



NOTES

1. WELDING TO 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.
4. SLEEVE CAN BE FABRICATED FROM 6IN SCH40 PIPE.

ITEM NO.	QTY.	DESCRIPTION	MATERIAL
6	1	RING, 3.00 x 11.88 DIA x .048	SS - 316L, ASTM A-240
5	1	CONE, 5.31 X 11.88 DIA X .048	SS - 316L, ASTM A-240
4	1	SLEEVE, 55.00 X 6.25 DIA X .048	SS - 316L, ASTM A-240
3	2	TAB, 1.64 X 1.50 X .50	SS - 316L, ASTM A-240
2	1	BOSS, 1.00 OD X .50	SS - 316L, ASTM A-240
1	1	END PLATE, 6.25 OD X .25	SS - 316L, ASTM A-240

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/09/2005 DRW T OQUIN 06/09/2005 CHK P SPAMPINATO 02/07/2006 ENG V GRAVES 06/09/2005 QA		<p><b>MERIT EXPERIMENT</b> <b>SECONDARY TUBE ASSY</b> <b>SECONDARY CONTAINMENT WELDMENT</b></p>		
CAD FILE SEC CONTAIN WELDMENT HJT		PREV ASSY 203-HJT-0710	SCALE 1:6	SHEET 1 of 1
DRAWING APPROVALS		DATE	SIZE DWG NO. C 203-HJT-0711	REV 0