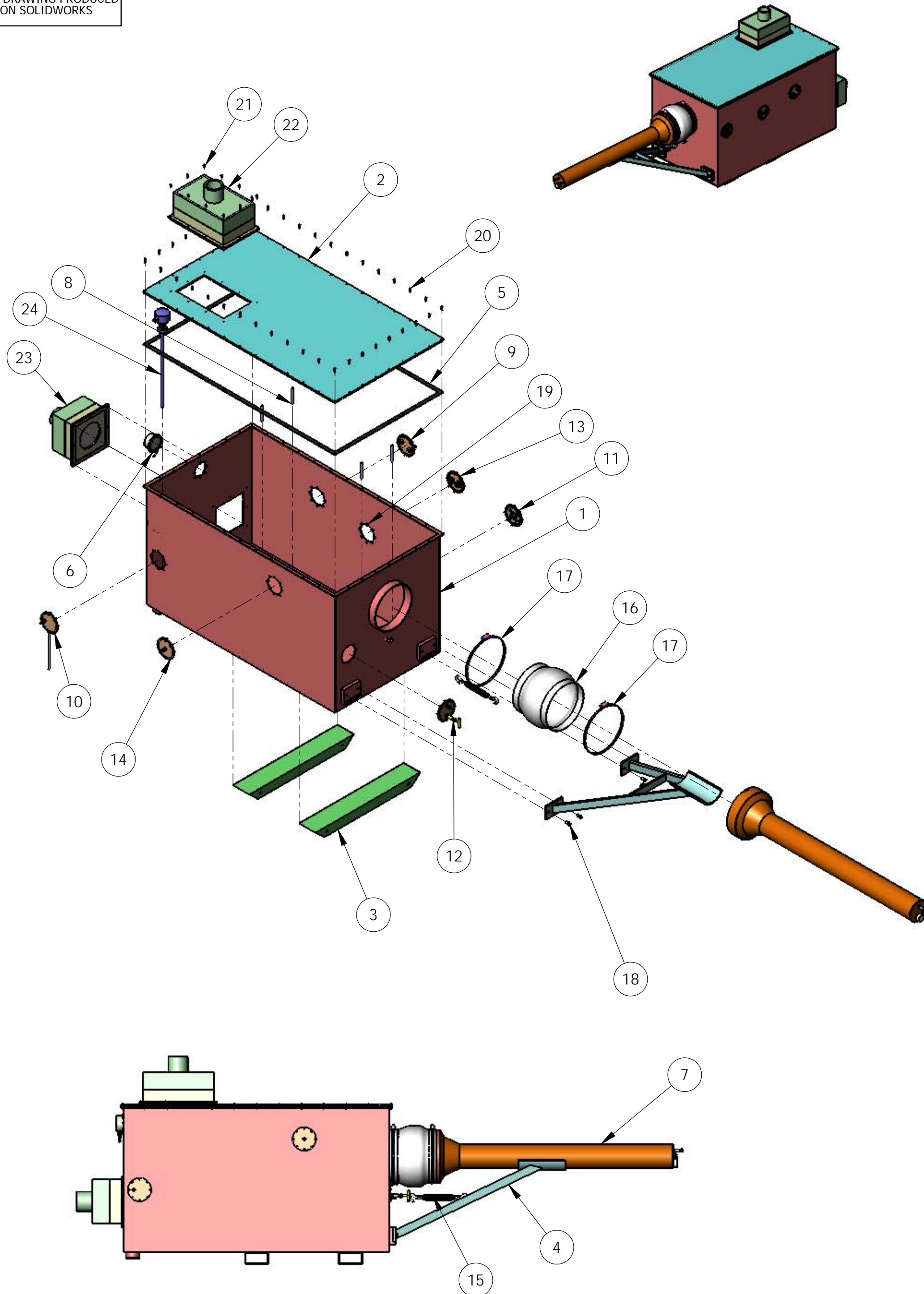


S THIS DRAWING PRODUCED ON SOLIDWORKS



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

24	1	omega level sensor	---	OEM	N/A
23	1	airfiltronix assy hjt	N/A	AIR FILTER ASSY - SQUARE	N/A
22	1	airfiltronix assy hjt	N/A	AIR FILTER ASSY - RECTANGULAR	N/A
21	10	SBHCSCREW 0.25-20x0.875-HX-N	SS - 8-18	BHCS - 1/4-20	N/A
20	40	socket button head cap screw_ai	SS - 18-8	BHCS - 1/4-20	N/A
19	88	PEM WNS-0420-0 ---N	SS - 18-8	PEM WELDNUT - 1/4-20	N/A
18	4	HX-SHCS 0.5-13x1x1-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
17	2	Hose Clamp	SS - 316 OR BETTER	BLADDER HOSE CLAMP	N/A
16	1	sec contain bladder hjt	---	---	N/A
15	1	3022T652	----	MCMMASTER-CARR 3022T652	N/A
14	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - HG INLET	203-HJT-0780
13	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - ELECTRICAL	203-HJT-0770
12	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - DRAIN	203-HJT-0760
11	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - OPTICS	203-HJT-0750
10	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - EXTRACTION	203-HJT-0740
9	1	connector plate assy hjt	---	CONNECTOR PLATE ASSY - HYDRAULICS	203-HJT-0730
8	4	weld stud hjt	SS - 18-8	WELD STUD, 0.5 X 3.0	N/A
7	1	sec tube assy hjt	---	---	203-HJT-0710
6	1	double window monitored	---	DOWNSTREAM	203-HJT-0706
5	1	sec base cover gasket hjt	BUNA-N SHEET - 50A	MCMMASTER-CARR #86715K869	203-HJT-0705
4	1	support cradle hjt	AL 6061-T6511, ASTM B-221	SECONDARY TUBE SUPPORT CRADLE	203-HJT-0704
3	2	rect tubing support hjt	AL - 6061 T52, ASTM B221	3.00 X 6.00 X 38.00 X .188 WALL	203-HJT-0703
2	1	sec top cover hjt	LEXAN - 1/2"	69.50 X 39.50 X .500	203-HJT-0702
1	1	sec base hjt	---	SECONDARY CONTAINMENT BASE	203-HJT-0701
ITEM	with brace/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

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. 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

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DES	V GRAVES	06/04/2005
DRW	T OQUIN	06/04/2005
CHK		
ENG	V GRAVES	06/04/2005
QA		

**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

**MERIT EXPERIMENT  
HG DELIVERY SYSTEM  
SECONDARY CONTAINMENT ASSY**

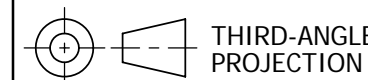
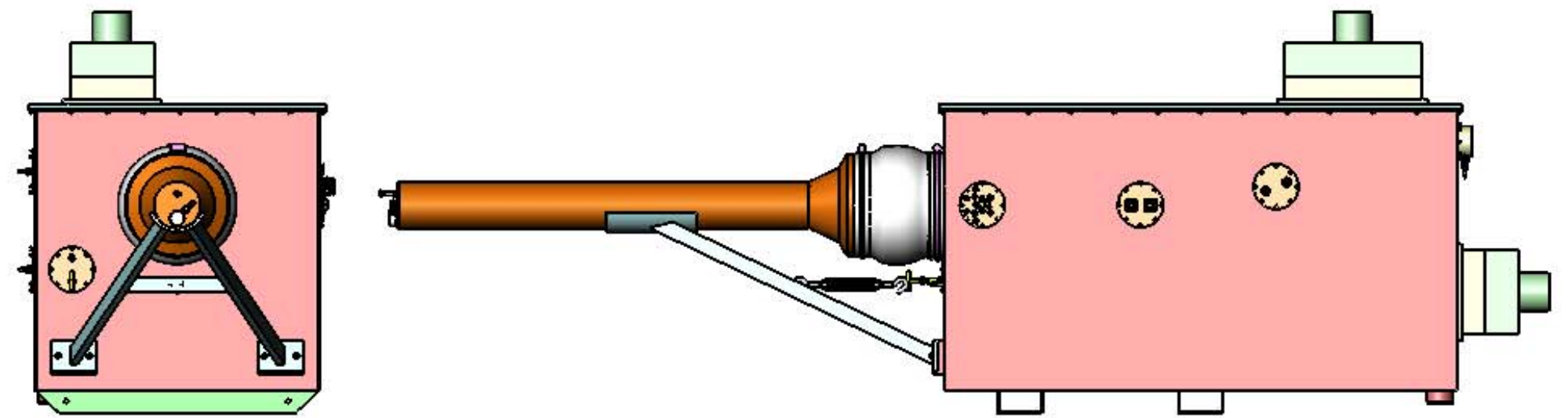
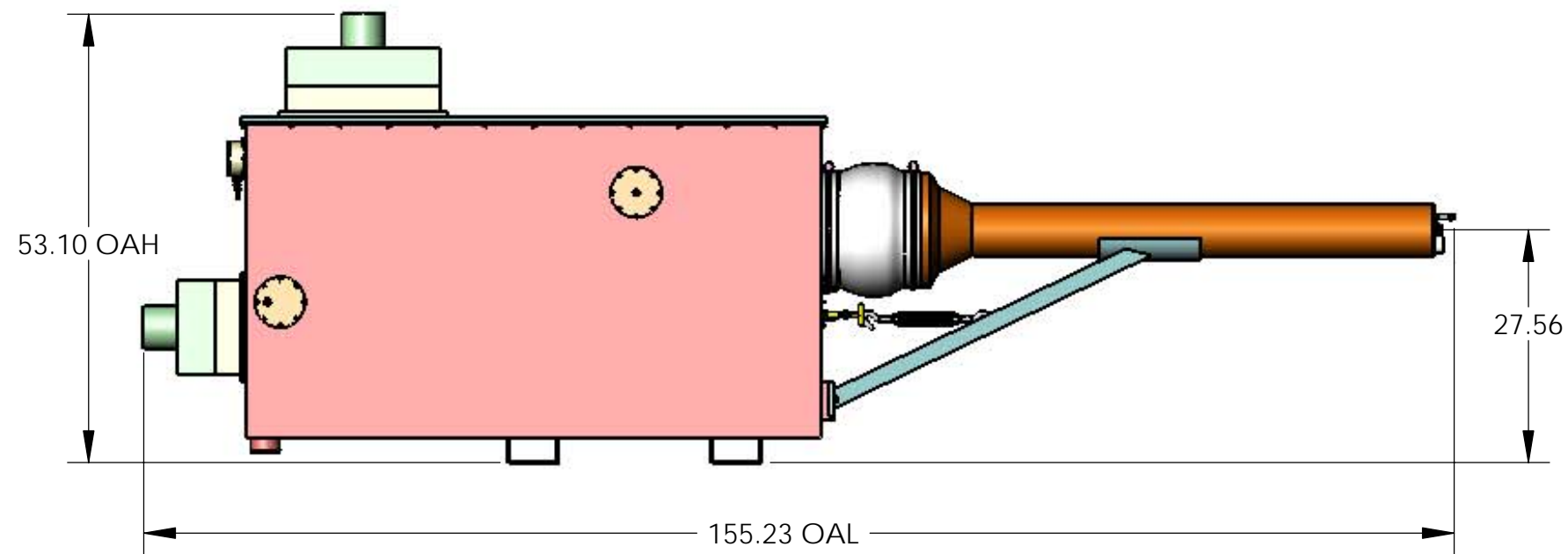
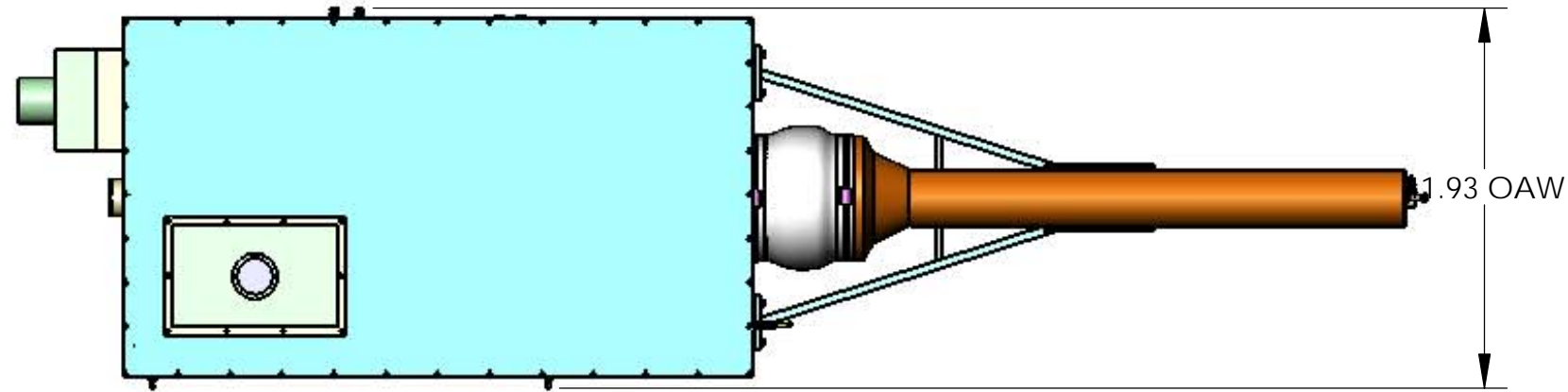
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SEC CONTAIN ASSY HJT	203-HJT-0500	1:22	1 of 3
SIZE	DWG NO.	REV	
C	203-HJT-0700	A	

DWG NO. 203-HJT-0700

S THIS DRAWING PRODUCED ON SOLIDWORKS

NOTES

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2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
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THIRD-ANGLE PROJECTION

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

DES	V GRAVES	06/04/2005
DRW	T OQUIN	06/04/2005
CHK		
ENG	V GRAVES	06/04/2005

**MERIT EXPERIMENT  
HG DELIVERY SYSTEM  
SECONDARY CONTAINMENT ASSY**

QA		
-	-	-

CAD FILE	PREV ASSY	SCALE	SHEET
SEC CONTAIN ASSY HJT	203-HJT-0500	1:20	2 of 3
SIZE	DWG NO.		REV
C	203-HJT-0700		A

DRAWING APPROVALS      DATE

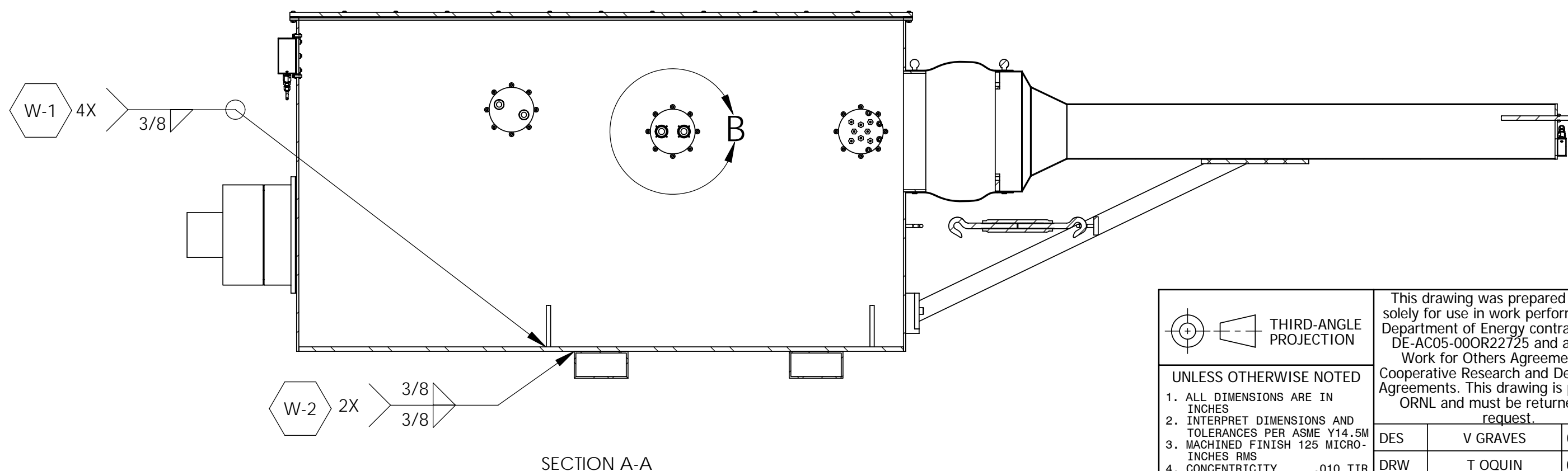
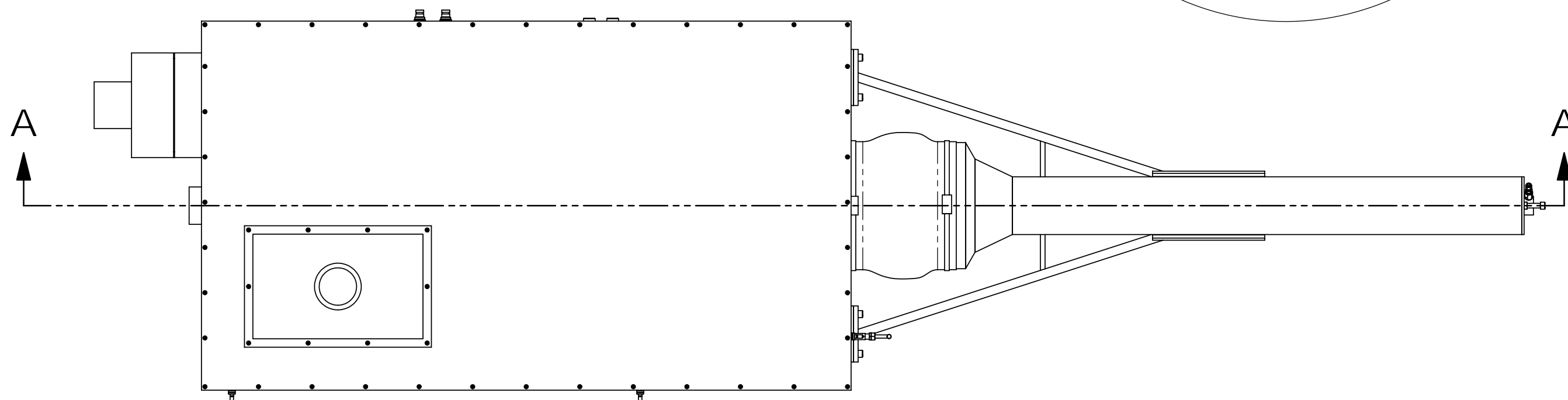
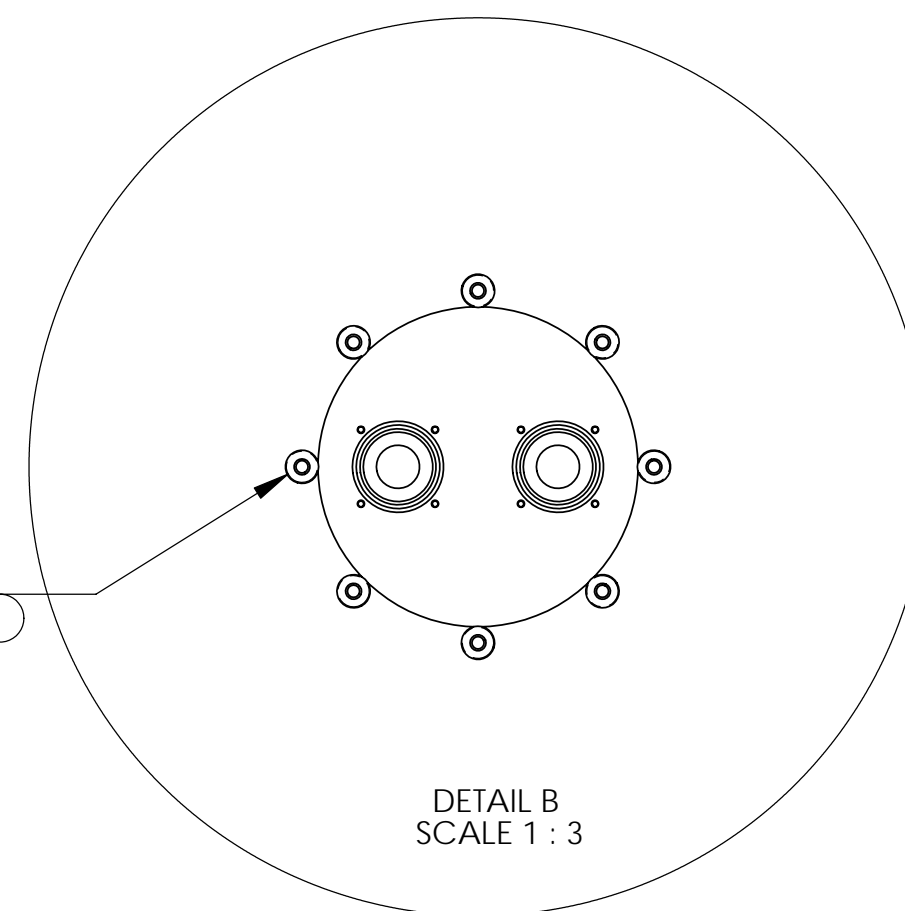
DWG NO. 203-HJT-0700

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NOTES

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WELDNUTS  
8X FOR EACH  
CONNECTOR PLATE ASSY  
7 PLCS.



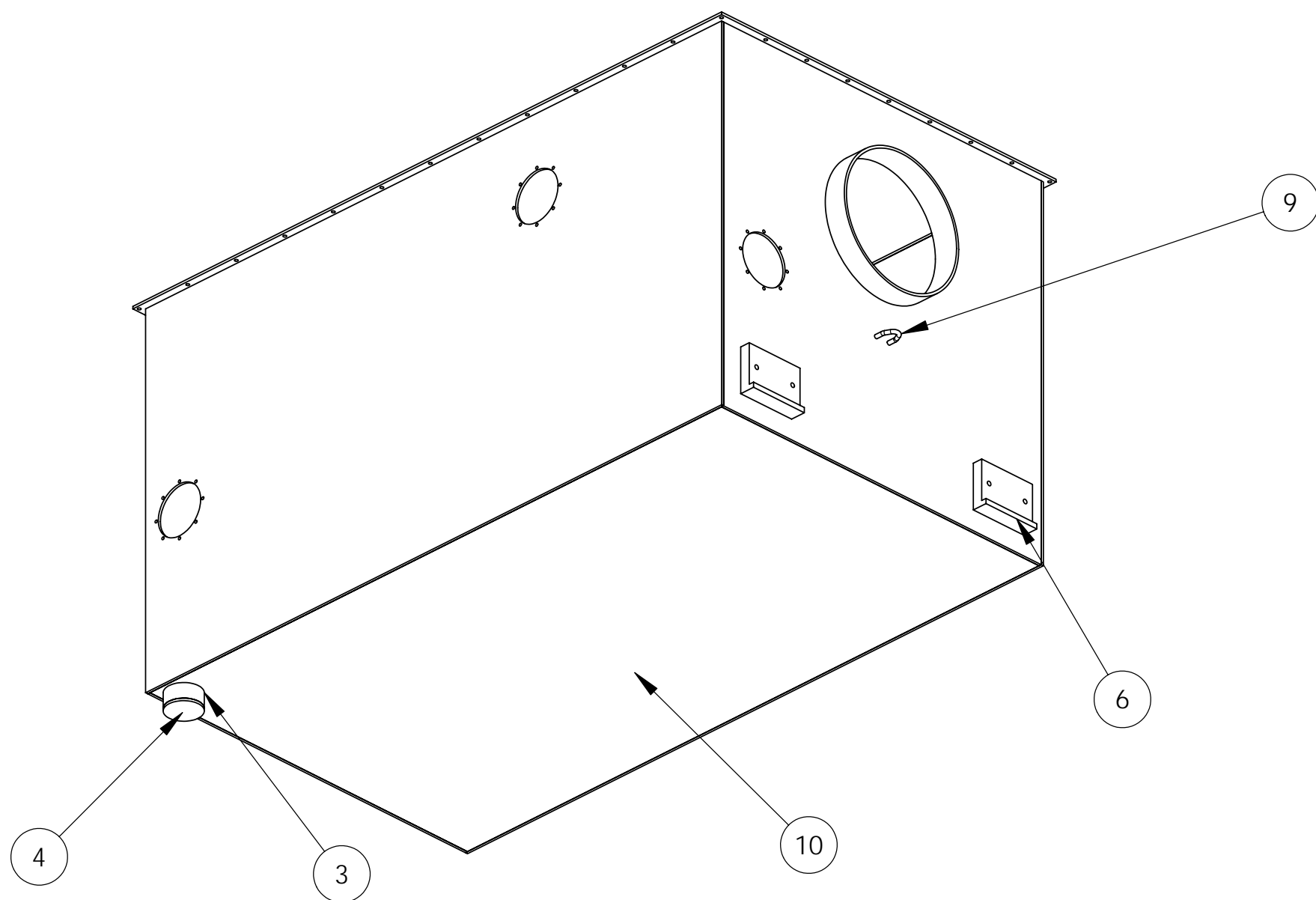
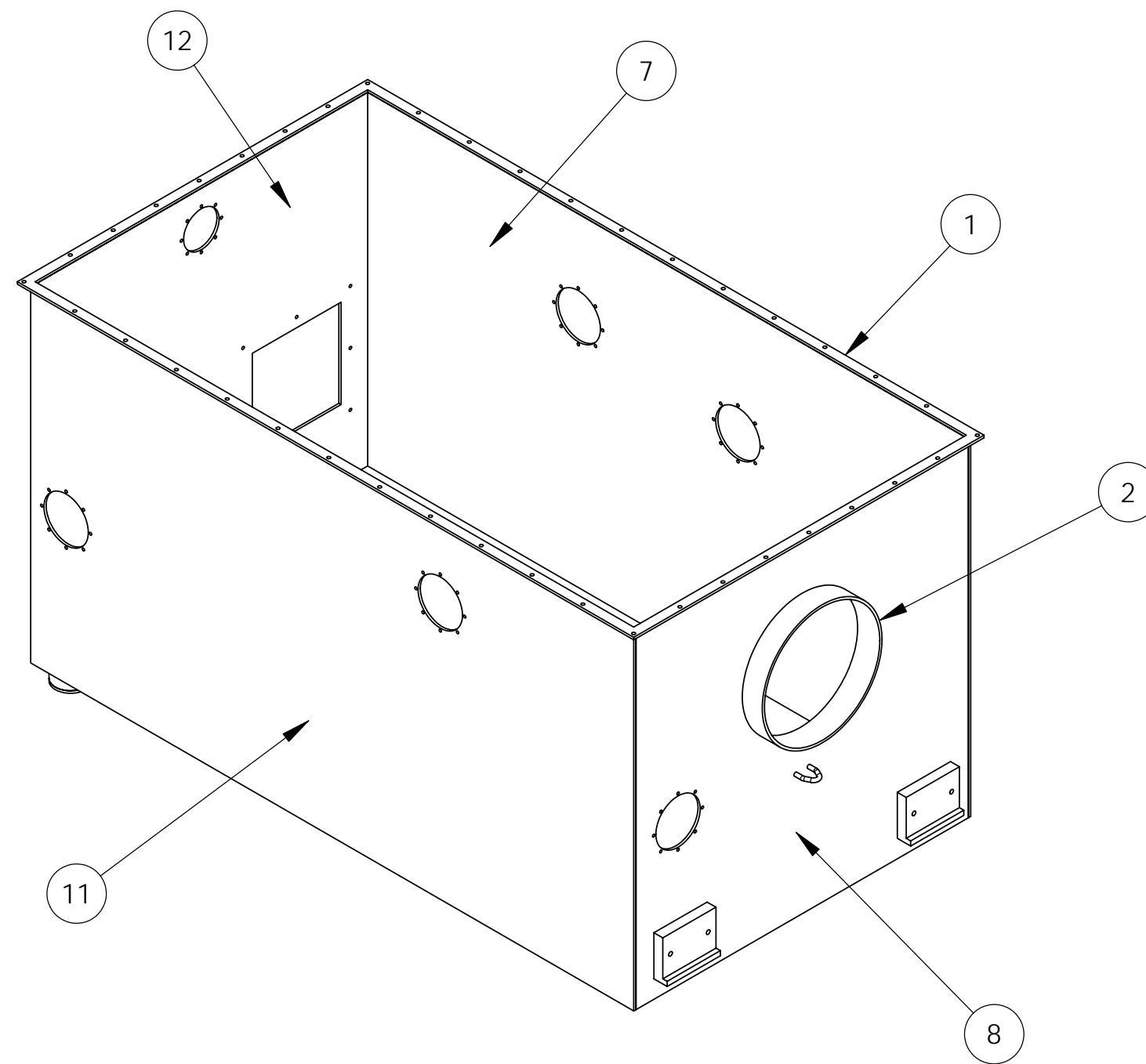
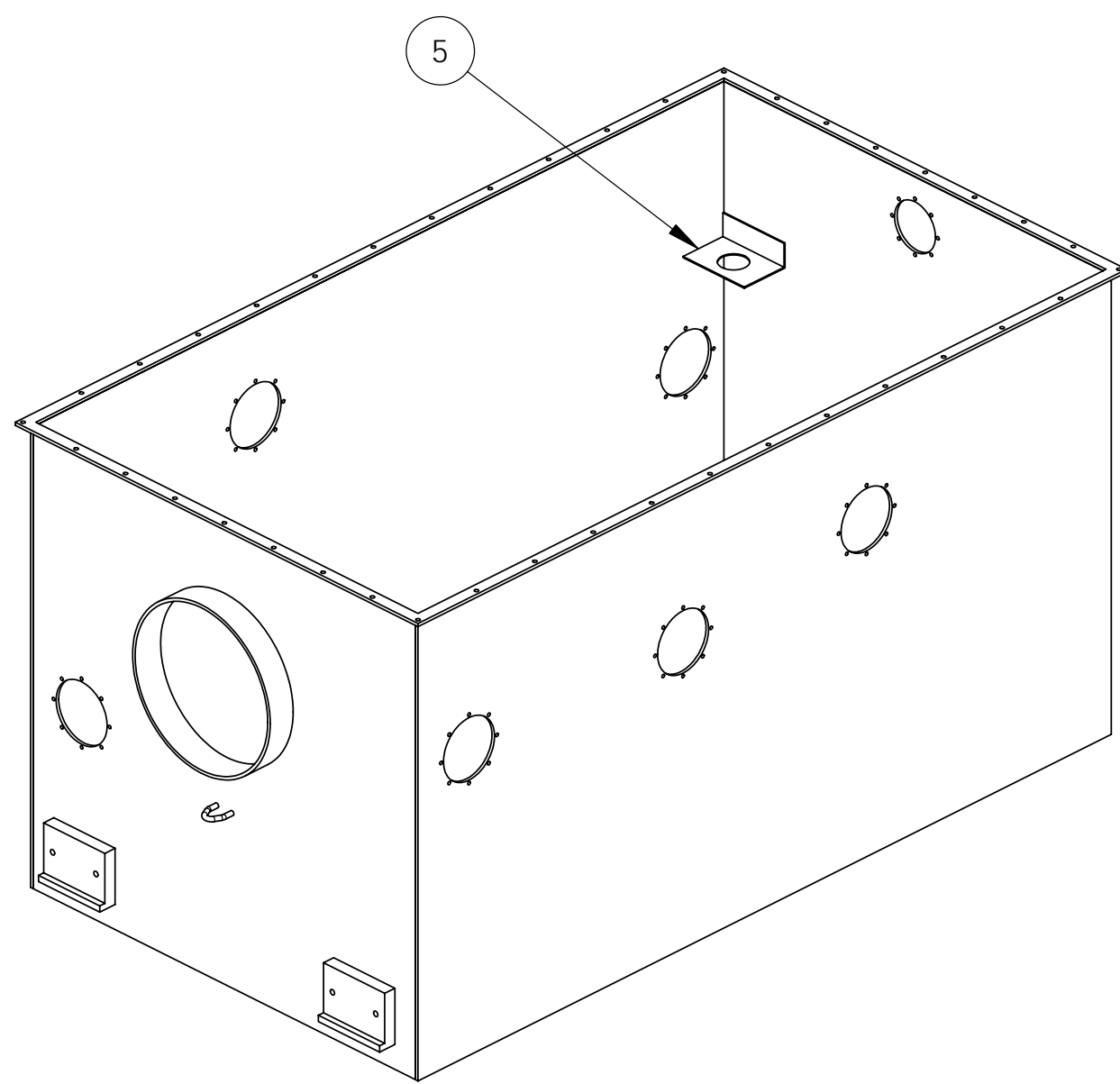
SECTION A-A

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° 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	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.			<b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN		
	DES	V GRAVES	06/04/2005	<b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE & TECHNOLOGY DIVISION		
DRW	T OQUIN	06/04/2005	<b>MERIT EXPERIMENT          HG DELIVERY SYSTEM          SECONDARY CONTAINMENT ASSY</b>			
CHK						
ENG	V GRAVES	06/04/2005	CAD FILE	PREV ASSY	SCALE	SHEET
QA			SEC CONTAIN ASSY HJT	203-HJT-0500	1:12	3 of 3
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0700	A	

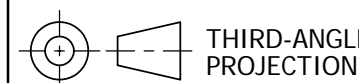
DWG NO. 203-HJT-0700

NOTES

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2. ALL BENDS SHARP UNLESS NOTED OTHERWISE
3. ALL BENDS  $90^\circ \pm 1^\circ$
4. PANELS 8, 9 & 10 CAN BE MADE AS ONE PEICE OF SHEET METAL WRAPPED AROUND PANEL 6
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6. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
7. MATERIAL CERTIFICATIONS REQUIRED



ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
12	1	SHEET, 38.00 x 37.00 x .250	SS - 304L, ASTM A240	37.00
11	1	SHEET, 37.00 X 68.00 x .250	SS - 304L, ASTM A240	68.00
10	1	PLATE, 37.50 x 67.50 x .50	SS - 304L, ASTM A240	67.50
9	1	ROUND, .38 OD x 4.25	SS - 304L, ASTM A276	4.25
8	1	SHEET, 37.50 x 37.00 x .25	SS - 304L, ASTM A240	37.50
7	1	SHEET, 37.00 x 68.00 x .25	SS - 304L, ASTM A240	68.00
6	2	PLATE, 4.50 x 6.00 x 1.50	SS - 304L, ASTM A240	1.50
5	1	SHEET, 6.00 x 6.00 x .10	SS - 304L, ASTM A240	6.00
4	1	PLATE, 3.43 OD x .25 THK.	SS - 304L, ASTM A240	N/A
3	1	PIPE, 3.00 OD SCH 40 x 1.50	SS - 304L, ASTM A312	1.50
2	1	PLATE, 2.50 x 48.70 x .250	SS - 304L, ASTM A240	48.70
1	1	SHEET, 39.50 x 69.50 x .250	SS - 304L, ASTM A240	69.50



THIRD-ANGLE PROJECTION

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

DES	V GRAVES	05/31/2005
DRW	T OQUIN	05/31/2005
CHK		
ENG	V GRAVES	05/31/2005
QA		

**MERIT EXPERIMENT**  
**SECONDARY CONTAINMENT ASSY**  
**SECONDARY CONTAINMENT BASE WELDMENT**

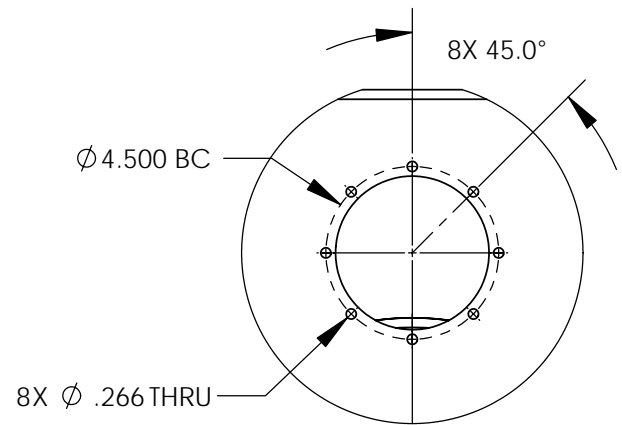
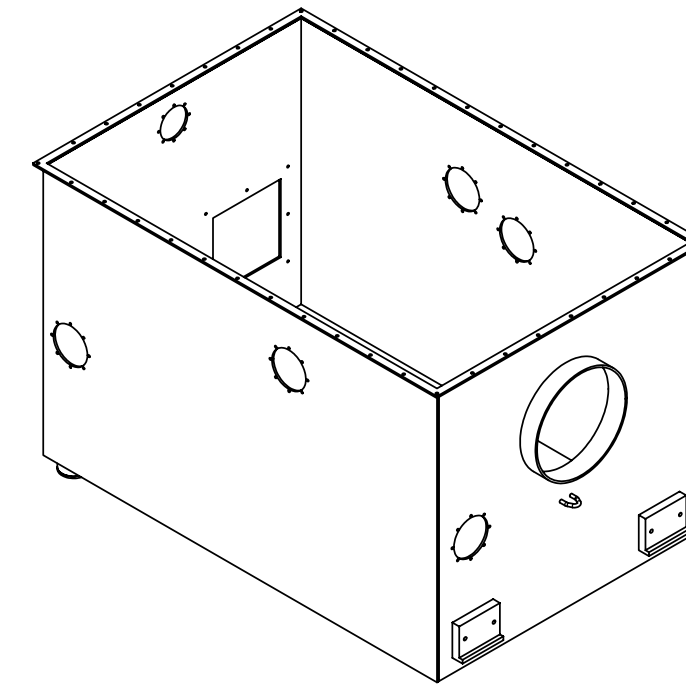
CAD FILE	SEC BASE HJT	PREV ASSY	SCALE	SHEET
SIZE	DWG NO.	203-HJT-0700	1:12	1 of 4

DRAWING APPROVALS	DATE	203-HJT-0701	REV
C			A

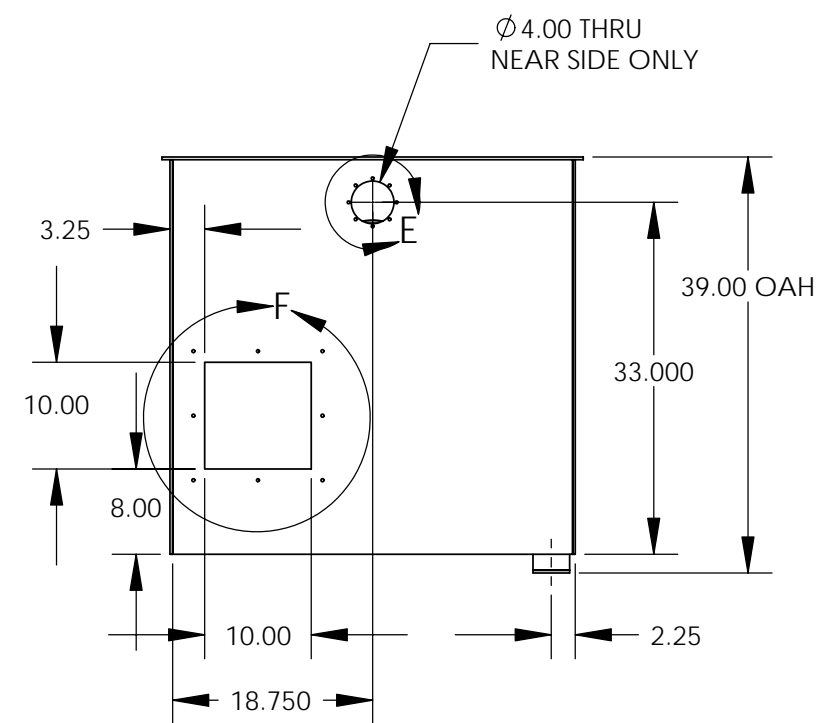
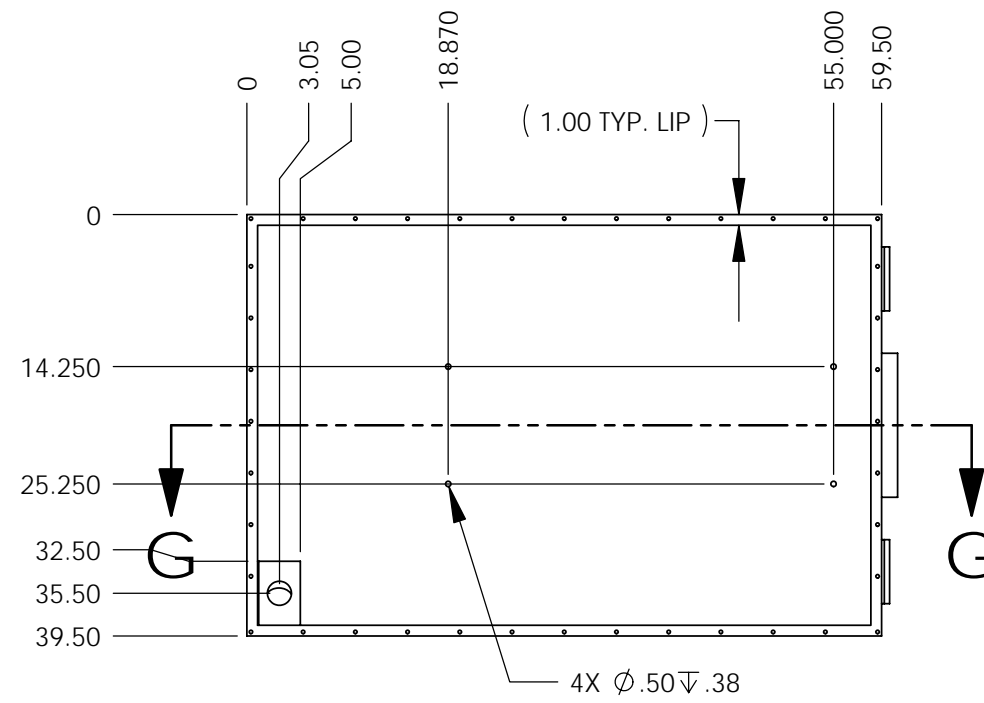
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NOTES

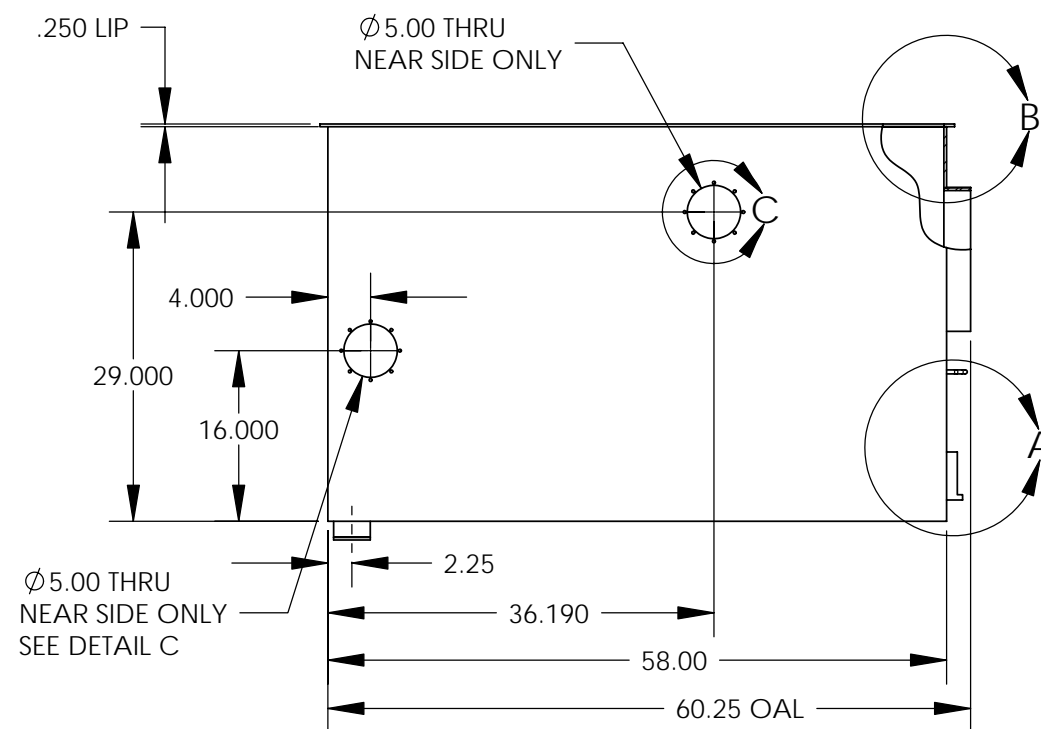
1. ALL WELDS MUST BE WATERTIGHT
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3. ALL BENDS  $90^\circ \pm 1^\circ$
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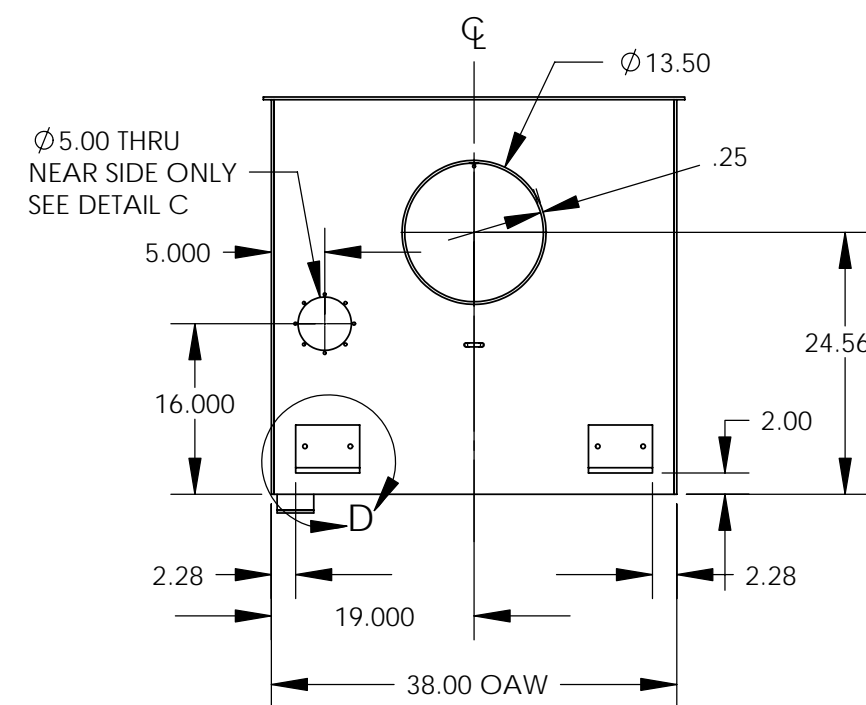
DETAIL E  
SCALE 1 : 5



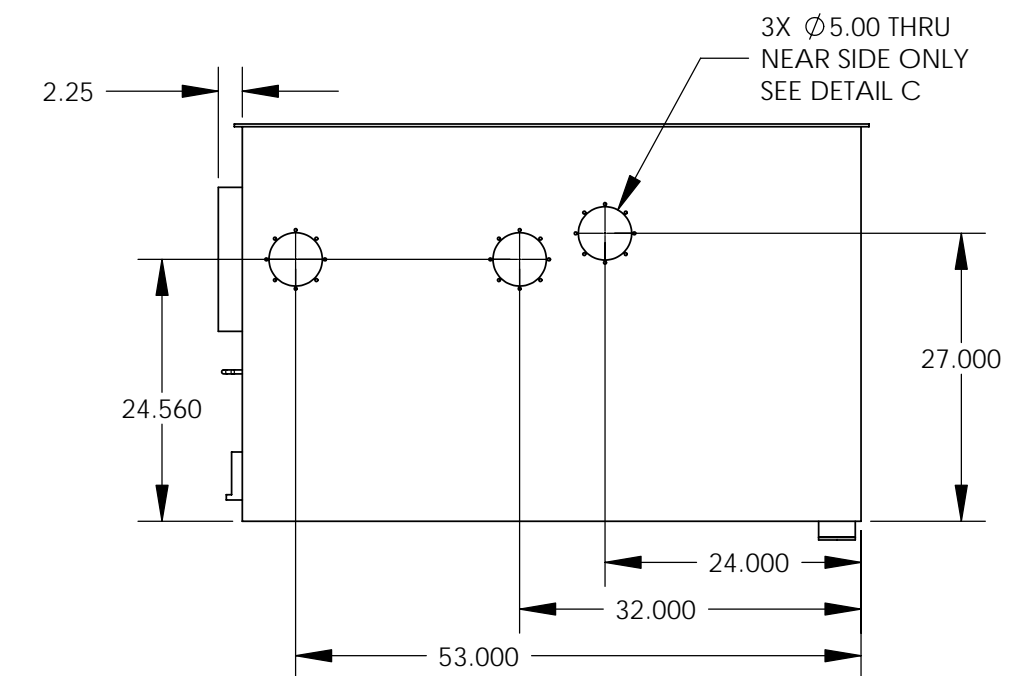
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SCALE 1 : 6



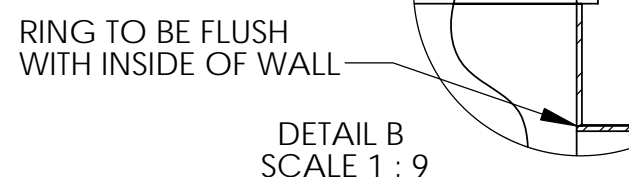
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SCALE 1 : 9



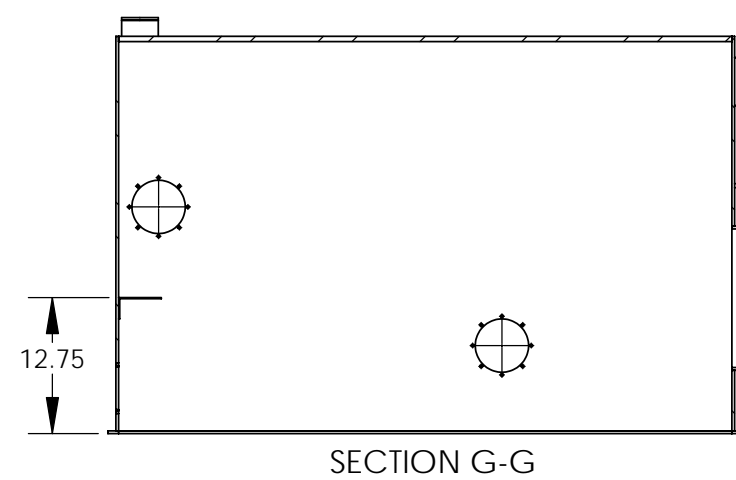
DETAIL C  
SCALE 1 : 5



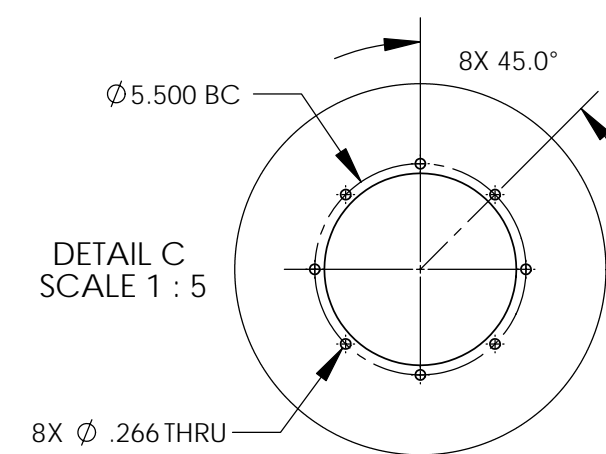
DETAIL D  
SCALE 1 : 9



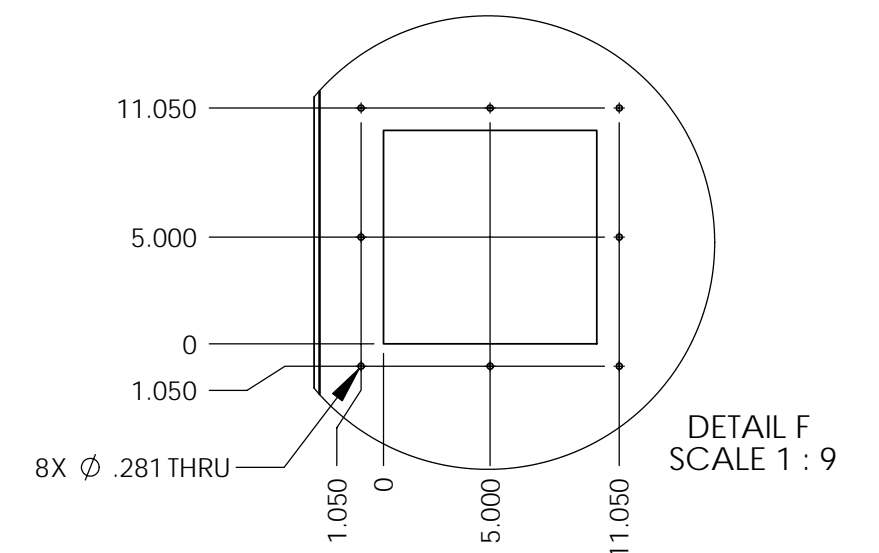
DETAIL E  
SCALE 1 : 9



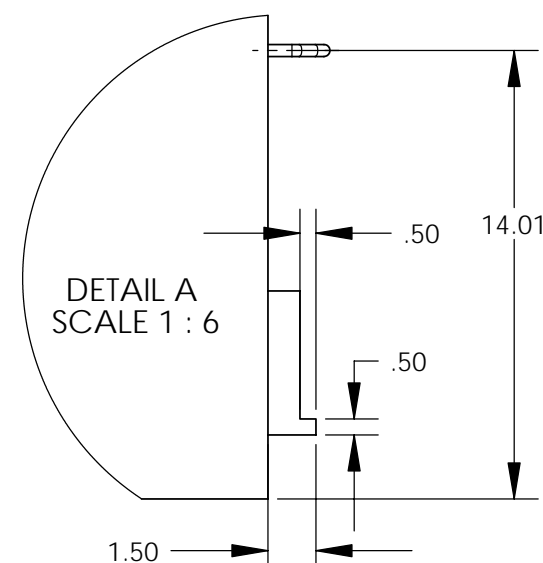
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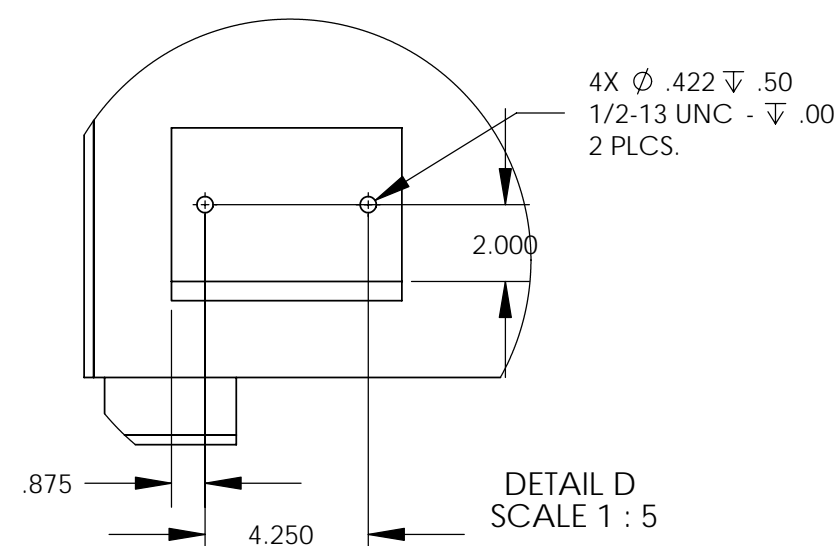
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SCALE 1 : 5



DETAIL G  
SCALE 1 : 9



DETAIL H  
SCALE 1 : 6



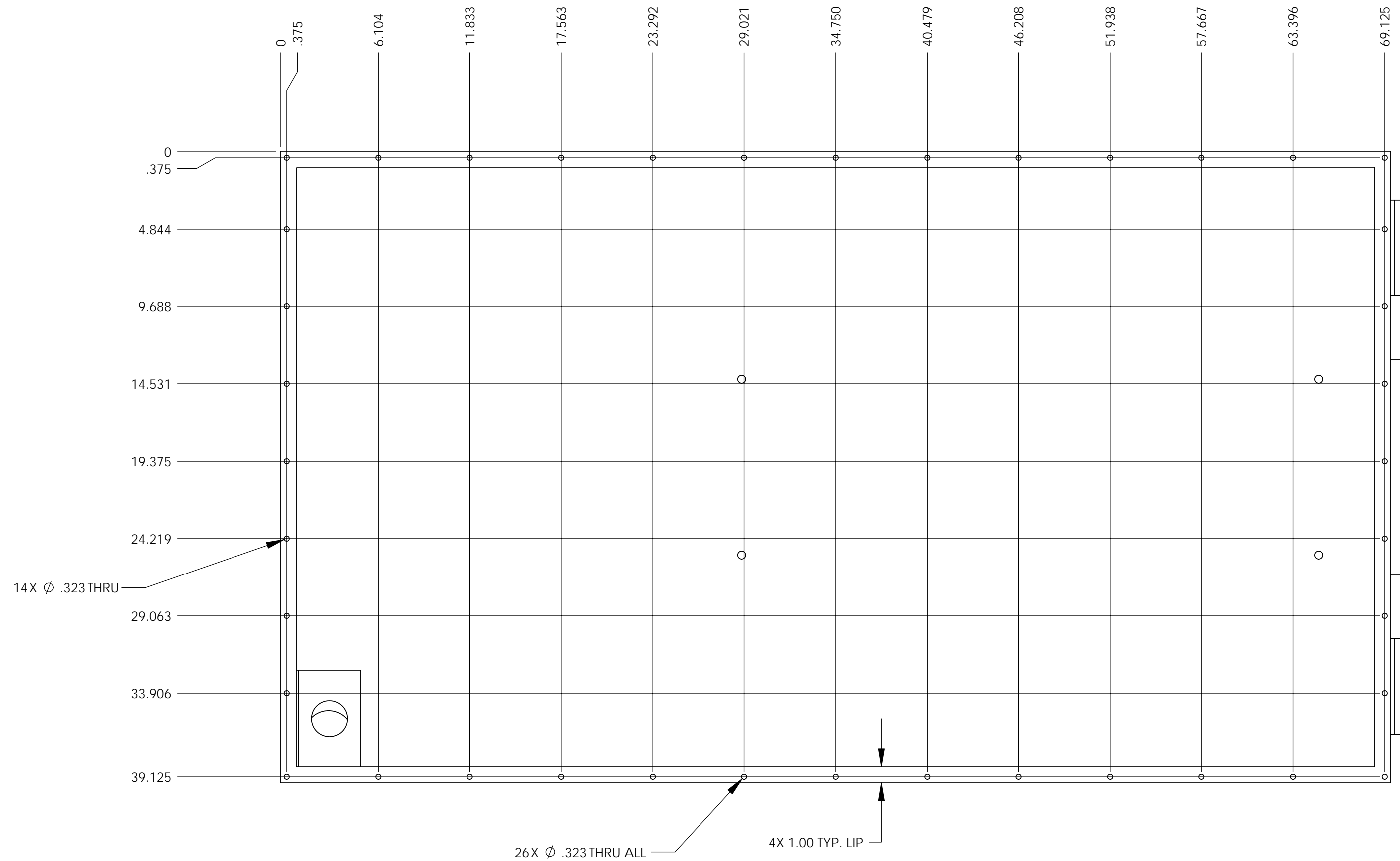
DETAIL I  
SCALE 1 : 5

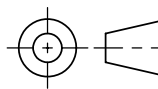


<p>THIRD-ANGLE PROJECTION</p>	<p>This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.</p>			<p><b>OAK RIDGE NATIONAL LABORATORY</b> 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"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY .010 TIR</li> <li>5. MACHINED ANGLES <math>\pm 1/2^\circ</math></li> <li>6. FORMED ANGLES <math>\pm 1^\circ</math></li> <li>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>8. WHOLE NUMBERS AND FRACTIONS <math>\pm 1/16</math></li> <li>9. X DECIMALS <math>\pm .030</math></li> <li>10. XX DECIMALS <math>\pm .010</math></li> <li>11. XXX DECIMALS <math>\pm .005</math></li> </ol>			<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	05/31/2005	<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SECONDARY CONTAINMENT BASE WELDMENT</b></p>			
DRW	T OQUIN	05/31/2005				
CHK						
ENG	V GRAVES	05/31/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			SEC BASE HJT	203-HJT-0700	1:18	2 of 4
DRAWING APPROVALS			DATE	SIZE	DWG NO.	REV
				C	203-HJT-0701	A

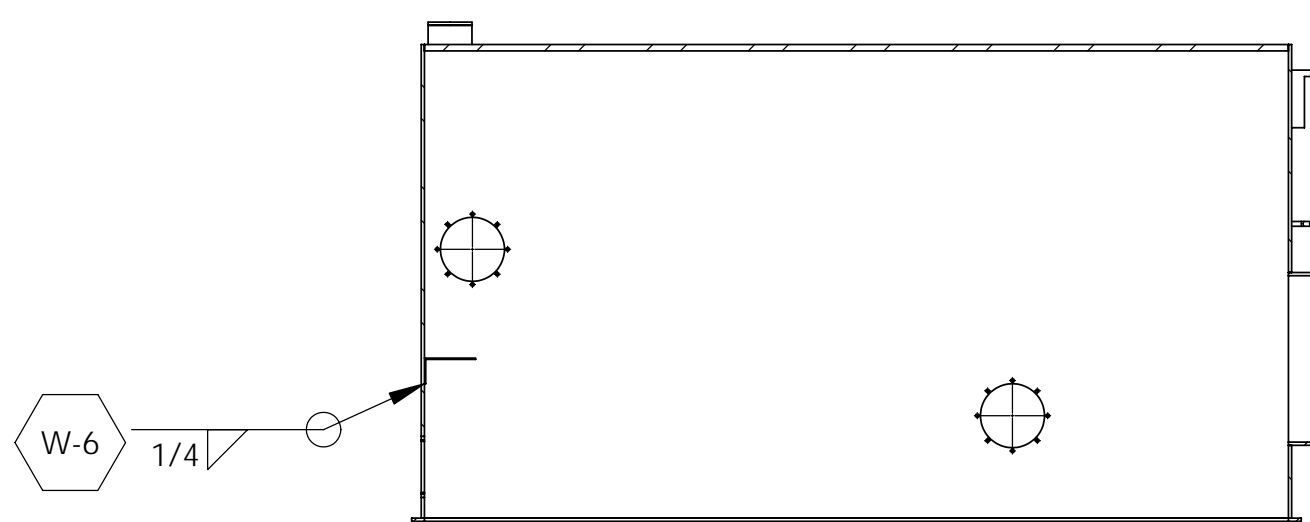
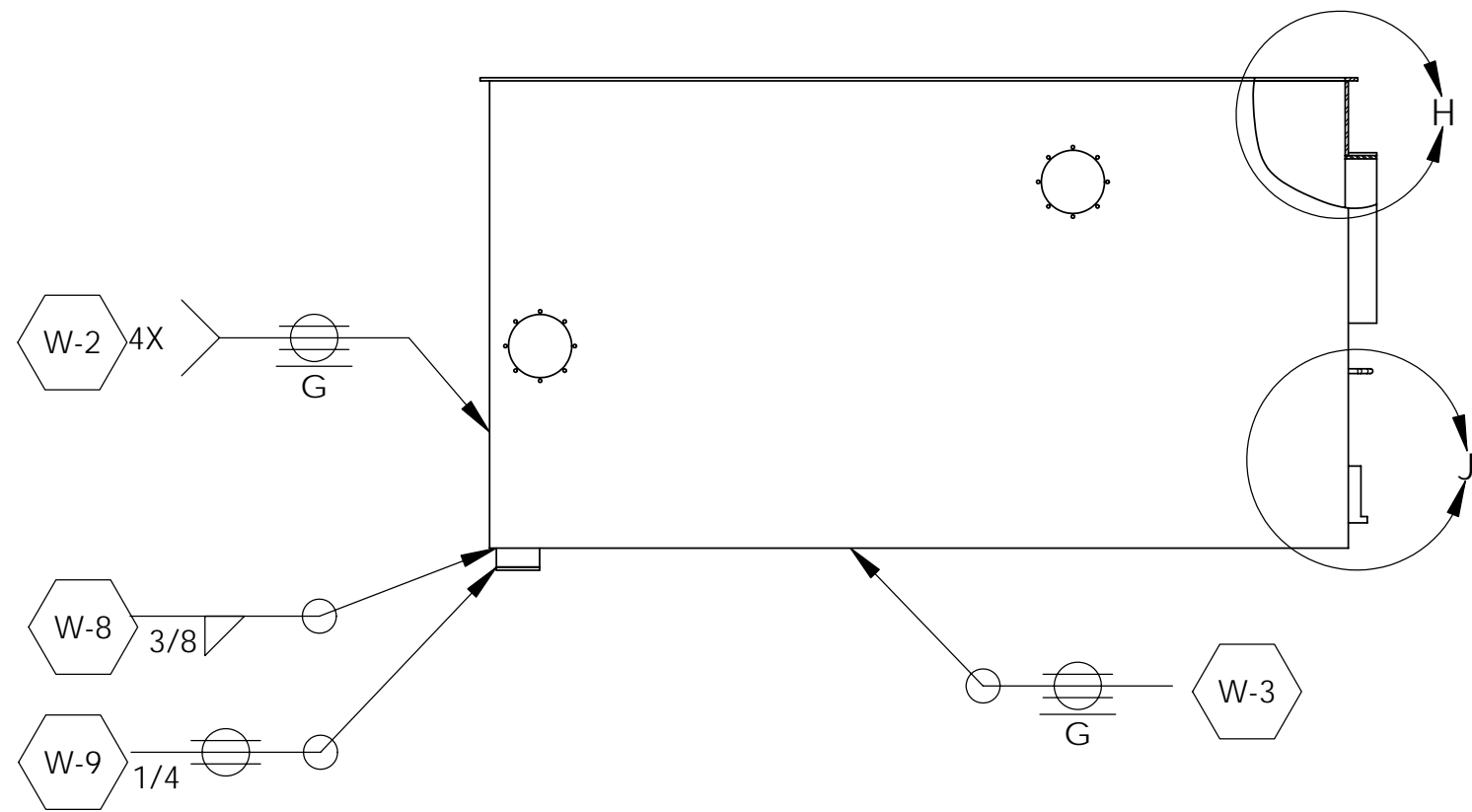
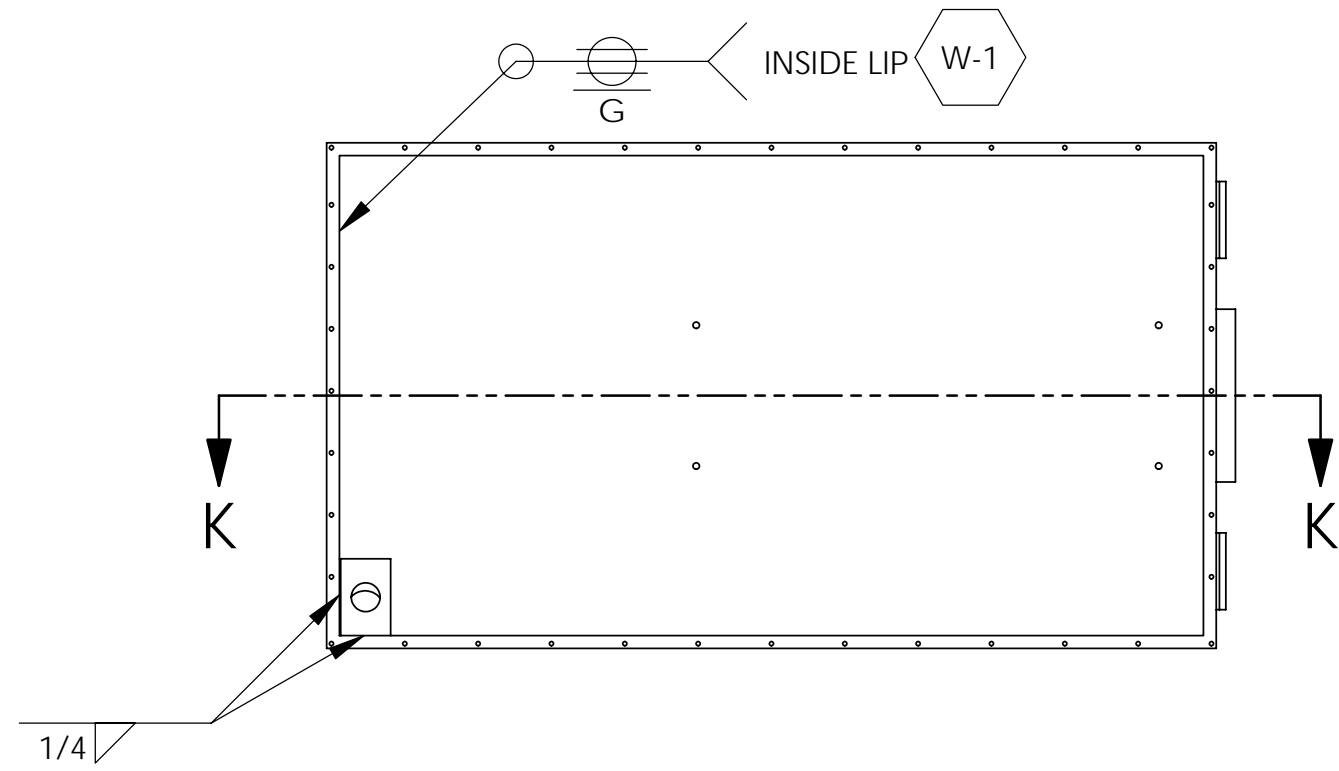
DWG NO. 203-HJT-0701

NOTES

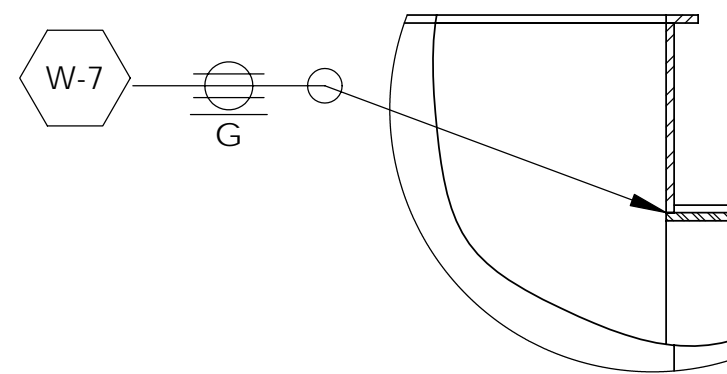
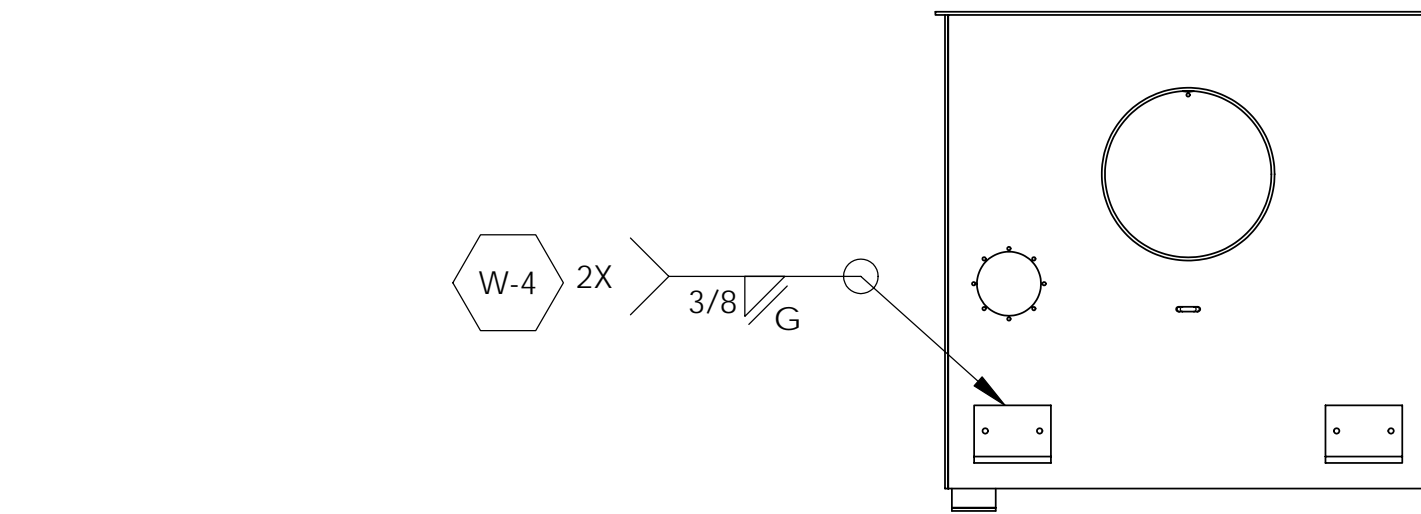
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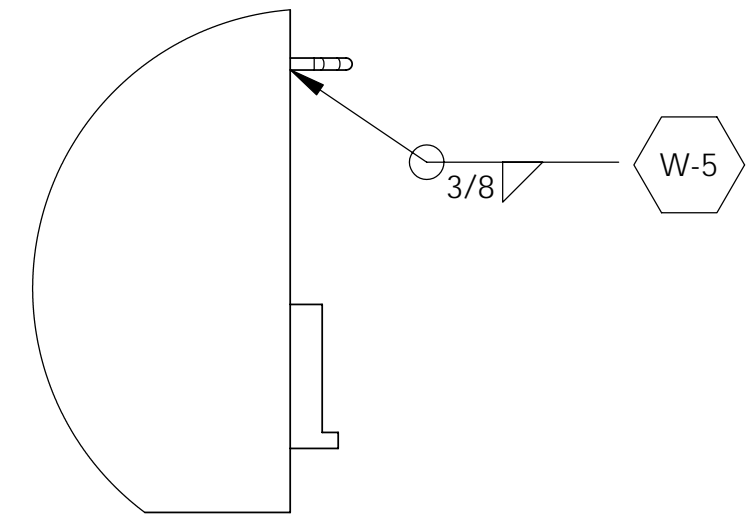
 <p>THIRD-ANGLE PROJECTION</p>	<p>This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.</p>	 <p><b>OAK RIDGE NATIONAL LABORATORY</b> 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"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY .010 TIR</li> <li>5. MACHINED ANGLES <math>\pm 1/2^\circ</math> FORMED ANGLES <math>\pm 1^\circ</math></li> <li>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>7. WHOLE NUMBERS AND FRACTIONS <math>\pm 1/16</math></li> <li>8. X DECIMALS <math>\pm .030</math></li> <li>9. XX DECIMALS <math>\pm .010</math></li> <li>10. XXX DECIMALS <math>\pm .005</math></li> </ol>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="font-size: 8px;">DES</td> <td style="font-size: 8px;">V GRAVES</td> <td style="font-size: 8px;">05/31/2005</td> </tr> <tr> <td style="font-size: 8px;">DRW</td> <td style="font-size: 8px;">T OQUIN</td> <td style="font-size: 8px;">05/31/2005</td> </tr> <tr> <td style="font-size: 8px;">CHK</td> <td></td> <td></td> </tr> <tr> <td style="font-size: 8px;">ENG</td> <td style="font-size: 8px;">V GRAVES</td> <td style="font-size: 8px;">05/31/2005</td> </tr> <tr> <td style="font-size: 8px;">QA</td> <td></td> <td></td> </tr> </table>	DES	V GRAVES	05/31/2005	DRW	T OQUIN	05/31/2005	CHK			ENG	V GRAVES	05/31/2005	QA			 <p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
	DES	V GRAVES	05/31/2005															
DRW	T OQUIN	05/31/2005																
CHK																		
ENG	V GRAVES	05/31/2005																
QA																		
<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SECONDARY CONTAINMENT BASE WELDMENT</b></p>		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="font-size: 8px;">CAD FILE</td> <td style="font-size: 8px;">PREV ASSY</td> <td style="font-size: 8px;">SCALE</td> <td style="font-size: 8px;">SHEET</td> </tr> <tr> <td style="font-size: 8px;">SEC BASE HJT</td> <td style="font-size: 8px;">203-HJT-0700</td> <td style="font-size: 8px;">1:6</td> <td style="font-size: 8px;">3 of 4</td> </tr> <tr> <td style="font-size: 8px;">SIZE</td> <td style="font-size: 8px;">DWG NO.</td> <td style="font-size: 8px;">REV</td> <td></td> </tr> <tr> <td style="font-size: 8px;">C</td> <td style="font-size: 8px;">203-HJT-0701</td> <td style="font-size: 8px;">A</td> <td></td> </tr> </table>	CAD FILE	PREV ASSY	SCALE	SHEET	SEC BASE HJT	203-HJT-0700	1:6	3 of 4	SIZE	DWG NO.	REV		C	203-HJT-0701	A	
CAD FILE	PREV ASSY	SCALE	SHEET															
SEC BASE HJT	203-HJT-0700	1:6	3 of 4															
SIZE	DWG NO.	REV																
C	203-HJT-0701	A																
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="font-size: 8px;">DRAWING APPROVALS</td> <td style="font-size: 8px;">DATE</td> </tr> <tr> <td style="height: 20px;"></td> <td></td> </tr> </table>		DRAWING APPROVALS	DATE															
DRAWING APPROVALS	DATE																	



SECTION K-K



DETAIL H  
SCALE 1 : 6



DETAIL J  
SCALE 1 : 6

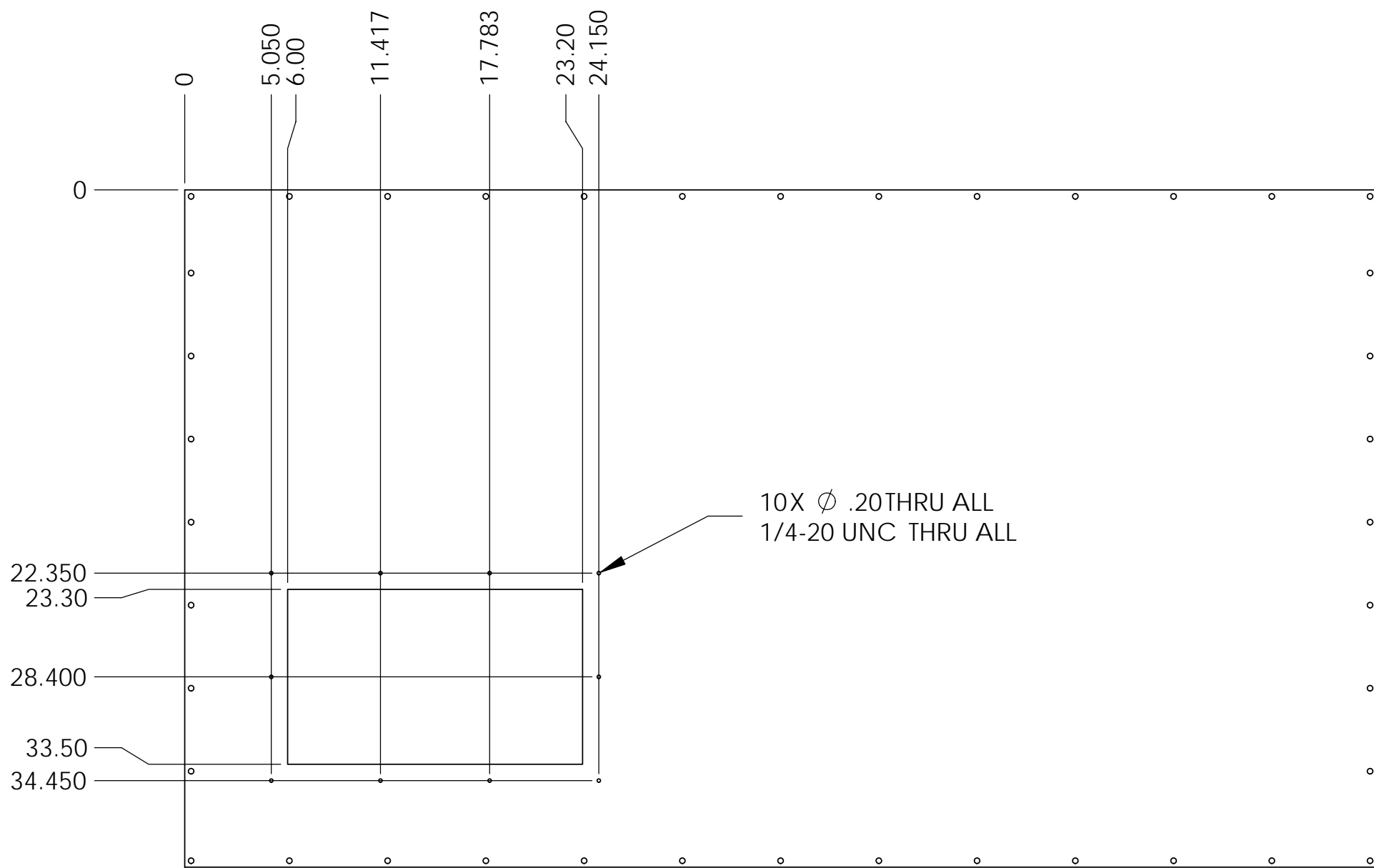
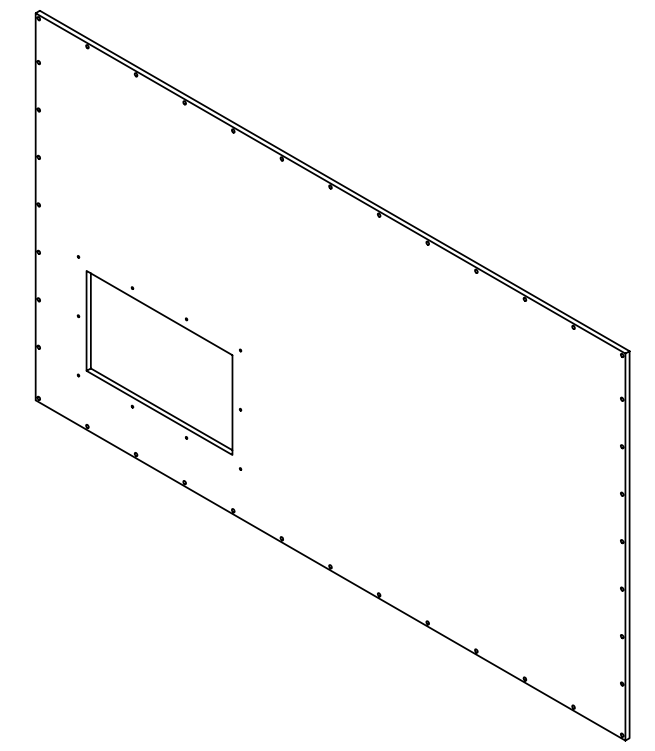
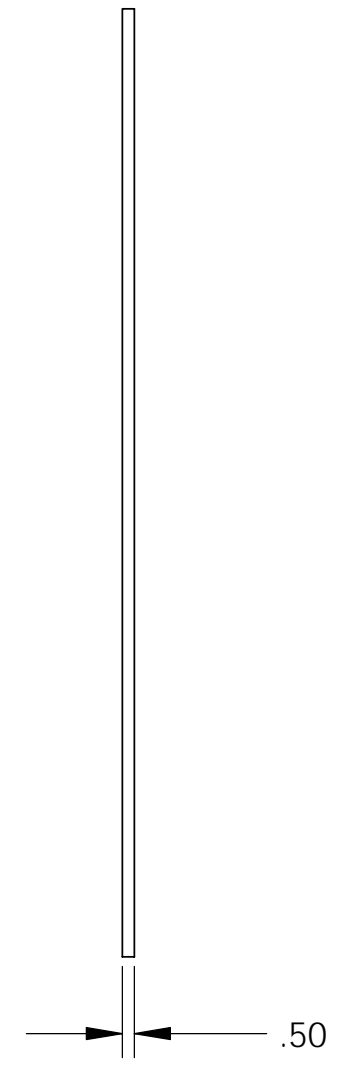
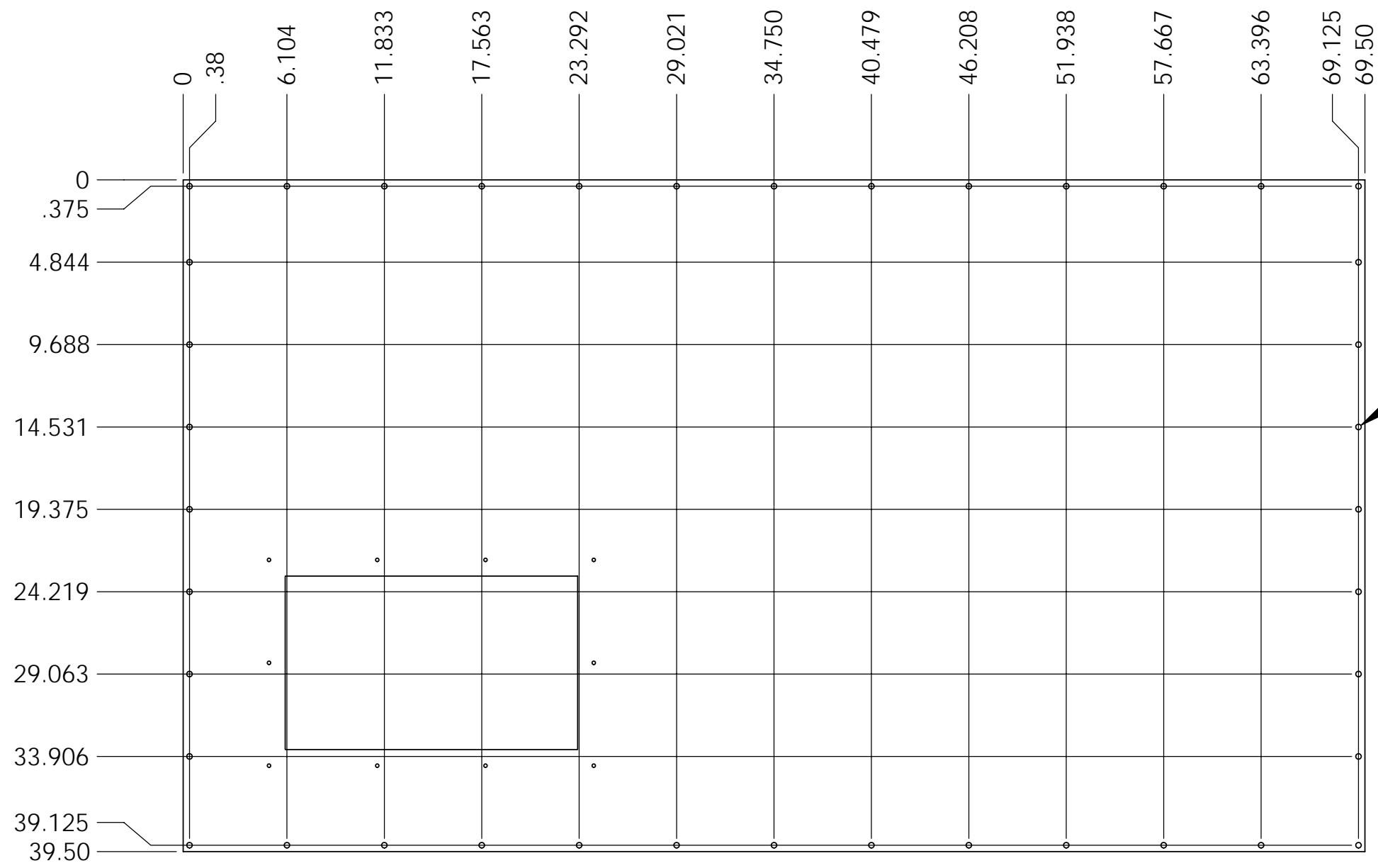
NOTES

1. ALL WELDS MUST BE WATERTIGHT
2. ALL BENDS SHARP UNLESS NOTED OTHERWISE
3. ALL BENDS  $90^\circ \pm 1^\circ$
4. PANELS 8, 9 & 10 CAN BE MADE AS ONE PEICE OF SHEET METAL WRAPPED AROUND PANEL 6
5. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
6. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
7. MATERIAL CERTIFICATIONS REQUIRED

<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 $\pm 1/2^\circ$ 6. BREAK SHARP CORNERS AND REMOVE ALL BURRS 7. WHOLE NUMBERS AND FRACTIONS $\pm 1/16$ 8. X DECIMALS $\pm .030$ 9. XX DECIMALS $\pm .010$ 10. XXX DECIMALS $\pm .005$			<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	05/31/2005	<b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SECONDARY CONTAINMENT BASE WELDMENT</b>			
DRW	T OQUIN	05/31/2005				
CHK						
ENG	V GRAVES	05/31/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			SEC BASE HJT	203-HJT-0700	1:15	4 of 4
DRAWING APPROVALS		DATE	SIZE	DWG NO.		REV
			C	203-HJT-0701		A

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



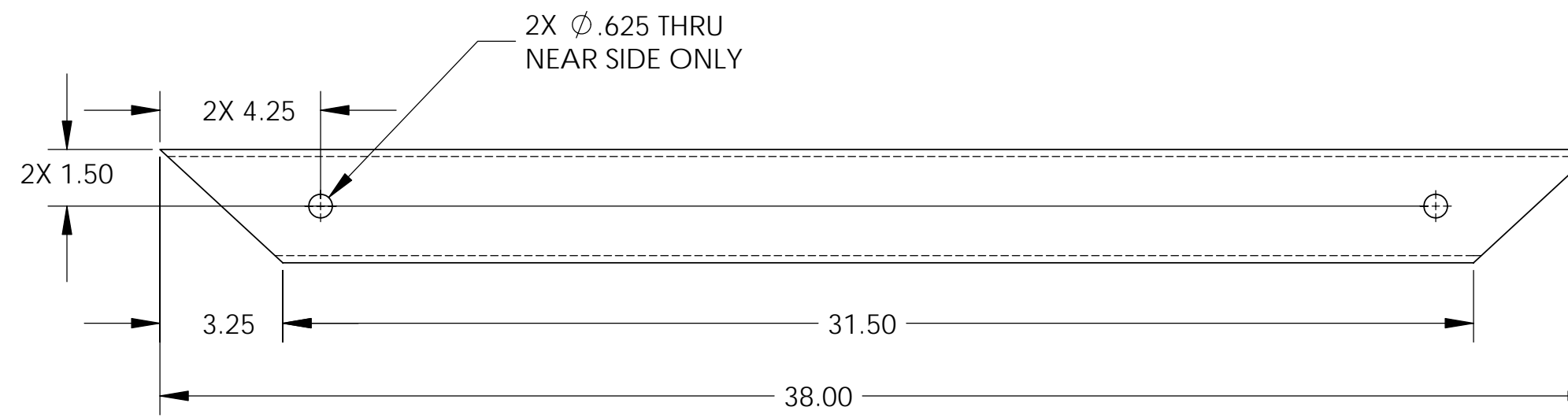
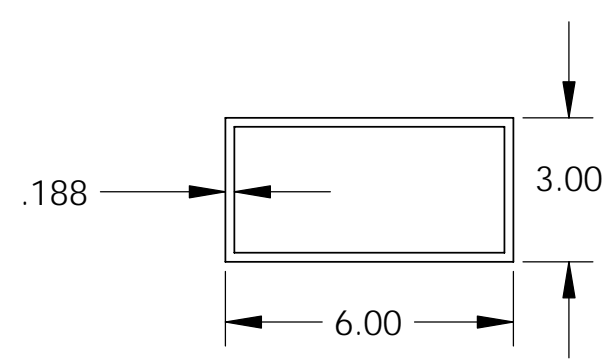
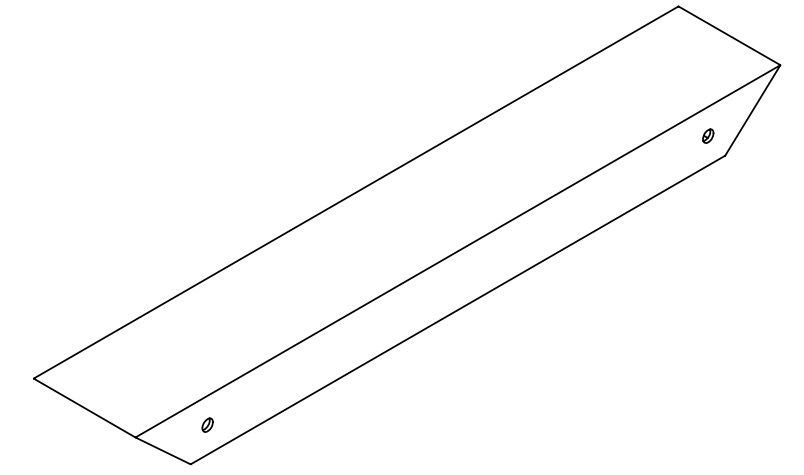
MATERIAL: LEXAN - 1/2"

<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>		
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DES	V GRAVES	06/09/2005	<b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SECONDARY CONTAINMENT TOP COVER</b>			
DRW	T OQUIN	06/09/2005				
CHK						
ENG	V GRAVES	06/09/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			SEC TOP COVER HJT	203-HJT-0700	1:8	1 of 1
DRAWING APPROVALS			DATE	SIZE	DWG NO.	REV
				C	203-HJT-0702	A



NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

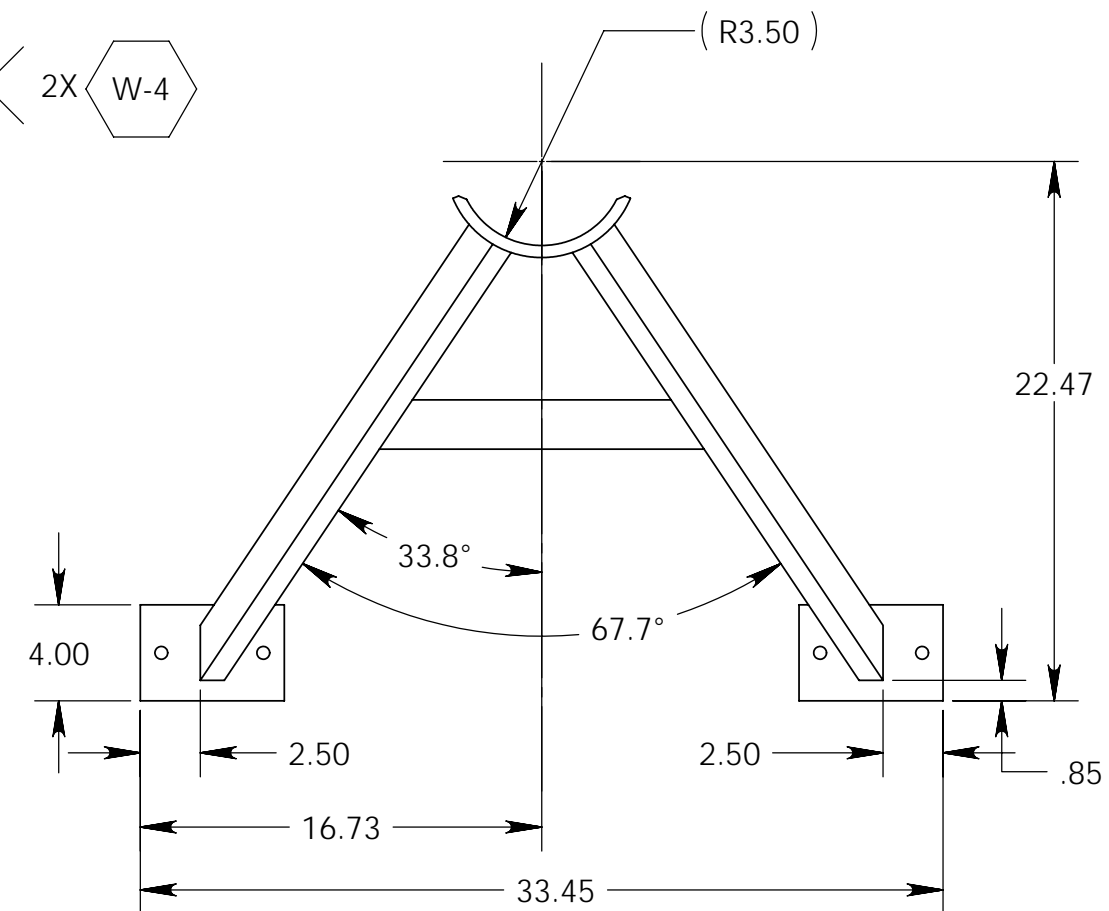
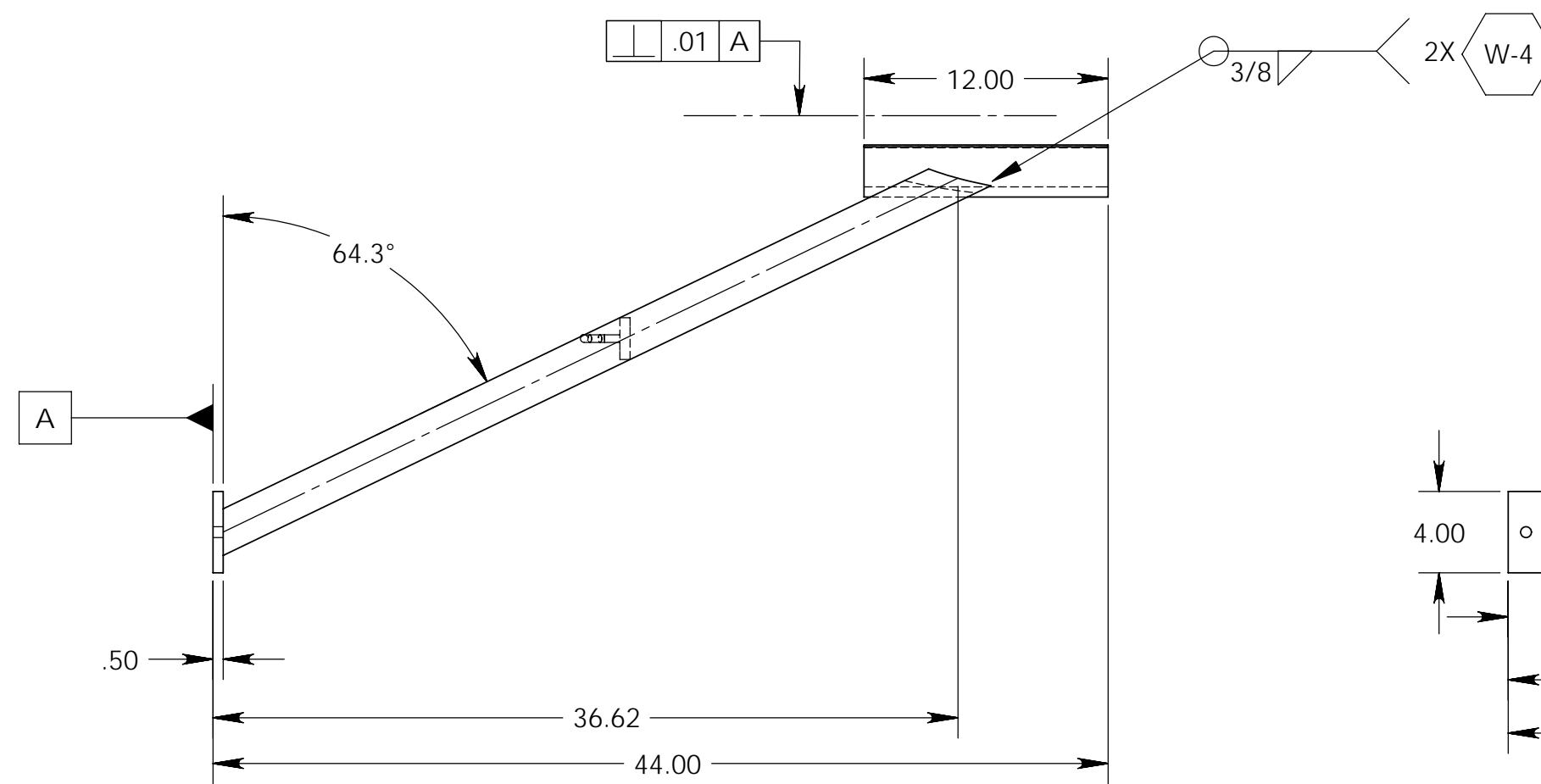
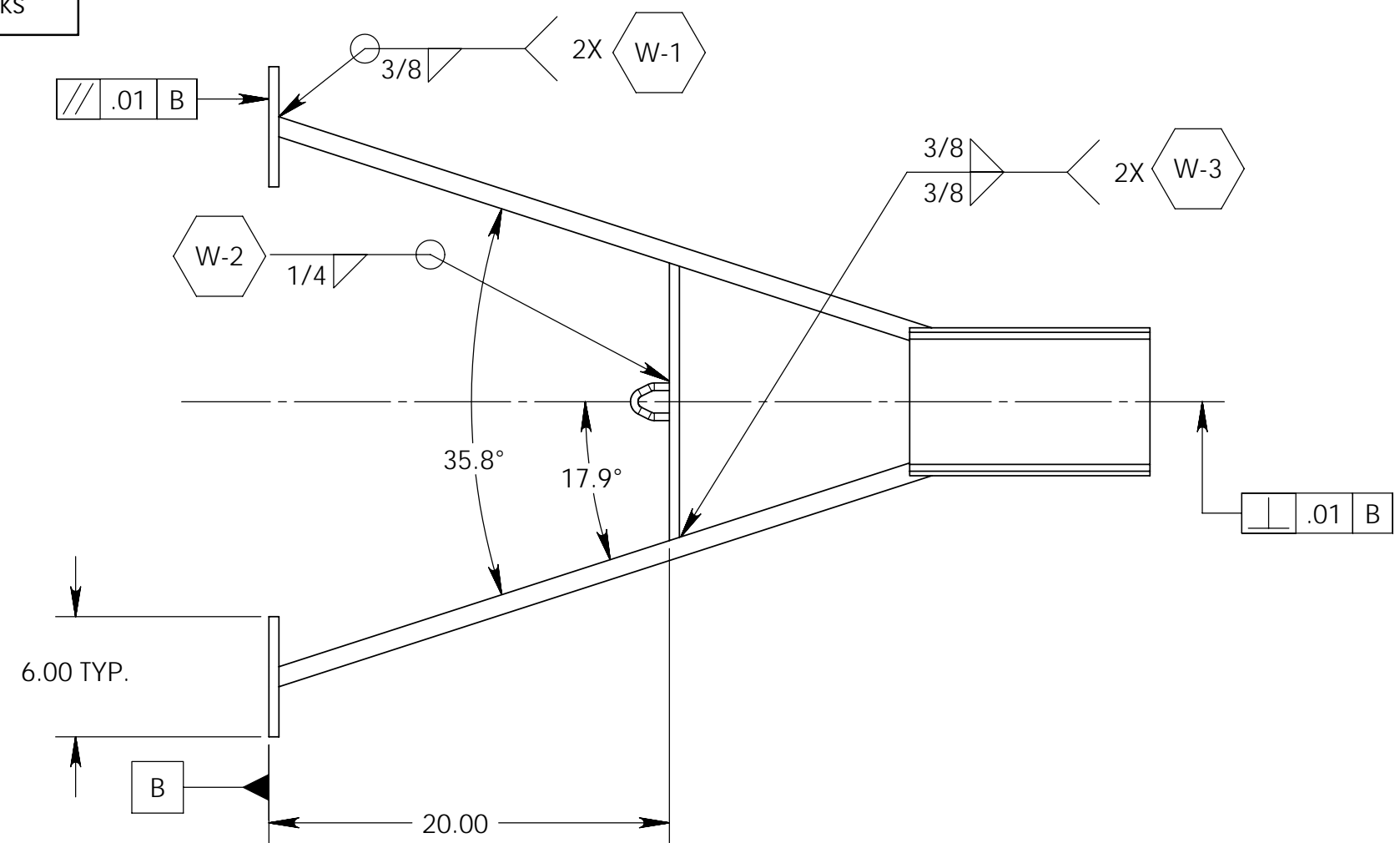


NO BURRS OR SHARP EDGES PERMITTED INSIDE LIP ON EITHER END

MATERIAL: AL - 6061 T52, ASTM B221

<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>		
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DES	V GRAVES	06/09/2005	<b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY RECTANGULAR TUBING SUPPORT</b>			
DRW	T OQUIN	06/09/2005				
CHK						
ENG	V GRAVES	06/09/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			RECT TUBING SUPPORT HJT	203-HJT-0700	1:4	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.		REV
			C	203-HJT-0703		A

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
5	1	ROUND, .38 OD x 4.25	AL - 6061-T6, ASTM B-211	4.25
4	1	BAR, 2.05 x 13.53 x .50	AL - 6061-T6511, ASTM B-221	13.53
3	2	BAR, 1.00 x 2.00 x 42.00	AL - 6061-T6511, ASTM B-221	42.00
2	1	DRAWN SEAMLESS TUBE, 8.00 OD x 1" WALL	AL - 6061-T6, ASTM B-210	12.00
1	2	PLATE, 4.00 x 6.00 x .50	AL - 6061-T6511, ASTM B-221	6.00

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

**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

**MERIT EXPERIMENT  
SECONDARY CONTAINMENT ASSY  
SUPPORT CRADLE**

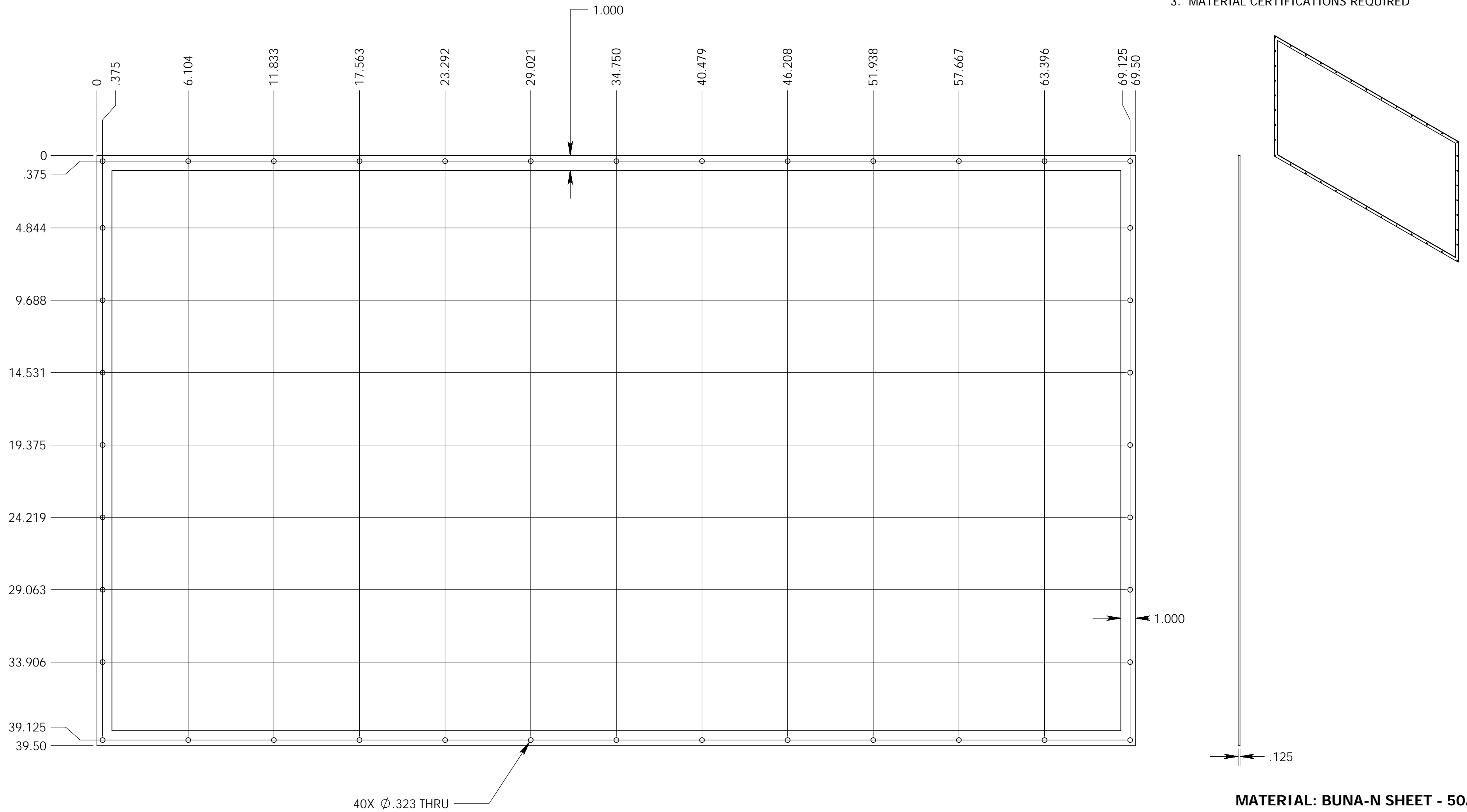
CAD FILE	PREV ASSY	SCALE	SHEET
SUPPORT CRADLE HJT	203-HJT-0700	1:8	1 of 1
SIZE	DWG NO.	REV	
C	203-HJT-0704	A	

DRAWING APPROVALS DATE

DWG NO. 203-HJT-0704

NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

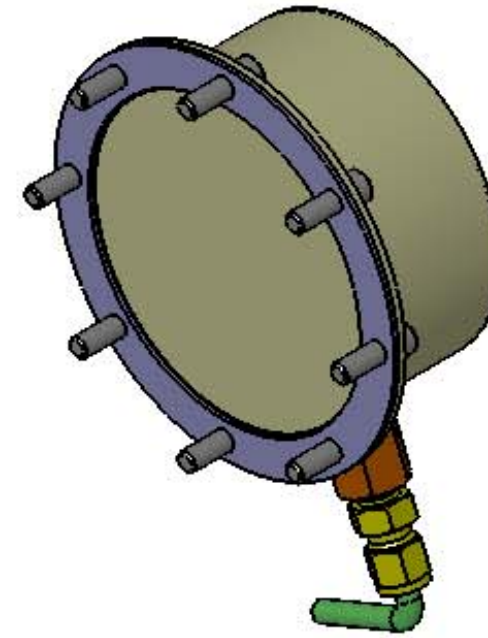
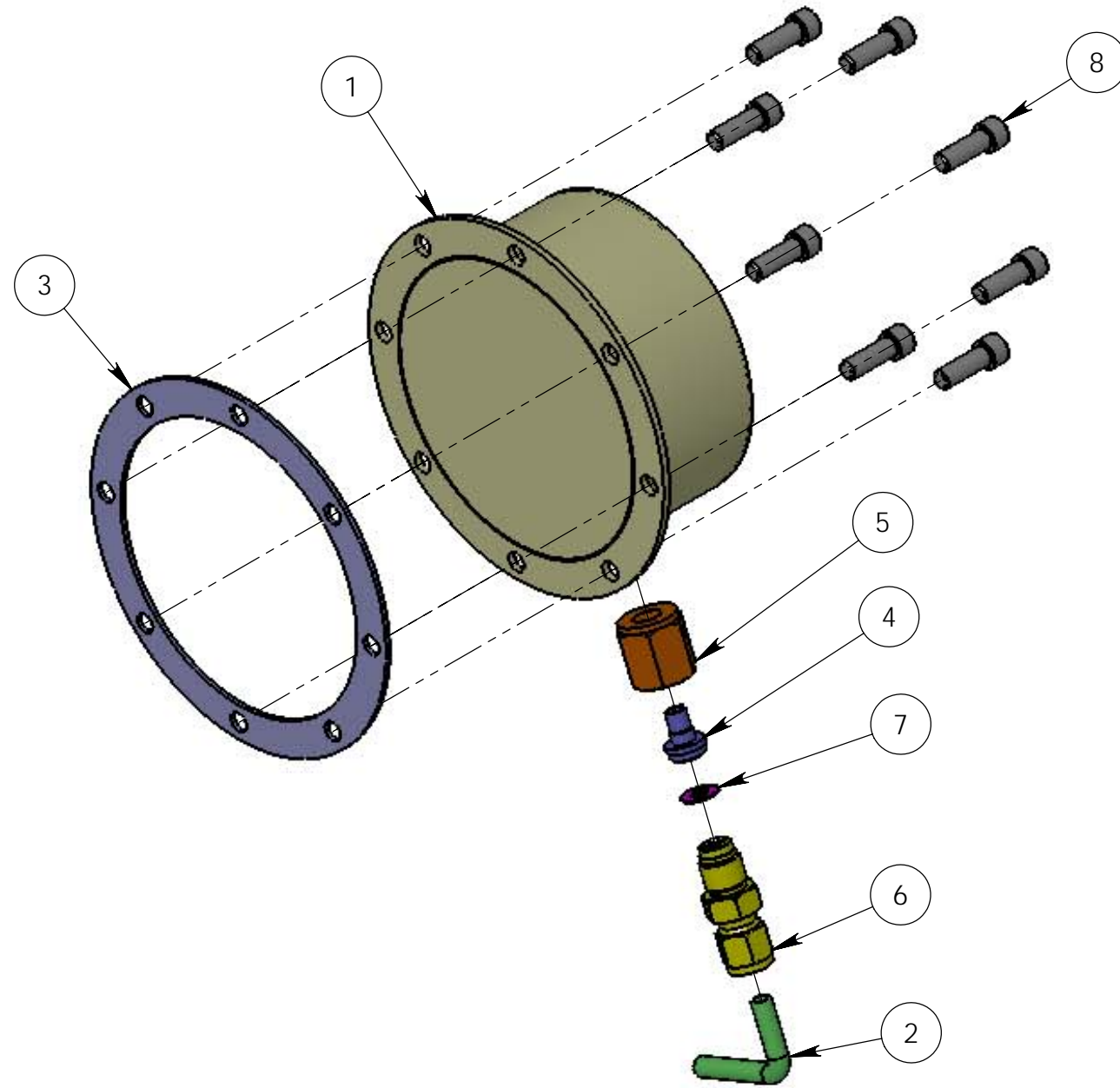


MATERIAL: BUNA-N SHEET - 50A

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DES V GRAVES 07/25/2005 DRW T OQUIN 07/25/2005 CHK ENG V GRAVES 07/25/2005 QA			<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SECONDARY BASE COVER GASKET</b></p>				
CAD FILE SEC BASE COVER GASKET HJT			PREV ASSY 203-HJT-0700		SCALE 1:5	SHEET 1 of 1	
DRAWING APPROVALS			DATE		SIZE C	DWG NO. 203-HJT-0705	REV A

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

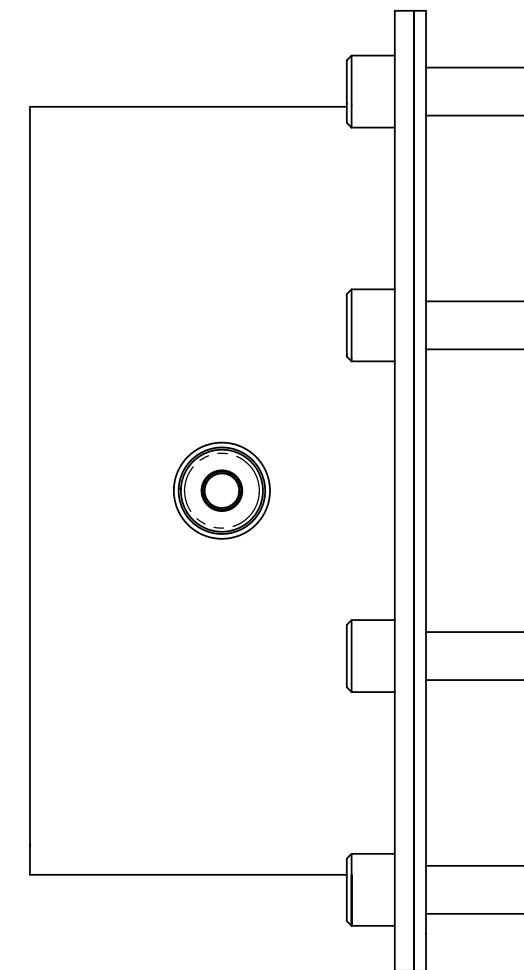
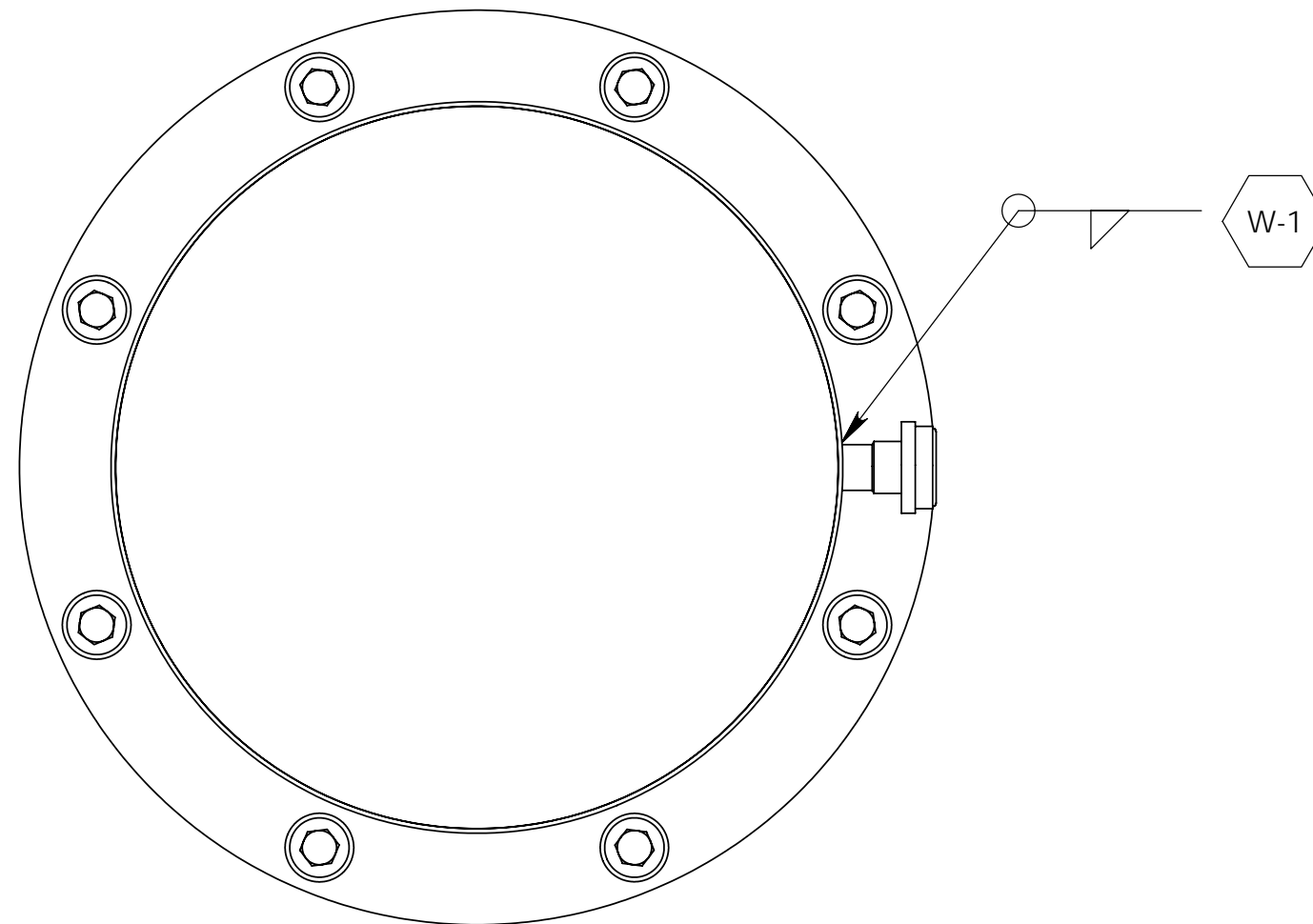


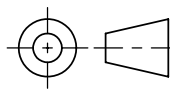


8	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5-16 SHCS	N/A
7	1	Non-Retained Style_CU-4-VCR-2-VS_0.22_Swagelok Company__15DD_4F3B7	---	NON-RETAINED STYLE	N/A
6	1	Swagelok Tube Fitting Connector_SS-4-VCR-6-400_1_4_Swagelok Company__184F3_575E59	---	SWAGELOK TUBE FITTING CONNECTOR	N/A
5	1	Nuts,Caps and Plugs_SS-4-VCR-1_3_4_Swagelok Company__DDB7_31464D	---	NUTS,CAPS AND PLUGS	N/A
4	1	Short Tube Butt Weld, Fractional_6LV-4-VCR-3S-4TB2_1_4_Swagelok Company__47C6_FEE01	---	SHORT TUBE BUTT WELD, FRACTIONAL	N/A
3	1	window gasket hjt	1/16" BUNA-N SHEET, 50A	McMASTER-CARR #86715K279	203-HJT-0709
2	1	double window tubing hjt	SS - 304L, ASTM A269	.250" OD X 22 GA	203-HJT-0708
1	1	double window hjt	---	4.00 OD x 2.00	203-HJT-0707
ITEM	downstream/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

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	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</p>		<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	09/26/2005	<p align="center"><b>MERIT EXPERIMENT</b></p> <p align="center"><b>SECONDARY CONTAINMENT ASSY</b></p> <p align="center"><b>DBL WINDOW MONITORED - DOWNSTREAM</b></p>		
DRW	T OQUIN	09/26/2005			
CHK					
ENG	V GRAVES	09/26/2005			
QA			<p>CAD FILE DOUBLE WINDOW MONITORED</p> <p>PREV ASSY 203-HJT-0700</p> <p>SCALE 1:2</p> <p>SHEET 1 of 2</p>		
DRAWING APPROVALS		DATE	<p>SIZE C</p> <p>DWG NO. 203-HJT-0706</p>	<p>REV A</p>	

NOTES

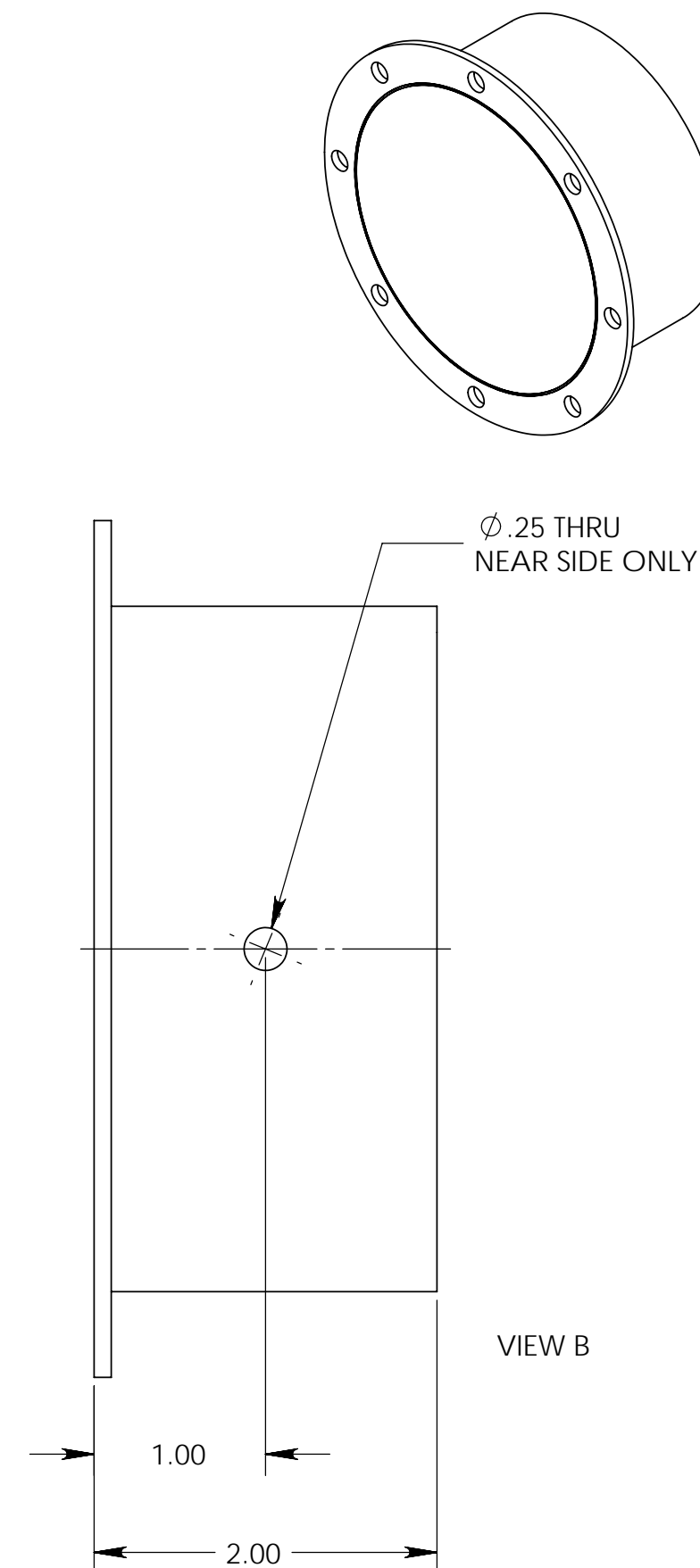
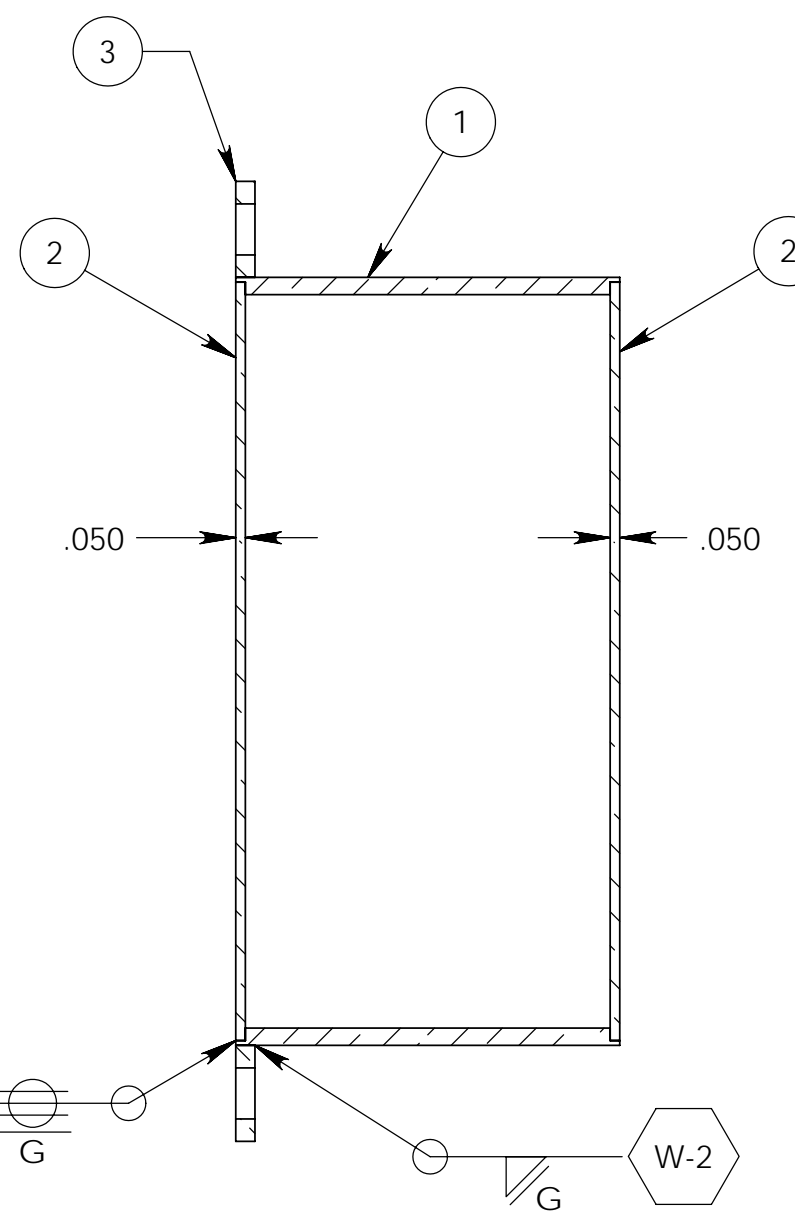
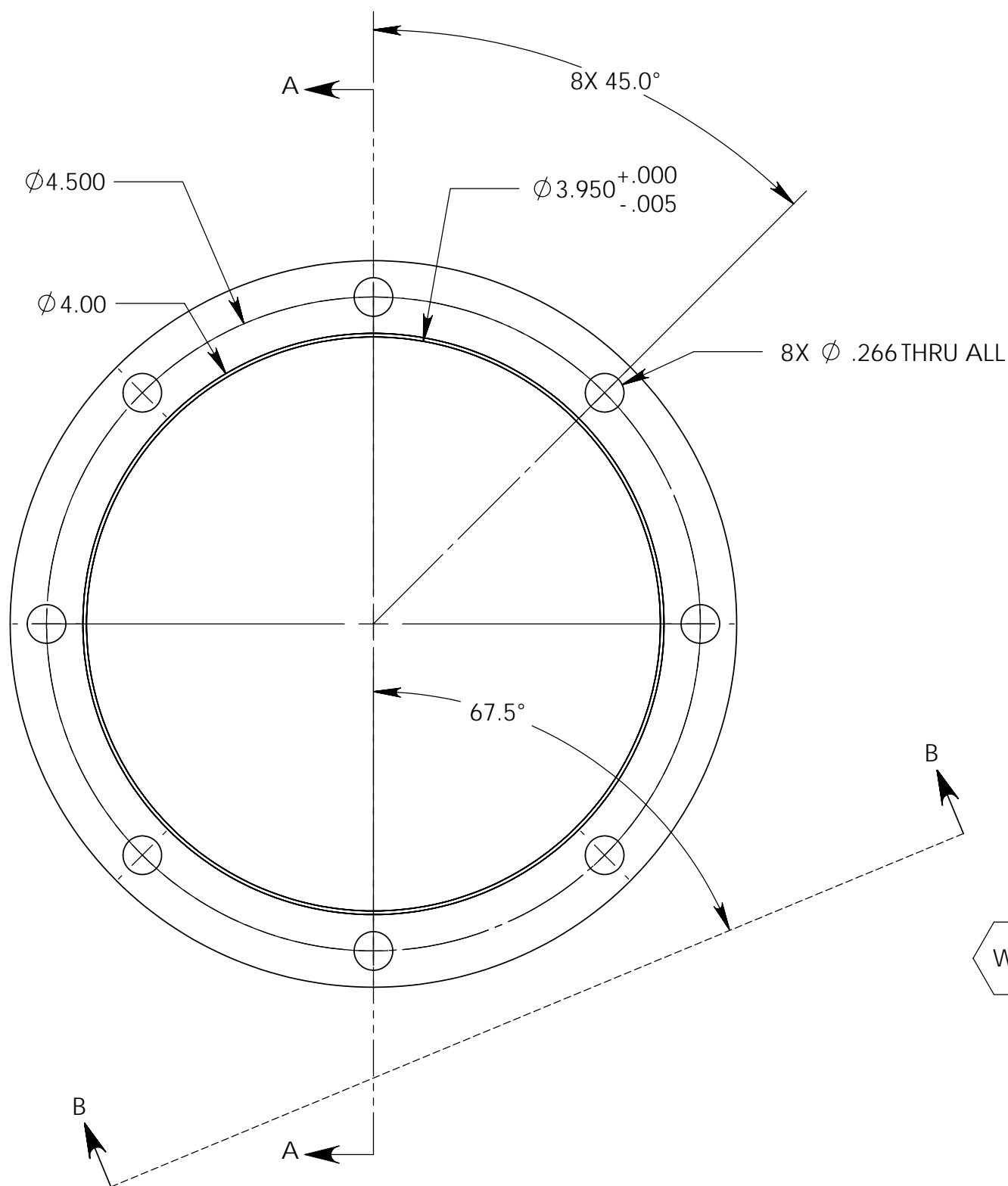
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



 THIRD-ANGLE PROJECTION	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.			 <b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN	
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° 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	DES DRW CHK ENG QA - - -	V GRAVES T OQUIN - V GRAVES - - -	09/26/2005 09/26/2005 - 09/26/2005 - - -	 <b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE & TECHNOLOGY DIVISION	
<b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY DBL WINDOW MONITORED - DOWNSTREAM</b>					
CAD FILE DOUBLE WINDOW MONITORED		PREV ASSY 203-HJT-0700	SCALE 1:1	SHEET 2 of 2	
SIZE C		DWG NO. 203-HJT-0706		REV A	
DRAWING APPROVALS		DATE			

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
3	1	SHEET, 5.00 OD x .10 THK	SS - 304L, ASTM A240	N/A
2	2	SHEET, 3.95 OD x .05 THK	TI - 6AL-4V, ASTM GRADE 5 TI	N/A
1	1	PIPE, 4.00 OD SCH 40	SS - 304L PIPE	2.00

**THIRD-ANGLE PROJECTION**

UNLESS OTHERWISE NOTED

1. ALL DIMENSIONS ARE IN INCHES
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3. MACHINED FINISH 125 MICRO-INCHES RMS
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DES	V GRAVES	09/26/2005
DRW	T OQUIN	09/26/2005
CHK		
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

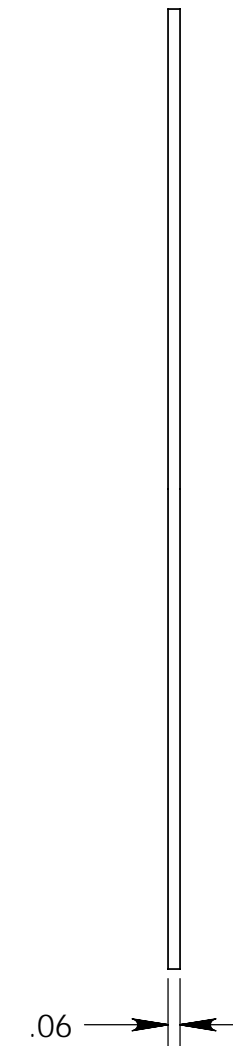
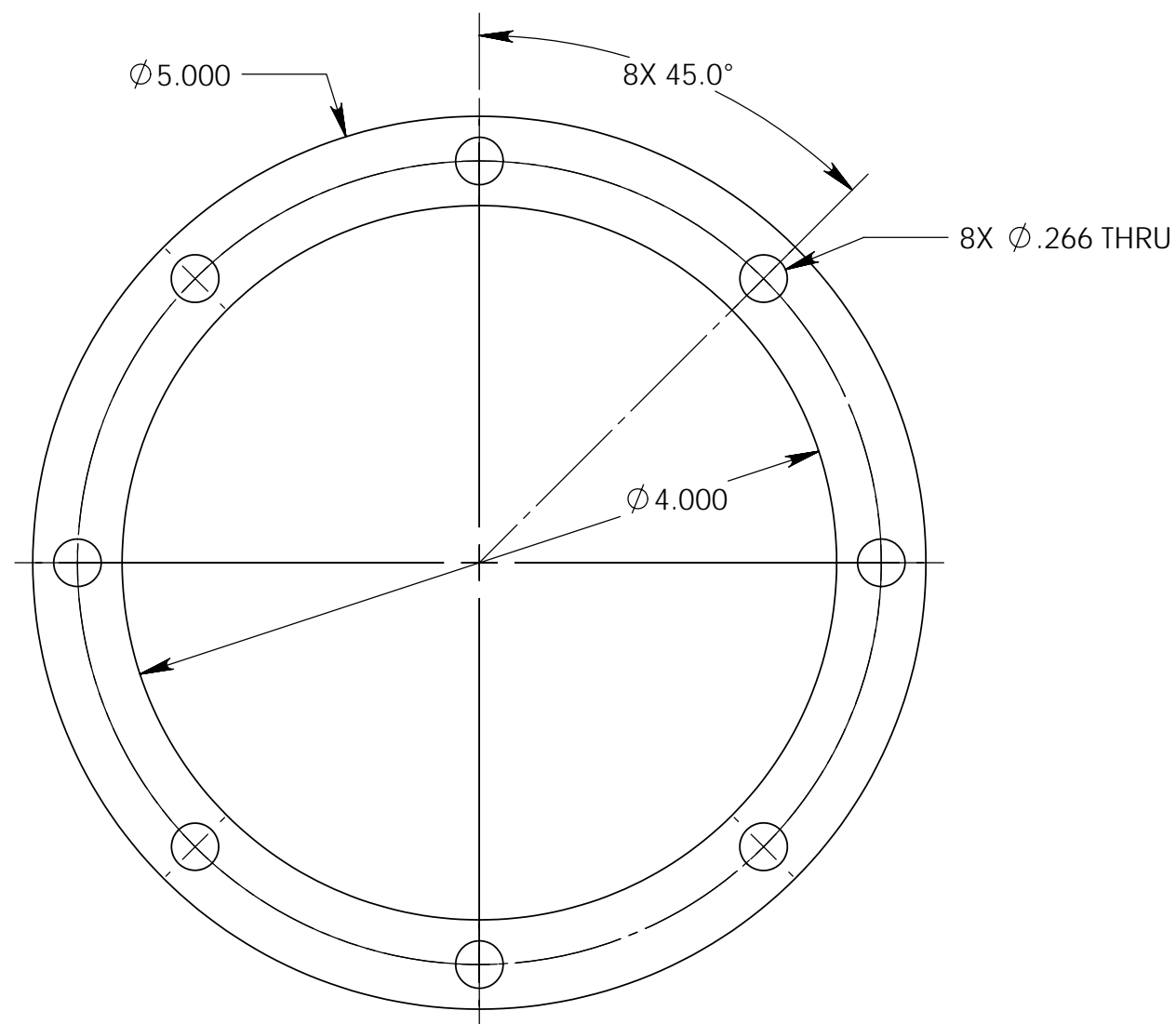
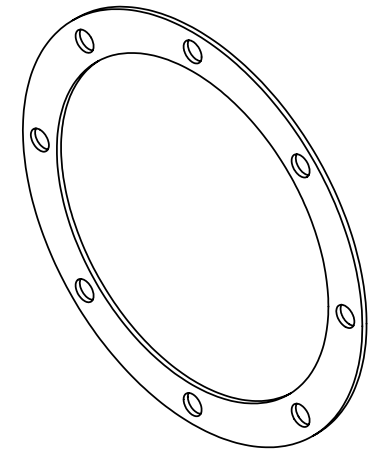
**NSTB** REMOTE SYSTEMS GROUP  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**MERIT EXPERIMENT**  
**SECONDARY CONTAINMENT ASSY**  
**DBL WINDOW WELDMENT - DOWNSTREAM**

CAD FILE	PREV ASSY	SCALE	SHEET
DOUBLE WINDOW HJT	203-HJT-0700	1:1	1 of 1
SIZE	DWG NO.		REV
C	203-HJT-0707		A

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

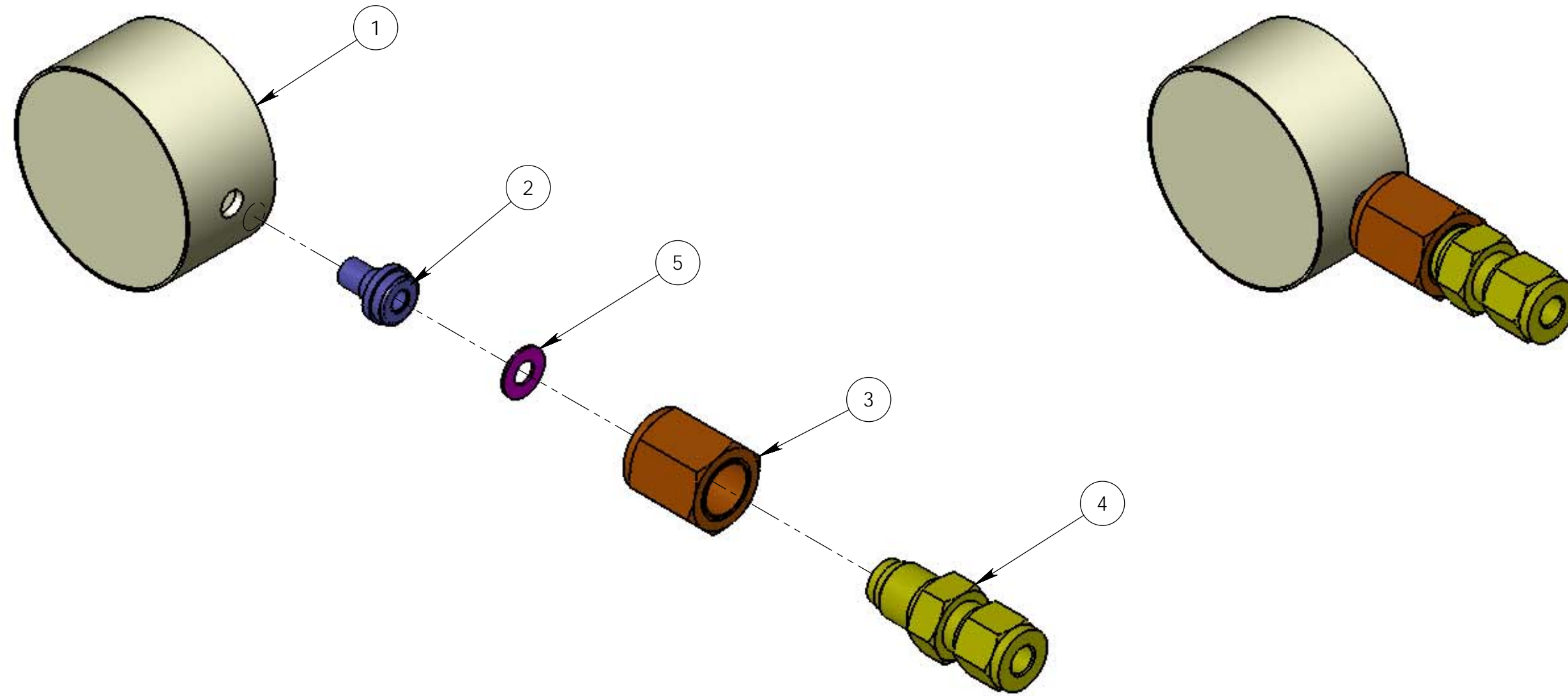


MATERIAL: 1/16" BUNA-N SHEET, 50A

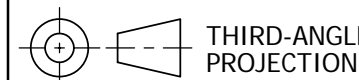
<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned 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° 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	01/09/2006	<b>MERIT EXPERIMENT</b> <b>DBL WINDOW MONITORED - DOWNSTREAM WINDOW GASKET</b>			
DRW	T OQUIN	01/09/2006				
CHK						
ENG	V GRAVES	01/09/2006				
QA			CAD FILE WINDOW GASKET HJT	PREV ASSY 203-HJT-0706	SCALE 1:1	SHEET 1 of 1
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0709	REV A	

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	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
5	1	Non-Retained Style_CU-4-VCR-2-VS_0.22_Swagelok Company__15DD_4F3B7	---	NON-RETAINED STYLE	N/A
4	1	Swagelok Tube Fitting Connector_SS-4-VCR-6-400_1_4_Swagelok Company__184F3_575E59	---	SWAGELOK TUBE FITTING CONNECTOR	N/A
3	1	Nuts,Caps and Plugs_SS-4-VCR-1_3_4_Swagelok Company__DDB7_31464D	---	NUTS,CAPS AND PLUGS	N/A
2	1	Short Tube Butt Weld, Fractional_6LV-4-VCR-3S-4TB2_1_4_Swagelok Company__47C6_FEE01	---	SHORT TUBE BUTT WELD, FRACTIONAL	N/A
1	1	double window hjt	---	2.00 OD x 1.00	203-HJT-0713



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. X DECIMALS ±.030
9. XX DECIMALS ±.010
10. XXX DECIMALS ±.005

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**OAK RIDGE NATIONAL LABORATORY**  
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**REMOTE SYSTEMS GROUP**  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

DES	V GRAVES	09/26/2005
DRW	T OQUIN	09/26/2005
CHK		
ENG	V GRAVES	09/26/2005
QA		

**MERIT EXPERIMENT**  
**SECONDARY CONTAINMENT ASSY**  
**DBL WINDOW MONITORED - UPSTREAM**

CAD FILE	PREV ASSY	SCALE	SHEET
DOUBLE WINDOW MONITORED	203-HJT-0700	1:1	1 of 2

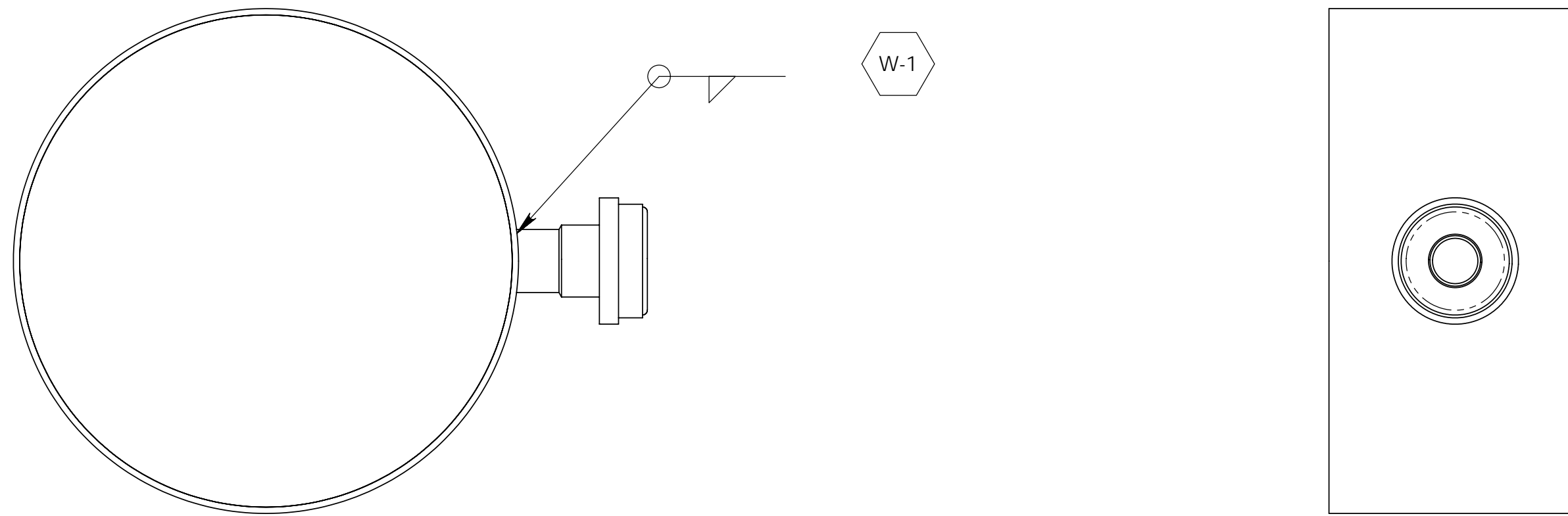
SIZE	DWG NO.	REV
C	203-HJT-0712	A

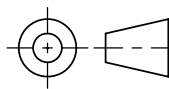


DRAWING APPROVALS DATE



NOTES

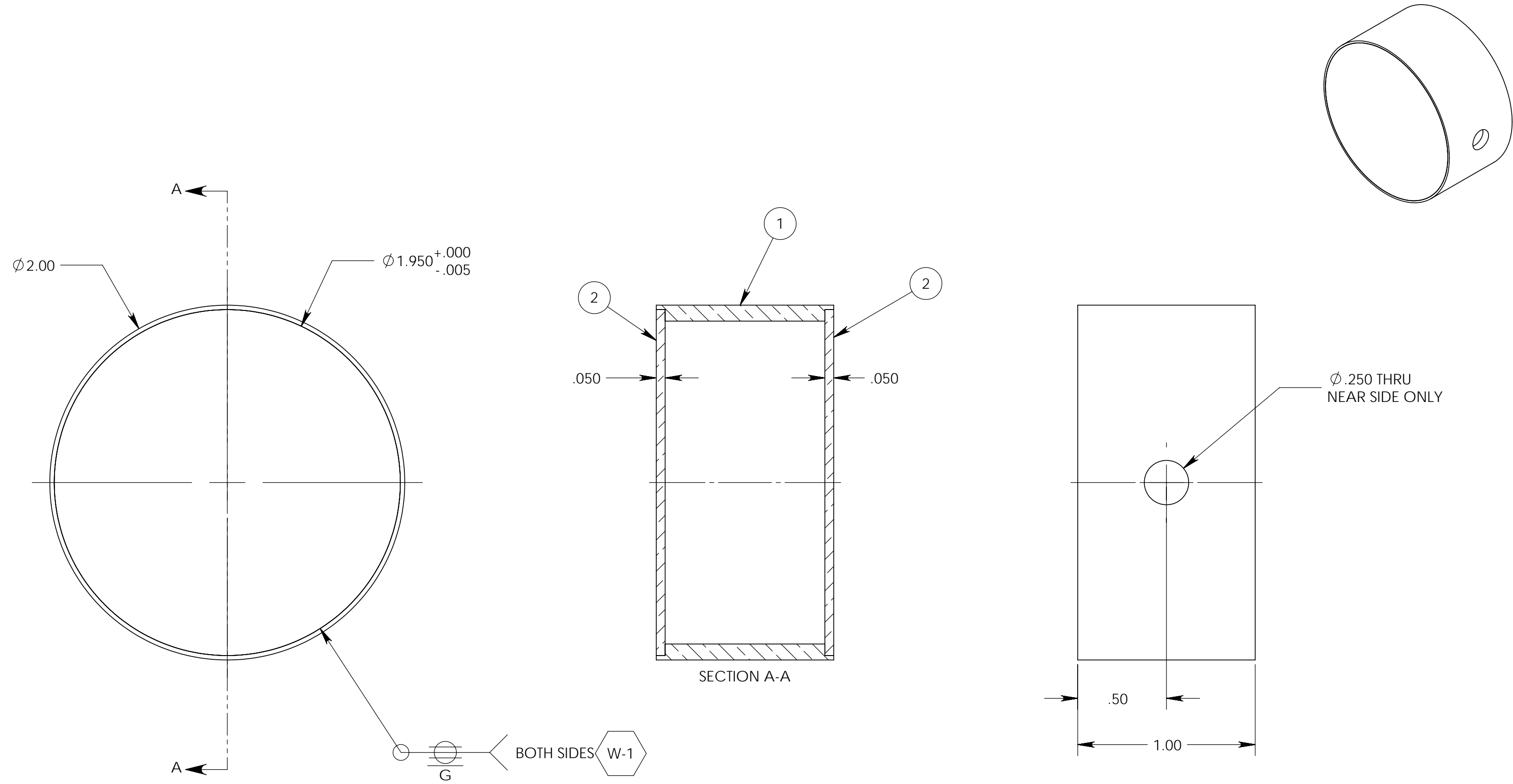
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



 <b>THIRD-ANGLE PROJECTION</b>	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.			 <b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN		
	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° 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			 <b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE & TECHNOLOGY DIVISION		
DES	V GRAVES	09/26/2005	<b>MERIT EXPERIMENT                  SECONDARY CONTAINMENT ASSY                  DBL WINDOW MONITORED - UPSTREAM</b>			
DRW	T OQUIN	09/26/2005				
CHK						
ENG	V GRAVES	09/26/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			DOUBLE WINDOW MONITORED	203-HJT-0700	2:1	2 of 2
DRAWING APPROVALS			DATE	SIZE	DWG NO.	REV
				C	203-HJT-0712	A

NOTES

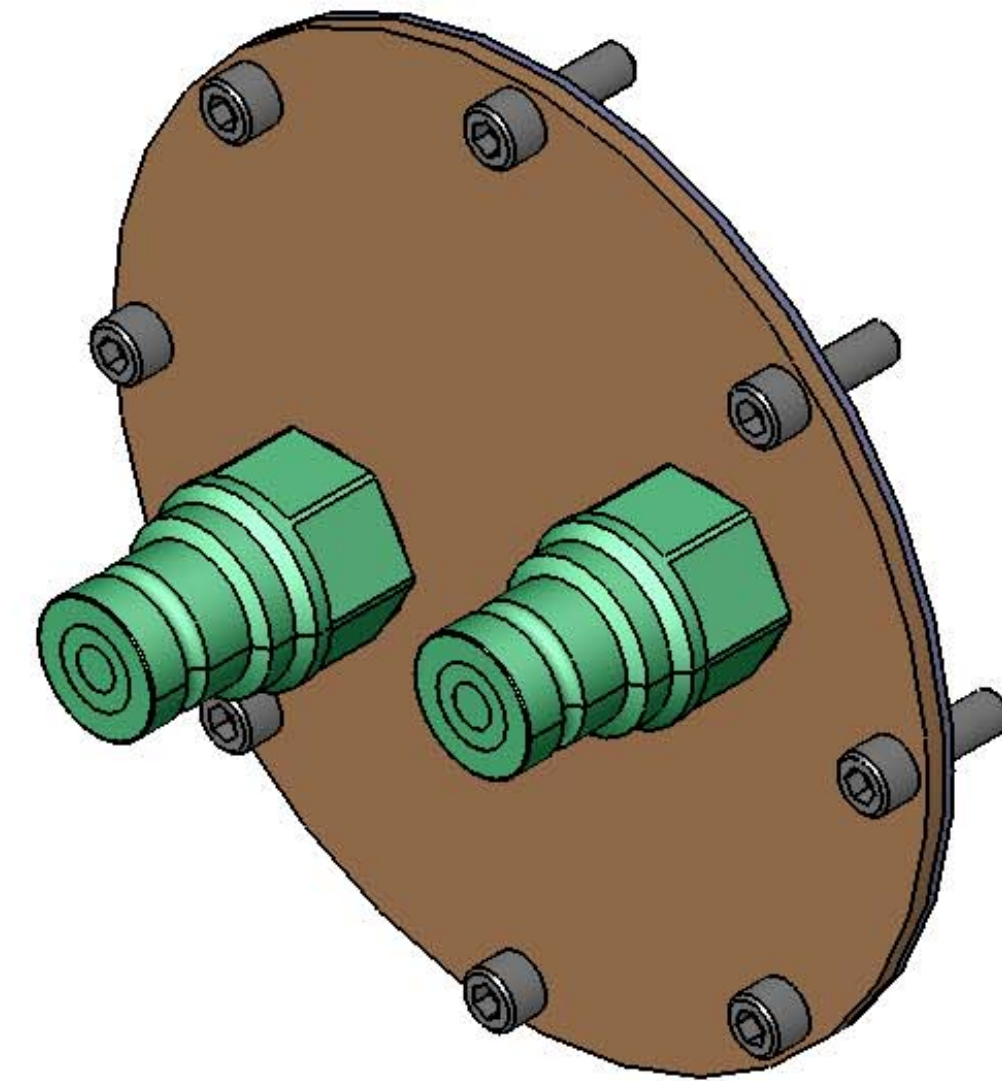
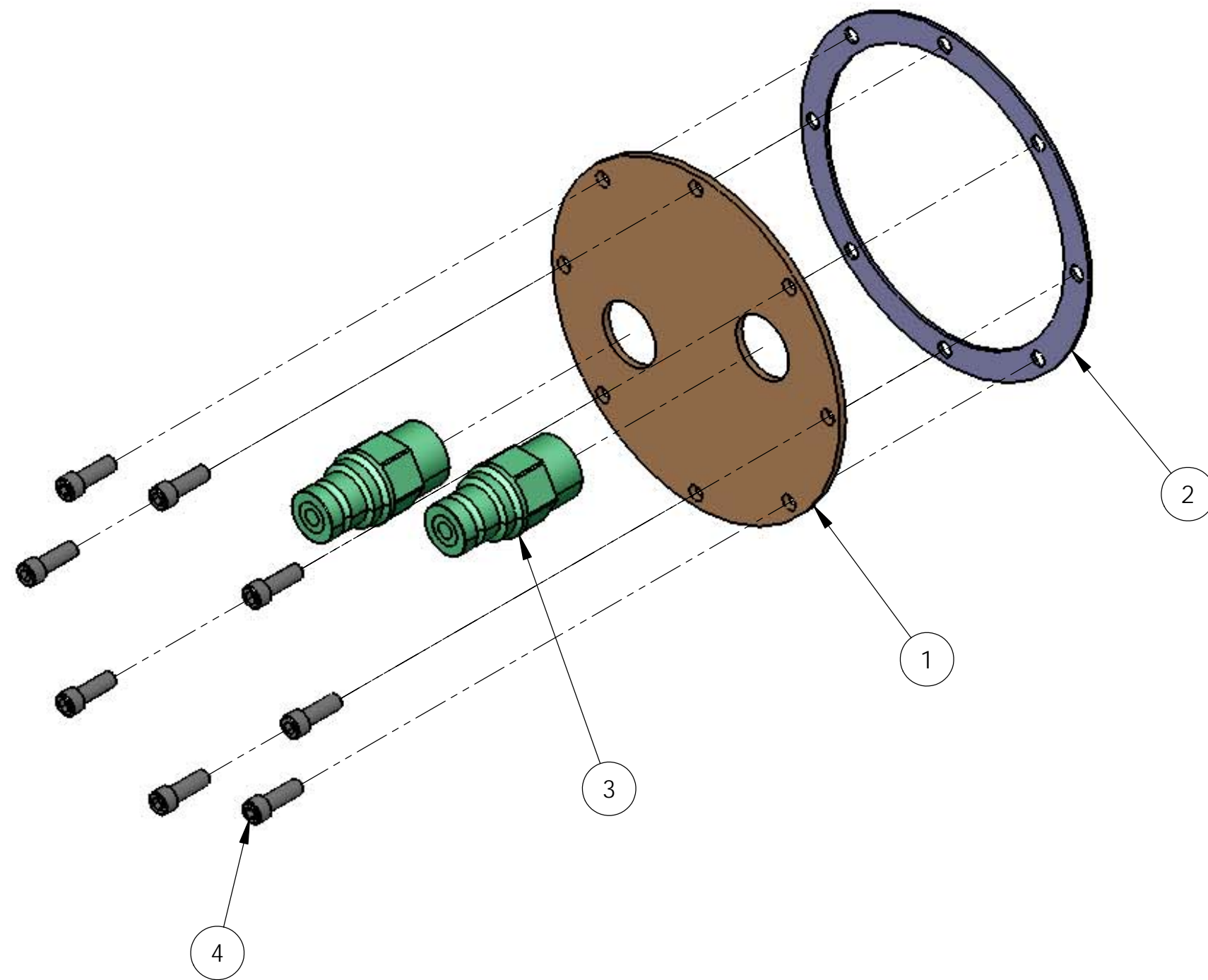
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



2	2	SHEET, 1.95 OD x .05 THK	TI - 6AL-4V, ASTM GRADE 5 TI	N/A		
1	1	PIPE, 2.00 OD SCH 40	SS - 304L PIPE	1.00		
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH		
		<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <ol style="list-style-type: none"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY .010 TIR</li> <li>5. MACHINED ANGLES ±1/2°</li> <li>6. FORMED ANGLES ±1°</li> <li>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>8. WHOLE NUMBERS AND FRACTIONS ±1/16</li> <li>9. X DECIMALS ±.030</li> <li>10. XX DECIMALS ±.010</li> <li>11. XXX DECIMALS ±.005</li> </ol>	<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>			
DES	V GRAVES		09/26/2005	<p><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p> <p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p> <p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>DBL WINDOW WELDMENT - UPSTREAM</b></p>		
DRW	T OQUIN		09/26/2005			
CHK						
ENG	V GRAVES		09/26/2005			
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			DOUBLE WINDOW HJT	203-HJT-0700	2:1	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0713	A	

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

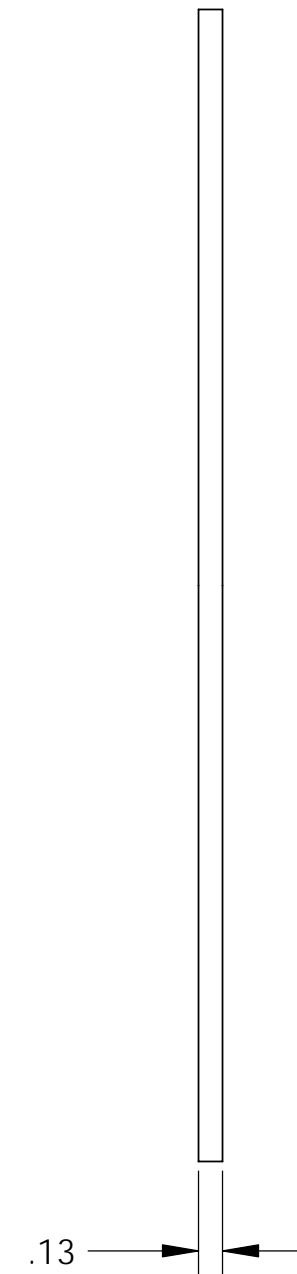
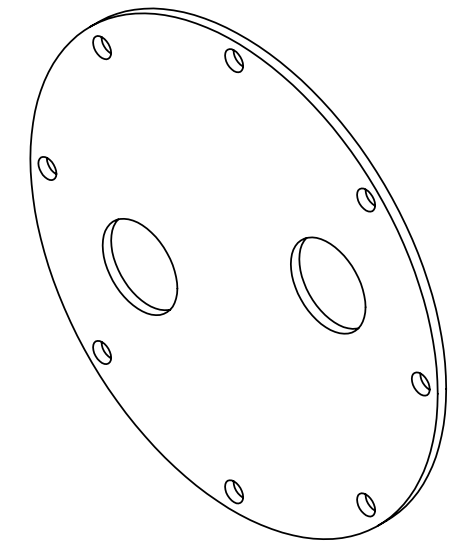
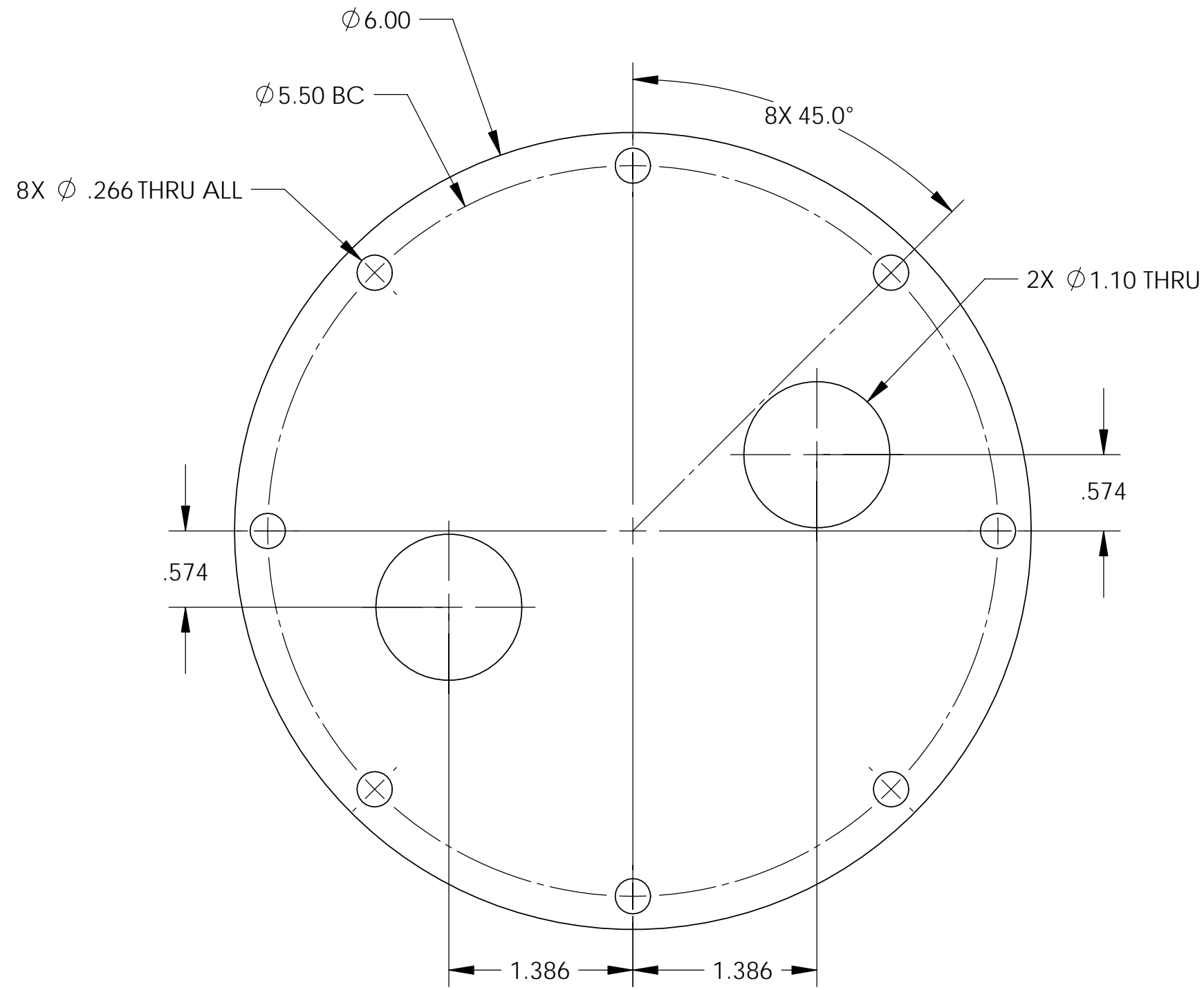


4	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
3	2	staubli_plug_spx06_7202	---	OEM	N/A
2	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
1	1	hydraulics plate	SS - 304L, ASTM A-240	PLATE, 6.000 x .125 THK	203-HJT-0731
ITEM	hydraulics/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. FORMED ANGLES ±1°</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>HYDRAULICS ASSY</b></p>		
<p>CAD FILE CONNECTOR PLATE ASSY HJT</p>		<p>PREV ASSY 203-HJT-0700</p>		<p>SCALE 1:2</p>	<p>SHEET 1 of 1</p>
<p>DRAWING APPROVALS</p>		<p>DATE</p>		<p>SIZE C</p>	<p>REV A</p>
		<p>DWG NO. 203-HJT-0730</p>			

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

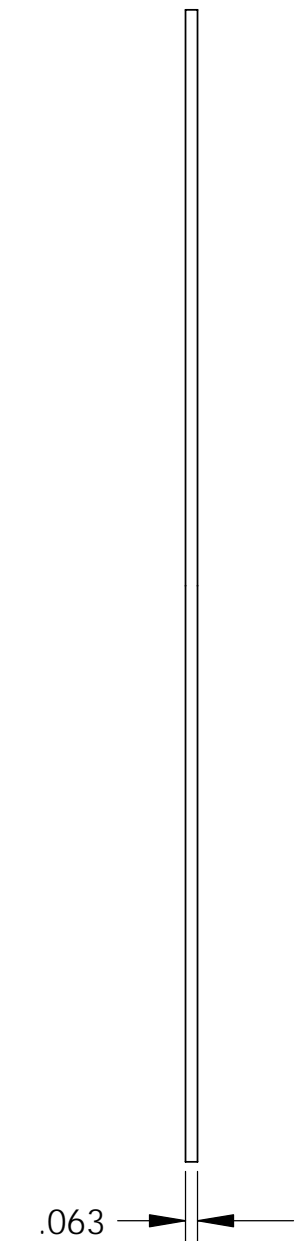
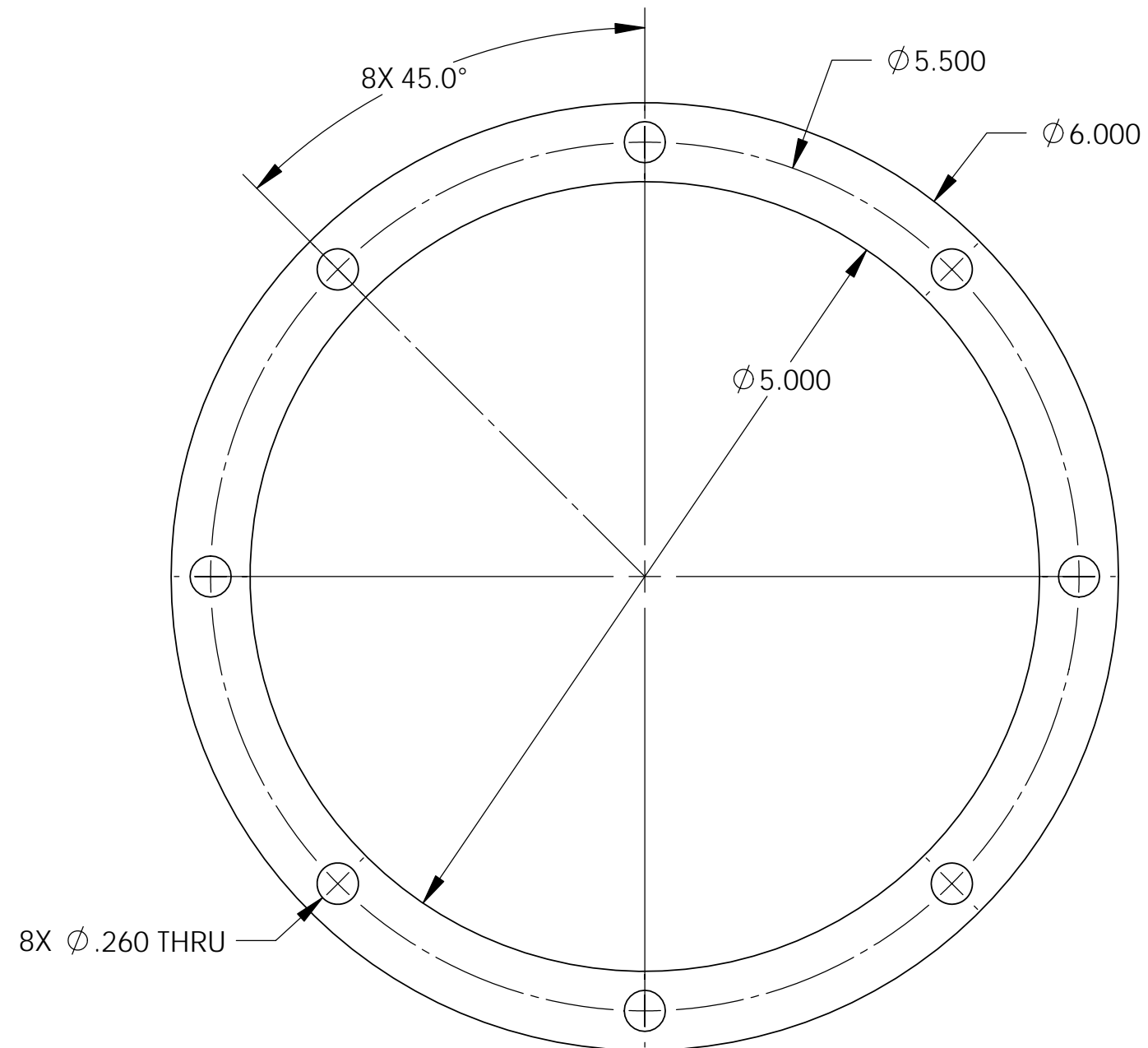
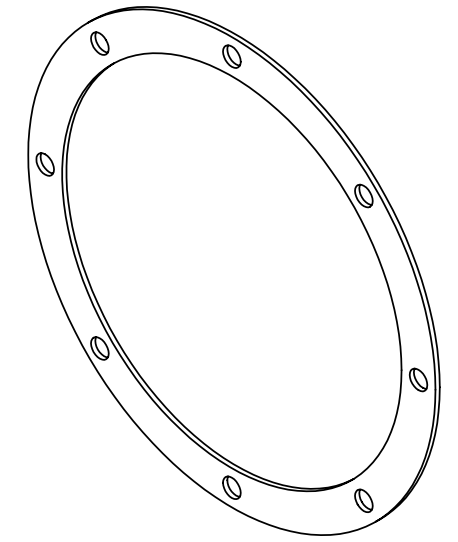


MATERIAL: SS - 304L, ASTM A-240

<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>	
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DES V GRAVES 01/06/2006 DRW T OQUIN 01/06/2006 CHK ENG V GRAVES 01/06/2006 QA			<p align="center"><b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY HYDRAULICS CONNECTOR PLATE</b></p>		
DRAWING APPROVALS DATE			CAD FILE CONNECTOR PLATE HJT SIZE DWG NO.	PREV ASSY 203-HJT-0730 SCALE 1:1	SHEET 1 of 1 REV A
			203-HJT-0731		

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

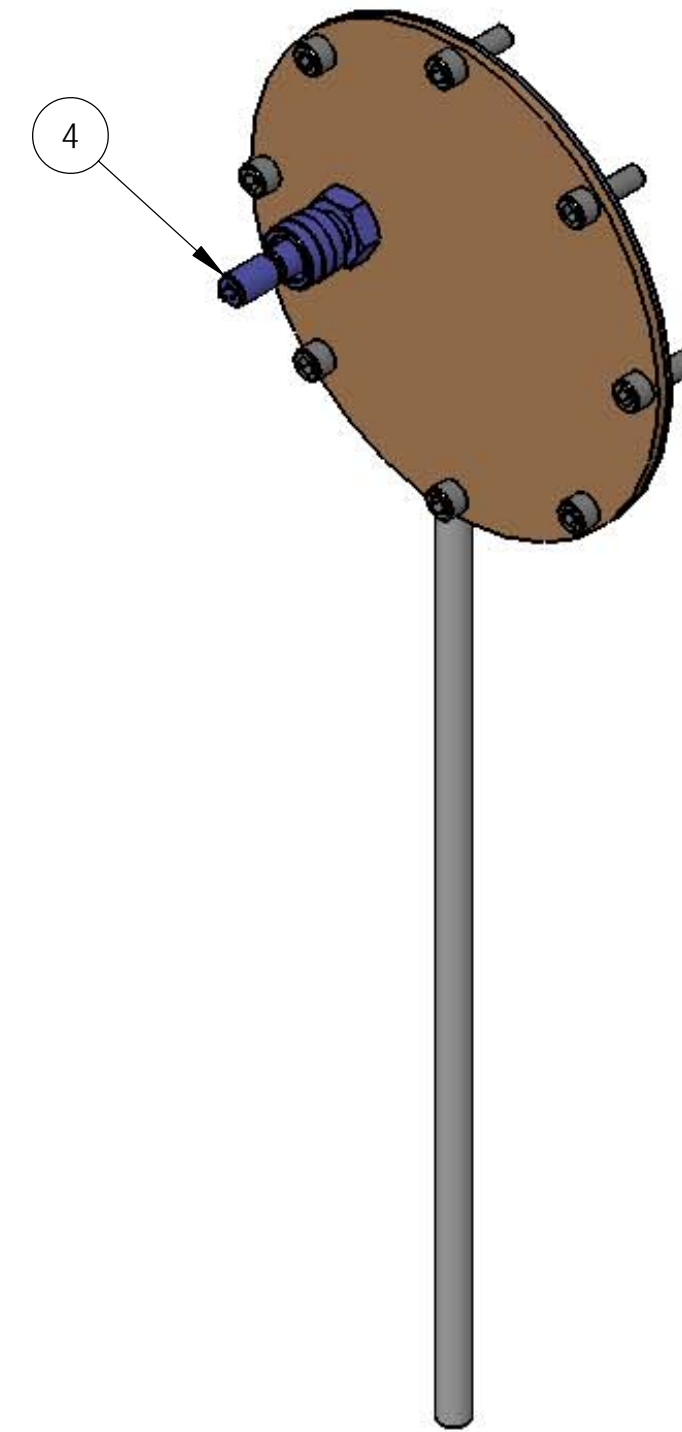
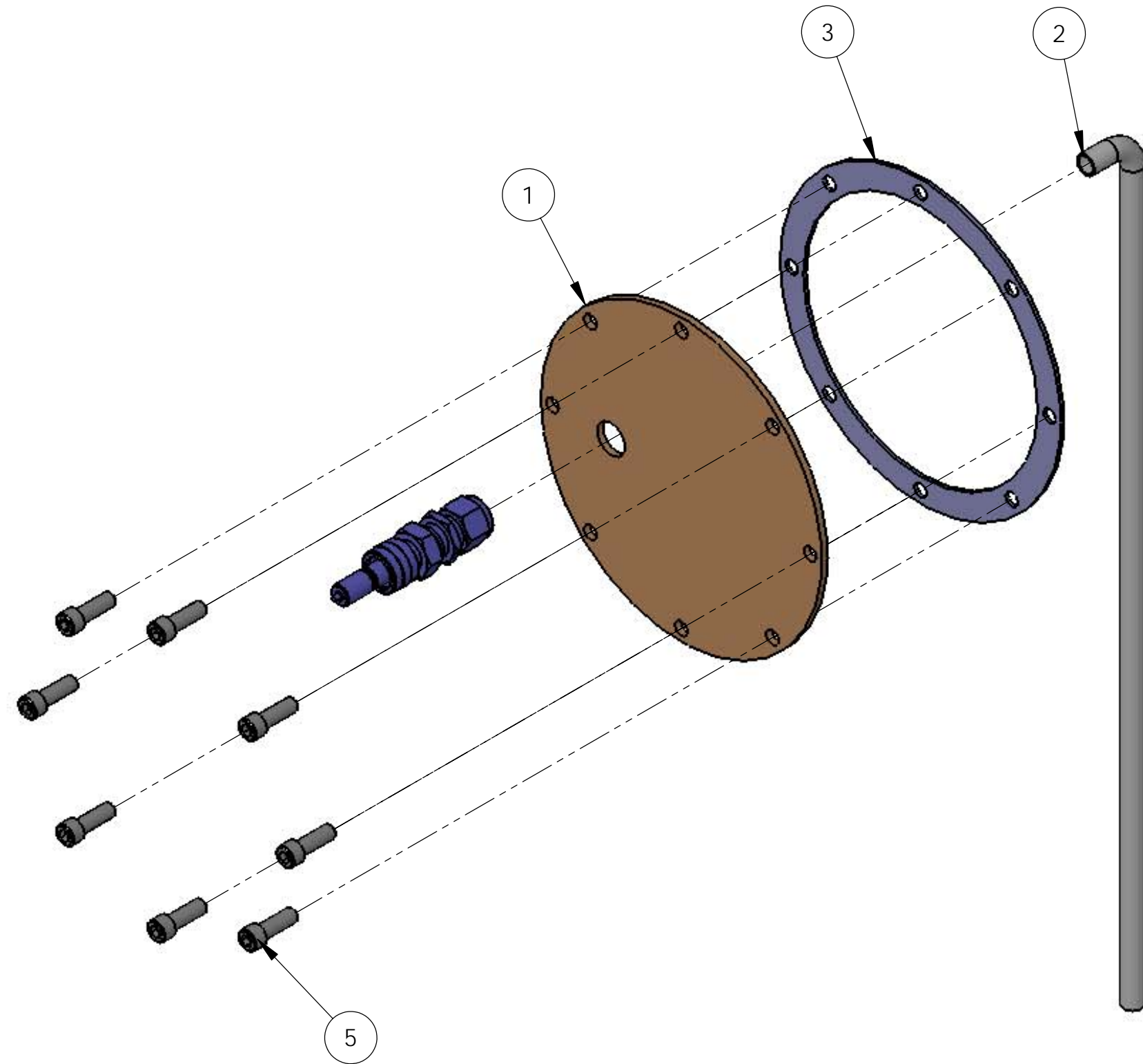


MATERIAL: 1/16" BUNA-N SHEET. 50A

<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>		
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DES	V GRAVES	01/06/2006	<b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY CONNECTOR PLATE GASKET</b>			
DRW	T OQUIN	01/06/2006				
CHK						
ENG	V GRAVES	01/06/2006				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CONNECTOR PLATE GASKET HJT	203-HJT-0700	1:1	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0732	A	

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

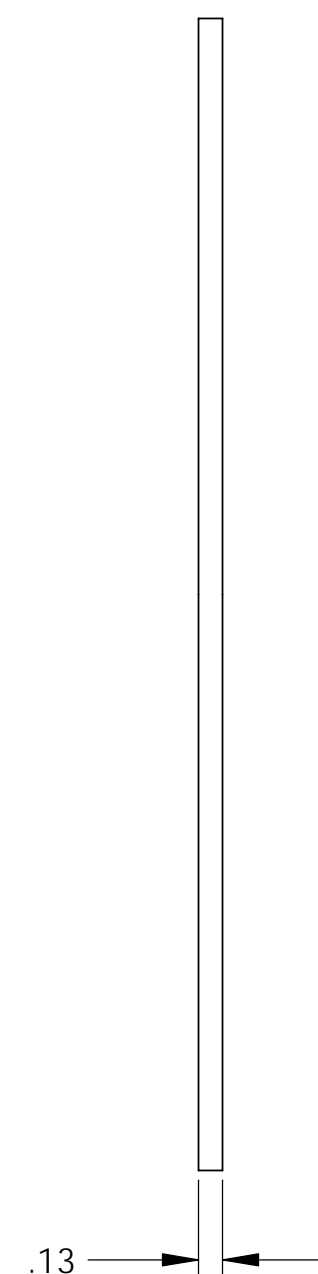
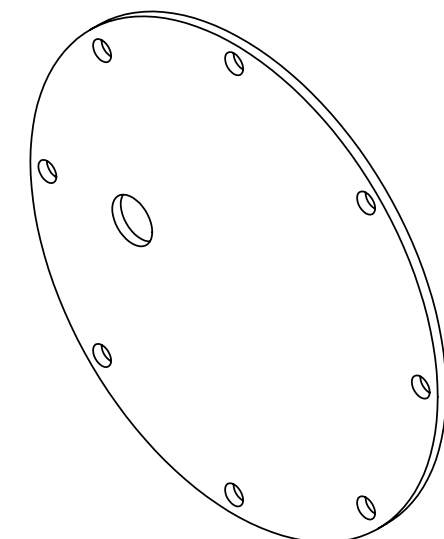
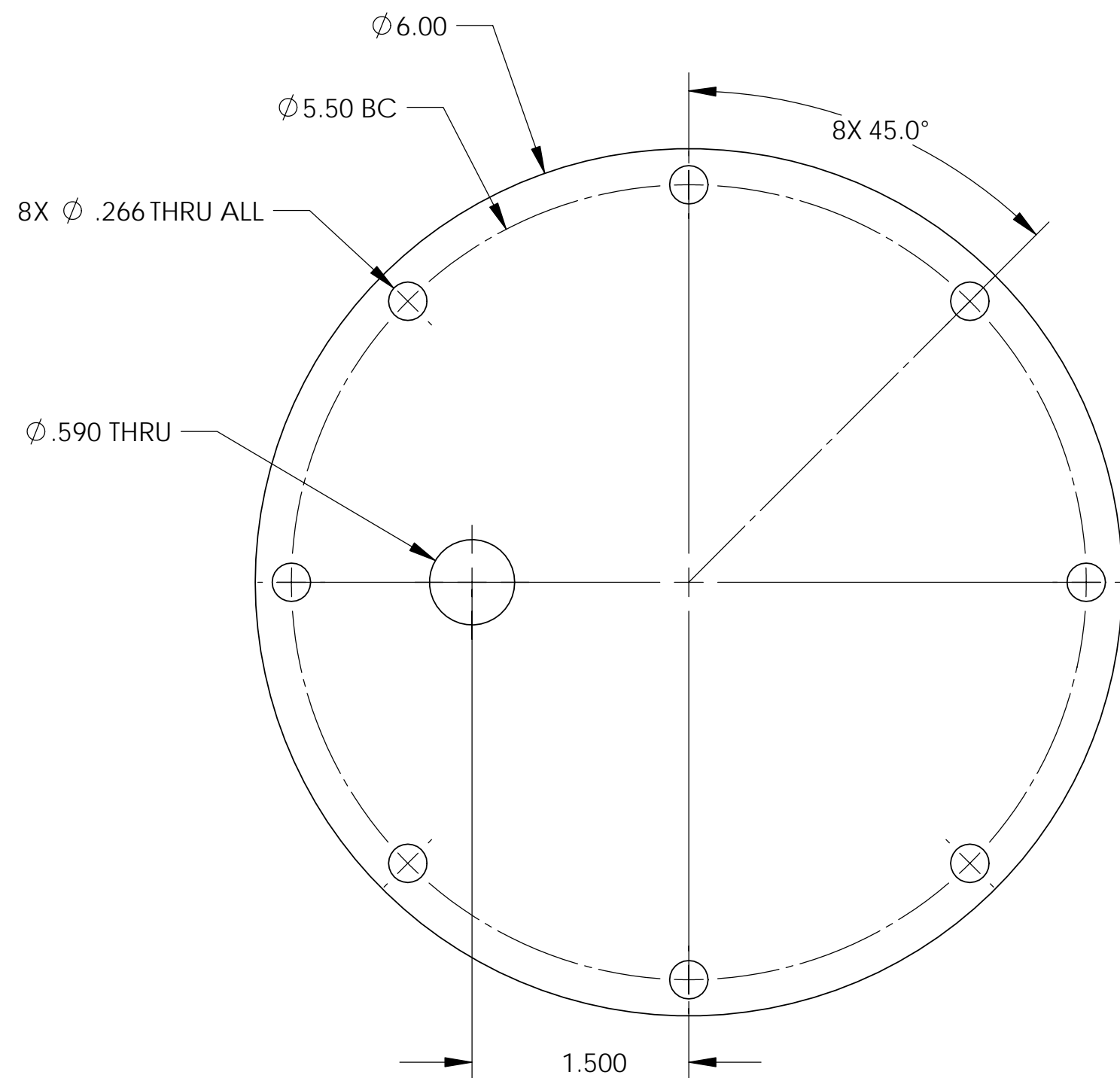


5	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
4	1	Instrumentation Quick-Connects - QC Series_SS-QC6-D1-600_3_8 _ Swagelok Bulkhead Tube Fitting	N/A	INSTRUMENTATION QUICK-CONNECTS - QC SERIES	N/A
3	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
2	1	extraction tube hjt	SS - 304L, ASTM A269	TUBE, .375 OD X .035 WALL	203-HJT-0742
1	1	extraction plate	SS - 304L, ASTM A-240	PLATE, 6 x 0 THK	203-HJT-0741
ITEM	extraction/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
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<p>DES V GRAVES 01/06/2006</p> <p>DRW T OQUIN 01/06/2006</p> <p>CHK</p> <p>ENG V GRAVES 01/06/2006</p> <p>QA</p>		<p><b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY EXTRACTION ASSY</b></p>		<p>CAD FILE CONNECTOR PLATE ASSY HJT</p>	
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>PREV ASSY 203-HJT-0700</p>	<p>SCALE 1:2</p>	<p>SHEET 1 of 1</p>
<p>SIZE C</p>		<p>DWG NO. 203-HJT-0740</p>		<p>REV A</p>	

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



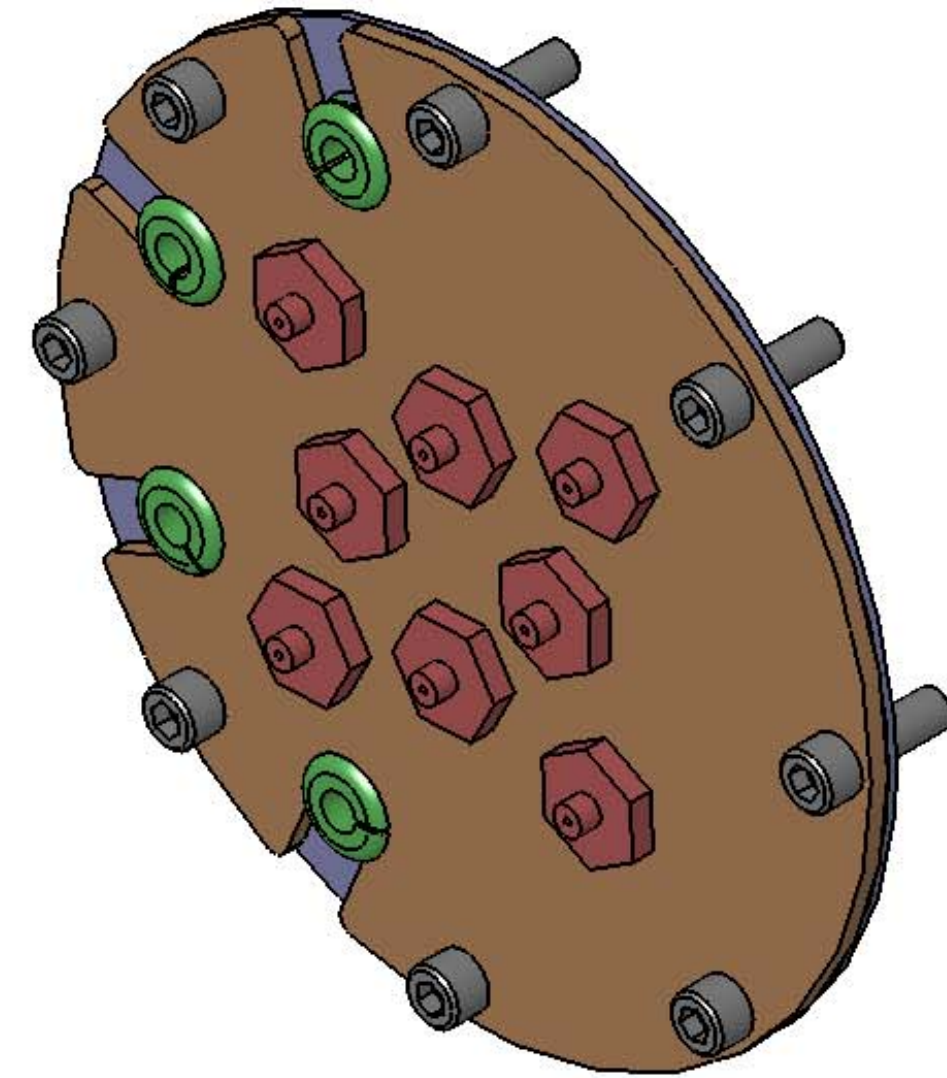
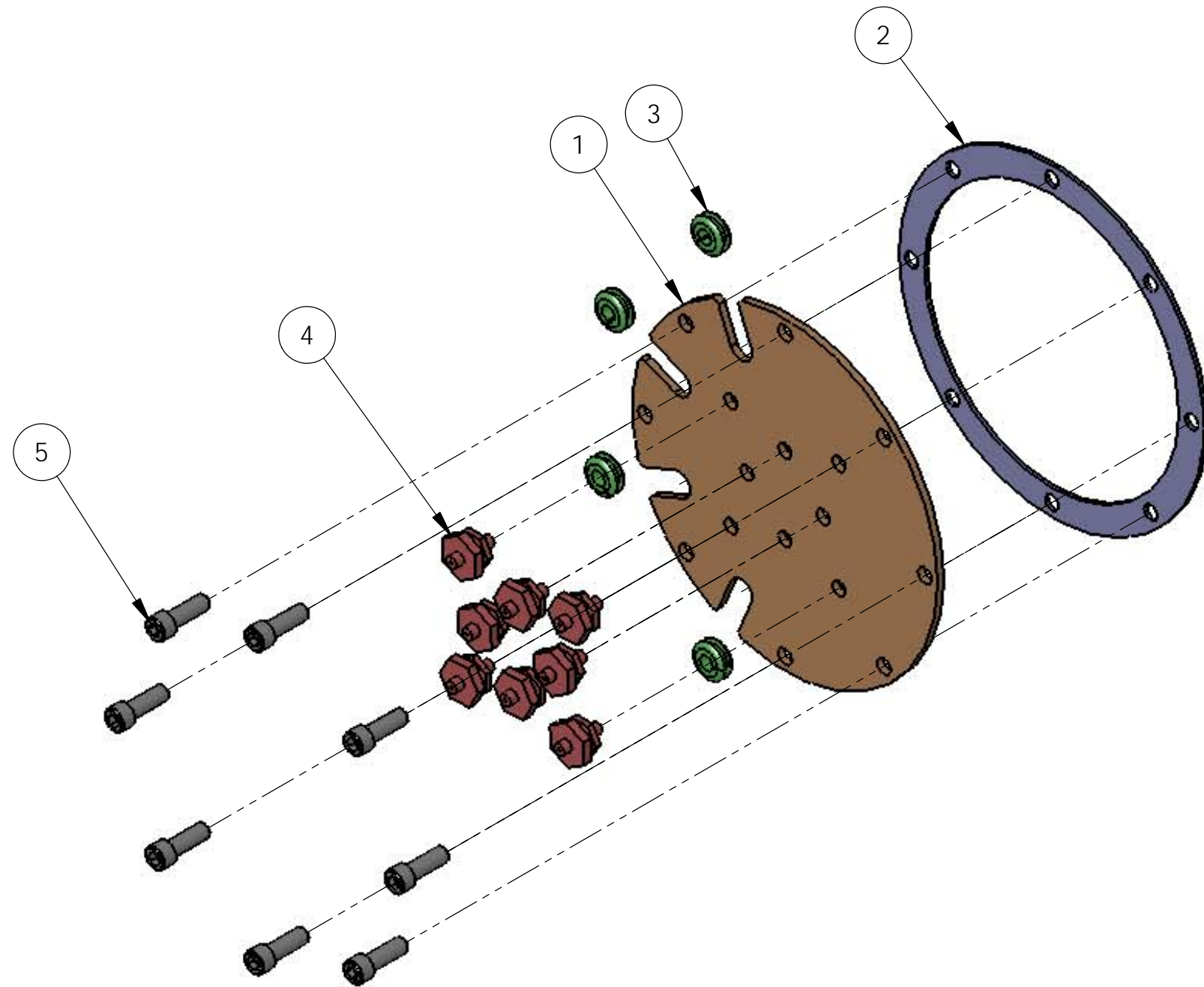
MATERIAL: SS - 304L, ASTM A-240

THIRD-ANGLE PROJECTION	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		
	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 $\pm 1/2^\circ$ FORMED ANGLES $\pm 1^\circ$ 6. BREAK SHARP CORNERS AND REMOVE ALL BURRS 7. WHOLE NUMBERS AND FRACTIONS $\pm 1/16$ 8. X DECIMALS $\pm .030$ 9. XX DECIMALS $\pm .010$ 10. XXX DECIMALS $\pm .005$			REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION		
DES V GRAVES 01/06/2006 DRW T OQUIN 01/06/2006 CHK ENG V GRAVES 01/06/2006 QA			MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY EXTRACTION CONNECTOR PLATE			
DRAWING APPROVALS DATE					CAD FILE CONNECTOR PLATE HJT	PREV ASSY 203-HJT-0730
			SIZE C	DWG NO. 203-HJT-0741	REV A	

DWG NO. 203-HJT-0741

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



ITEM	optics/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
5	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
4	8	illumination fiber sleeve hjt	---	THOR ADAMSA	N/A
3	4	optic fiber grommet hjt	N/A	GROMMET - FIBER OPTIC	N/A
2	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
1	1	optics plate	SS - 304L, ASTM A-240	PLATE, 6 x 0 THK	203-HJT-0751

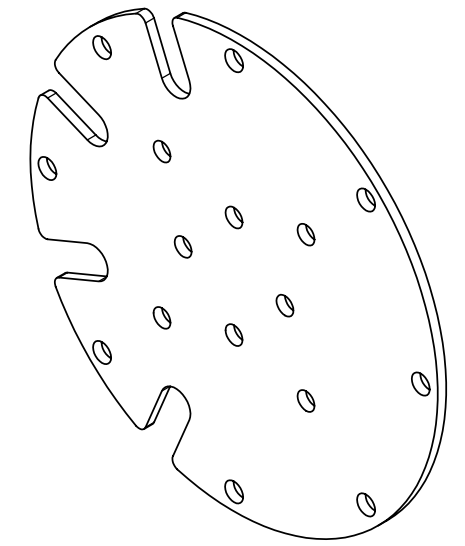
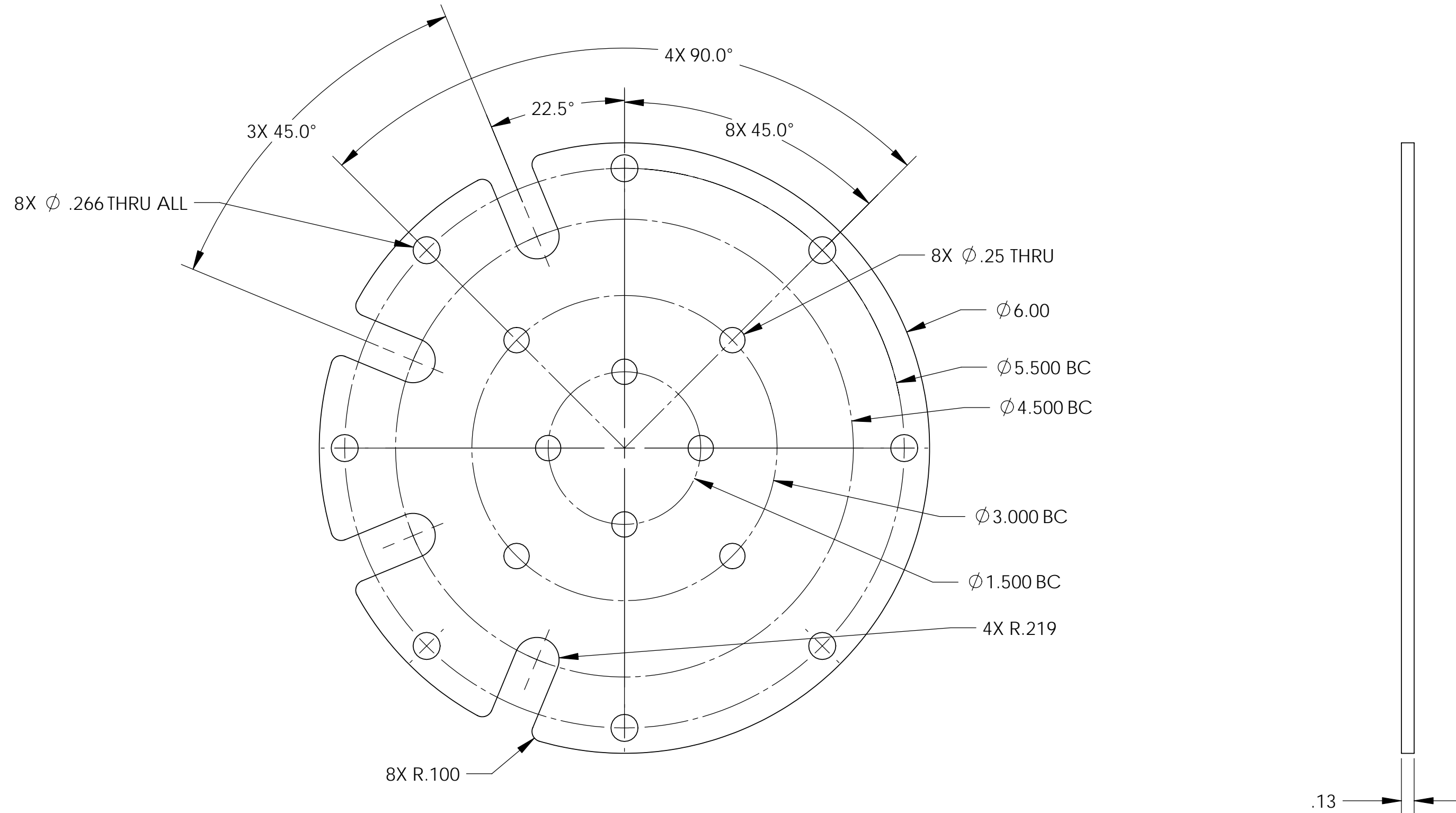
<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>DIAGNOSTICS ASSY</b></p>			
DES	V GRAVES	01/06/2006	CAD FILE	PREV ASSY	SCALE	SHEET
DRW	T OQUIN	01/06/2006	CONNECTOR PLATE ASSY HJT	203-HJT-0700	1:2	1 of 1
CHK			SIZE	DWG NO.		REV
ENG	V GRAVES	01/06/2006	C	203-HJT-0750		A
QA			DRAWING APPROVALS		DATE	

DWG NO. 203-HJT-0750



NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

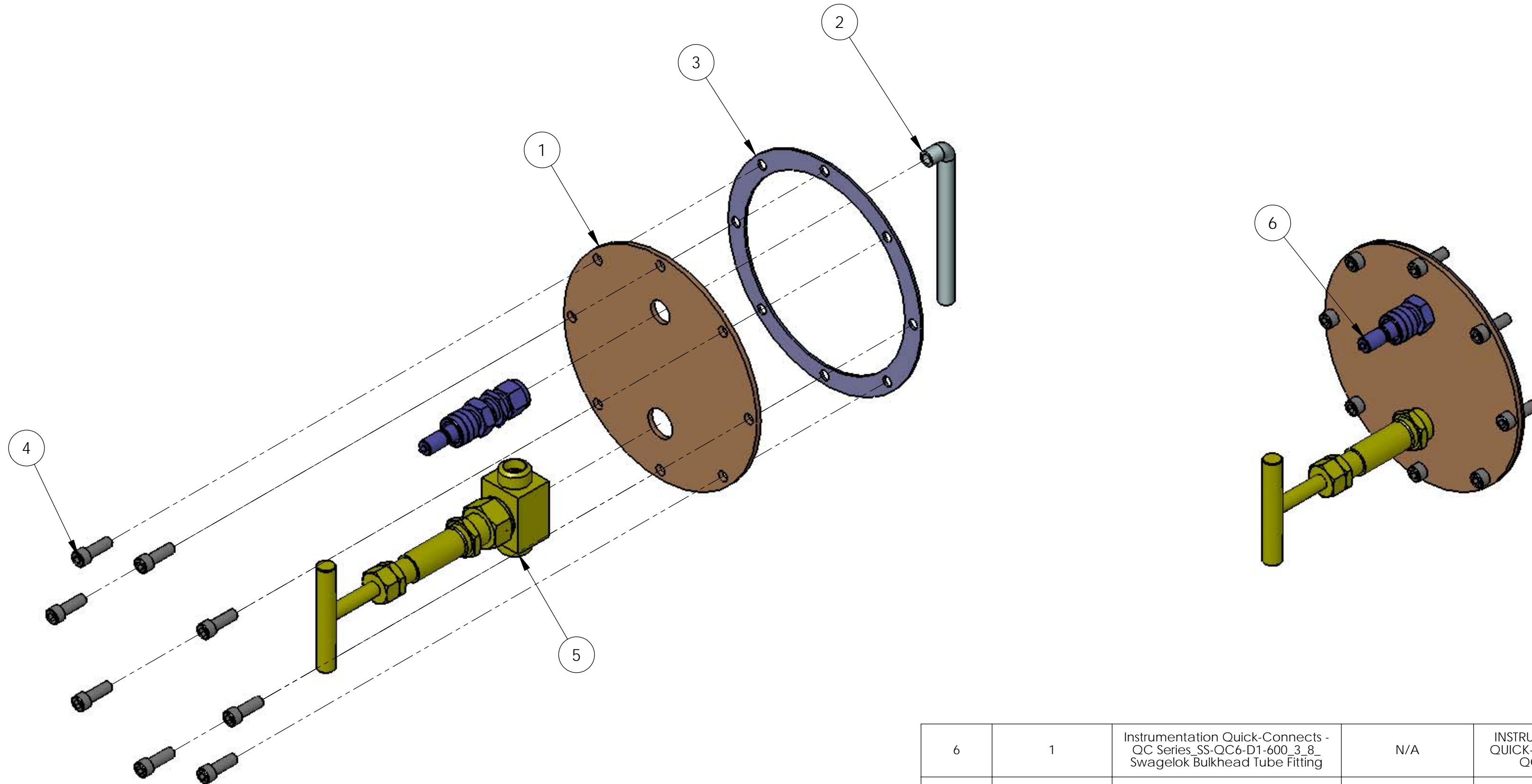


MATERIAL: SS - 304L, ASTM A-240

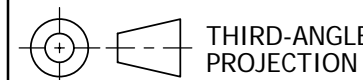
<p>THIRD-ANGLE PROJECTION</p>	<p>This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.</p>			<p><b>OAK RIDGE NATIONAL LABORATORY</b> 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"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY .010 TIR</li> <li>5. MACHINED ANGLES <math>\pm 1/2^\circ</math></li> <li>6. FORMED ANGLES <math>\pm 1^\circ</math></li> <li>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>8. WHOLE NUMBERS AND FRACTIONS <math>\pm 1/16</math></li> <li>9. X DECIMALS <math>\pm .030</math></li> <li>10. XX DECIMALS <math>\pm .010</math></li> <li>11. XXX DECIMALS <math>\pm .005</math></li> </ol>			<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	01/06/2006	<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>OPTICS CONNECTOR PLATE</b></p>			
DRW	T OQUIN	01/06/2006				
CHK						
ENG	V GRAVES	01/06/2006				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CONNECTOR PLATE HJT	203-HJT-0730	1:1	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0751	A	

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



ITEM	drain/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
6	1	Instrumentation Quick-Connects - QC Series_SS-QC6-D1-600_3_8_Swagelok Bulkhead Tube Fitting	N/A	INSTRUMENTATION QUICK-CONNECTS - QC SERIES	N/A
5	1	U Series_SS-8UW-TP3_Tube Weld 1_2 or 3_4_Swagelok Company_Created with PartSpec_2DC48_A4E451	N/A	U SERIES	N/A
4	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
3	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
2	1	vacuum port tubing hjt	SS - 304L, ASTM A269	VACUUM PORT TUBING	203-HJT-0762
1	1	drain plate	SS - 304L, ASTM A-240	PLATE, 6 x 0 THK	203-HJT-0761



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° 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

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**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	01/06/2006
DRW	T OQUIN	01/06/2006
CHK		
ENG	V GRAVES	01/06/2006
QA		

**MERIT EXPERIMENT  
SECONDARY CONTAINMENT ASSY  
VACUUM ASSY**

CAD FILE	CONNECTOR PLATE ASSY HJT	PREV ASSY	203-HJT-0700	SCALE	1:2	SHEET	1 of 1
SIZE	DWG NO.	REV	A				

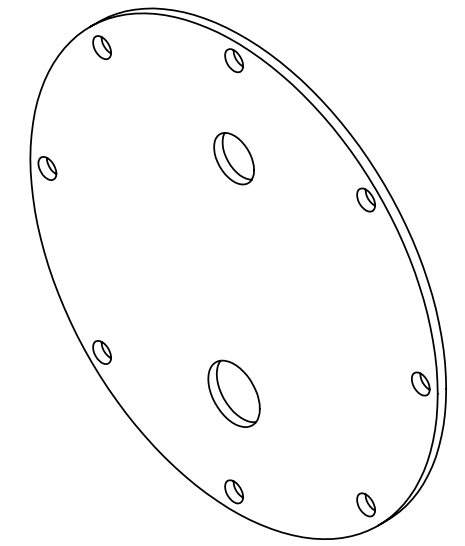
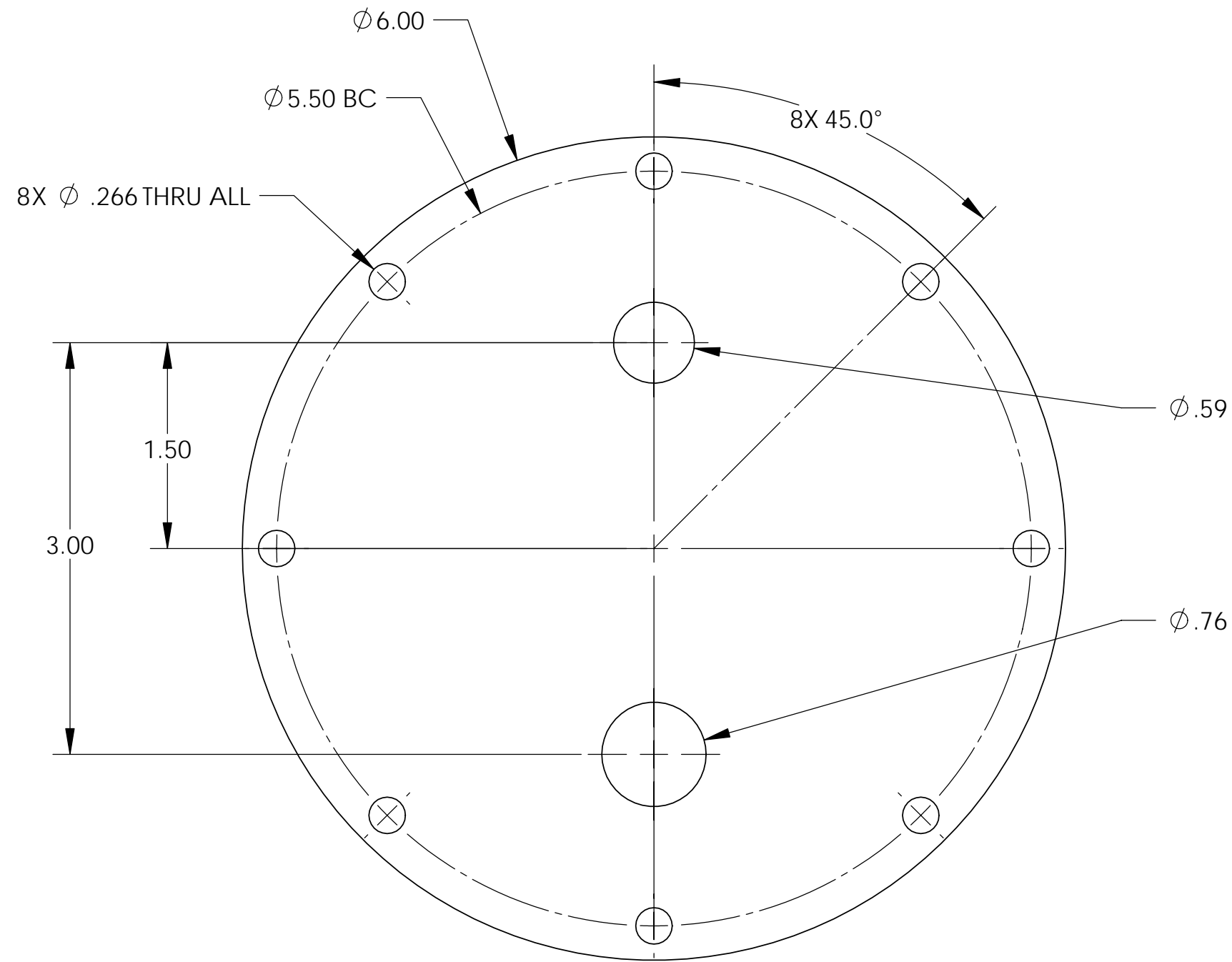
**203-HJT-0760**

DRAWING APPROVALS

DATE

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



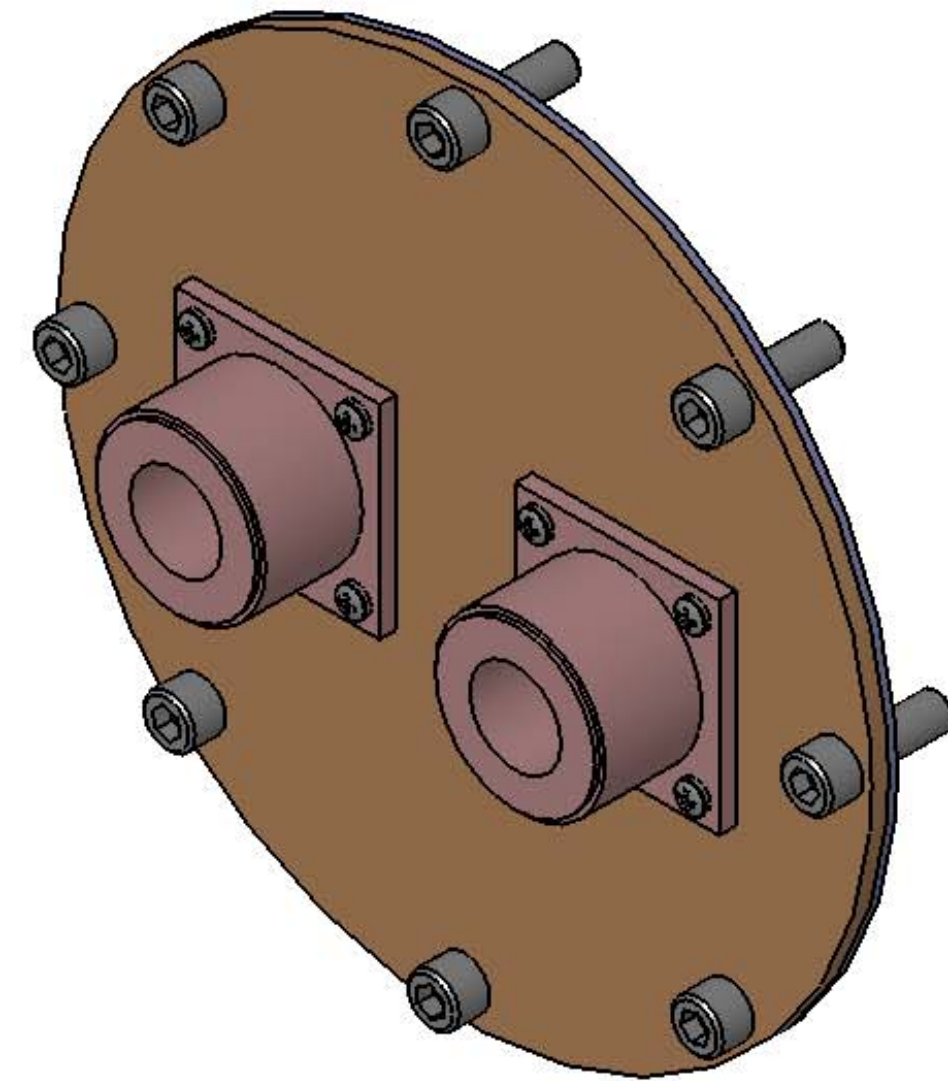
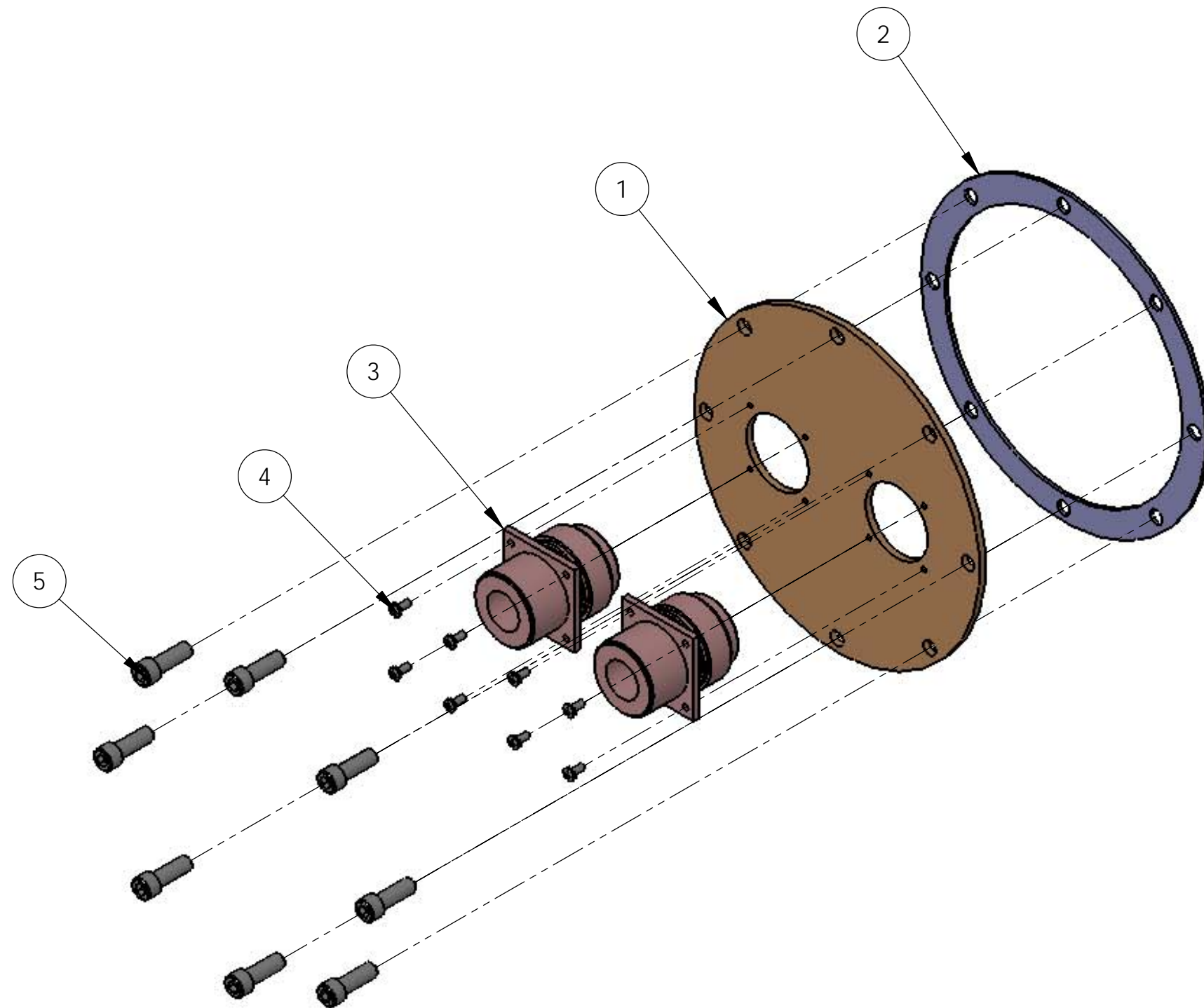
.13

MATERIAL: SS - 304L, ASTM A-240

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY .010 TIR</li> <li>5. MACHINED ANGLES ±1/2° FORMED ANGLES ±1°</li> <li>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>7. WHOLE NUMBERS AND FRACTIONS ±1/16</li> <li>8. X DECIMALS ±.030</li> <li>9. XX DECIMALS ±.010</li> <li>10. XXX DECIMALS ±.005</li> </ol>			<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
<p>DES V GRAVES 01/06/2006</p> <p>DRW T OQUIN 01/06/2006</p> <p>CHK</p> <p>ENG V GRAVES 01/06/2006</p> <p>QA</p>			<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>DRAIN CONNECTOR PLATE</b></p>		
<p>DRAWING APPROVALS DATE</p>					
<p>SIZE DWG NO. C 203-HJT-0761</p>			<p>REV A</p>		

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



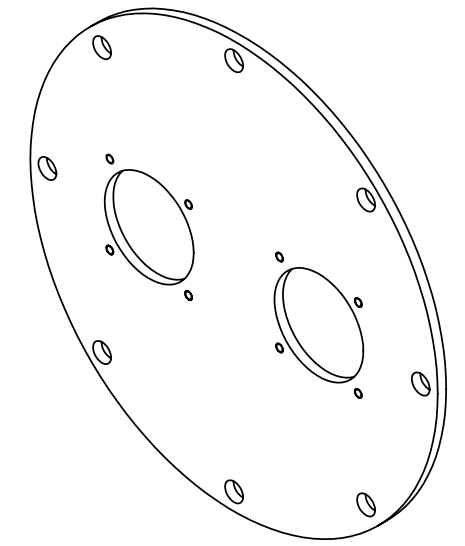
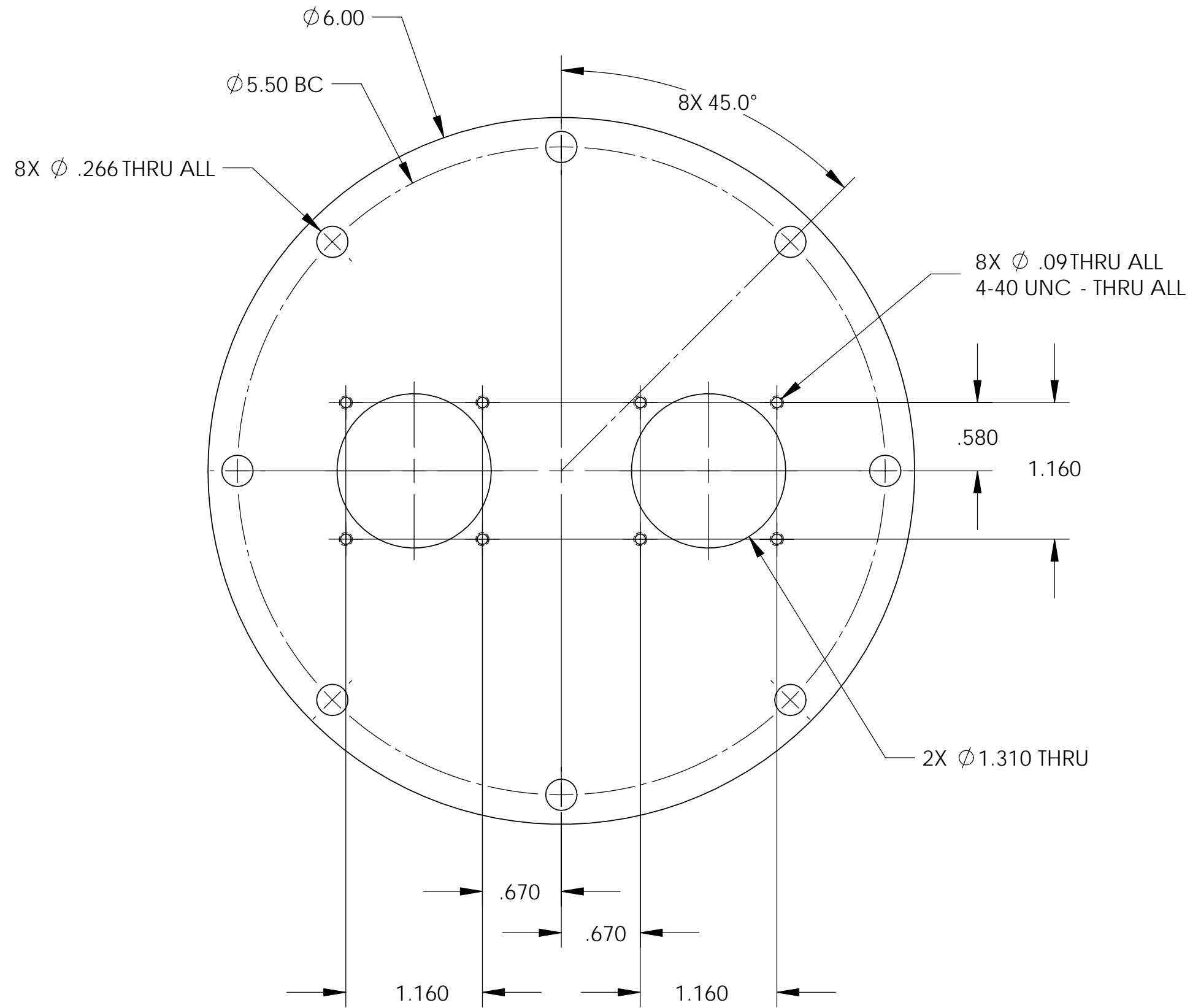
ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
5	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
4	8	CR-PHMS 0.112-40x0.25x0.25-N	SS - 316	PAN CROSS HEAD MACHINE SCREW - 4-40 x 1/4	N/A
3	2	20	---	AMPHENOL 97-4100 - SERIES 20	N/A
2	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
1	1	electrical plate	SS - 304L, ASTM A-240	PLATE, 6 x 0 THK	203-HJT-0771

<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. FORMED ANGLES ±1°</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>SENSOR ASSY</b></p>			
DES	V GRAVES	01/06/2006	CAD FILE	PREV ASSY	SCALE	SHEET
DRW	T OQUIN	01/06/2006	CONNECTOR PLATE ASSY HJT	203-HJT-0700	1:2	1 of 1
CHK			SIZE	DWG NO.		REV
ENG	V GRAVES	01/06/2006	C	203-HJT-0770		A
QA			DRAWING APPROVALS	DATE		

DWG NO. 203-HJT-0770

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

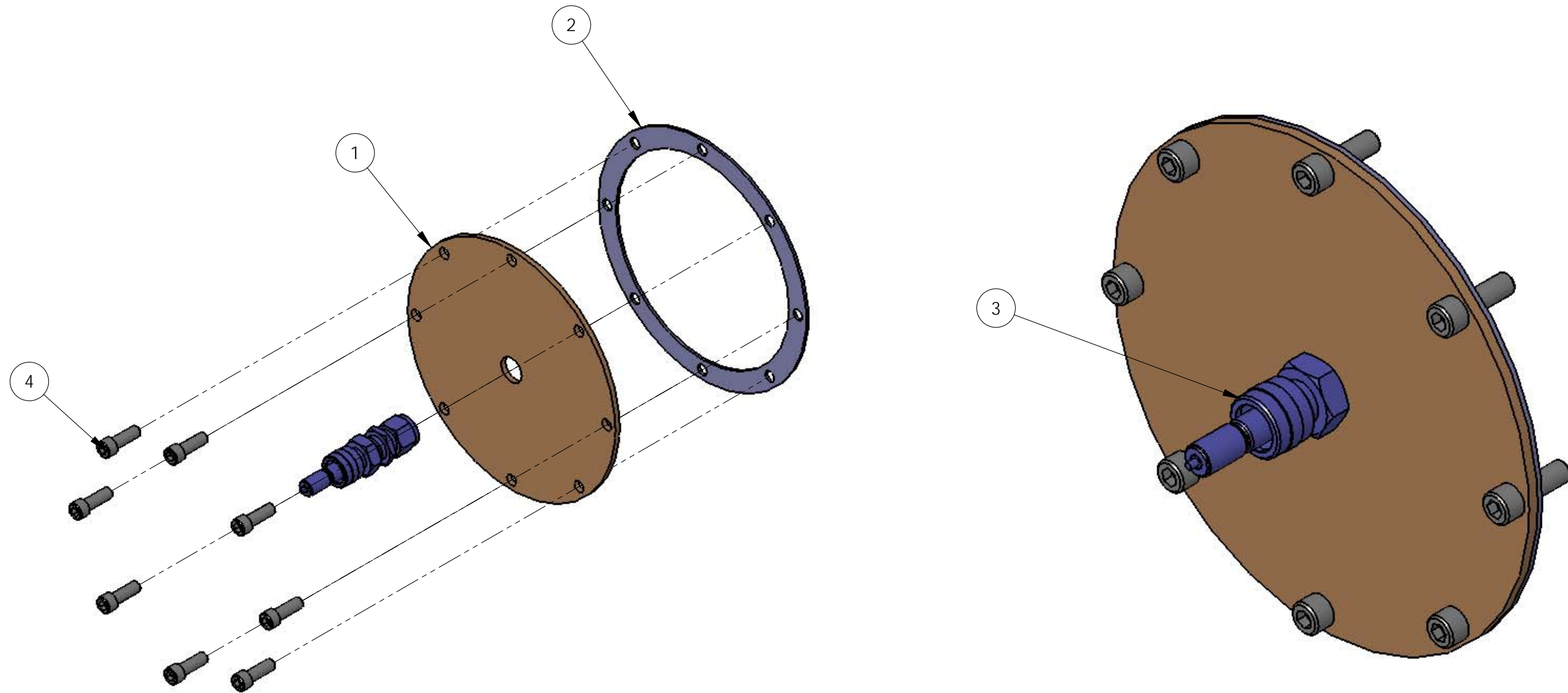


MATERIAL: SS - 304L, ASTM A-240

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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"> <li>1. ALL DIMENSIONS ARE IN INCHES</li> <li>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</li> <li>3. MACHINED FINISH 125 MICRO-INCHES RMS</li> <li>4. CONCENTRICITY <math>.010</math> TIR</li> <li>5. MACHINED ANGLES <math>\pm 1/2^\circ</math></li> <li>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</li> <li>7. WHOLE NUMBERS AND FRACTIONS <math>\pm 1/16</math></li> <li>8. X DECIMALS <math>\pm .030</math></li> <li>9. XX DECIMALS <math>\pm .010</math></li> <li>10. XXX DECIMALS <math>\pm .005</math></li> </ol>			<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	01/06/2006	<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>ELECTRICAL CONNECTOR PLATE</b></p>			
DRW	T OQUIN	01/06/2006				
CHK						
ENG	V GRAVES	01/06/2006				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CONNECTOR PLATE HJT	203-HJT-0730	1:1	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0771	A	

NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED

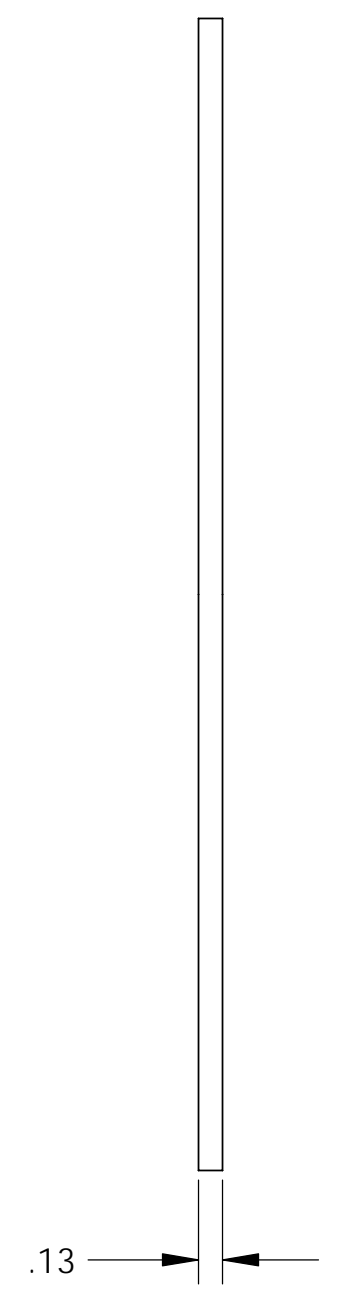
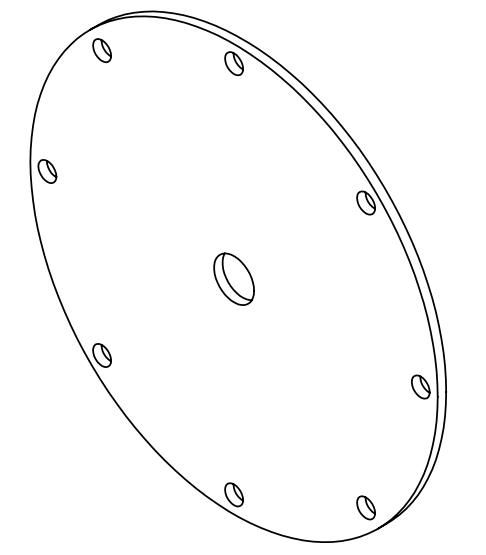
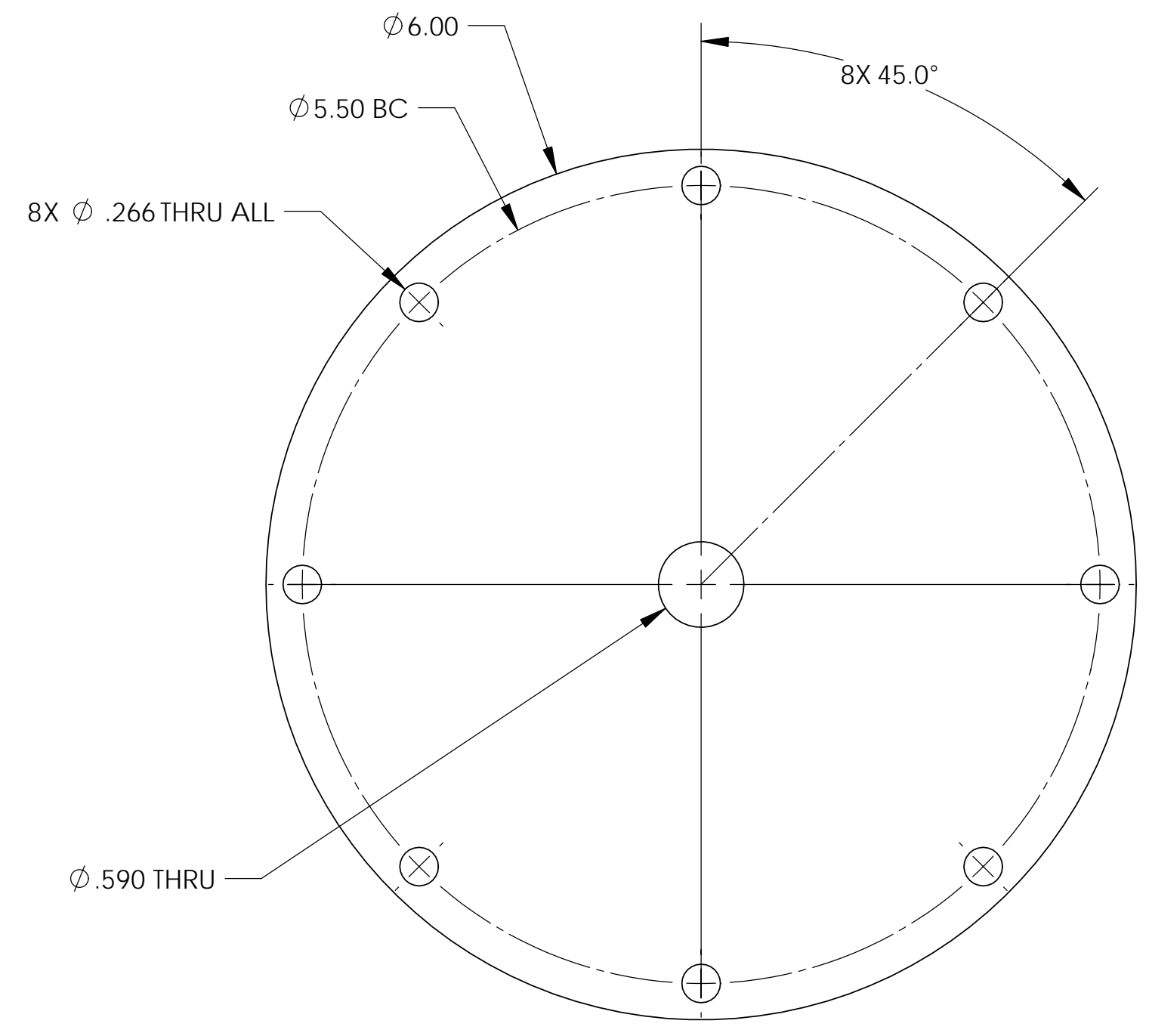


4	8	HX-SHCS 0.25-20x0.75x0.75-N	SS - 18-8	.38 X .5 -16 SHCS	N/A
3	1	Instrumentation Quick-Connects - QC Series_SS-QC6-D1-600_3_8_Swagelok Bulkhead Tube Fitting	N/A	INSTRUMENTATION QUICK-CONNECTS - QC SERIES	N/A
2	1	connector plate gasket hjt	1/16" BUNA-N SHEET. 50A	McMASTER-CARR #86715K279	203-HJT-0732
1	1	connector plate hjt	SS - 304L, ASTM A-240	PLATE, 6.00 x .13 THK	203-HJT-0781
ITEM	hg inlet/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>SECONDARY CONTAINMENT ASSY</b> <b>HG INLET PLATE ASSY</b></p>			
DES	V GRAVES	01/06/2006	CAD FILE	PREV ASSY	SCALE	SHEET
DRW	T OQUIN	01/06/2006	CONNECTOR PLATE ASSY HJT	203-HJT-0700	1:2	1 of 1
CHK			SIZE	DWG NO.		REV
ENG	V GRAVES	01/06/2006	C	203-HJT-0780		A
QA			DRAWING APPROVALS	DATE		

DWG NO. 203-HJT-0780

NOTES  
1. MATERIAL CERTIFICATIONS REQUIRED



MATERIAL: SS - 304L, 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° 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
DES V GRAVES 01/06/2006 DRW T OQUIN 01/06/2006 CHK ENG V GRAVES 01/06/2006 QA			<p align="center"><b>MERIT EXPERIMENT SECONDARY CONTAINMENT ASSY HG INLET CONNECTOR PLATE</b></p>		
CAD FILE CONNECTOR PLATE HJT SIZE DWG NO.		PREV ASSY 203-HJT-0730 SCALE 1:1		SHEET 1 of 1 REV A	
DRAWING APPROVALS DATE			C 203-HJT-0781		

DWG NO. 203-HJT-0781