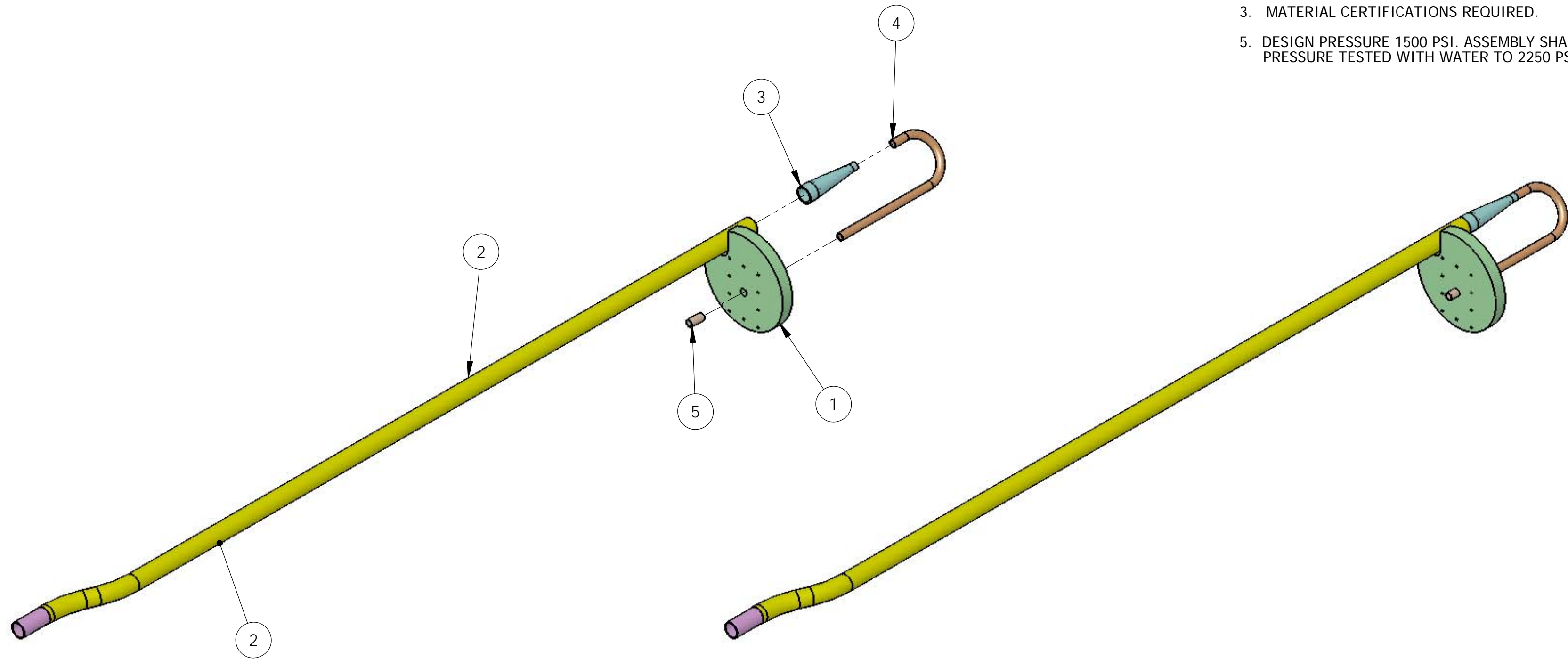
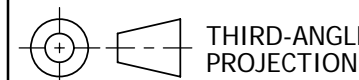


NOTES

1. WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.
5. DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.



ITEM	smalldiabend/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
5	1	hg nozzle hjt	SS - 316L, ASTM A269	RIGID SEAMLESS TUBE, 12MM OD X 1MM WALL X 1.000	N/A
4	1	tubing bend hjt	SS - 316L	SEAMLESS RIGID TUBING, 12MM OD X 1MM WALL	203-HJT-0625B
3	1	hg supply reducer hjt	SS - 316L, ASTM A276	FLOW REDUCER	203-HJT-0624A
2	1	hg primary supply assy	SS - 316L	RIGID SEAMLESS TUBE & PIPE	203-HJT-0623B
1	1	hg nozzle flange hjt	SS - 316L, ASTM A240	NOZZLE FLANGE	203-HJT-0622A



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

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.

DES	V GRAVES	02/06/2006
DRW	T OQUIN	02/17/2006
CHK	P SPAMPINATO	03/07/2006
ENG	V GRAVES	02/06/2006

**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

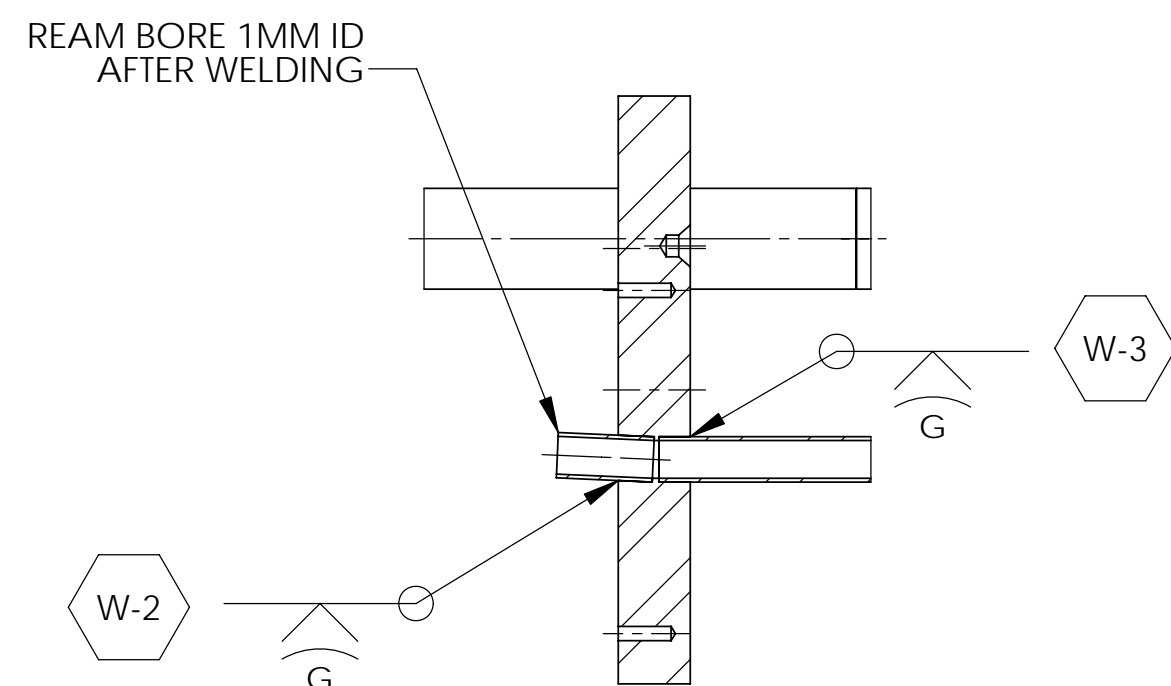
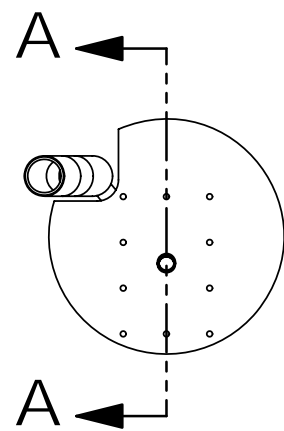
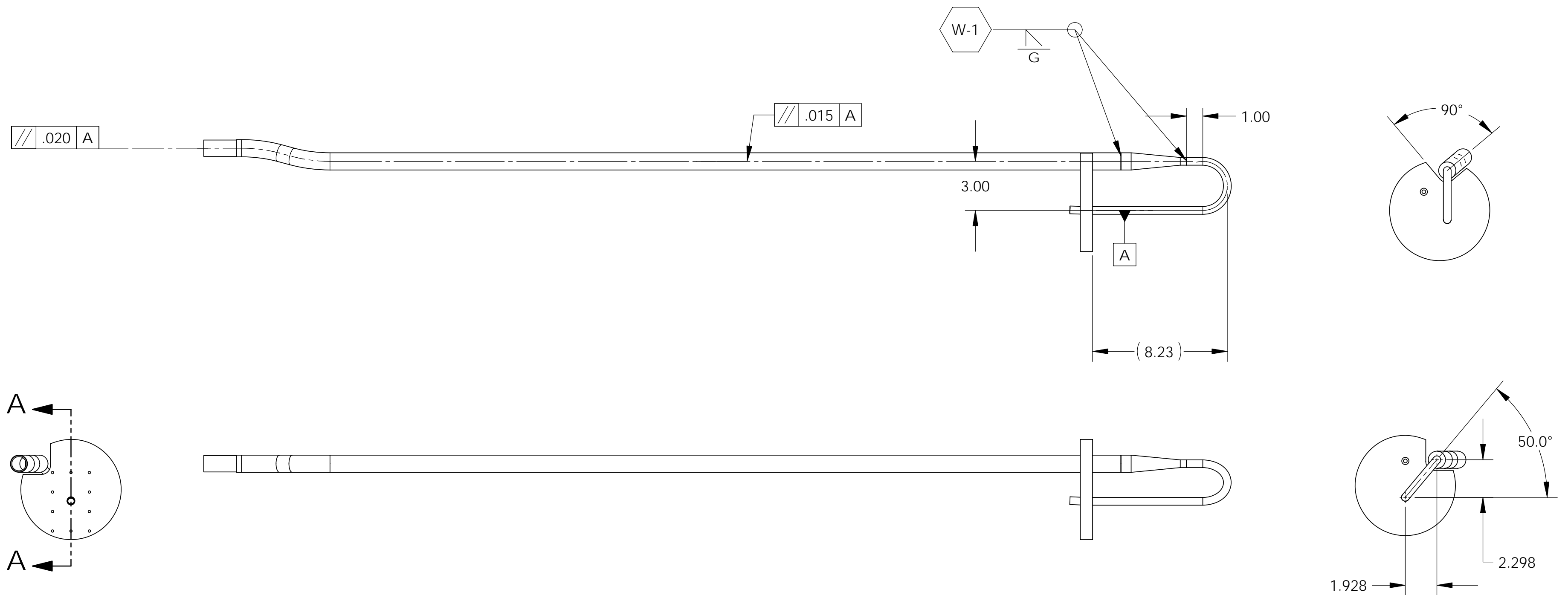
**MERIT EXPERIMENT  
PRIMARY TUBE ASSY  
HG SUPPLY ASSY**

CAD FILE	PREV ASSY	SCALE	SHEET
HG SUPPLY ASSY HJT	---	1:5	1 of 2
SIZE	DWG NO.	REV	
C	203-HJT-0620B	0	

DRAWING APPROVALS DATE

NOTES

1. WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NUMBER OF PIPE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.
5. DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.



SECTION A-A  
SCALE 1 : 2

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 $\pm 0.10$ TR 5. MACHINED ANGLES $\pm 1/2^\circ$ 6. FORMED ANGLES $\pm 1^\circ$ 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. X DECIMALS $\pm 0.030$ 9. XX DECIMALS $\pm 0.010$ 10. XXX DECIMALS $\pm 0.005$		DES V GRAVES 02/06/2006 DRW T OQUIN 02/17/2006 CHK P SPAMPINATO 03/07/2006 ENG V GRAVES 02/06/2006 QA - - -		<b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE & TECHNOLOGY DIVISION	
<b>DRAWING APPROVALS</b>		<b>DATE</b>		<b>CAD FILE</b> HG SUPPLY ASSY HJT	
<b>SIZE</b>		<b>DWG NO.</b>		<b>PREV ASSY</b> ---	
C		203-HJT-0620B		<b>SCALE</b> 1:12	
0		0		<b>SHEET</b> 2 of 2	