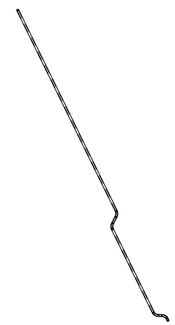
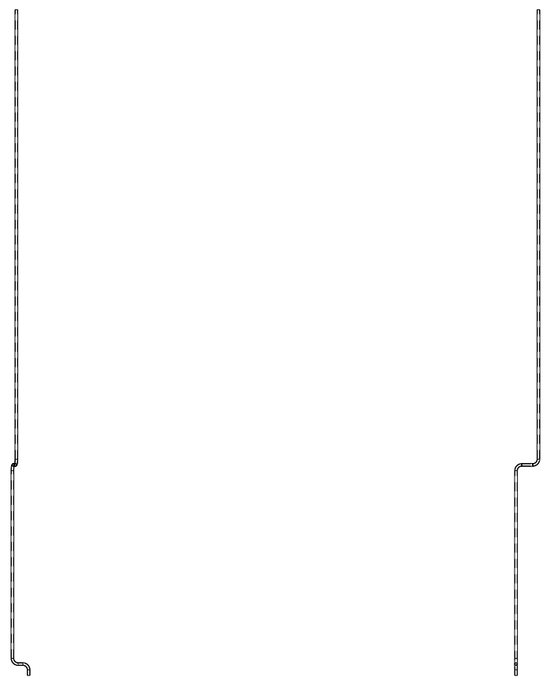
NEXT ASS'Y: FINAL ASS'Y:

NOTES

1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.



SCALE 0.090



SCALE 0.125

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	NEXT ASSEMBLY	PARTS LIST			

0000000000M 8E8700A000 -1

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE SNS-TS-G002

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
303	MATERIAL MILL TEST REPORT	-
325	MATERIAL SELLER CERT	-
326	SPECIAL MATERIAL INSPECTION REPORT	-
205	MANUFACTURING, INSPECTION, AND TEST PLAN	-
312	FIELD INSPECTION AND TEST PLAN	-
321	WELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (WICHART)	-
310	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	-
330	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

* SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

QA REP DATE

RPE

REV. XX DATE XX/XX/XX

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PRELIMINARY

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM___XXXX___
SNS PROCEDURE___XXXX___

REV	CHANGE TYPE	CHANGE CONTROL SYSTEM	ASSIGNED SUBJECT	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
				REVISION OR ISSUE PURPOSE				REVISION APPROVALS				

SCALE AS NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES	DMW/MEP	07/16/01
DRW	M.E.PHILLIPS	07/16/01
CHK		
L3		
L2		

DRAWING APPROVALS DATE

ornl Oak Ridge National Laboratory
operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725
Oak Ridge, Tennessee

SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
FACILITY CORE VESSEL INSERTS
XXX

BLDG	FL	SHT	OF	CLASS
8700	1ST	1	1	U

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