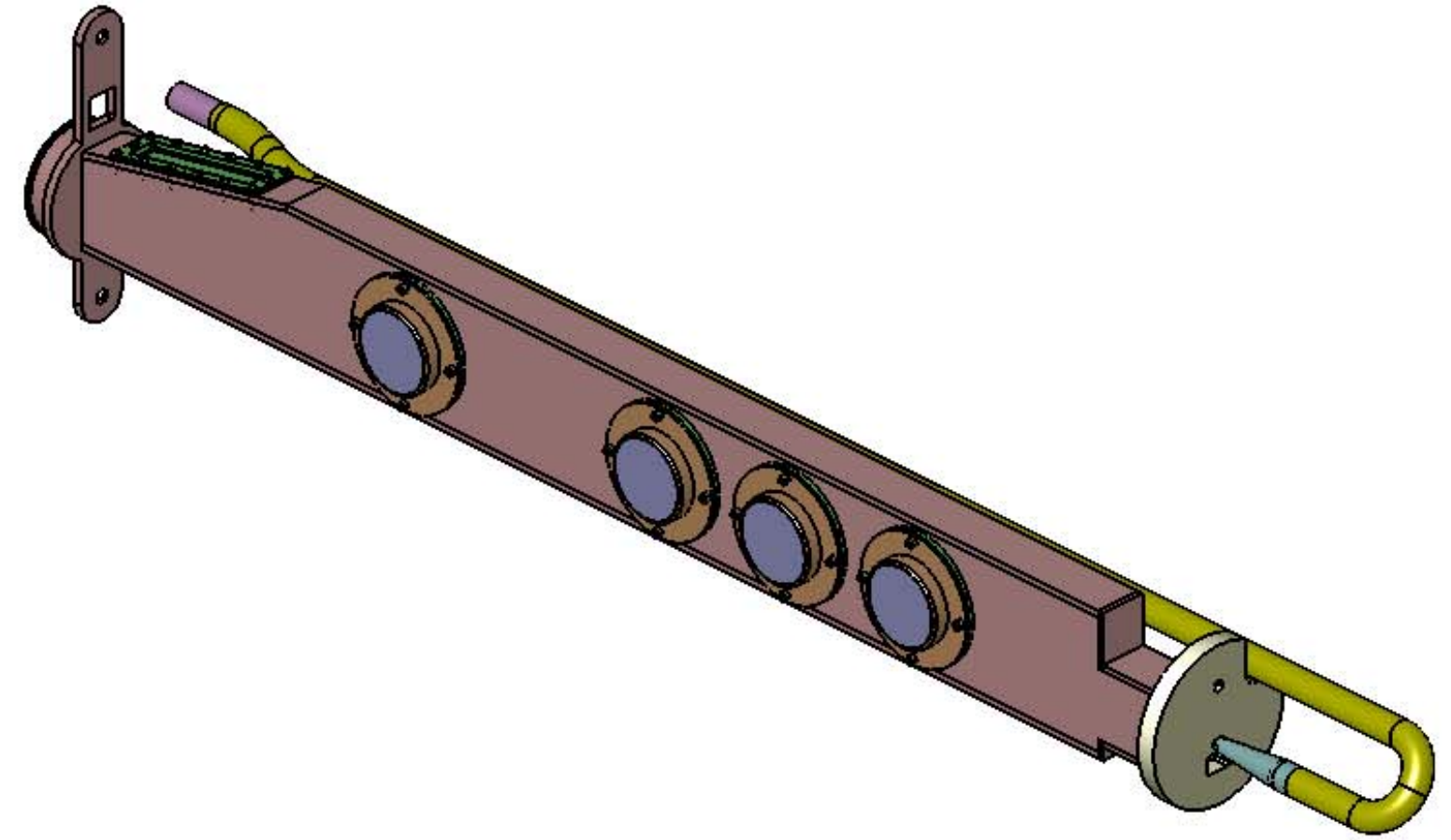
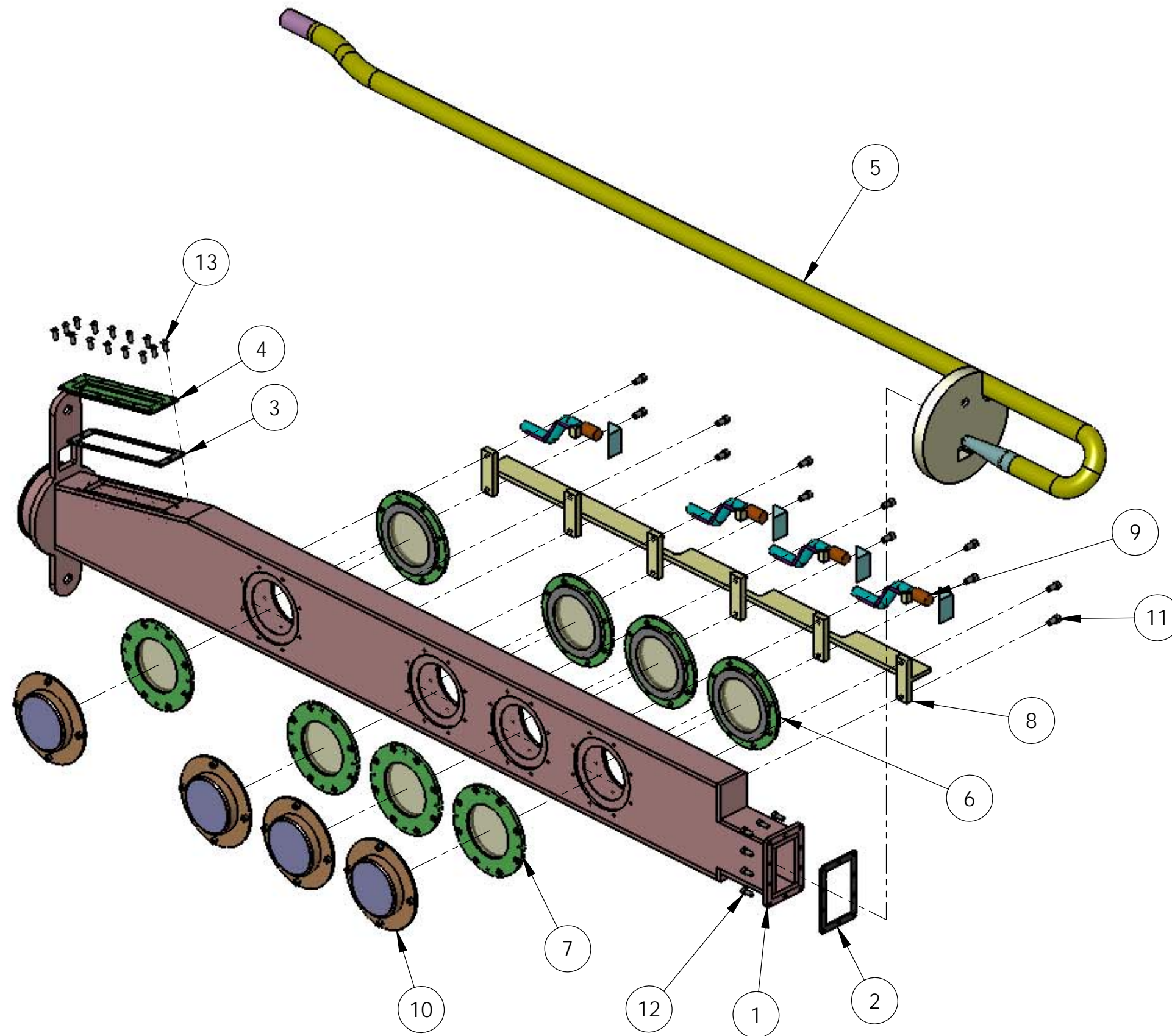


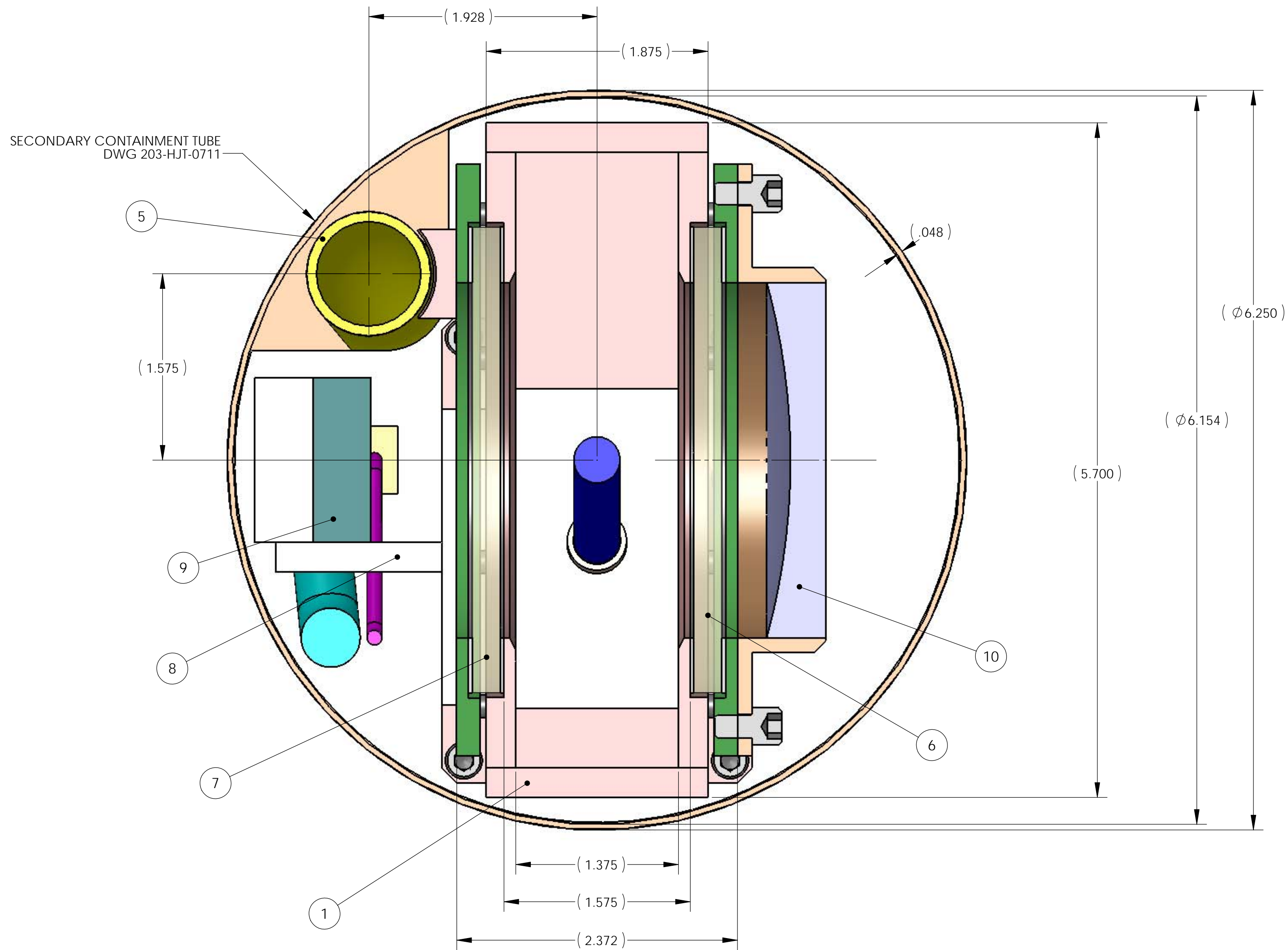
NOTE: ASSEMBLY SHALL BE SOAP-BUBBLE PRESSURE TESTED TO 2 PSIG.



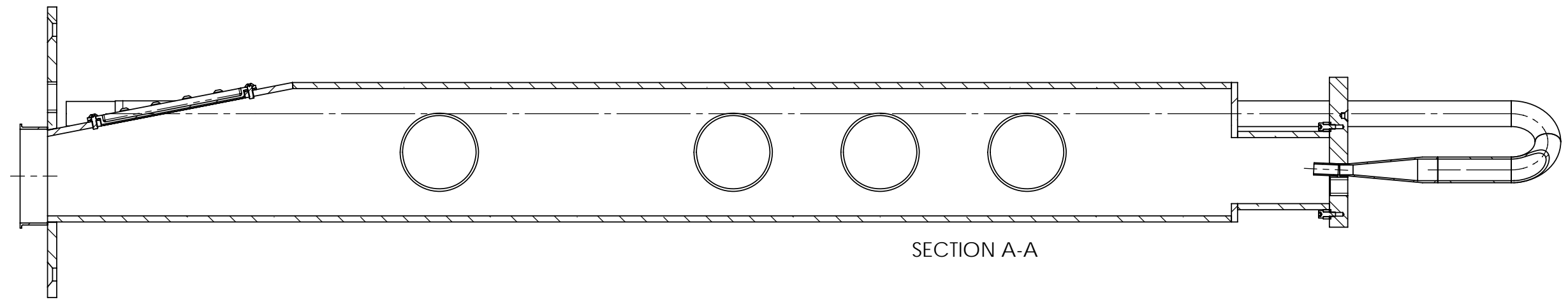
| ITEM | FOR DWG/QTY. | NAME | MATERIAL | DESCRIPTION | DWG |
|------|--------------|---------------------------------|-----------------------|-----------------------------|--------------|
| 13 | 14 | socket button head cap screw_ai | SS - 18-8 | BHCS - 1/4-20 | N/A |
| 12 | 10 | Socket Head Cap Screw_AI | 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>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p> | | |
| | <p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p> | | <p>MERIT EXPERIMENT HG DELIVERY SYSTEM PRIMARY TUBE ASSY</p> | | |
| <p>CAD FILE PRI TUBE ASSY HJT</p> | | <p>PREV ASSY 203-HJT-0600</p> | | <p>SCALE 1:6</p> | <p>SHEET 1 of 3</p> |
| <p>DRAWING APPROVALS</p> | | <p>DATE</p> | | <p>REV 0</p> | |

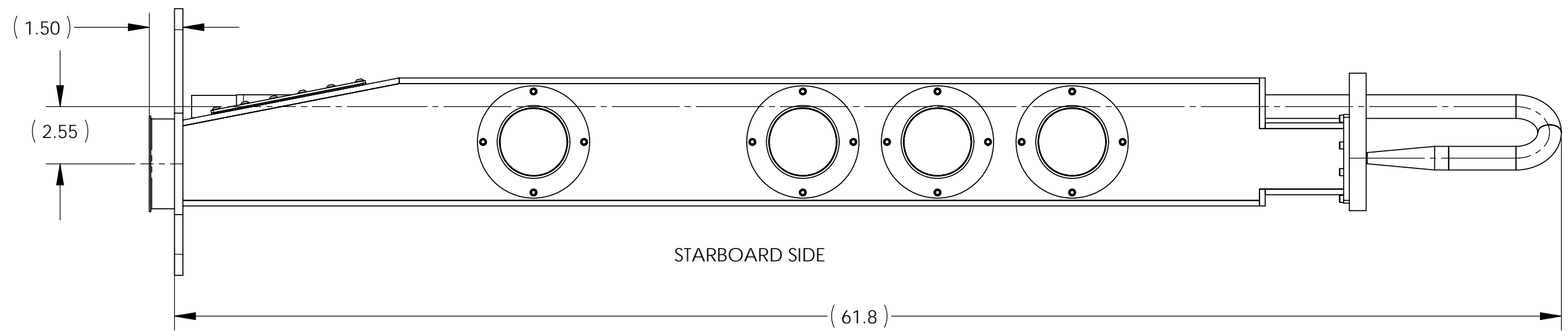
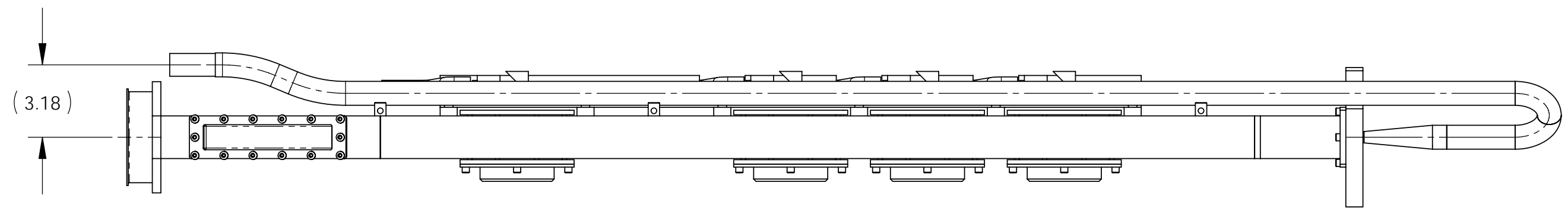
DWG NO. 203-HJT-0610



| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|------------|------------|---|---|------------|---------|--------------|------------|--------------|----------|------------|----|--|--|---|--|--|--|----------|-----------|-------|-------|-------------------|--------------|-----|--------|
| <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>OAK RIDGE NATIONAL LABORATORY 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"> ALL DIMENSIONS ARE IN INCHES INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M MACHINED FINISH 125 MICRO-INCHES RMS CONCENTRICITY .010 TIR MACHINED ANGLES ±1/2° FORMED ANGLES ±1° BREAK SHARP CORNERS AND REMOVE ALL BURRS WHOLE NUMBERS AND FRACTIONS ±1/16 X DECIMALS ±.030 XX DECIMALS ±.010 XXX DECIMALS ±.005 | | | | <p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p> | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <tr><td>DES</td><td>V GRAVES</td><td>06/05/2005</td></tr> <tr><td>DRW</td><td>T OQUIN</td><td>06/05/2005</td></tr> <tr><td>CHK</td><td>P SPAMPINATO</td><td>02/07/2006</td></tr> <tr><td>ENG</td><td>V GRAVES</td><td>06/05/2005</td></tr> <tr><td>QA</td><td></td><td></td></tr> </table> | DES | V GRAVES | 06/05/2005 | DRW | T OQUIN | 06/05/2005 | CHK | P SPAMPINATO | 02/07/2006 | ENG | V GRAVES | 06/05/2005 | QA | | | <p>MERIT EXPERIMENT HG DELIVERY SYSTEM PRIMARY TUBE ASSY</p> | | | <table border="1"> <tr><td>CAD FILE</td><td>PREV ASSY</td><td>SCALE</td><td>SHEET</td></tr> <tr><td>PRI TUBE ASSY HJT</td><td>203-HJT-0600</td><td>3:2</td><td>2 of 3</td></tr> </table> | CAD FILE | PREV ASSY | SCALE | SHEET | PRI TUBE ASSY HJT | 203-HJT-0600 | 3:2 | 2 of 3 |
| DES | V GRAVES | 06/05/2005 | | | | | | | | | | | | | | | | | | | | | | | | | |
| DRW | T OQUIN | 06/05/2005 | | | | | | | | | | | | | | | | | | | | | | | | | |
| CHK | P SPAMPINATO | 02/07/2006 | | | | | | | | | | | | | | | | | | | | | | | | | |
| ENG | V GRAVES | 06/05/2005 | | | | | | | | | | | | | | | | | | | | | | | | | |
| QA | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CAD FILE | PREV ASSY | SCALE | SHEET | | | | | | | | | | | | | | | | | | | | | | | | |
| PRI TUBE ASSY HJT | 203-HJT-0600 | 3:2 | 2 of 3 | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <tr><td>DRAWING APPROVALS</td><td>DATE</td></tr> <tr><td></td><td></td></tr> </table> | DRAWING APPROVALS | DATE | | | <table border="1"> <tr><td>SIZE</td><td>DWG NO.</td><td>REV</td></tr> <tr><td>C</td><td>203-HJT-0610</td><td>0</td></tr> </table> | SIZE | DWG NO. | REV | C | 203-HJT-0610 | 0 | | | | | | | | | | | | | | | | |
| DRAWING APPROVALS | DATE | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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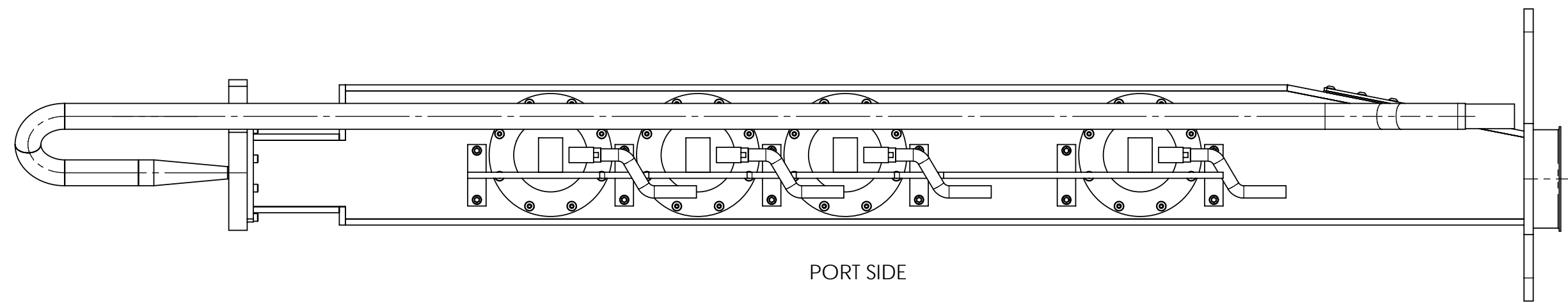


SECTION A-A

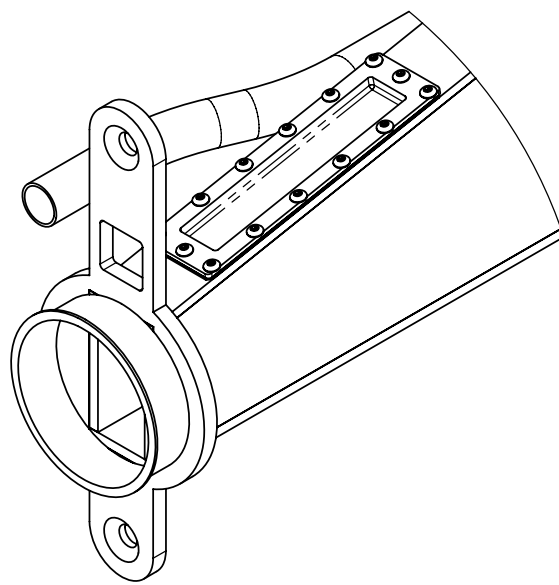
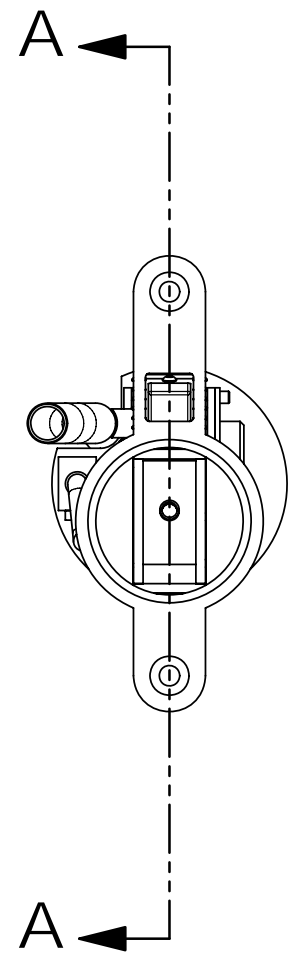


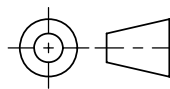


STARBOARD SIDE

(61.8)



PORT SIDE



| | | | | | | |
|--|--|--|---|---|----------------------|-------------------------|
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| <p>DRAWING APPROVALS DATE</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>C</p> | <p>203-HJT-0610</p> | <p>REV 0</p> | |