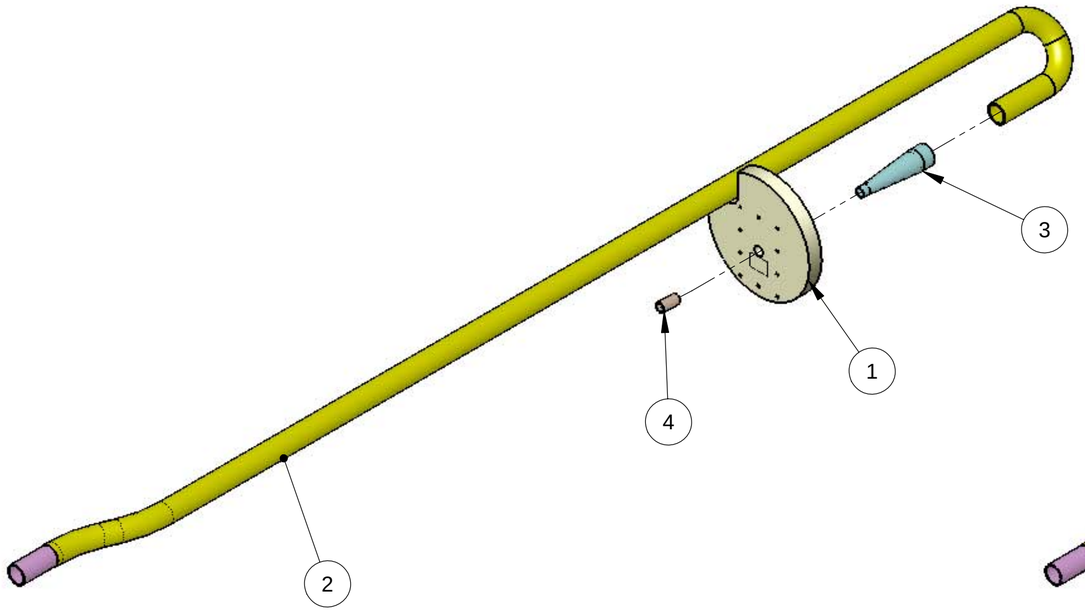
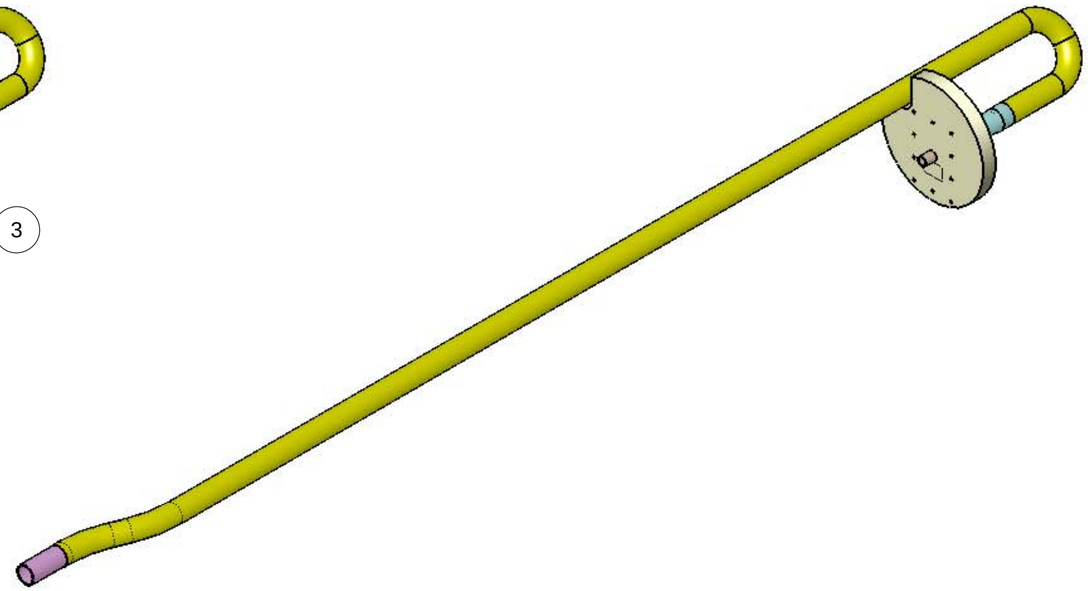
S THIS DRAWING PRODUCED ON SOLIDWORKS

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% RADIOGRAPHY REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.
4. ASSEMBLY SHALL BE ANODIZED PER AEROSPACE MATERIAL SPECIFICATION 2487 "ANODIC TREATMENT OF TITANIUM AND TITANIUM ALLOYS"
5. DESIGN PRESSURE 1500 PSI. ASSEMBLY SHALL BE PRESSURE TESTED WITH WATER TO 2250 PSI.
6. FOR PRESSURE TEST, INLET TUBE AND NOZZLE TIP SHALL BE FABRICATED 2-3 INCH LONGER THAN SHOWN. WILL BE CUT TO LENGTH DURING INSTALLATION.

△1





ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
4	1	hg nozzle hjt	TI GRADE 2, ASTM B-861	RIGID SEAMLESS TUBE, .500 OD X .065 WALL X 1.000	N/A
3	1	SS-16-TSW-6-8	TI-6AL-4V, ASTM B-348	FLOW REDUCER	203-HJT-0624
2	1	hg primary supply assy	TI GRADE 2, ASTM B-865	RIGID SEAMLESS TUBE & PIPE	203-HJT-0623
1	1	hg nozzle flange hjt	TI-6AL-4V, ASTM B-265	NOZZLE FLANGE	203-HJT-0622

REV	DESCRIPTION	DATE	BY	APPROVED
1	PRESSURE TEST CLARIFICATION	12/1/2006	VBG	VBG

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

DRAWING APPROVALS		DATE
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		
-	-	-

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

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	203-HJT-0610	1:5	1 of 2

SIZE	DWG NO.	REV
C	203-HJT-0620	1

DWG NO. 203-HJT-0620

S THIS DRAWING PRODUCED ON SOLIDWORKS

NOTES

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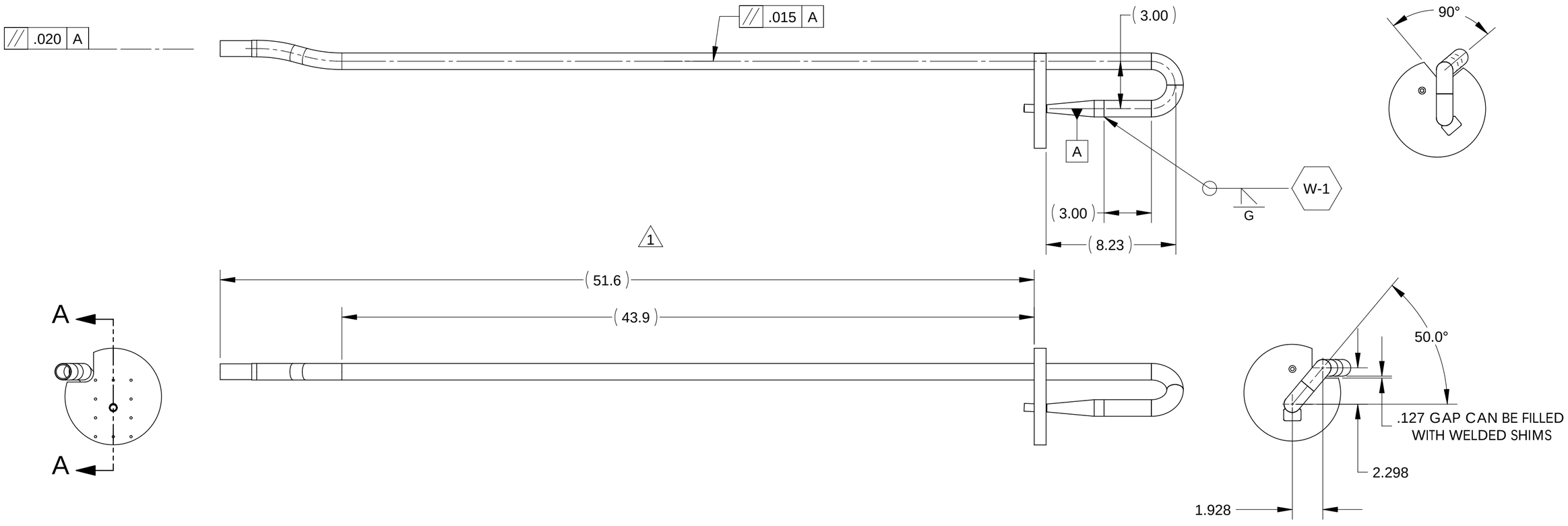

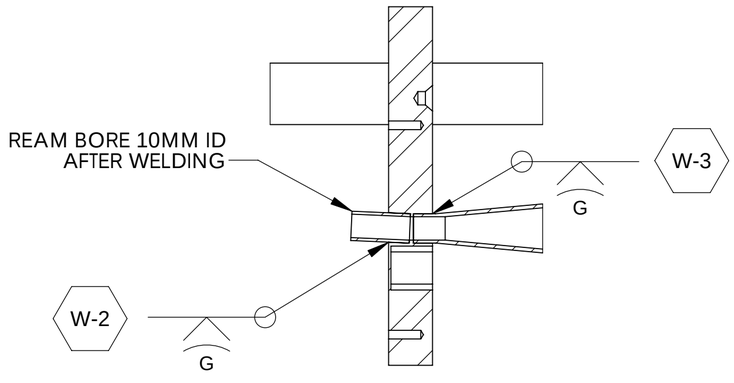

SECTION A-A
SCALE 1 : 2

THIRD-ANGLE PROJECTION

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8. X DECIMALS ±.030
9. XX DECIMALS ±.010
10. XXX DECIMALS ±.005

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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		
-	-	-
DRAWING APPROVALS		DATE

OAK RIDGE NATIONAL LABORATORY
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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	203-HJT-0610	1:12	2 of 2

SIZE	DWG NO.	REV
C	203-HJT-0620	1

DWG NO. 203-HJT-0620