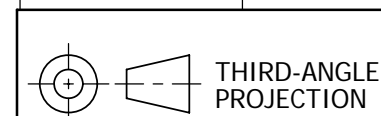


NOTES

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.
4. ALL WELDS TO BE WATERTIGHT EXCEPT THOSE ON SPLASH PLATE

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
4	1	PLATE, 8.00 x 16.58 x .25	SS - 304L, ASTM A240	16.58
3	1	PLATE, 22.00 OD x .25 THK	SS - 304L, ASTM A240	---
2	1	20-INCH SCH 10 PIPE x 9.50 L	SS - 304L, ASTM A240	20.00 DIA.
1	1	PLATE, 20.00 OD x .25 THK	SS - 304L, ASTM A240	---



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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

- 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

DES	V GRAVES	01/10/2006
DRW	T OQUIN	01/10/2006
CHK	P SPAMPINATO	01/31/2006
ENG	V GRAVES	01/10/2006
QA		

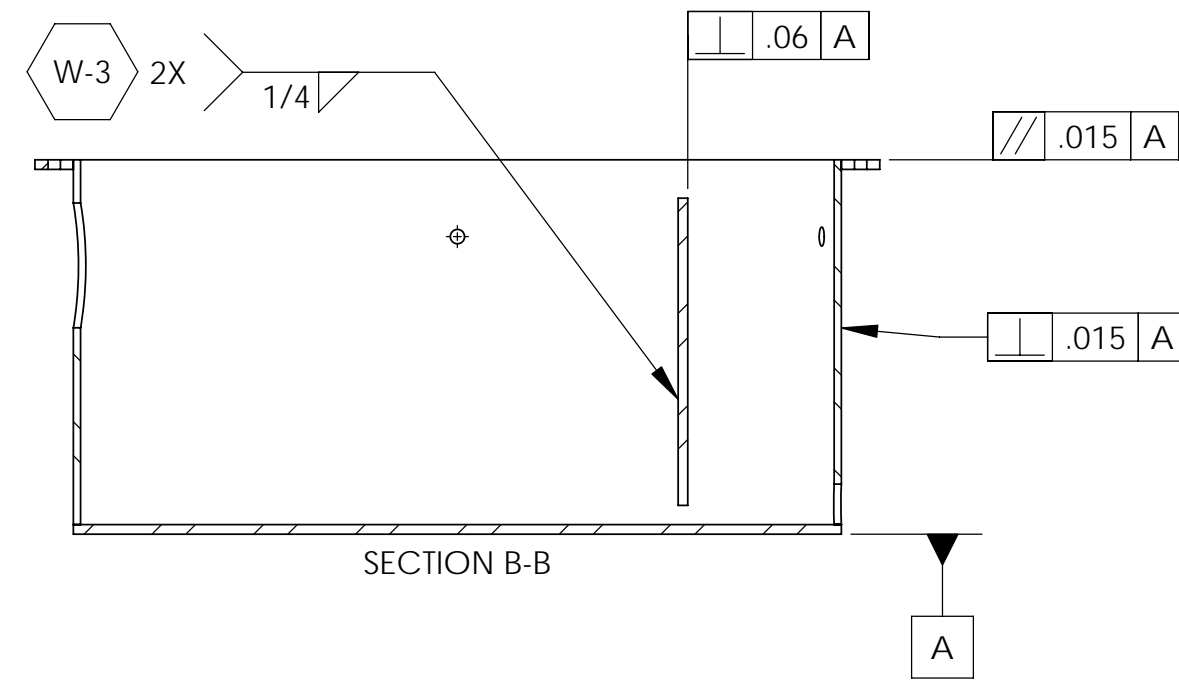
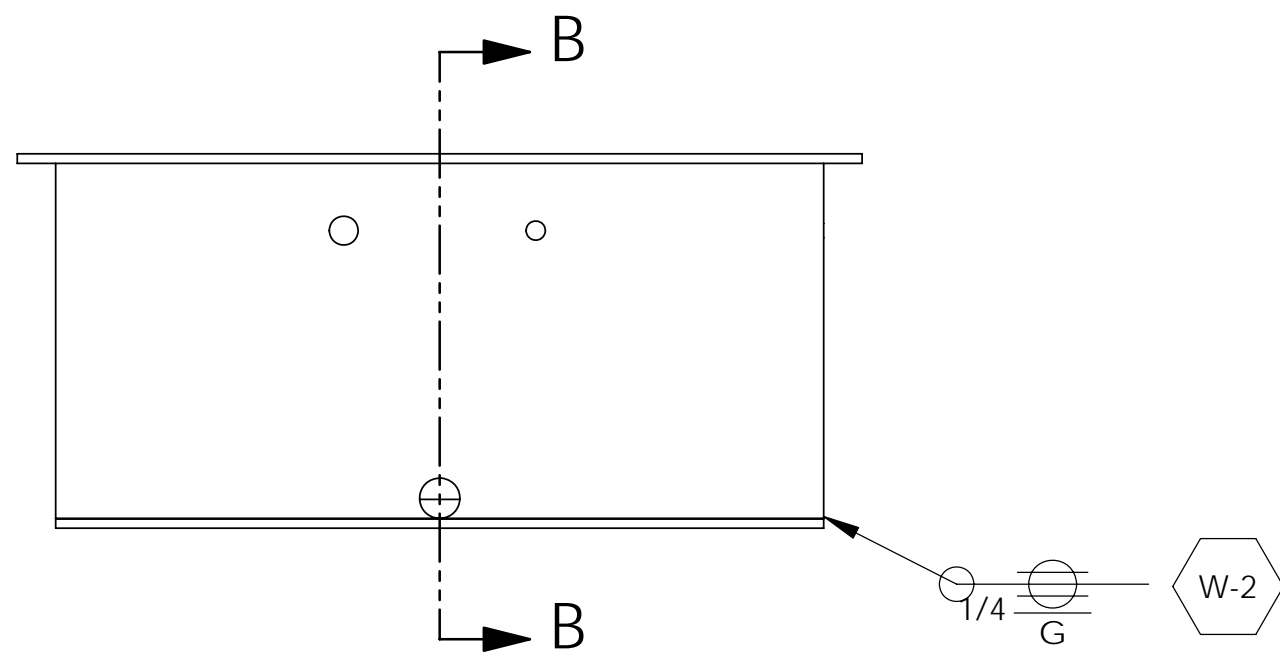
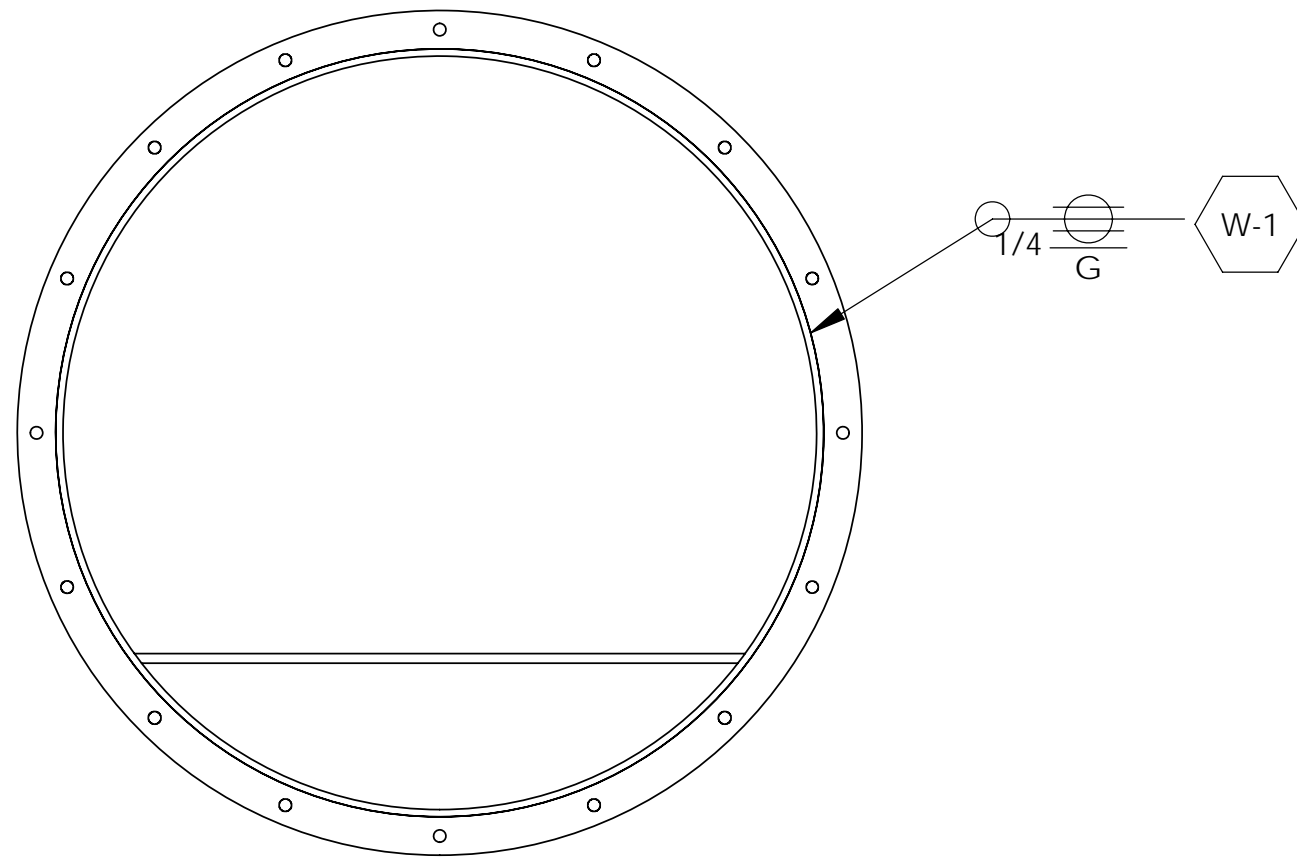
**MERIT EXPERIMENT
HG SYRINGE ASSY
SUMP TANK WELDMENT**

CAD FILE SUMP TANK HJT	PREV ASSY 203-HJT-0640	SCALE 1:5	SHEET 1 of 2
SIZE C	DWG NO. 203-HJT-0641	REV 0	

DRAWING APPROVALS DATE

NOTES

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<p>THIRD-ANGLE PROJECTION</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>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> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY ± 0.10 TR</p> <p>5. MACHINED ANGLES $\pm 1/2^\circ$</p> <p>6. FORMED ANGLES $\pm 1^\circ$</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. X DECIMALS ± 0.030</p> <p>9. XX DECIMALS ± 0.010</p> <p>10. XXX DECIMALS ± 0.005</p>			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>																					
<table border="1"> <tr><td>DES</td><td>V GRAVES</td><td>01/10/2006</td></tr> <tr><td>DRW</td><td>T OQUIN</td><td>01/10/2006</td></tr> <tr><td>CHK</td><td>P SPAMPINATO</td><td>01/31/2006</td></tr> <tr><td>ENG</td><td>V GRAVES</td><td>01/10/2006</td></tr> <tr><td>QA</td><td></td><td></td></tr> <tr><td>-</td><td>-</td><td>-</td></tr> </table>	DES	V GRAVES	01/10/2006	DRW	T OQUIN	01/10/2006	CHK	P SPAMPINATO	01/31/2006	ENG	V GRAVES	01/10/2006	QA			-	-	-	<p>MERIT EXPERIMENT HG SYRINGE ASSY SUMP TANK WELDMENT</p>			CAD FILE SUMP TANK HJT	PREV ASSY 203-HJT-0640	SCALE 1:4	SHEET 2 of 2
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