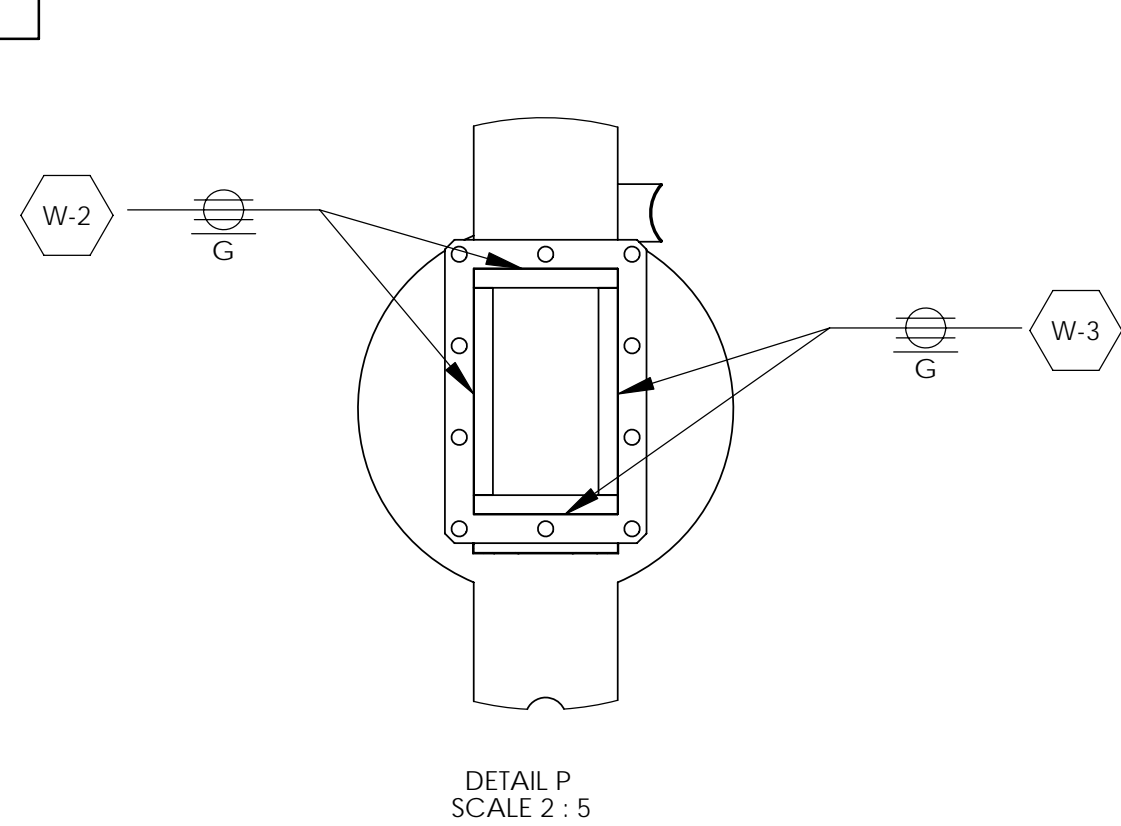
1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NO RADIOGRAPHY REQUIRED. ALL WELDS SHALL BE DYE PENETRANT INSPECTED.
3. MATERIAL CERTIFICATIONS REQUIRED.



RIGHT SIDE VIEW

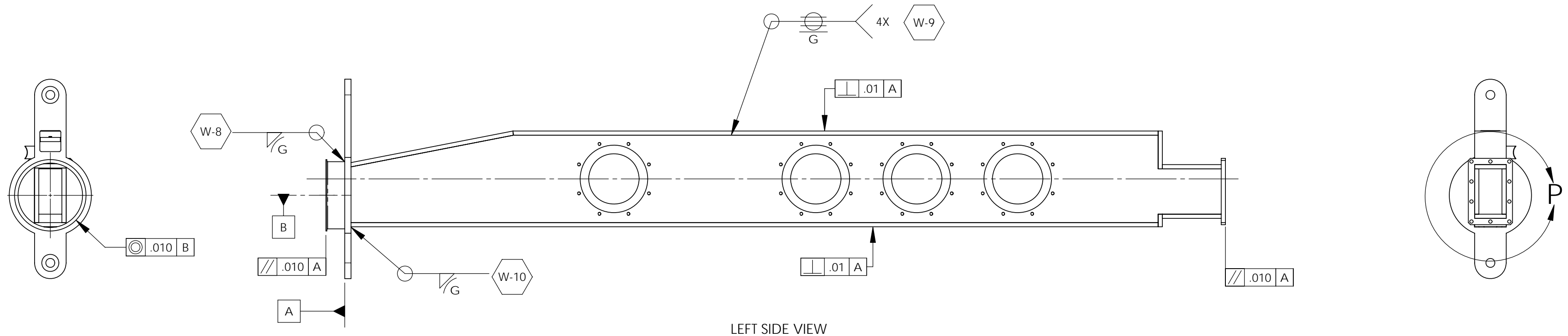
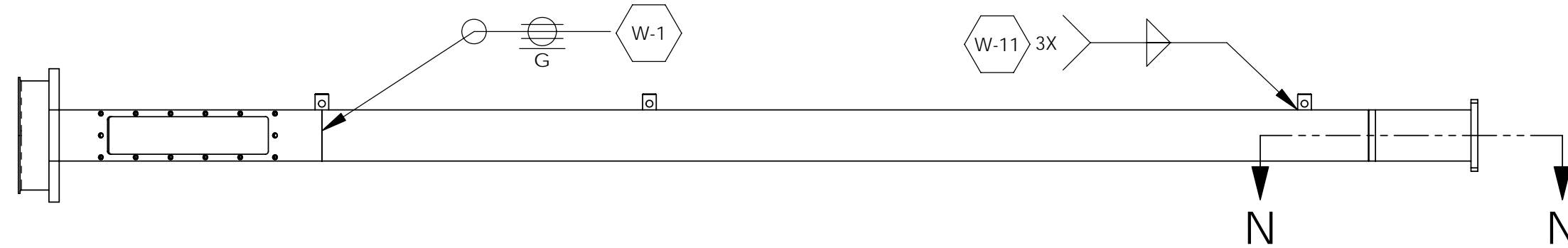
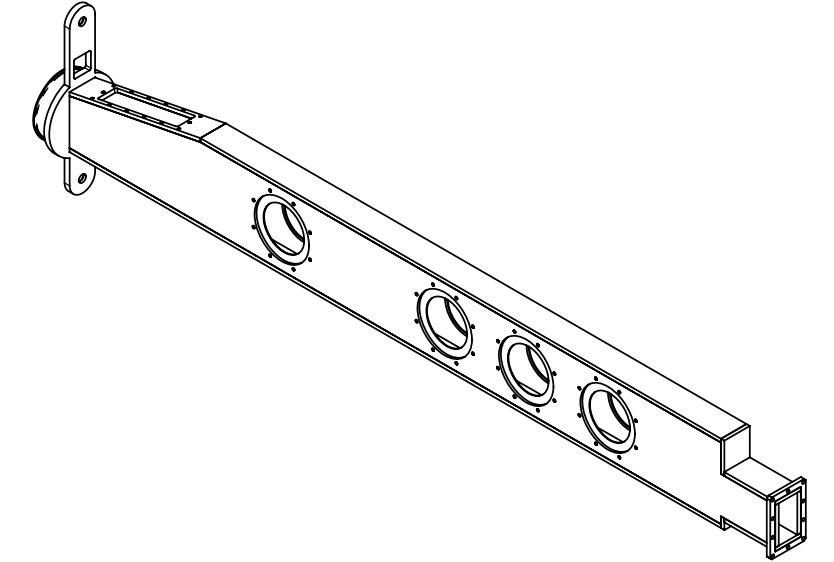
 <p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned 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 ±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	MERIT EXPERIMENT PRIMARY TUBE ASSY PRIMARY TUBE WELDMENT			
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	1:4	4 of 5
DRAWING APPROVALS		DATE	SIZE	DWG NO.		REV
			C	203-HJT-0611		1

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NO RADIOGRAPHY REQUIRED. ALL WELDS SHALL BE DYE PENETRANT INSPECTED.
3. MATERIAL CERTIFICATIONS REQUIRED.



LEFT SIDE VIEW

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

DWG NO. 203-HJT-0611