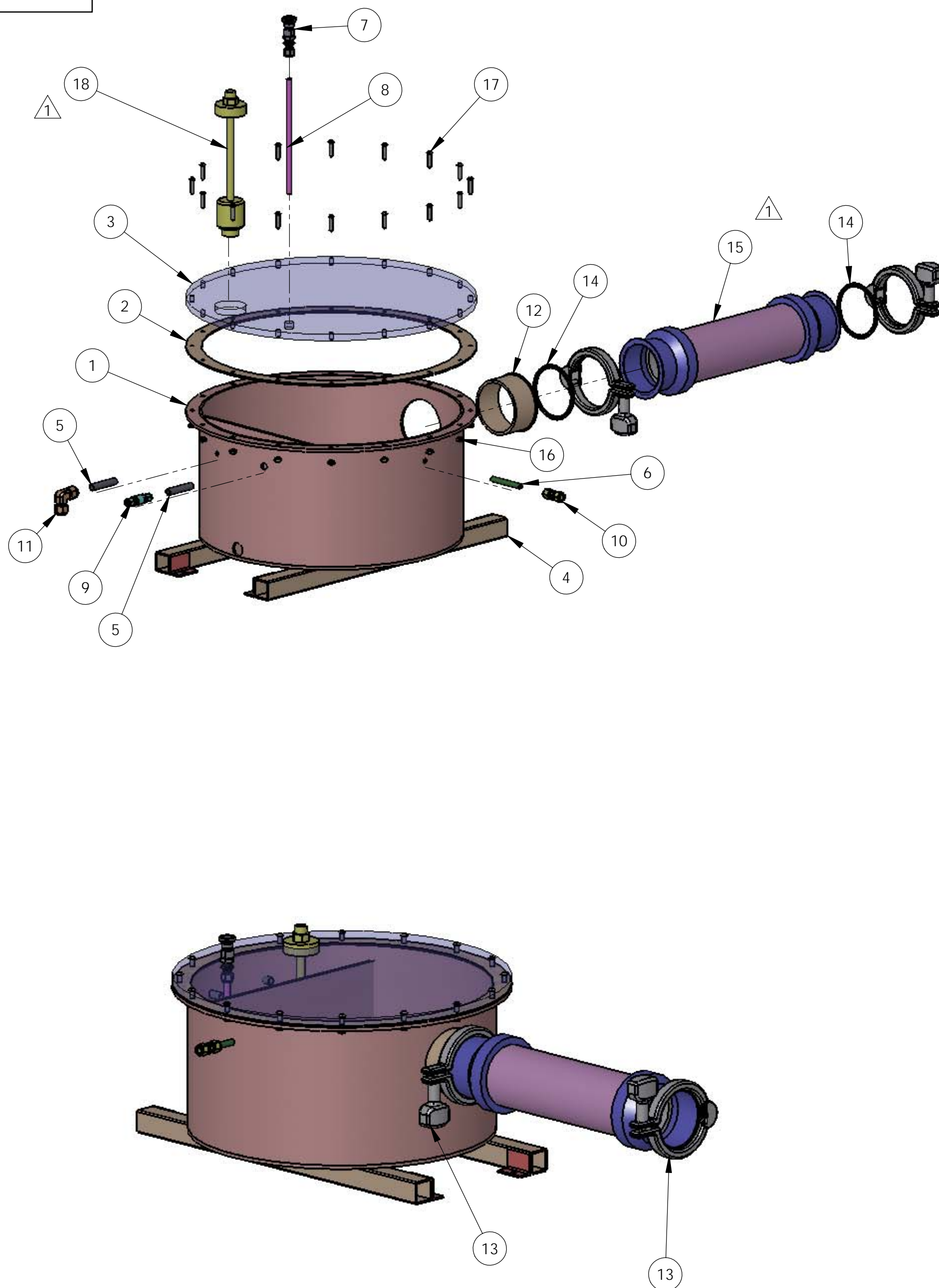


NOTES

1. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH ASME SECTION IX. NO CODE STAMP REQUIRED.
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED. NO RADIOGRAPHY REQUIRED.
3. MATERIAL CERTIFICATIONS REQUIRED.



ITEM	QTY	NAME	MATERIAL	DESCRIPTION	DWG
18	1	hg level sensor hjt	SS - 316	MADISON CO CONTINUOUS LEVEL SENSOR C3957-1033, 4-20 MA, WITH INTEGRATED RTD	N/A
17	16	socket button head cap screw_ai	SS - 18-8	BHCS - 1/4-20	N/A
16	16	PEM WNS-0420-0 ---N	SS - 18-8	PEM WELDNUT - 1/4-20	N/A
15	1	flex hose sanitary hjt	PTFE, SS-304	FLEXLINE 4.0" FLEX METAL HOSE W/SANITARY FLANGES, 61-400-6NT6NT-18.9, 18.9" FLANGE TO FLANGE	N/A
14	2	kwik-clamp gasket hjt	EPDM	SWAGELOK JC40E KWIK-CLAMP GASKET - 4"	N/A
13	2	Jensen Clamp #JC13HDR	SS - 304	JENSEN #JC13HDR - 4" CLAMP	N/A
12	1	tube4.0	SS - 304L	SWAGELOK JC14H - 4"	N/A
11	1	swagelok union elbow - 0.5	SS - 316	SWAGELOK UNION ELBOW SS-810-9	N/A
10	1	swagelok tubing union 0.375	SS 316	SWAGELOK 3/8 UNION, SS-600-6	N/A
9	1	swagelok chkvalve 0.375	SS 316	SWAGELOK CHECKVALVE SS-6C-1/3	N/A
8	1	hg straw hjt	SS - 304L, ASTM A269	.38" OD X .07 WALL, BEND TOWARDS DRAIN, FIELD FIT	N/A
7	1	swagelok qcbulkhead body 0.375	SS - 316	SWAGELOK BULKHEAD BODY W/PROTECTOR, SS-QC6-B1-600 & SS-QC6-BP	N/A
6	1	tubing	SS - 304L, ASTM A269	.38 OD x .07 WALL x 3.00 L	N/A
5	2	tubing	SS - 304L, ASTM A269	.50 OD x .07 WALL x 2.50 L	N/A
4	2	sump tank support hjt	SS - 304L, ASTM A-554	SUMP TANK SUPPORT	203-HJT-0647
3	1	sump tank cover hjt	LEXAN	SHEET, 22.00 OD X .50 THK, PROVIDED BY PRINCETON	203-HJT-0642
2	1	sump tank cover gasket hjt	1/8" BUNA-N SHEET, 50A	MCMaster-CARR #86715K869, PROVIDED BY PRINCETON	203-HJT-0643
1	1	sump tank hjt	SS - 304L	SUMP TANK	203-HJT-0641

REV	DESCRIPTION	DATE	BY	APPROVED
1	CHANGED HG LEVEL SENSOR AND HG RETURN HOSE	3/7/2006	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

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.

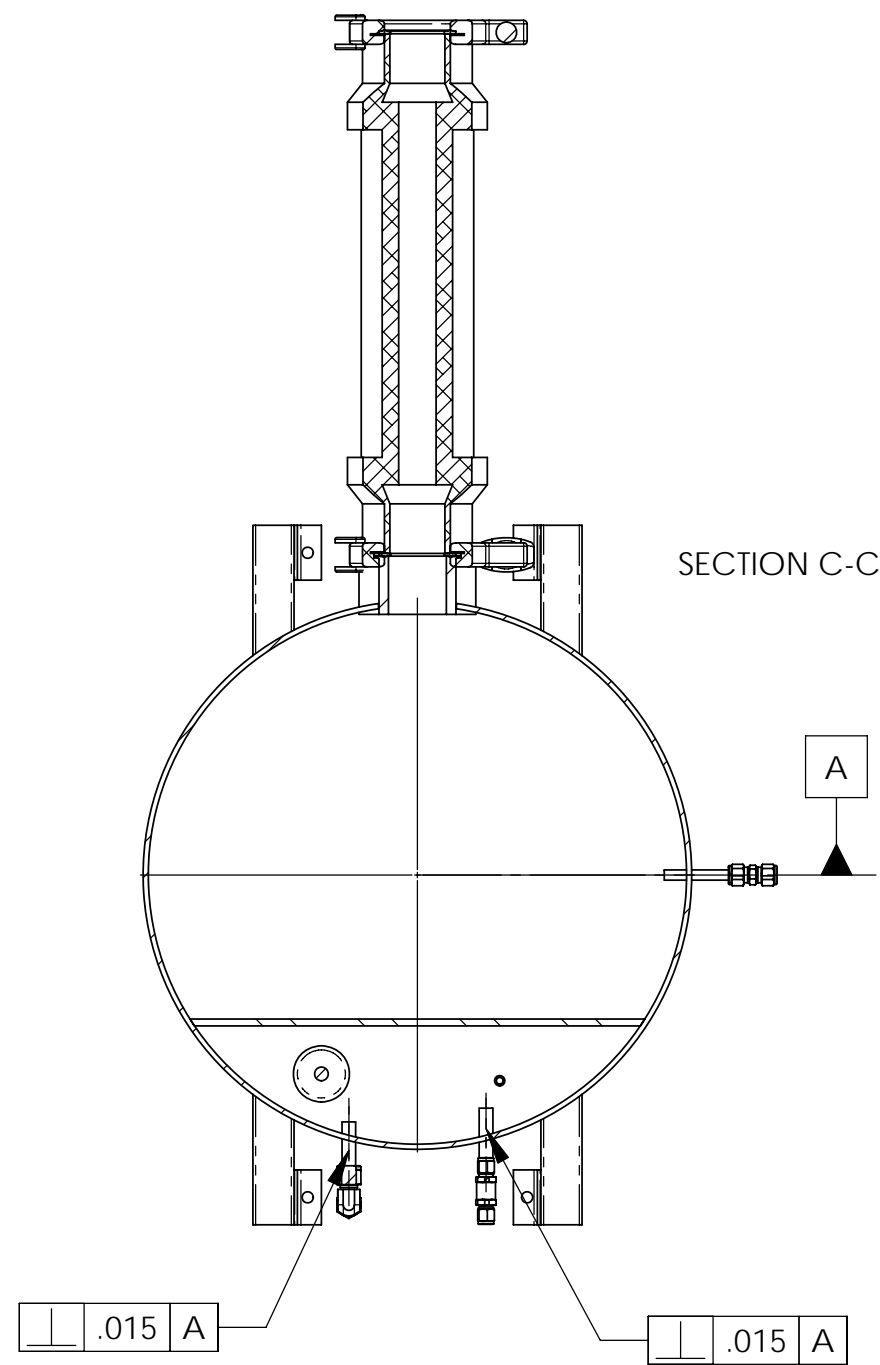
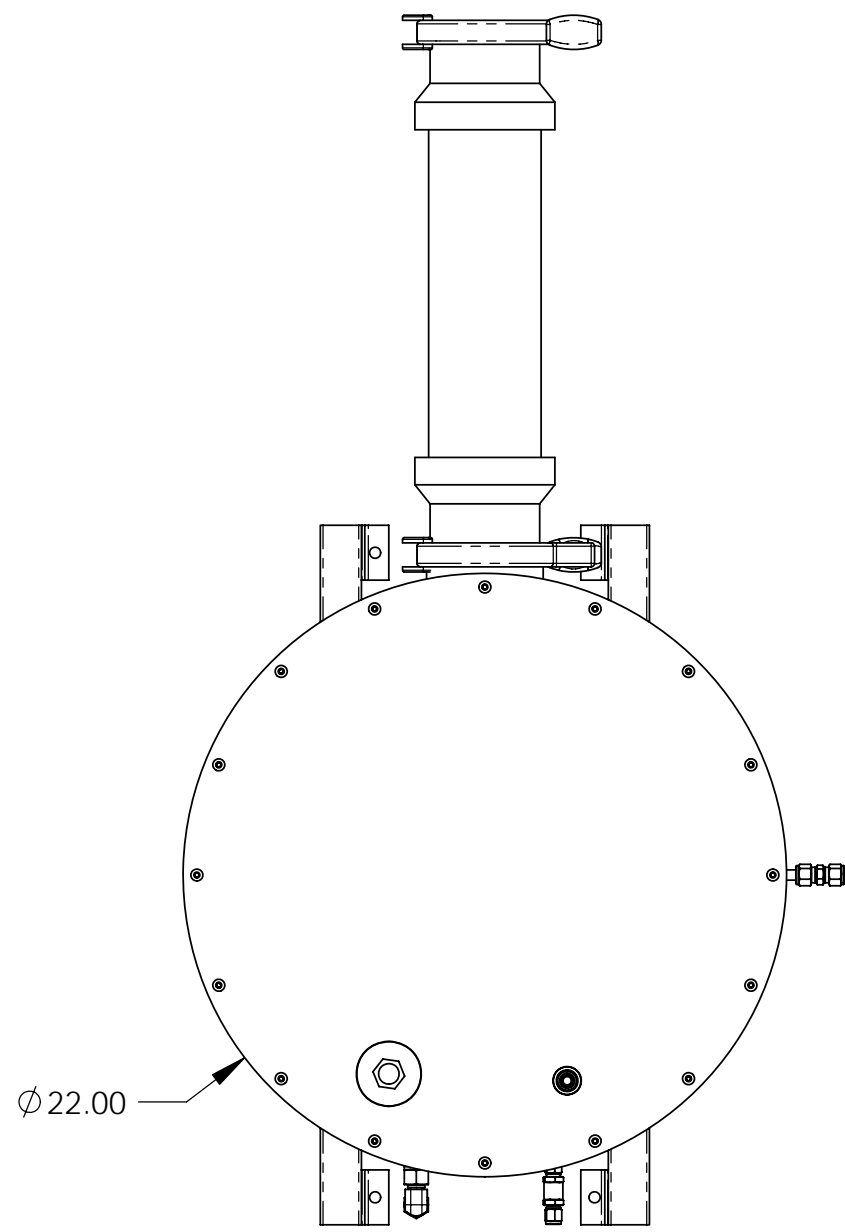
DES	V GRAVES	01/12/2006
DRW	T OQUIN	01/12/2006
CHK	P SPAMPINATO	01/31/2006
ENG	V GRAVES	01/12/2006
QA		

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

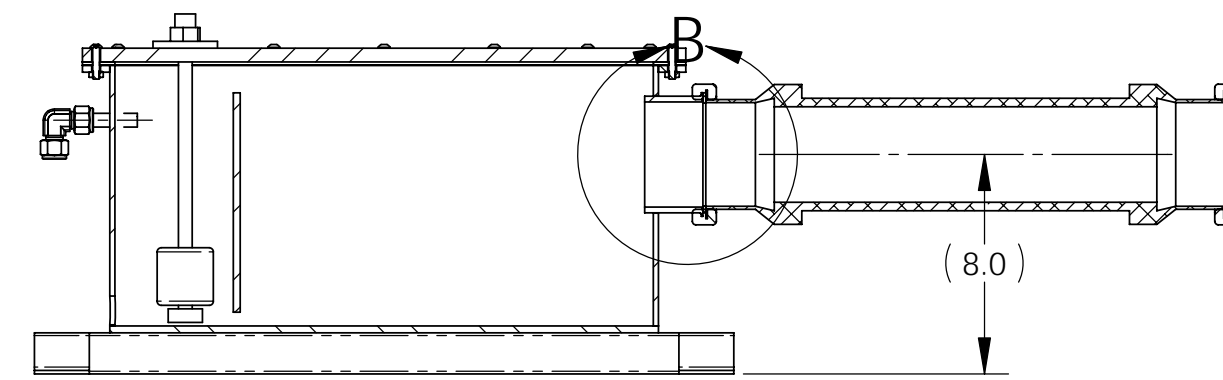
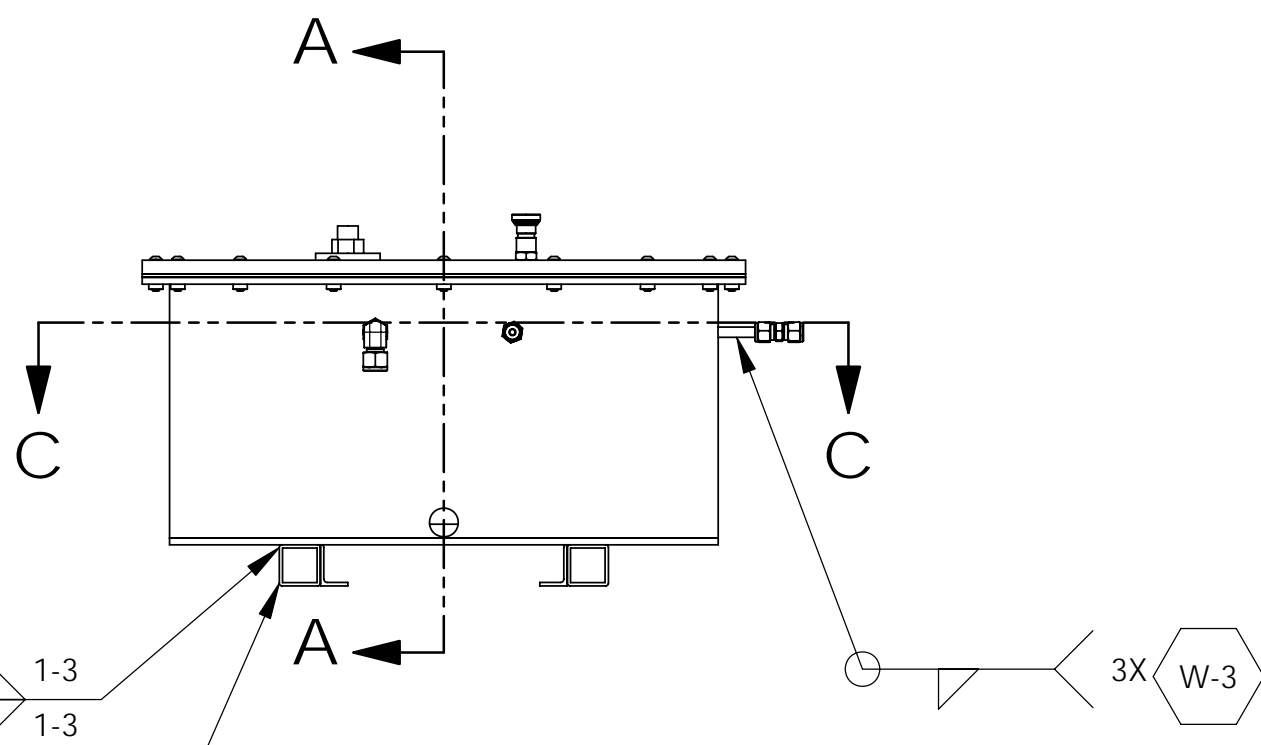
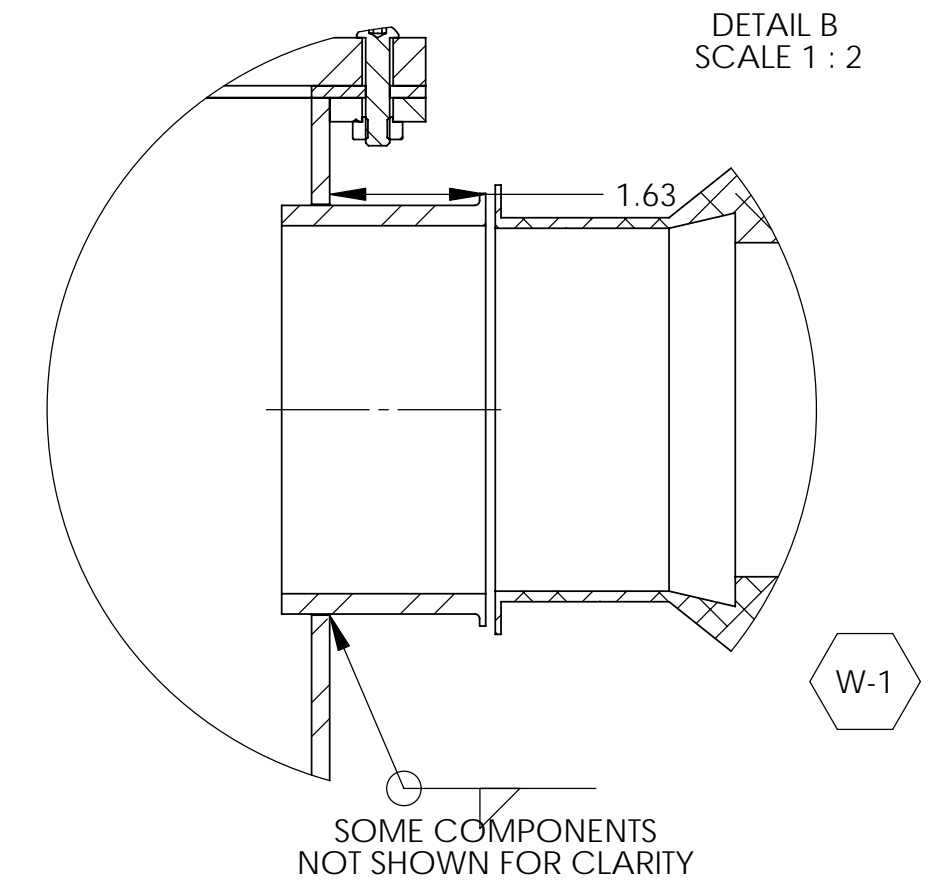
MERIT EXPERIMENT
HG SYRINGE ASSY
SUMP TANK ASSY

CAD FILE	PREV ASSY	SCALE	SHEET
SUMP TANK ASSY HJT	203-HJT-0600	1:6	1 of 2
SIZE	DWG NO.		REV
C	203-HJT-0640		1



NOTES

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SECTION A-A

BOLT SUMP TANK SUPPORTS TO TOP OF HG CYLINDERS PRIOR TO WELDING TO SUMP TANK !!!

<p>THIRD-ANGLE PROJECTION</p> <p>UNLESS OTHERWISE NOTED</p> <ol style="list-style-type: none"> 1. ALL DIMENSIONS ARE IN INCHES 2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M 3. MACHINED FINISH 125 MICRO-INCHES RMS 4. CONCENTRICITY ± 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. W HOLE NUMBERS AND FRACTIONS $\pm 1/16$ 9. X DECIMALS ± 0.030 10. XX DECIMALS ± 0.010 11. XXX DECIMALS ± 0.005 	<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 SYRINGE ASSY SUMP TANK ASSY</p>			
DES	V GRAVES	01/12/2006	CAD FILE	PREV ASSY	SCALE	SHEET
DRW	T OQUIN	01/12/2006	SUMP TANK ASSY HJT	203-HJT-0600	1:7	2 of 2
CHK	P SPAMPINATO	01/31/2006	SIZE	DWG NO.		REV
ENG	V GRAVES	01/12/2006	C	203-HJT-0640		0
QA			DRAWING APPROVALS	DATE		