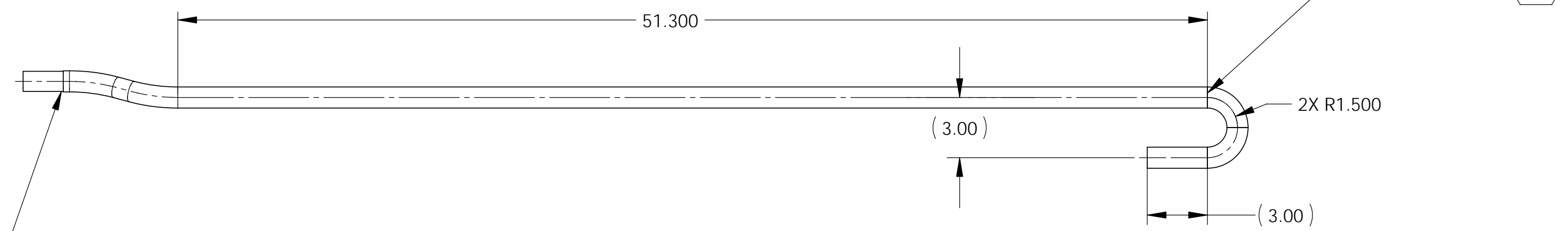
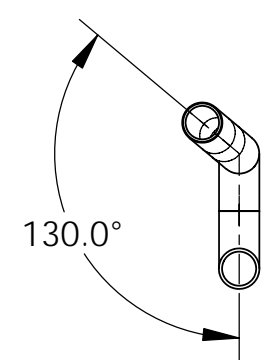
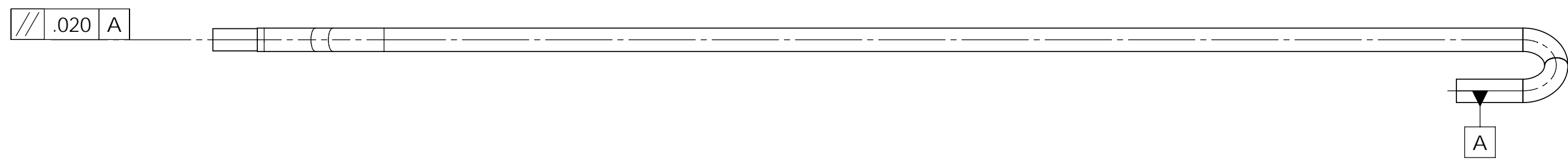
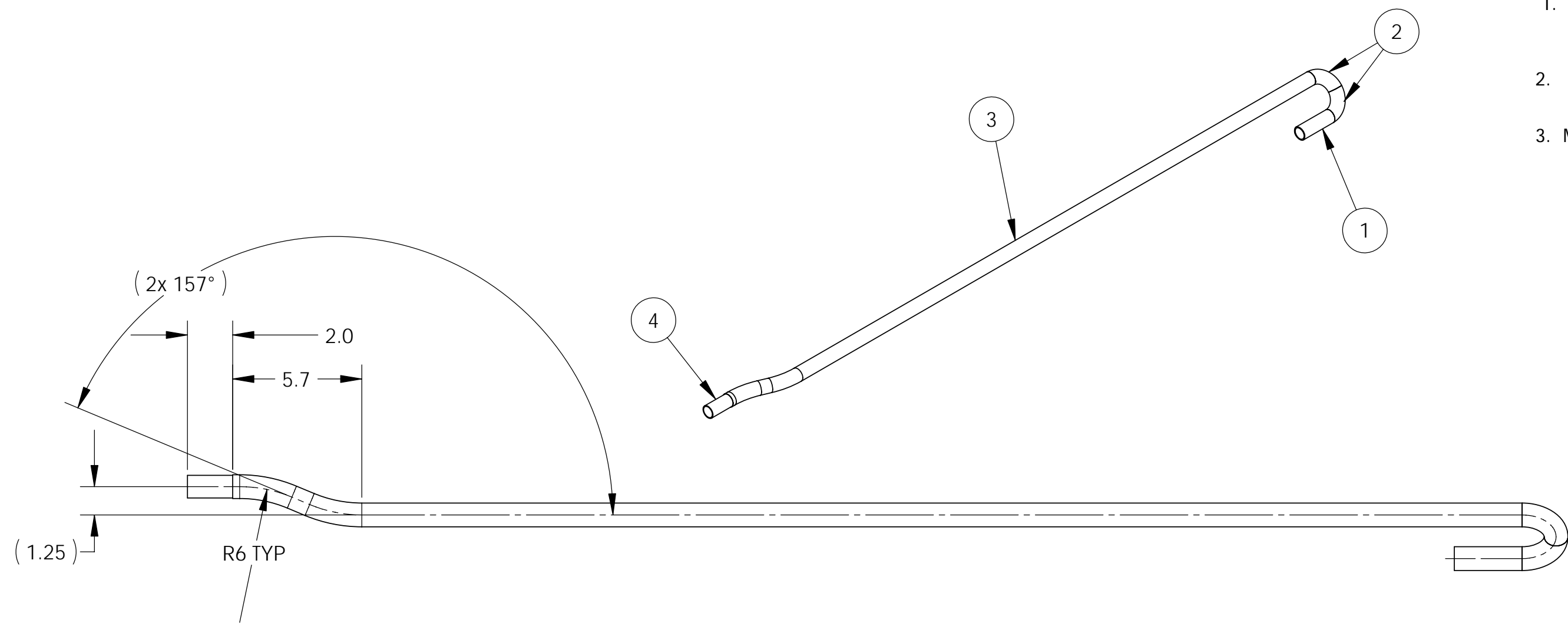


NOTES

1. WELDING AND INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. NUMBER OF TUBE BUTT WELDS SHOULD BE MINIMIZED. 100% DYE PENETRANT INSPECTION REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.



ITEM	Default/ QTY.	NAME	MATERIAL	DESCRIPTION	DWG
4	1	hg supply inlet hjt	SS 316L	RIGID SEAMLESS TUBE, 1.000 X .065 WALL X 2.000	N/A
3	1	hg supply line hjt	SS - 316L	RIGID SEAMLESS PIPE, 3/4" SCH10	N/A
2	2	hg supply elbow hjt	SS - 316L	RIGID SEAMLESS ELBOW, 3/4" SCH10	N/A
1	1	hg supply line hjt	SS - 316L	RIGID SEAMLESS PIPE, 3/4" SCH10	N/A

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

DRAWING APPROVALS DATE

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
HG PRIMARY TUBE ASSY
HG PRIMARY SUPPLY TUBE WELDMENT

CAD FILE	PREV ASSY	SCALE	SHEET
HG PRIMARY SUPPLY ASSY	203-HJT-0620A	1:5	1 of 1
SIZE	DWG NO.	REV	
C	203-HJT-0623A	0	