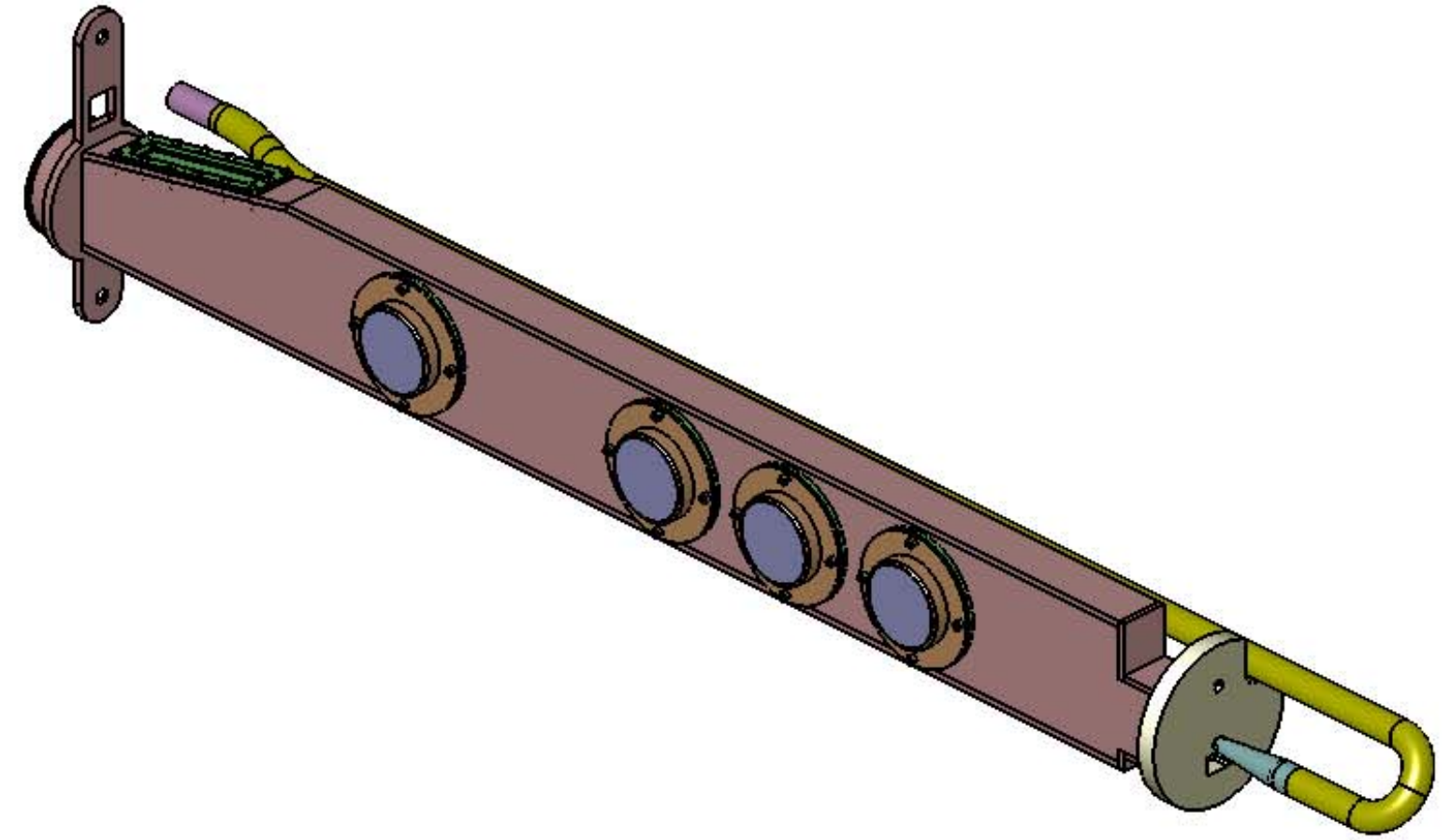
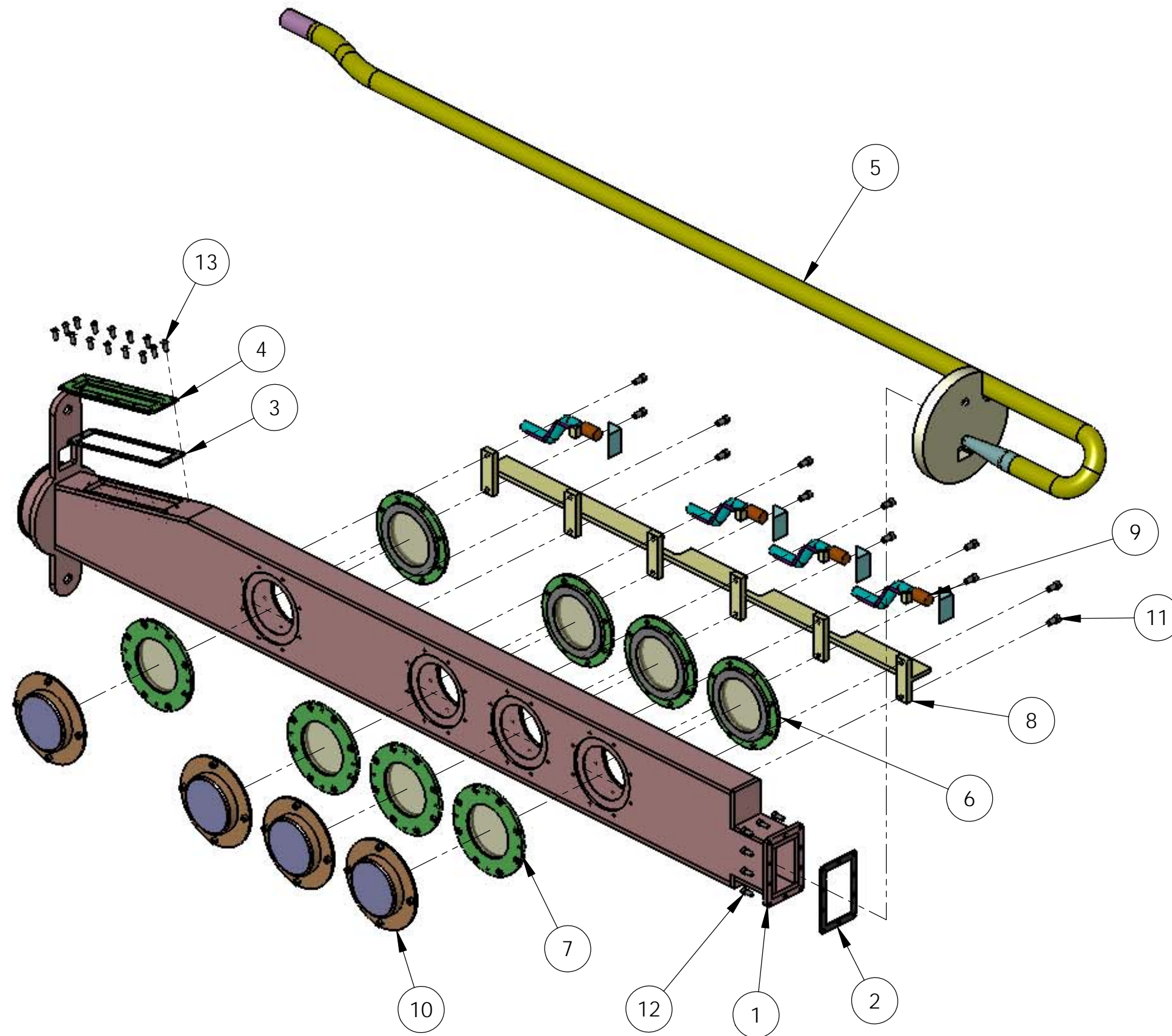


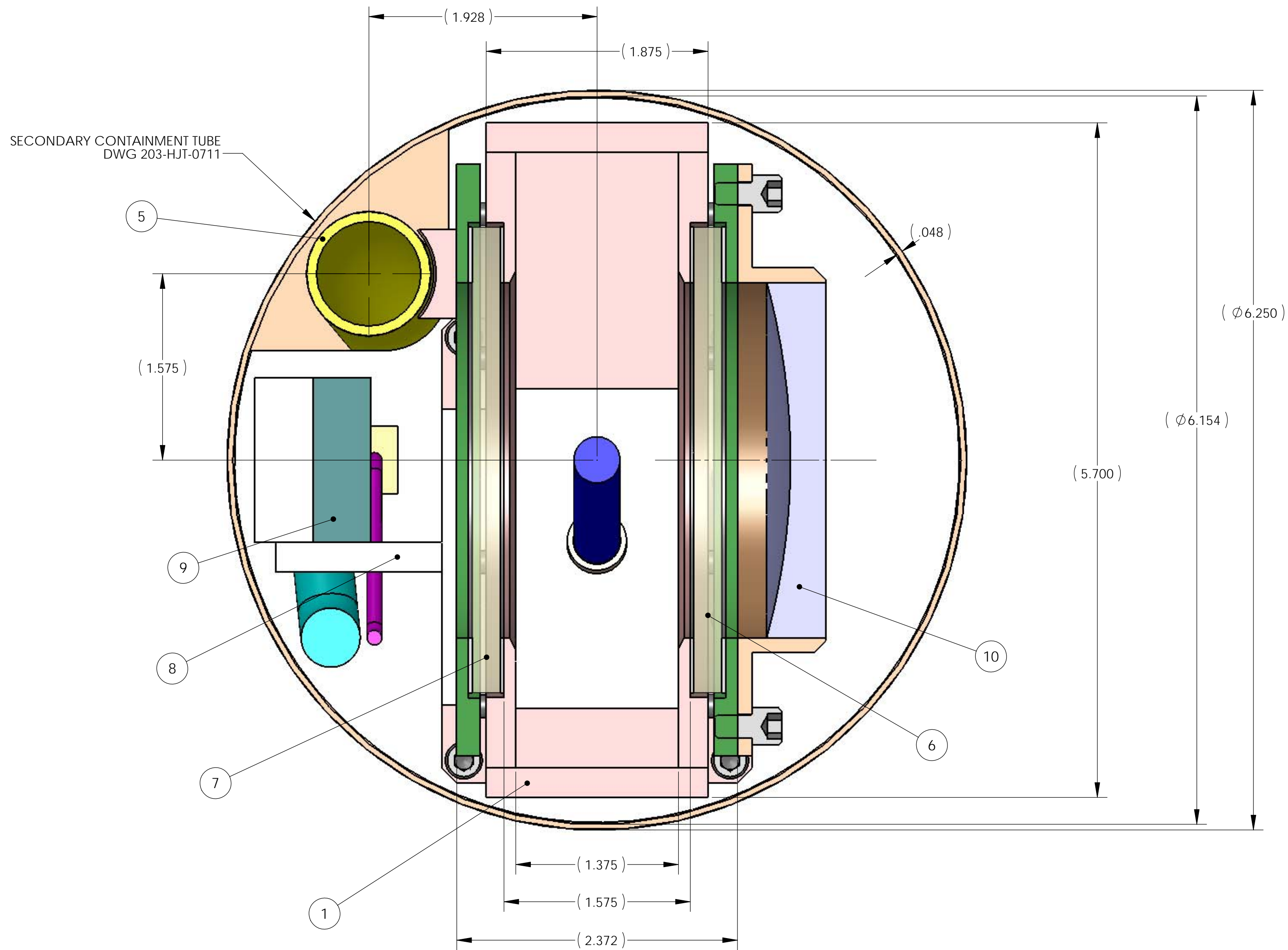
NOTE: ASSEMBLY SHALL BE SOAP-BUBBLE PRESSURE TESTED TO 2 PSIG.



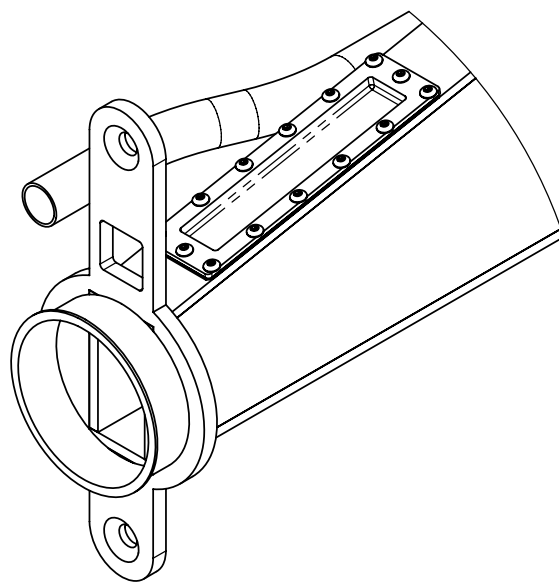
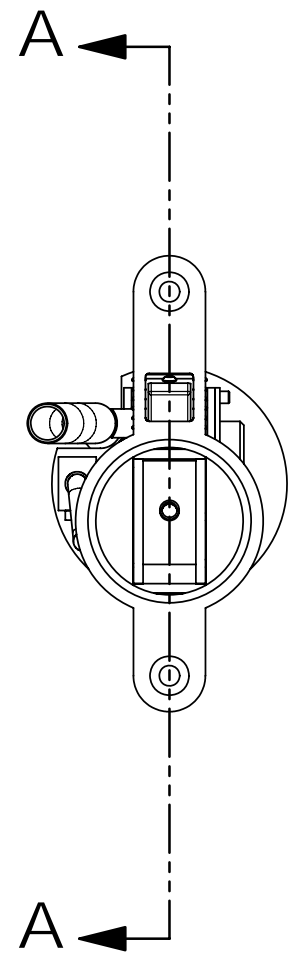
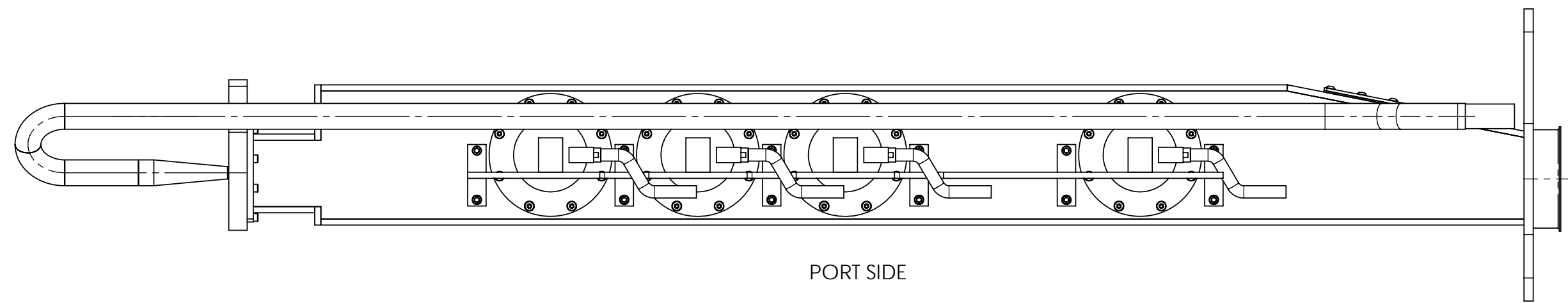
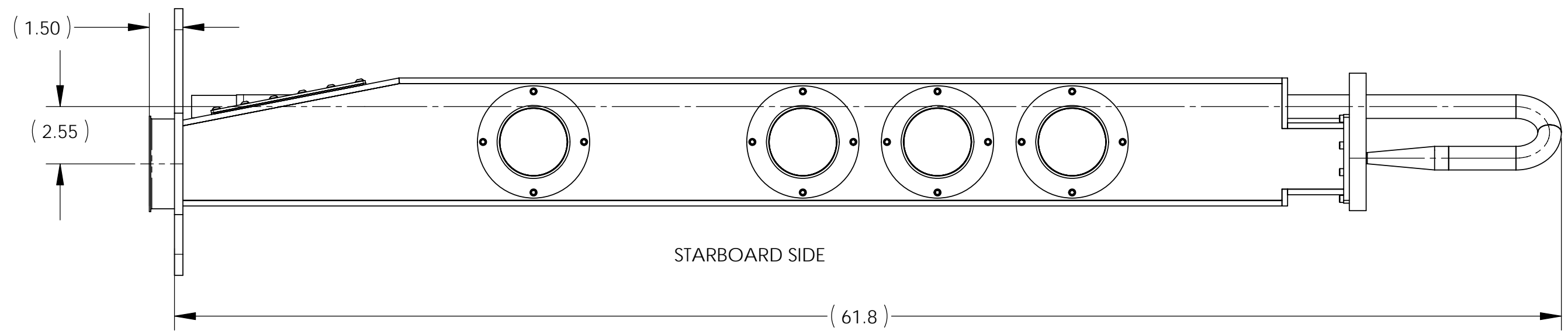
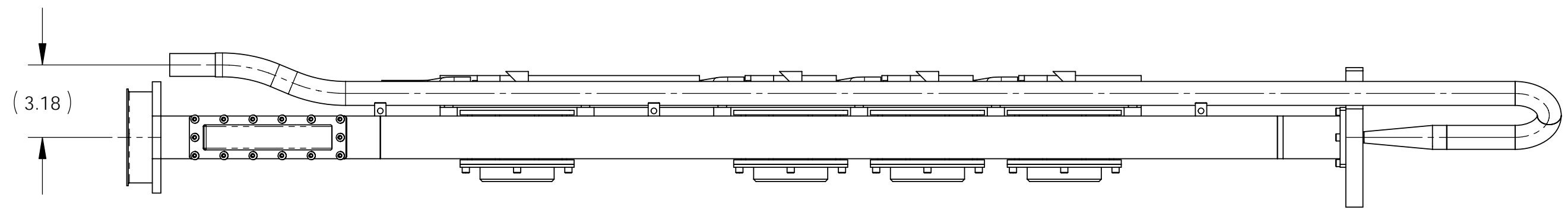
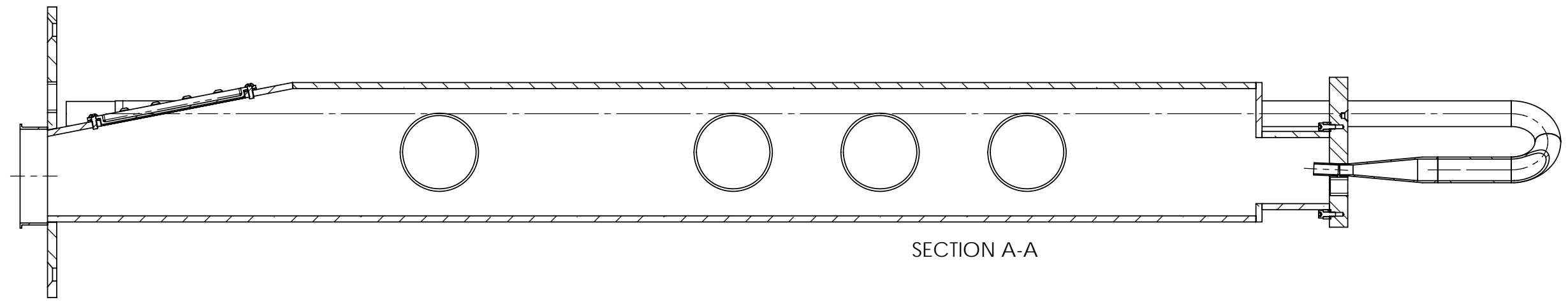
ITEM	FOR DWG/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
13	14	socket button head cap screw_ai	SS - 18-8	BHCS - 1/4-20	N/A
12	10	Socket Head Cap Screw_AI	SS - 18-8	SHCS - 10-32 x 1/2	N/A
11	12	HX-SHCS 0.25-20x0.5x0.5-N	SS - 18-8	SHCS - 1/4-20 x 1/2	N/A
10	4	optic reflector assy	---	PROVIDED BY OTHERS	N/A
9	4	optic diag assy hjt	---	PROVIDED BY OTHERS	N/A
8	1	optic support bkt hjt	---	PROVIDED BY OTHERS	N/A
7	4	optic viewport assy	---	VIEWPORT ASSY - REFLECTOR	203-HJT-0660
6	4	optic viewport assy	---	VIEWPORT ASSY - DIAGNOSTICS	203-HJT-0630
5	1	hg supply assy hjt	TITANIUM	HG SUPPLY AND NOZZLE	203-HJT-0620
4	1	pri dn window hjt	TI-6AL-4V, ASTM B-265	PLATE, 7.000 X 1.875 X .375	203-HJT-0616
3	1	pri dn window gasket hjt	BUNA-N	MCMaster-CARR #9028K23	203-HJT-0615
2	1	upstream pri flange gasket hjt	BUNA-N	MCMaster-CARR #9028K23	203-HJT-0614
1	1	pri tube weldment hjt	SS - 304L, ASTM A240	HG JET CHAMBER	203-HJT-0611

<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>HG DELIVERY SYSTEM</b> <b>PRIMARY TUBE ASSY</b></p>			
DES	V GRAVES	06/05/2005	CAD FILE	PREV ASSY	SCALE	SHEET
DRW	T OQUIN	06/05/2005	PRI TUBE ASSY HJT	203-HJT-0600	1:6	1 of 3
CHK	P SPAMPINATO	02/07/2006	SIZE	DWG NO.		REV
ENG	V GRAVES	06/05/2005	C	203-HJT-0610		0
QA						
DRAWING APPROVALS		DATE				

DWG NO. 203-HJT-0610



<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 06/05/2005</p> <p>DRW T OQUIN 06/05/2005</p> <p>CHK P SPAMPINATO 02/07/2006</p> <p>ENG V GRAVES 06/05/2005</p> <p>QA</p>			<p><b>MERIT EXPERIMENT</b> <b>HG DELIVERY SYSTEM</b> <b>PRIMARY TUBE ASSY</b></p>		
<p>CAD FILE PRI TUBE ASSY HJT SIZE DWG NO.</p>			<p>PREV ASSY 203-HJT-0600</p>	<p>SCALE 1:5</p>	<p>SHEET 3 of 3</p>
<p>DRAWING APPROVALS</p>			<p>DATE</p>	<p>203-HJT-0610</p>	<p>REV 0</p>