



1. WELDING TO BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.

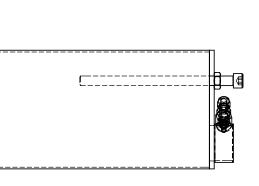
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED. NO RADIOGRAPHY REQUIRED.

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	A	N//	HEX JAM NUT, 0.500 - 13	SS	D-N	1 HJNUT 0.5000-13-D-N			4	
	A	N//	SHCS 0.5-13 X 11.0	SS - 18-8	Socket Head Cap Screw_Al			1	3	
	-0712	203-HJT	UPSTREAM DOUBLE BEAM WINDOW	TITANIUM	double window monitored			1	2	
0710	-0711	203-HJT	SECONDARY CONTAINMENT TUBE	TI GRADE 2, ASTM B-265	sec contain weldment hjt			1	1	
	'G	DW	DESCRIPTION	MATERIAL	NAME			Default/QTY.	ITEM	
r <b>5</b> 03	OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-000R22725 Oak Ridge, TN				rmed under ract number applicable	drawing was prepare for use in work perfo ment of Energy conto C05-00OR22725 and k for Others Agreem	solely Depar DE-A	THIRD-ANGLE	⊕-€-	
DWG NO	REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION				Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.			THERWISE NOTED INSIONS ARE IN	ALL DIMEN	
	MERIT EXPERIMENT				06/09/2005	V GRAVES	DES	OLERANCES PER ASME Y14.5M ACHINED FINISH 125 MICRO-		
								RICITY .010 TIR	INCHES R	
		SECONDARY TUBE ASSY					СНК	MACHINED ANGLES ±1/2° FORMED ANGLES ±1° BREAK SHARP CORNERS AND		
					06/09/2005	V GRAVES	ENG	MOVE ALL BURRS	REMOVE A	
	SHEET	SCALE	PREV ASSY	CAD FILE			QA	IS ±1/16	FRACTION X DECI	
	1 of 1	1:6		SEC TUBE AS	-	-		MALS ±.010	XX DECI	
<u>′</u>	REV B	SIZE DWG NO. C 203-HJT-0710		DATE	VING APPROVALS		1003 <u>1</u> .003			

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