



NOTES

1. WELDING TO 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	1	HJNUT 0.5000-13-D-N	SS	HEX JAM NUT, 0.500 - 13	N/A
3	1	Socket Head Cap Screw_AI	SS - 18-8	SHCS 0.5-13 X 11.0	N/A
2	1	double window monitored	TITANIUM	UPSTREAM DOUBLE BEAM WINDOW	203-HJT-0712
1	1	sec contain weldment hjt	TI GRADE 2, ASTM B-265	SECONDARY CONTAINMENT TUBE	203-HJT-0711
ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

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

**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

DES	V GRAVES	06/09/2005
DRW	T OQUIN	06/09/2005
CHK		
ENG	V GRAVES	06/09/2005
QA		
DRAWING APPROVALS		DATE

CAD FILE SEC TUBE ASSY HJT		PREV ASSY 203-HJT-0700	SCALE 1:6	SHEET 1 of 1
		SIZE DWG NO.	REV B	
C		203-HJT-0710		

**MERIT EXPERIMENT  
SECONDARY TUBE ASSY**