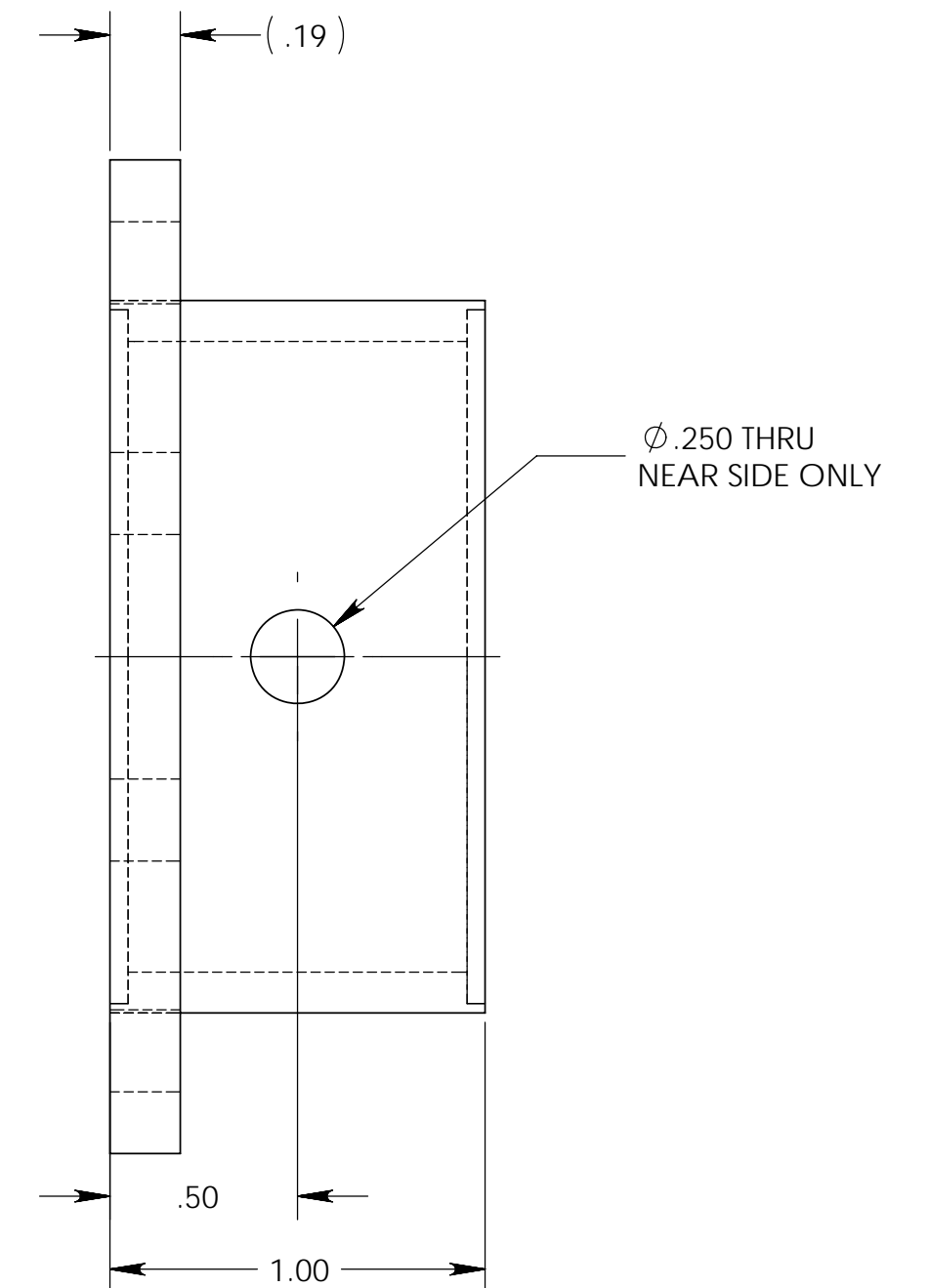
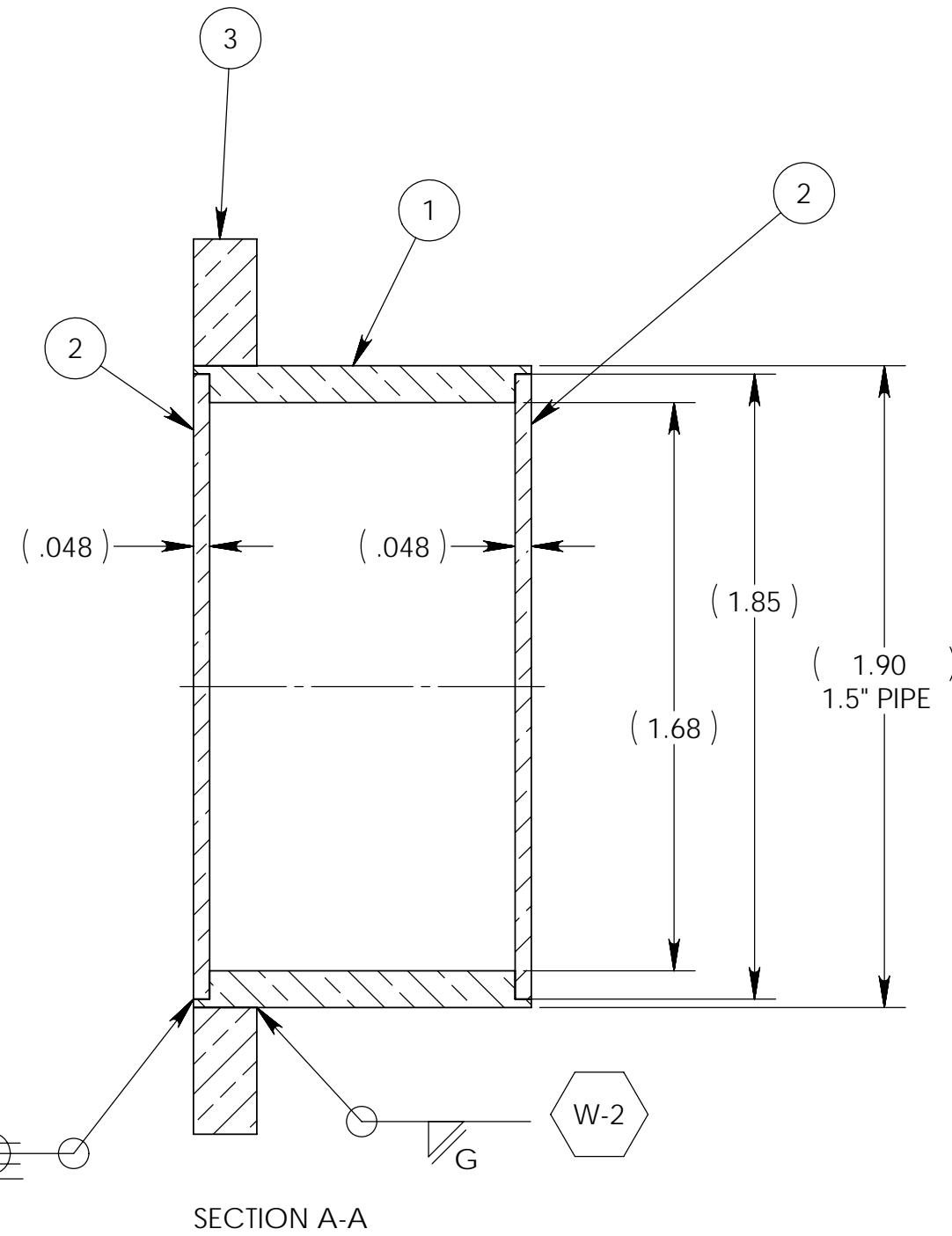
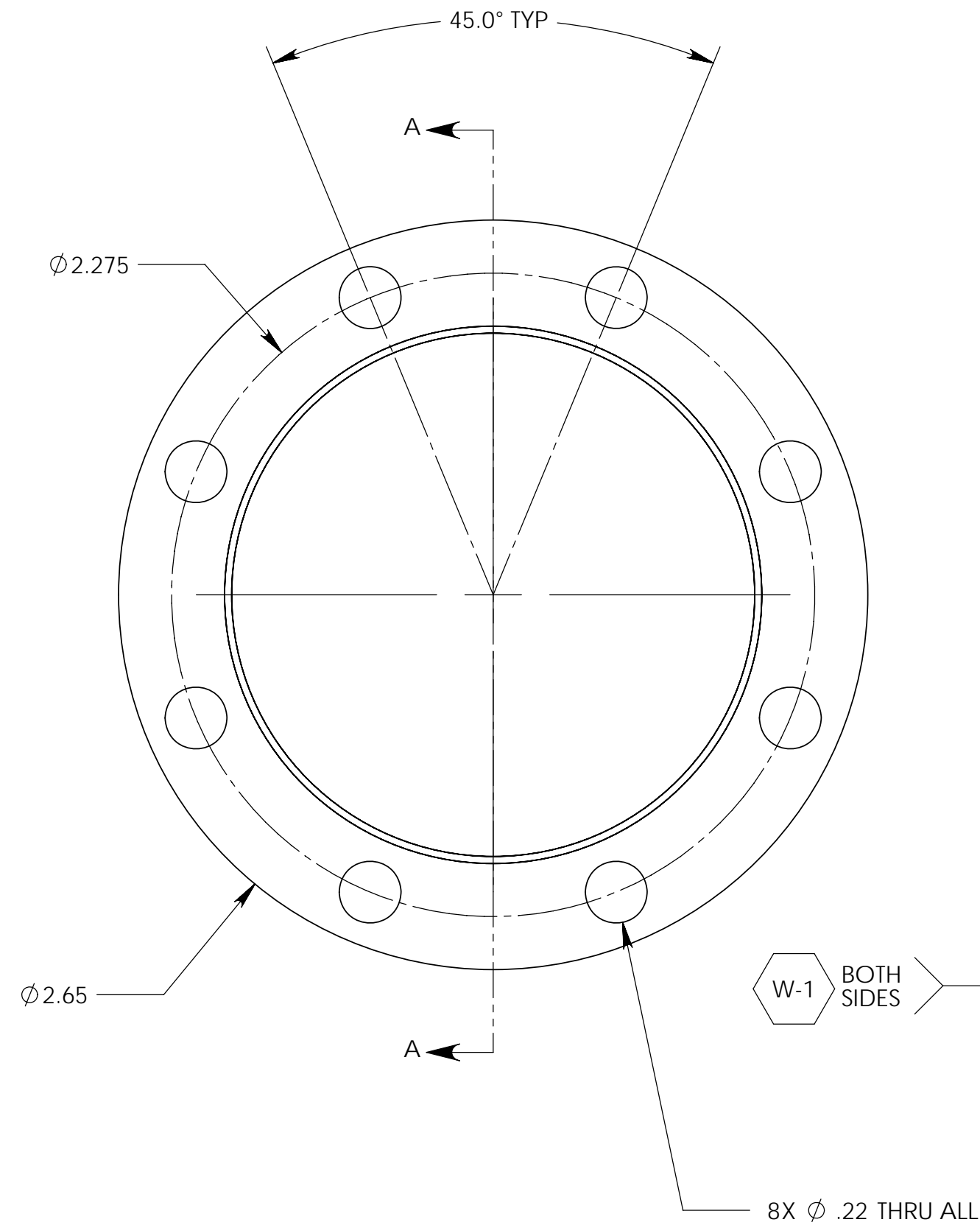


NOTES

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



ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
3	1	PLATE, 2.65 OD x .19 THK	TI GRADE 2, ASTM B-265	N/A
2	2	18GA SHEET, 1.85 OD	TI-6AL-4V, ASTM B-265	N/A
1	1	PIPE, SCH 10	TI GRADE 2, ASTM B-265	1.00

THIRD-ANGLE PROJECTION

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. WHOLE NUMBERS AND FRACTIONS ±1/16
9. X DECIMALS ±.030
10. XX DECIMALS ±.010
11. XXX DECIMALS ±.005

DES V GRAVES 09/26/2005

DRW T OQUIN 09/26/2005

CHK P SPAMPINATO 01/17/2006

ENG V GRAVES 09/26/2005

QA

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

**NSTB** REMOTE SYSTEMS GROUP  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

<b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY DBL WINDOW WELDMENT - UPSTREAM</b>			
CAD FILE DOUBLE WINDOW HJT	PREV ASSY 203-HJT-0712	SCALE 2:1	SHEET 1 of 1
SIZE C	DWG NO. 203-HJT-0713	REV 0	