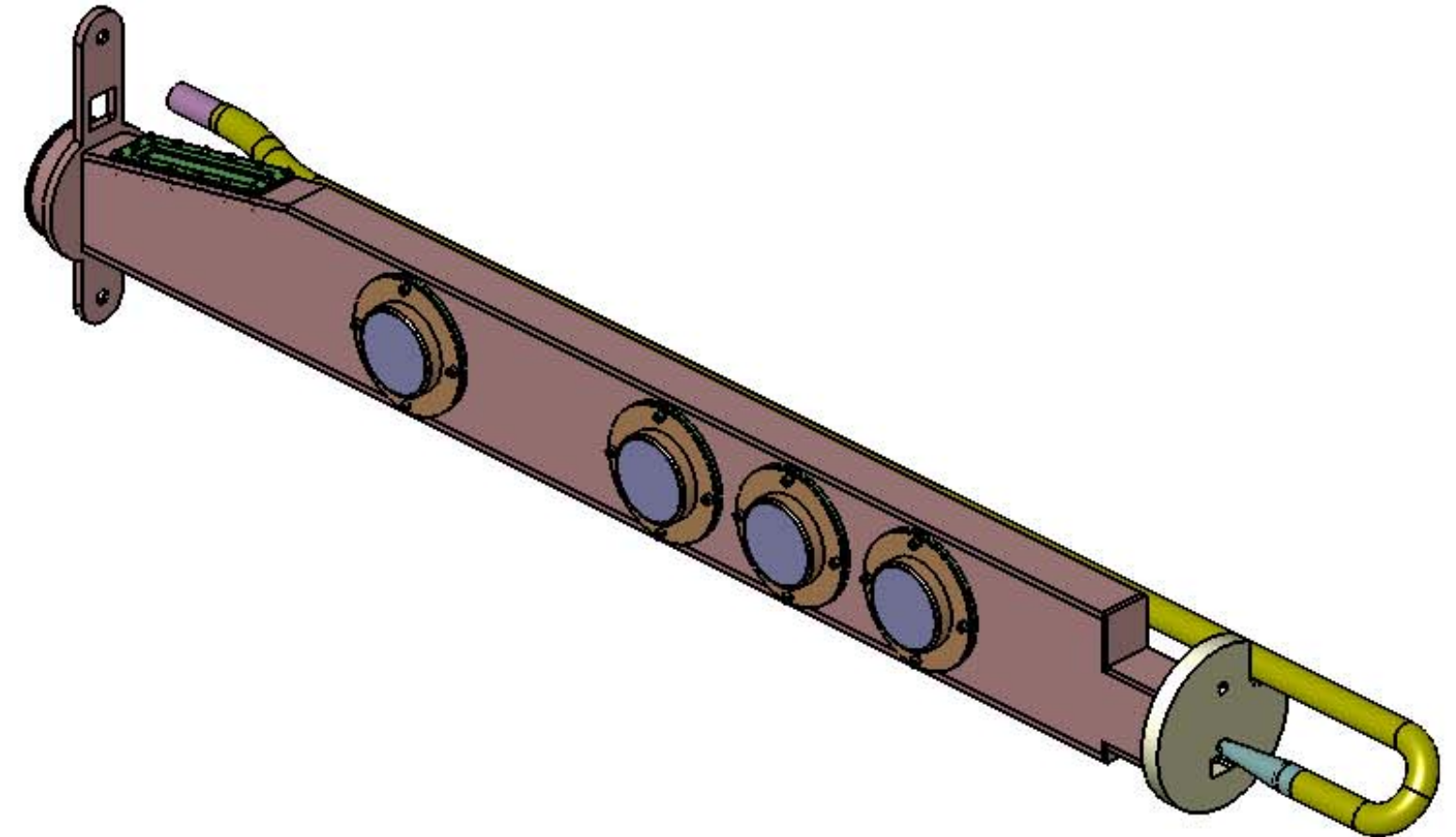
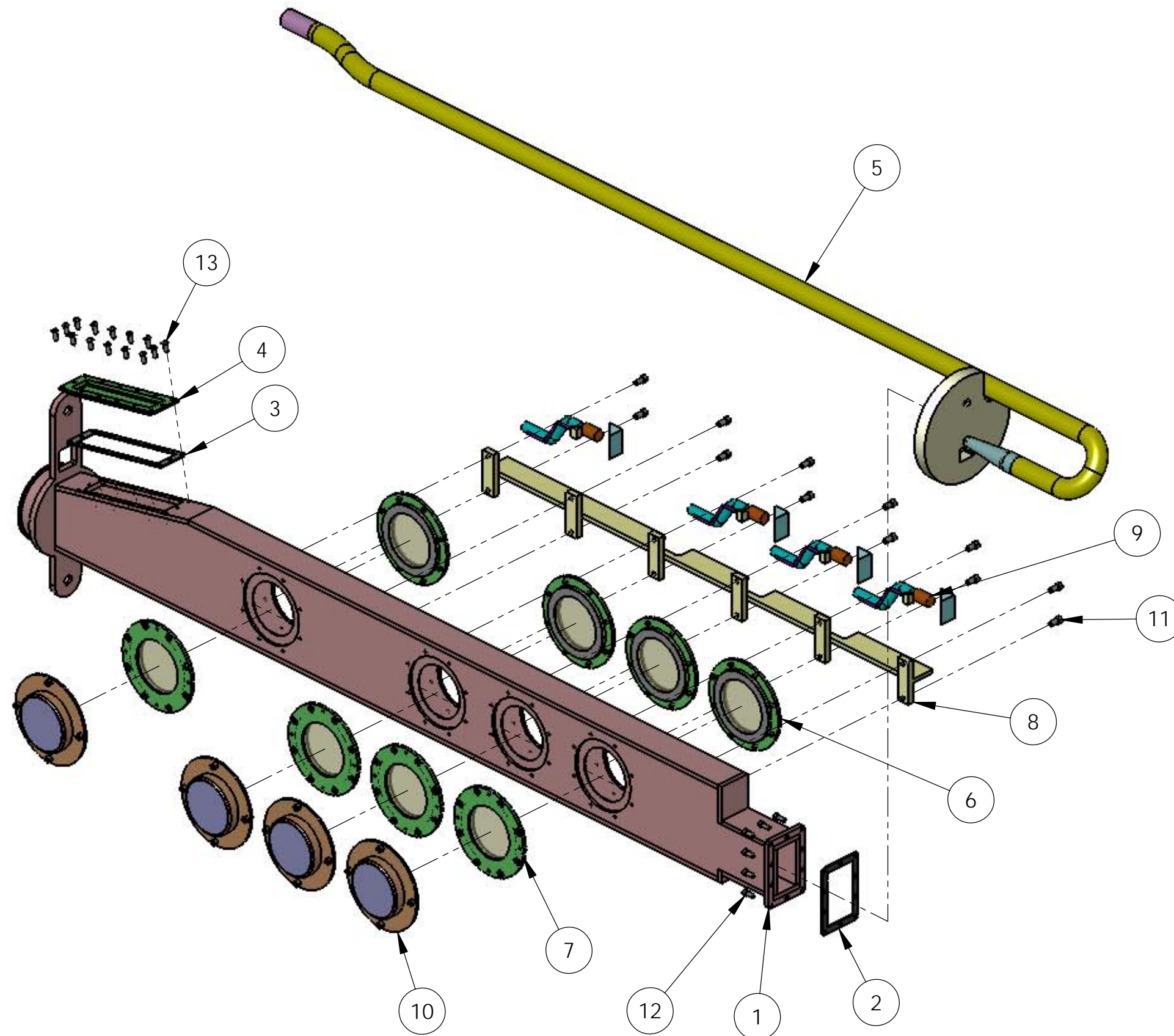


NOTE: ASSEMBLY SHALL BE SOAP-BUBBLE PRESSURE TESTED TO 2 PSIG.



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

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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operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

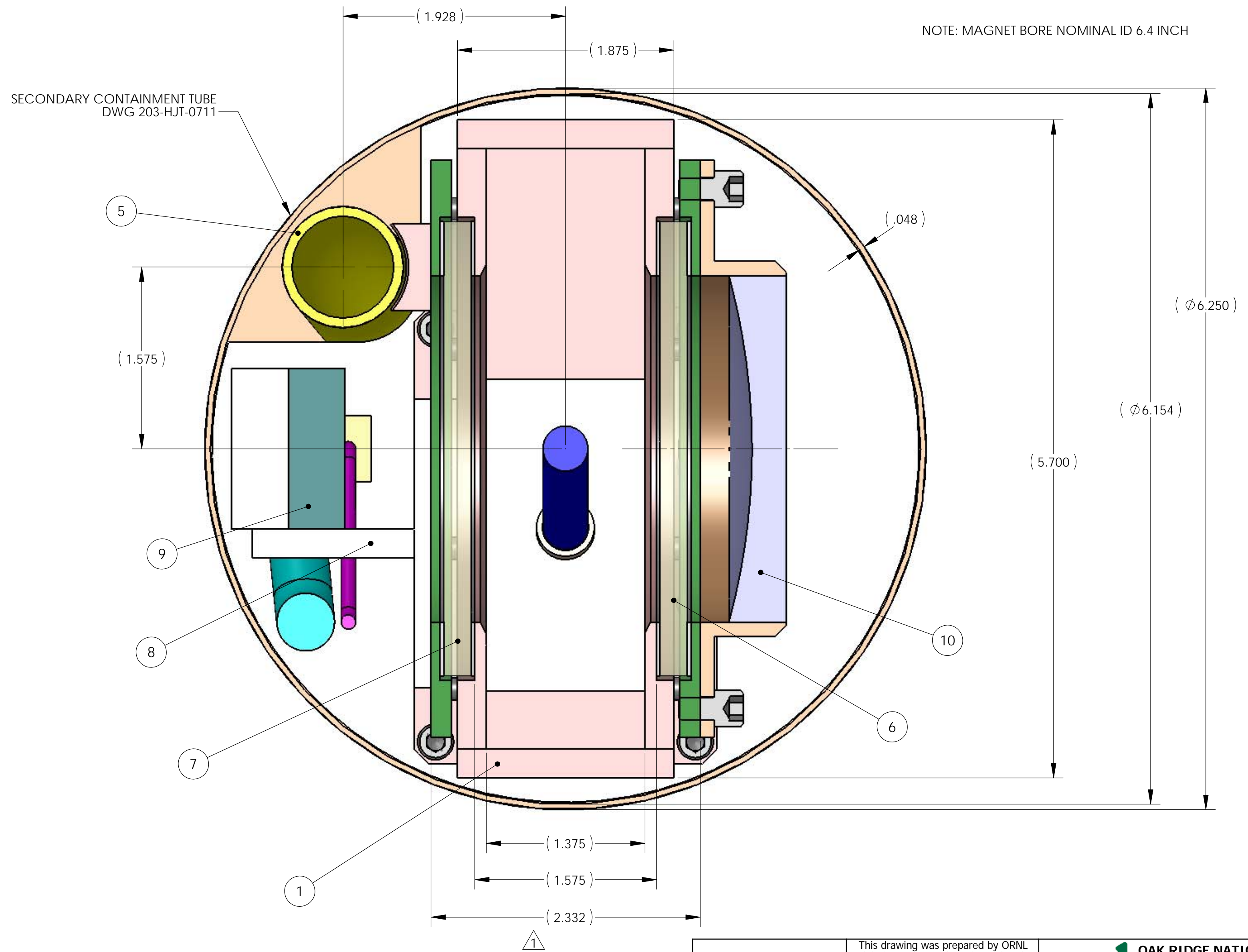
NSTB REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

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		

**MERIT EXPERIMENT
HG DELIVERY SYSTEM
PRIMARY TUBE ASSY**

1	VIEWPORT COVER MODIFIED; SHT 2 UPDATED	5/19/2006	VBG	VBG
REV	DESCRIPTION	DATE	BY	APPROVED

CAD FILE	PREV ASSY	SCALE	SHEET
PRI TUBE ASSY HJT	203-HJT-0600	1:6	1 of 3
SIZE	DWG NO.		REV
C	203-HJT-0610		1



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
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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		

DRAWING APPROVALS	DATE
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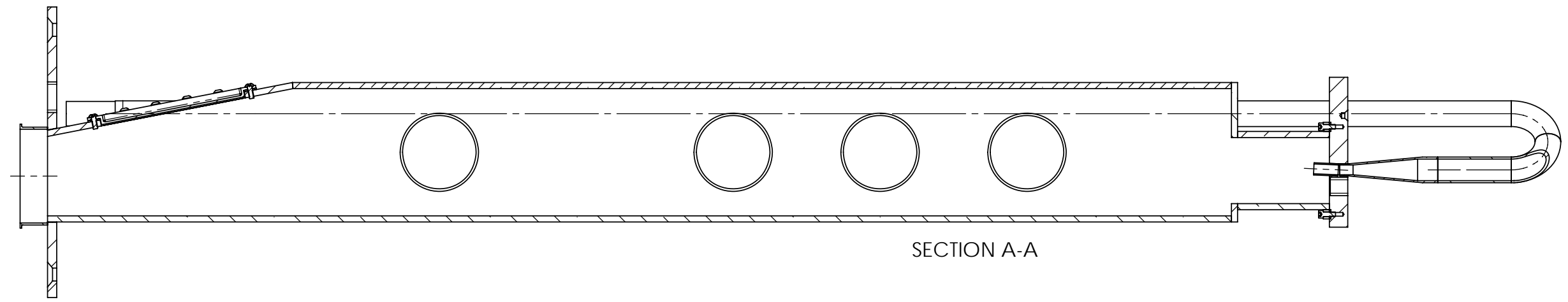


REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

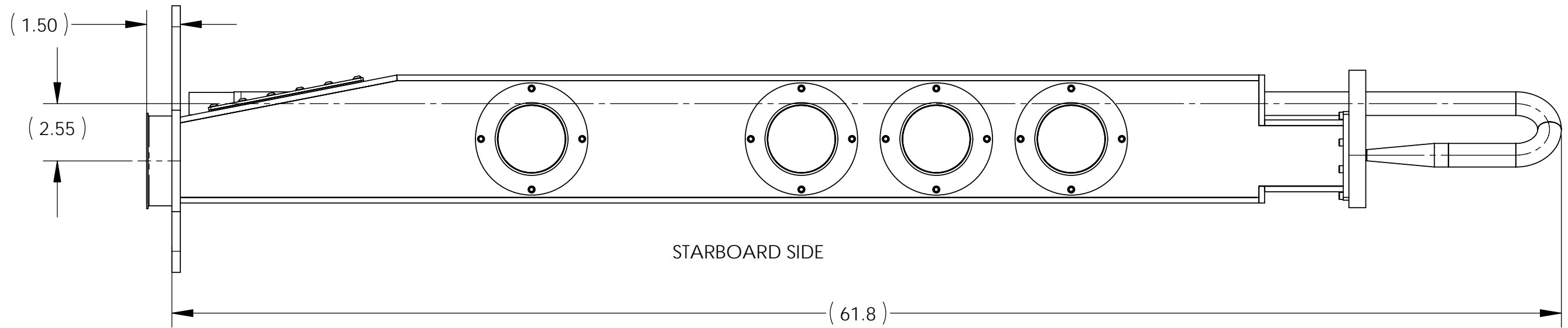
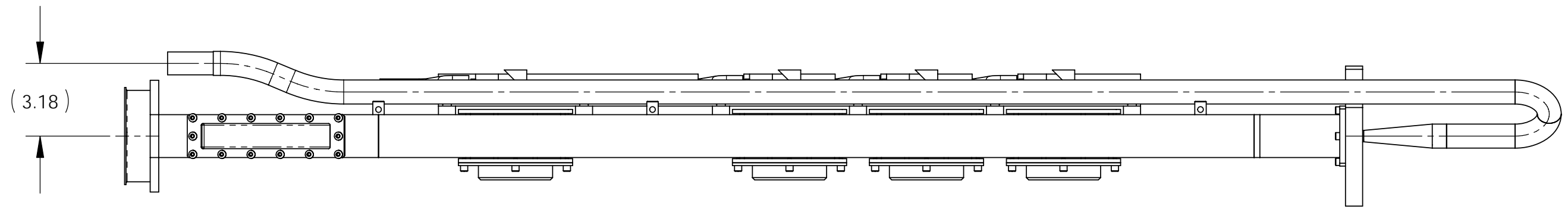
**MERIT EXPERIMENT
HG DELIVERY SYSTEM
PRIMARY TUBE ASSY**

CAD FILE PRI TUBE ASSY HJT	PREV ASSY 203-HJT-0600	SCALE 3:2	SHEET 2 of 3
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SIZE C	DWG NO. 203-HJT-0610	REV 1
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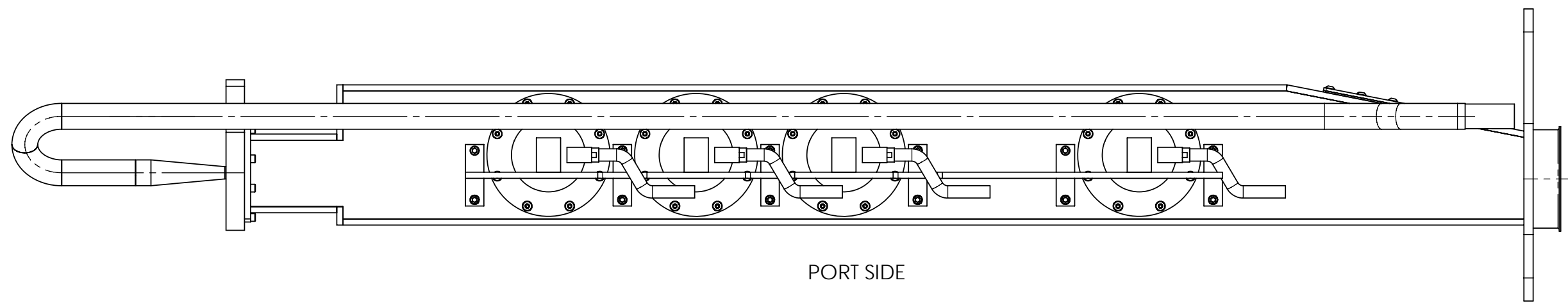


SECTION A-A

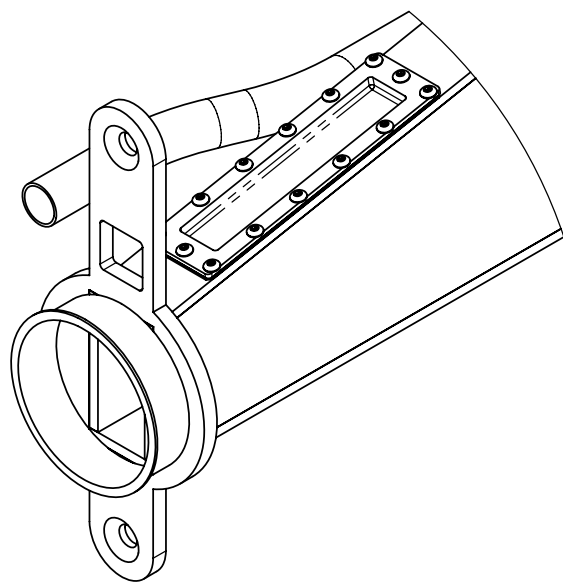
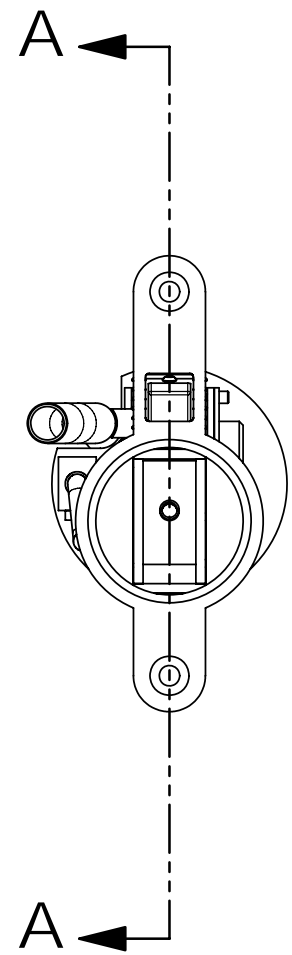


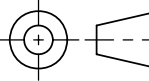


STARBOARD SIDE

(61.8)



PORT SIDE



 <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>	
<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>MERIT EXPERIMENT HG DELIVERY SYSTEM PRIMARY TUBE ASSY</p>		
<p>DRAWING APPROVALS DATE</p>			<p>CAD FILE PRI TUBE ASSY HJT</p>	<p>PREV ASSY 203-HJT-0600</p>	<p>SCALE 1:5</p>
<p>SIZE DWG NO. C</p>			<p>203-HJT-0610</p>	<p>SHEET 3 of 3</p>	<p>REV 1</p>