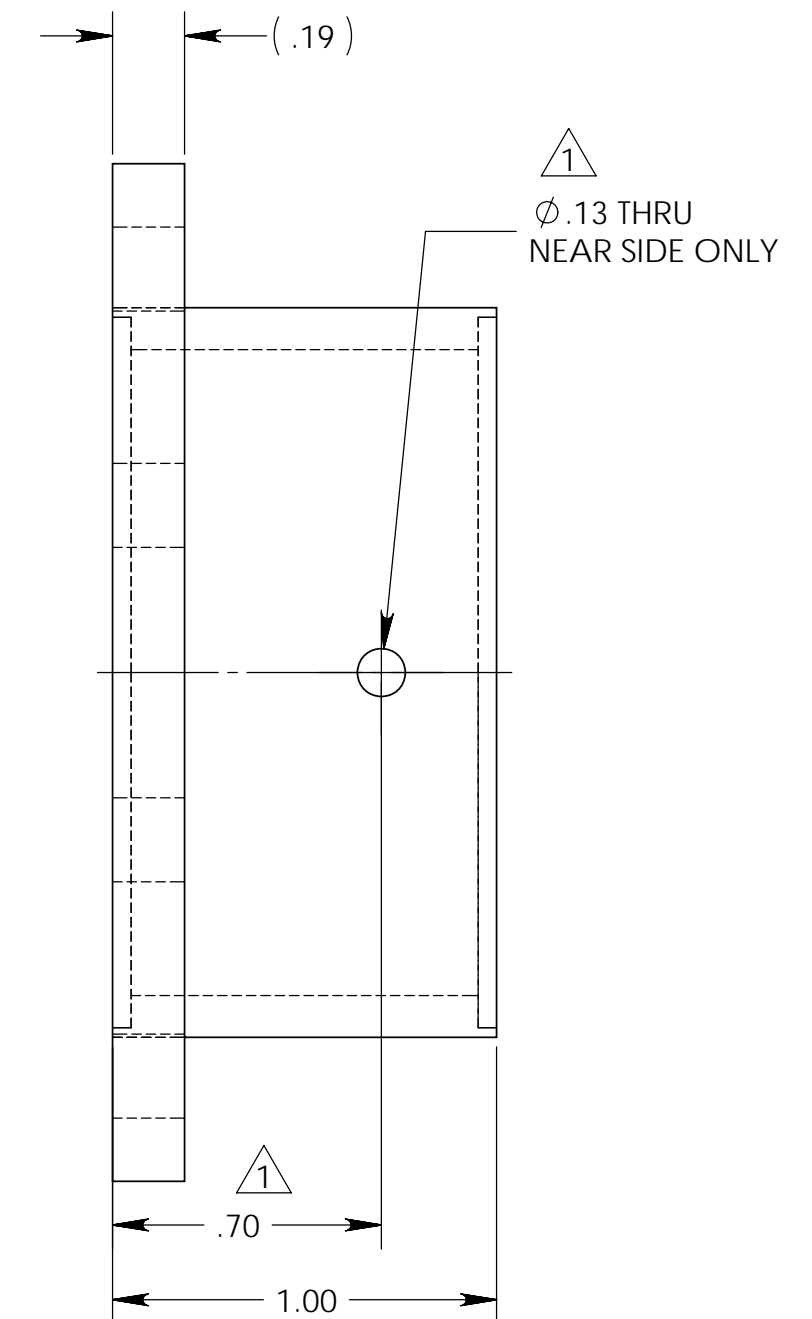
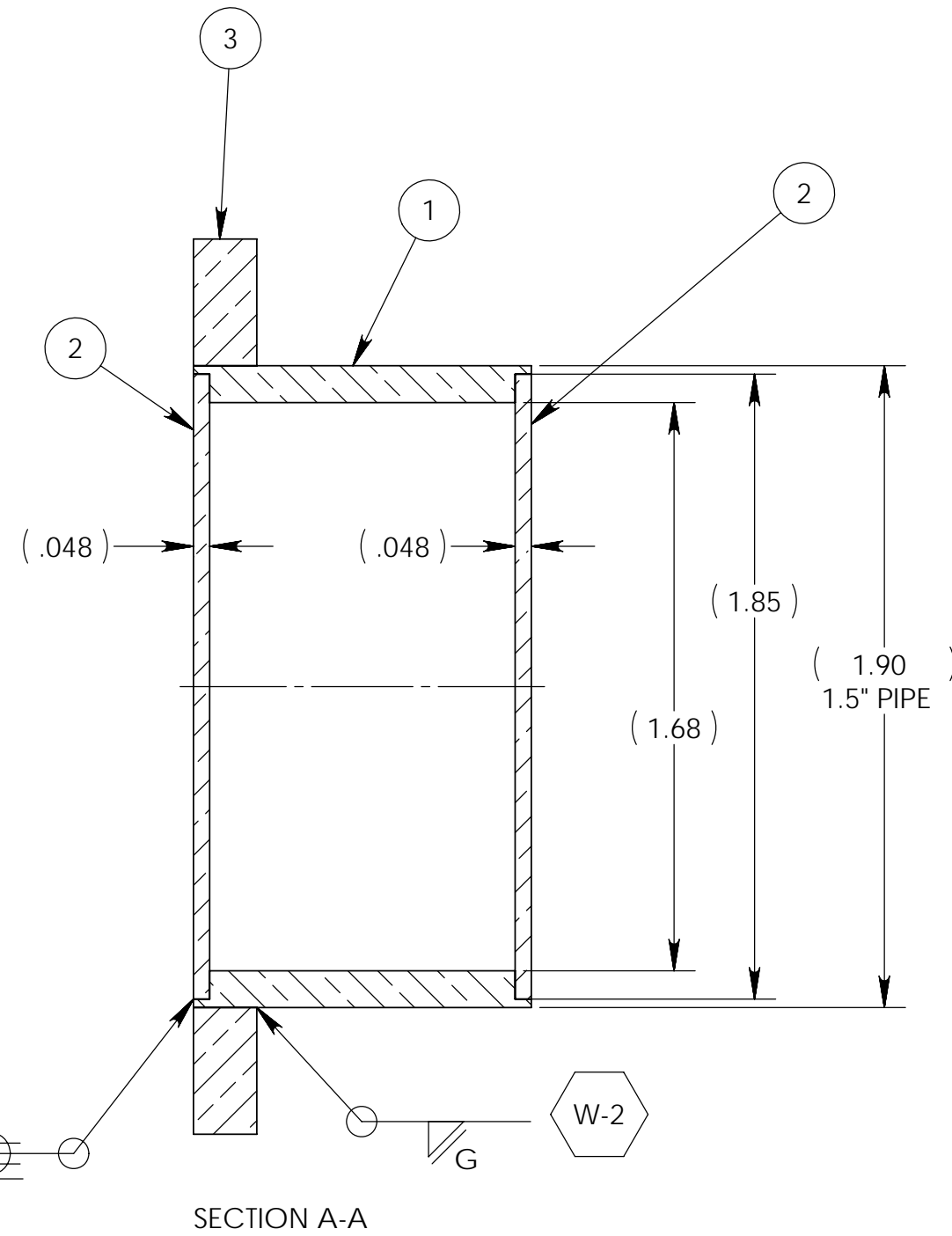
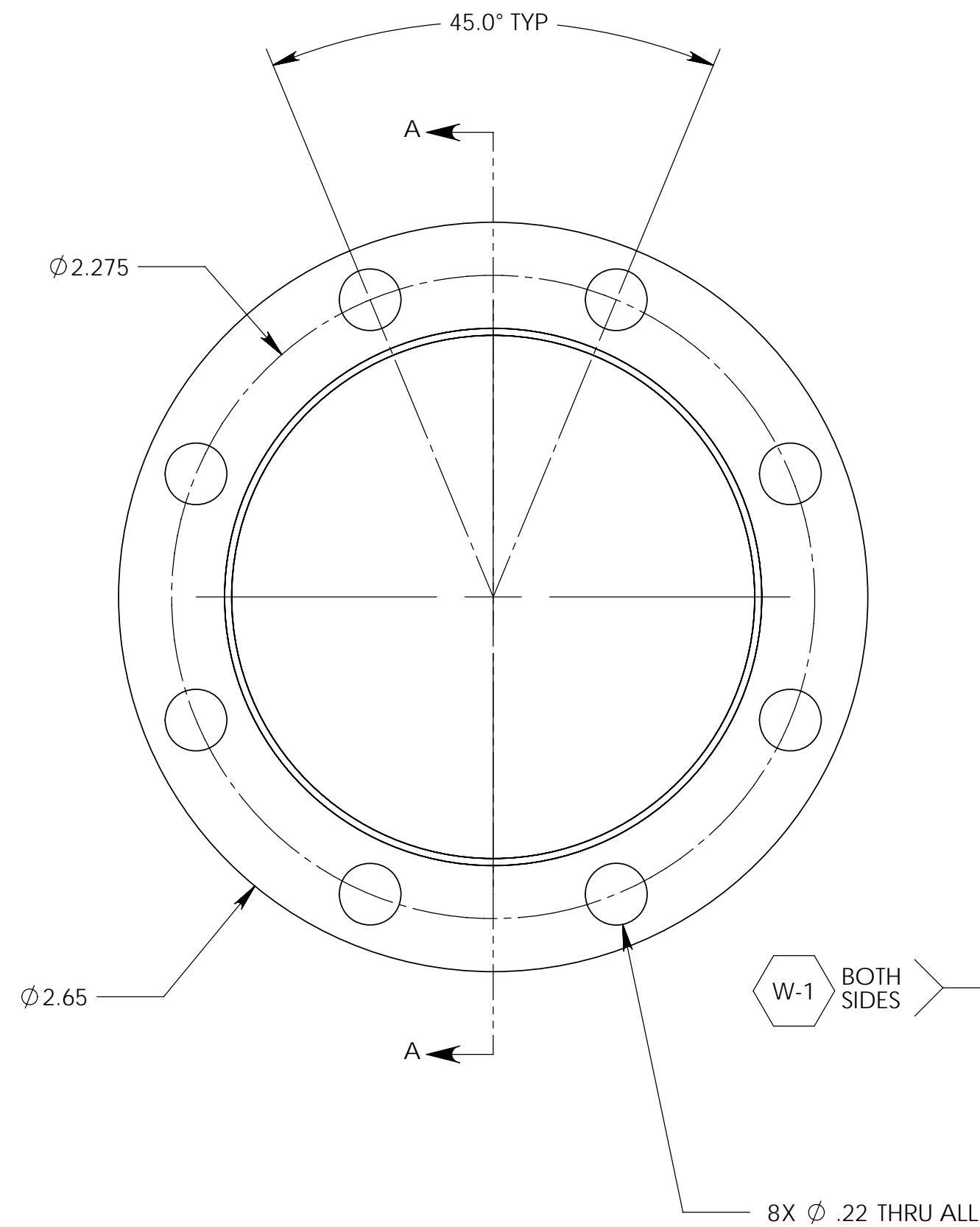


NOTES

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



ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
3	1	PLATE, 2.65 OD x .19 THK	TI GRADE 2, ASTM B-265	N/A
2	2	18GA SHEET, 1.85 OD	TI-6AL-4V, ASTM B-265	N/A
1	1	PIPE, SCH 10	TI GRADE 2, ASTM B-265	1.00

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 $\pm 1/2^\circ$
6. FORMED ANGLES $\pm 1^\circ$
7. BREAK SHARP CORNERS AND REMOVE ALL BURRS
8. X DECIMALS $\pm .030$
9. XX DECIMALS $\pm .010$
10. XXX DECIMALS $\pm .005$

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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

REV	DESCRIPTION	DATE	BY	APPROVED
1	MODIFIED TUBING HOLE	8/11/2006	VBG	VBG

DES	V GRAVES	09/26/2005
DRW	T OQUIN	09/26/2005
CHK	P SPAMPINATO	01/17/2006
ENG	V GRAVES	09/26/2005
QA		
-	-	-

MERIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
DBL WINDOW WELDMENT - UPSTREAM

CAD FILE	PREV ASSY	SCALE	SHEET
DOUBLE WINDOW HJT	203-HJT-0712	2:1	1 of 1
SIZE	DWG NO.		REV
C	203-HJT-0713		1