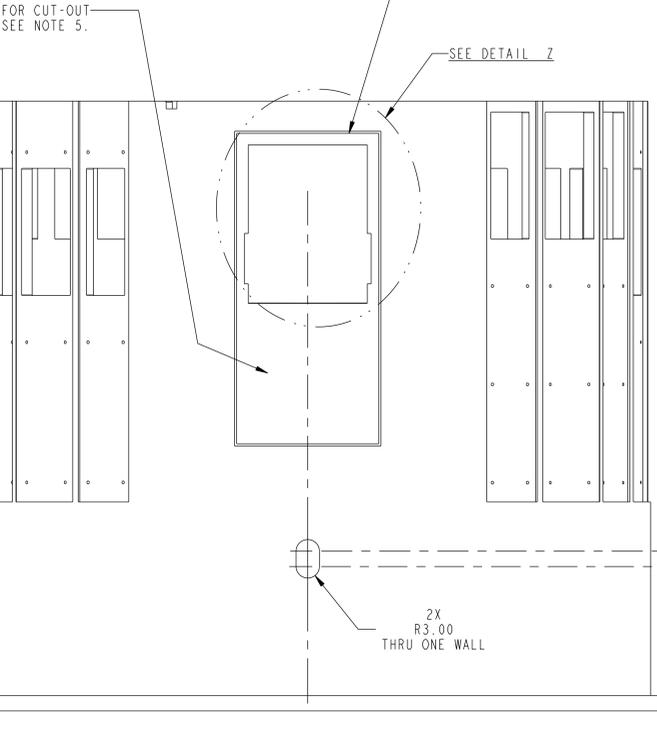
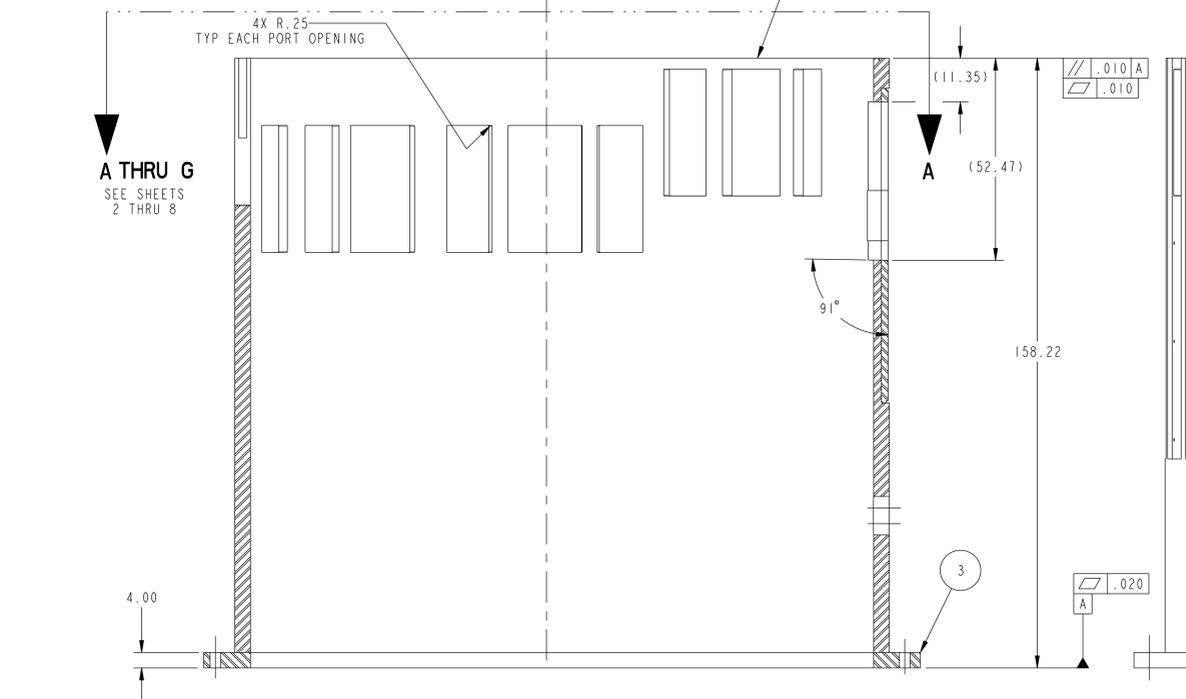
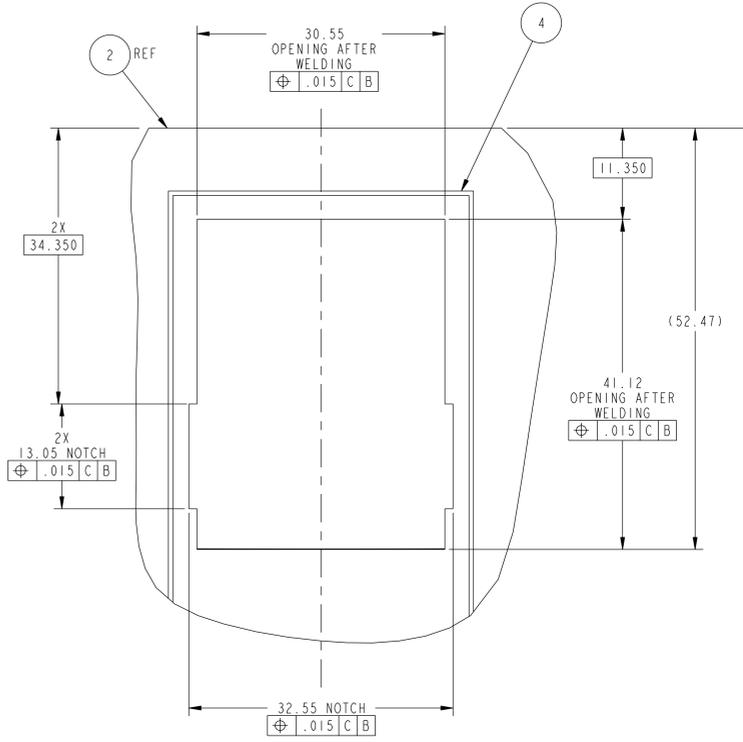


- NOTES** (UNLESS OTHERWISE SPECIFIED.)
1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL, LATEST REVISION.
 2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M, LATEST REVISION.
 3. DIMENSIONS ARE IN INCHES.
 4. SEE SNS EQUIP. SPECIFICATION #106040100-EQ0002 FOR REQUIREMENTS FOR MATERIALS OF CONSTRUCTION, FABRICATION, INSPECTION, TESTING AND DELIVERY.
 5. ALL TOOL RADIUS SHALL BE .030 MAX. UNLESS OTHERWISE SPECIFIED.
 6. SELLER SHALL PROVIDE FOR ALL WELD PREPARATIONS OR CLEARANCES BETWEEN PARTS AS REQUIRED UNLESS OTHERWISE SPECIFIED.



CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	106040101M8E8700A004-4	TARGET PORT PLATE	S31603	ASTM A 240	4
	106040101M8E8700A004-3	SUPPORT CYLINDER BOTTOM FLANGE	K02596	ASTM A 36	3
	106040101M8E8700A004-2	LOWER SUPPORT CYLINDER	K02596	ASTM A 36	2
	106040101M8E8700A004-1	OUTER SUPPORT CYLINDER WELDMENT	---	---	1

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
000	-	3					10/01/01			

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

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P THIS DRAWING PRODUCED ON PRO-ENGINEER
THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM...3...
SNS PROCEDURE SNS-TS-G001

SCALE .06
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.02
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES OR MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES	DA EVERITT	12/11/00
DRW	RON TAYLOR	12/11/00
CHK	KK CHIPLEY	10/01
L3	DA EVERITT	12/02/01

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

Spallation Neutron Source

**TARGET SYSTEMS
CORE VESSEL
OUTER SUPPORT CYLINDER WELDMENT**

BLDG 8700 FL SHT 1 OF 9 CLASS U
REV 000

106040101M8E8700A004

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FINAL ASS'Y:

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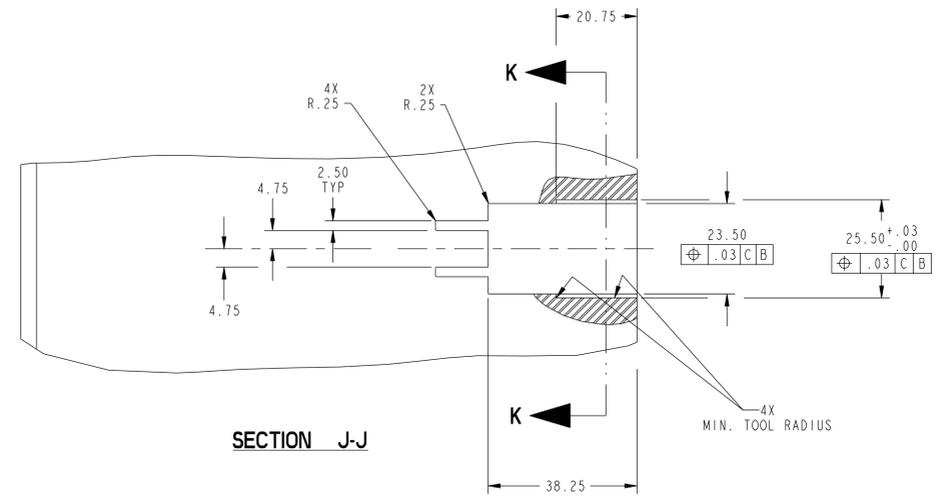
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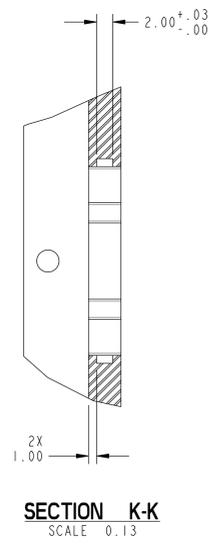
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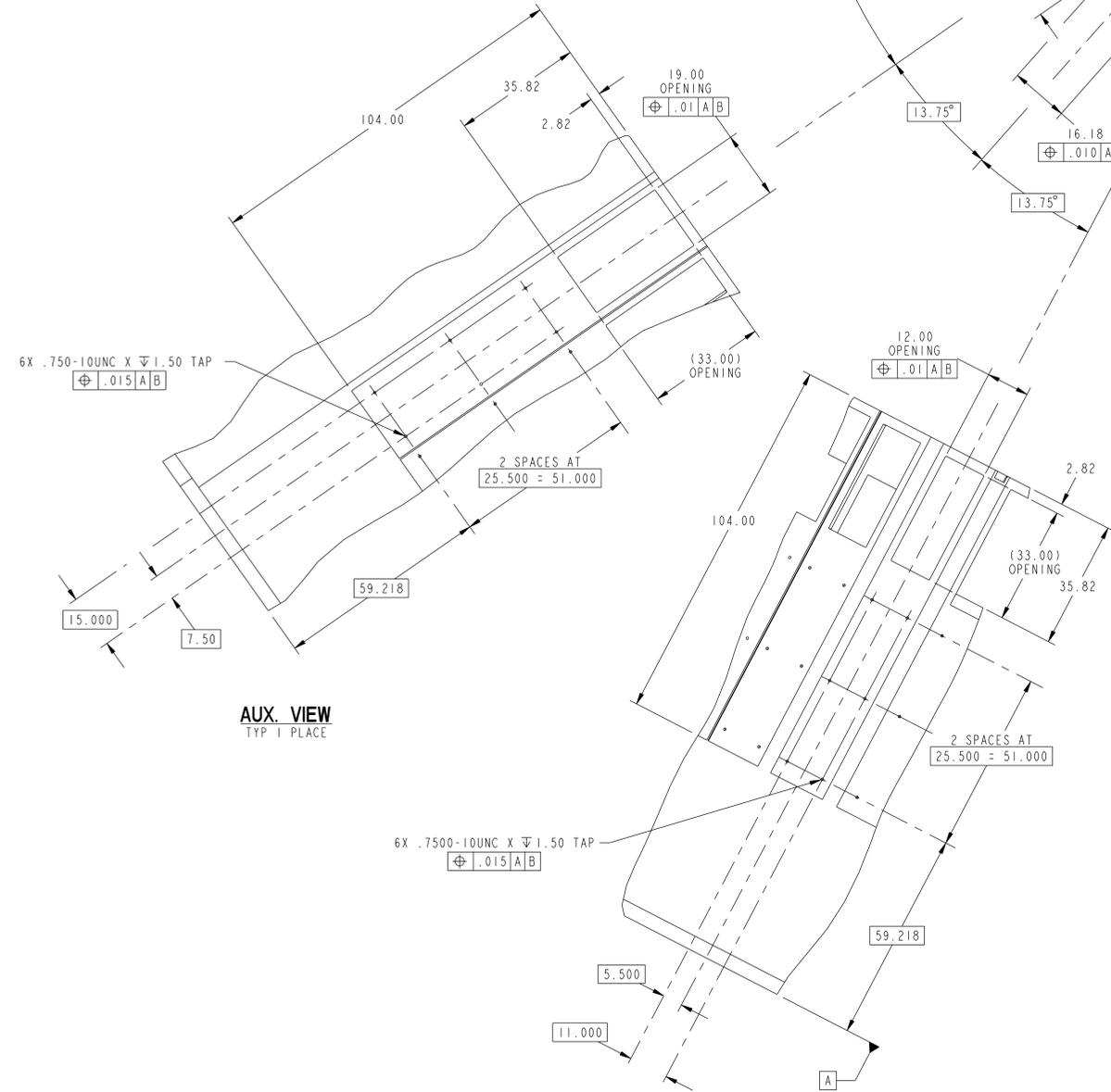
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SECTION J-J

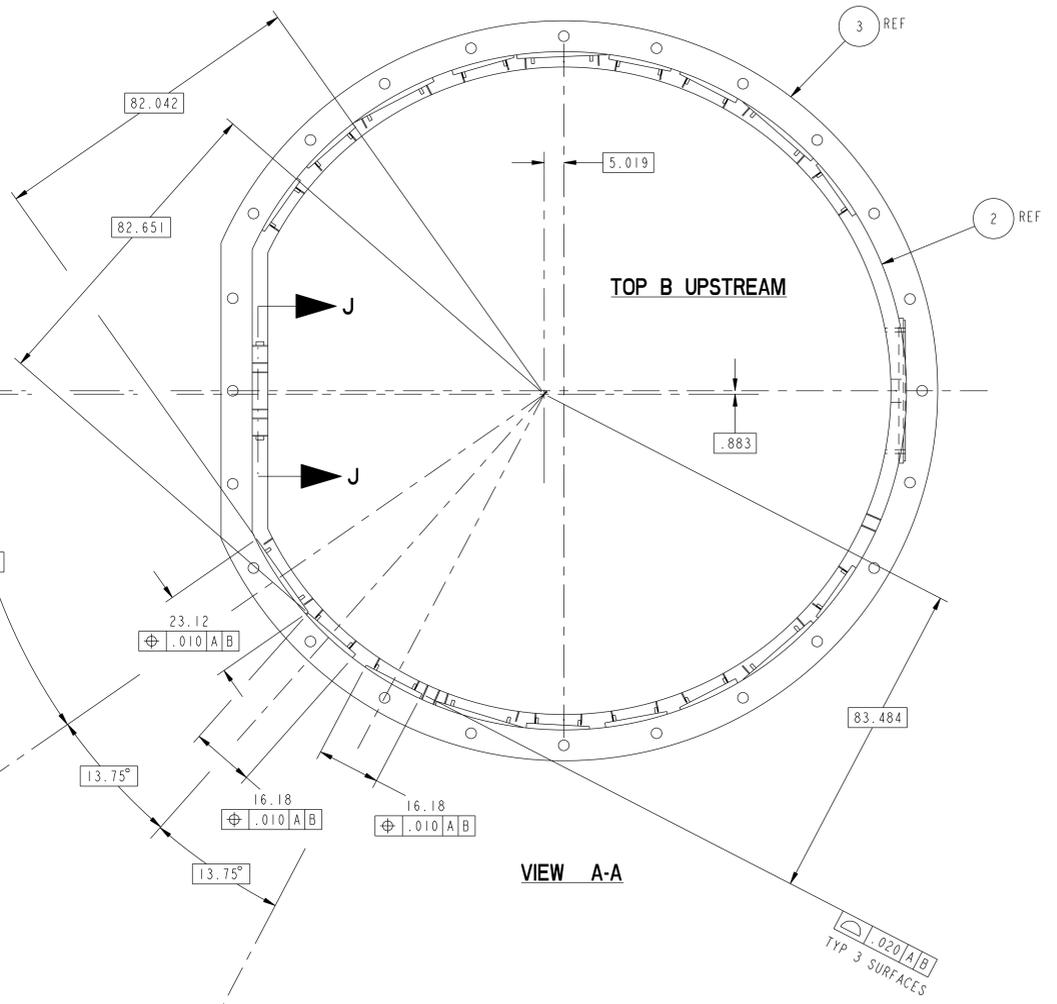


SECTION K-K
SCALE 0.13



AUX. VIEW
TYP 1 PLACES

AUX. VIEW
TYP 2 PLACES



VIEW A-A

TOP B UPSTREAM

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TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTIONS : XX DECIMALS ± .02 XXX DECIMALS ± .005 ANGLES ± 0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	
TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT	
BLDG 8700	FL SHT OF CLASS 2 9 U
106040101M8E8700A004	
REV 000	

106040101M8E8700A004

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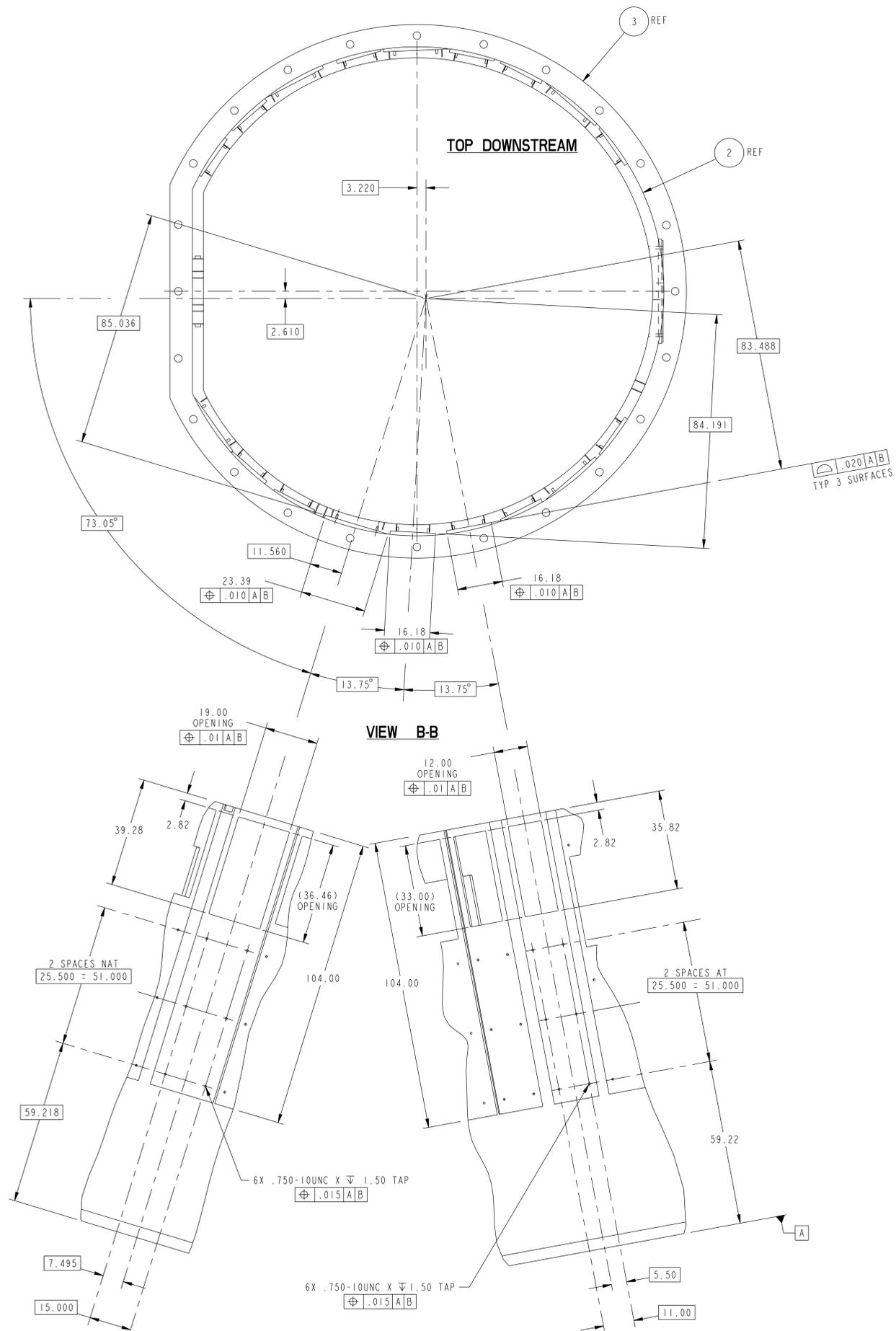
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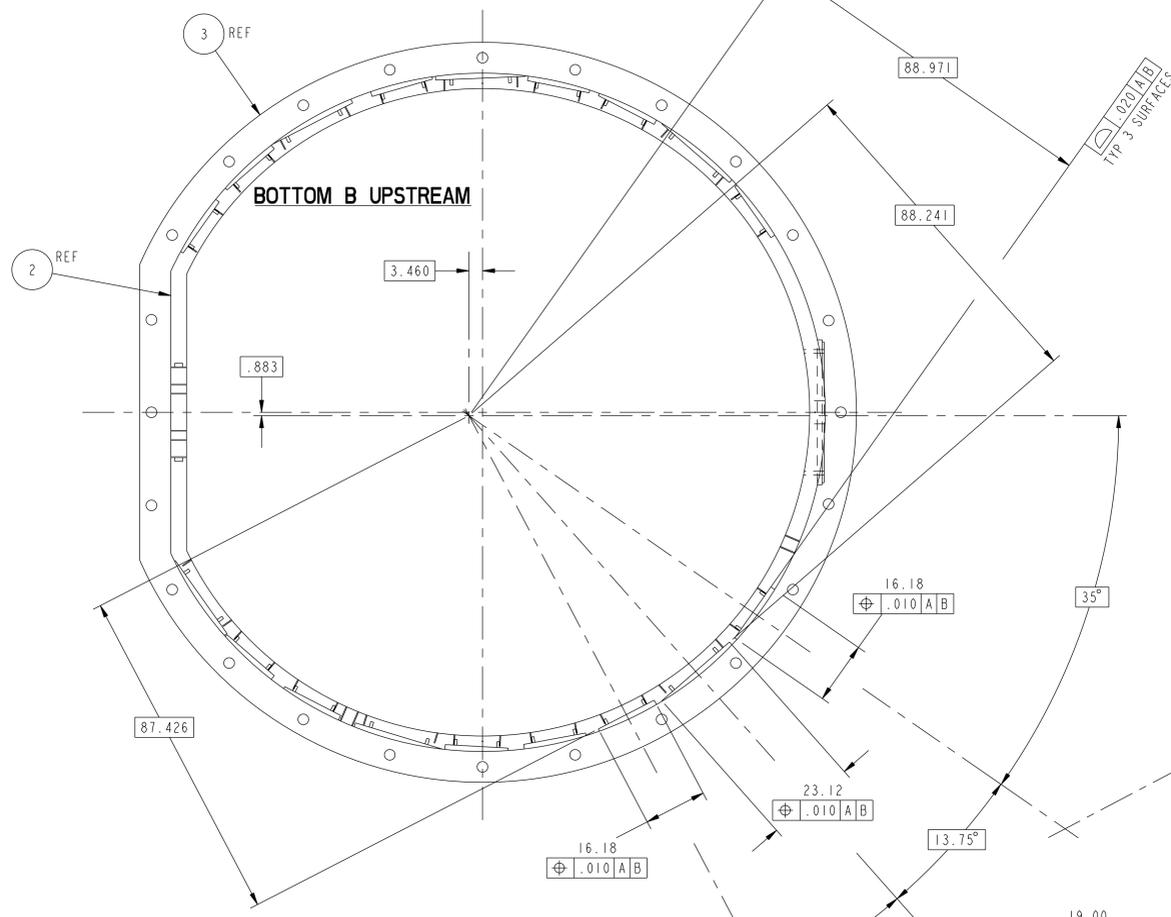
P THIS DRAWING PRODUCED ON PRO-ENGINEER

AUX VIEW
TYP 1 PLACE

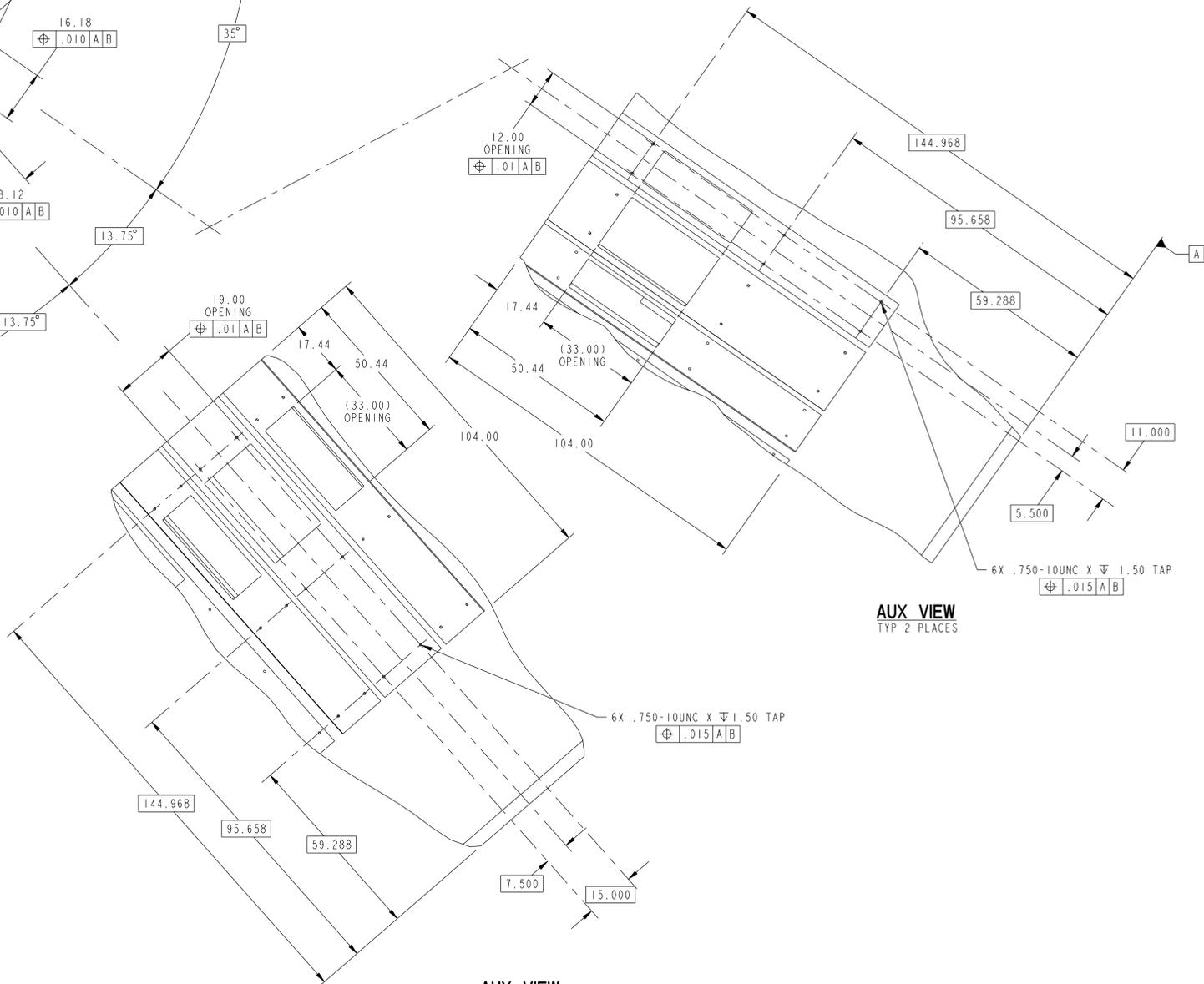
AUX VIEW
TYP 2 PLACES

SCALE .06	Oak Ridge National Laboratory operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee Spallation Neutron Source			
TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTIONS : XX DECIMALS ±.02 XXX DECIMALS ±.005 ANGLES ±0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED				
TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT				
BLDG 8700	FL 3	SHT 9	OF 9	CLASS U
106040101M8E8700A004				REV 000

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VIEW C-C



AUX VIEW
TYP 2 PLACES

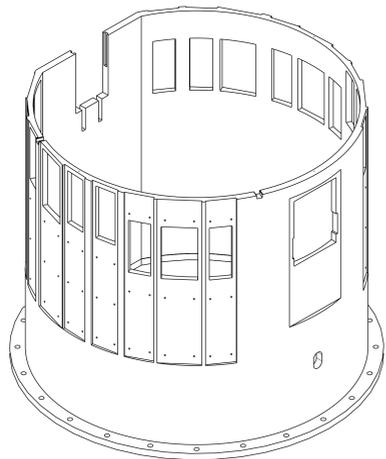
AUX VIEW
TYP 1 PLACE

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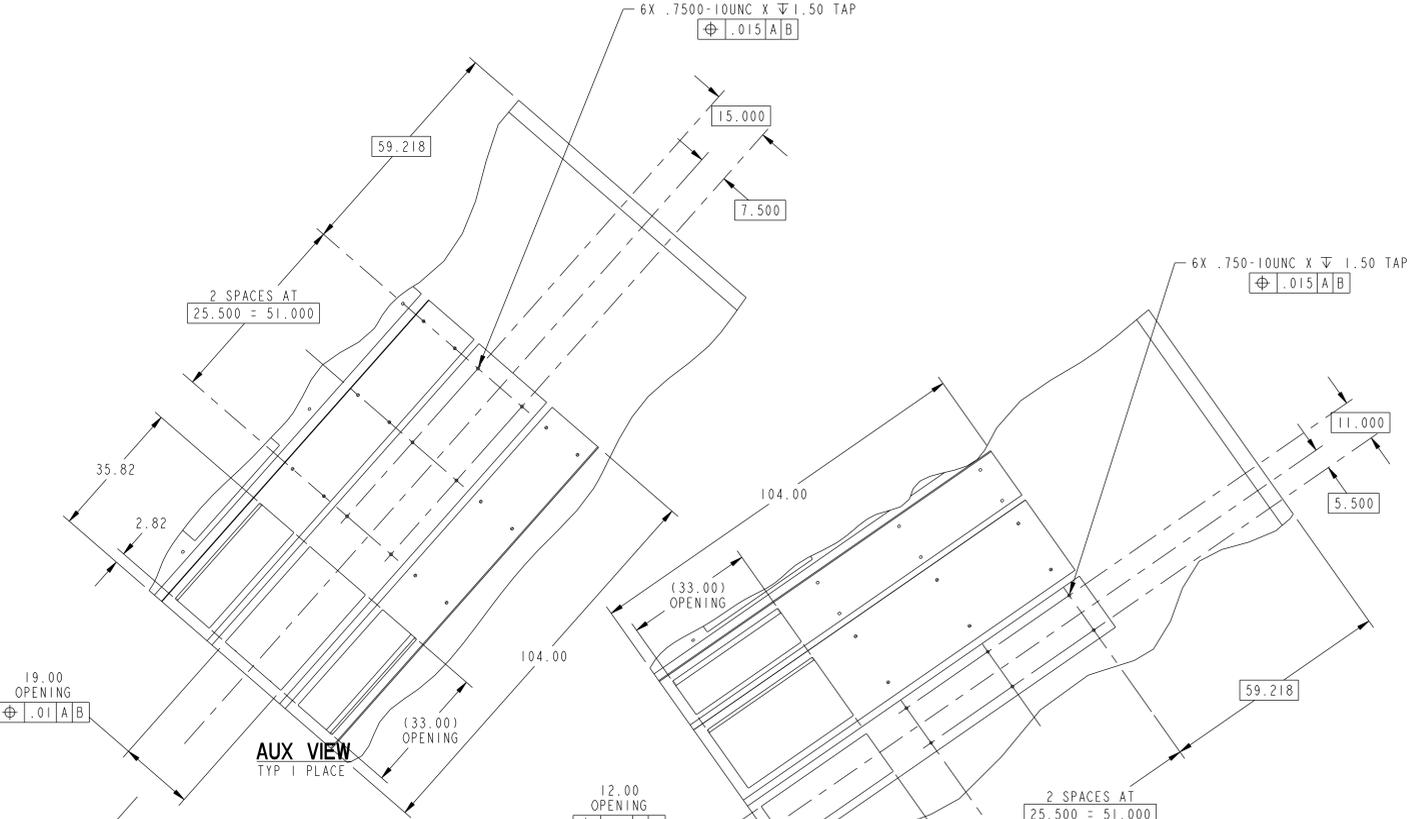
P THIS DRAWING PRODUCED ON PRO-ENGINEER

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TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS : XX DECIMALS ± .02 XXX DECIMALS ± .005 ANGLES ± 0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT
	BLDG 8700 FL 4 SHT 9 OF CLASS U 106040101M8E8700A004 REV 000

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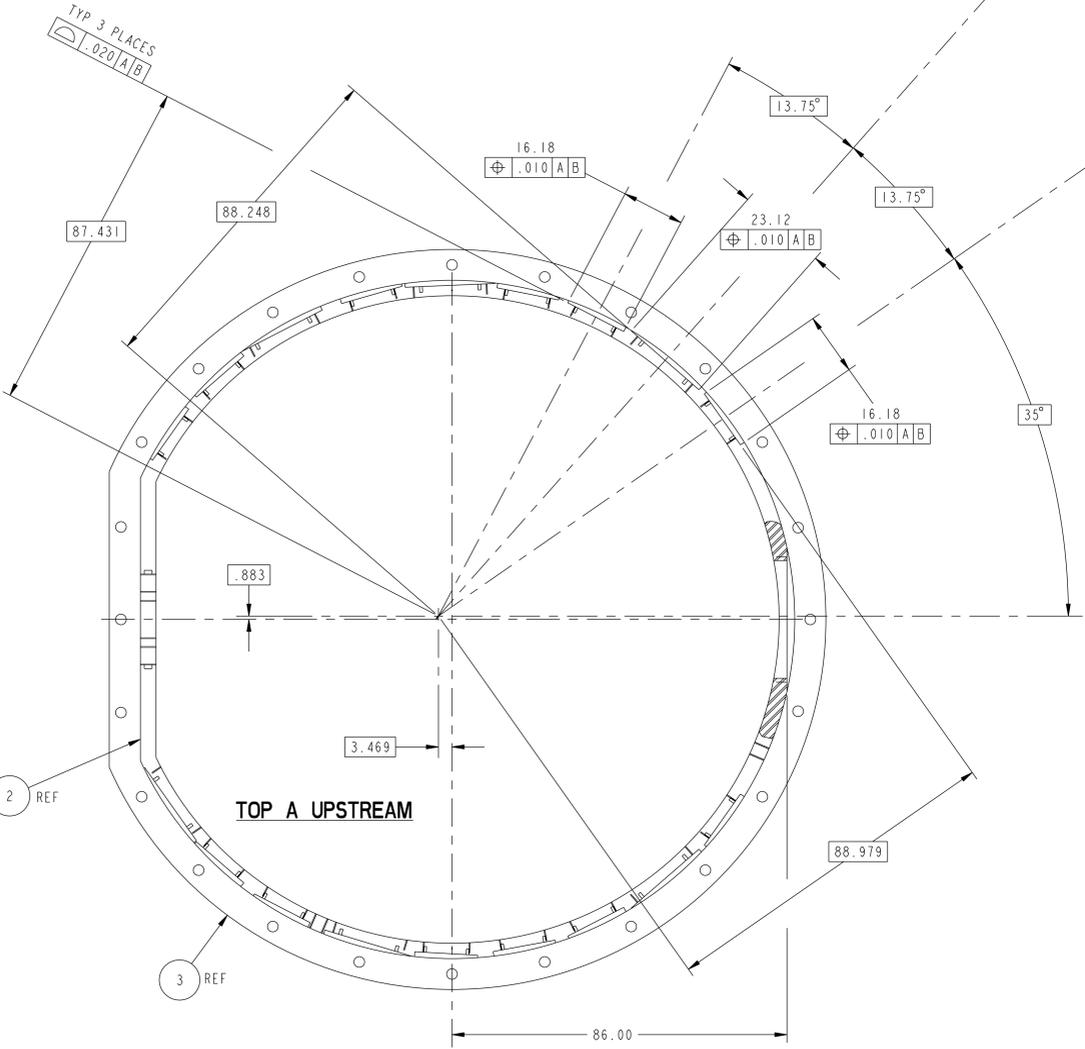


SCALE 0.030



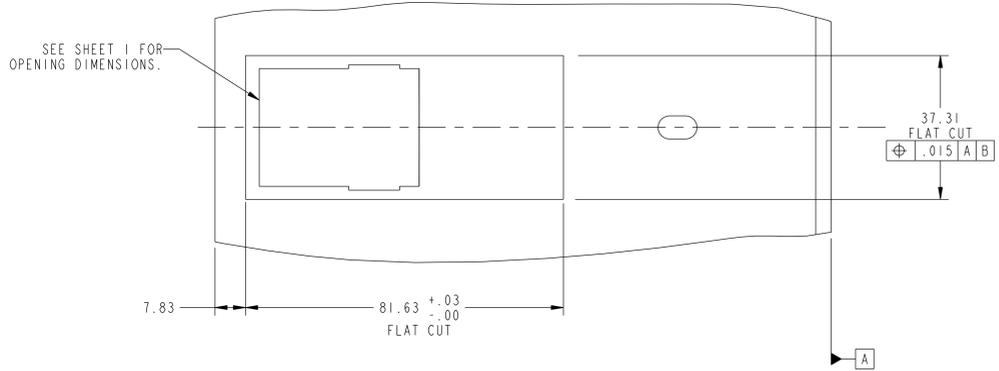
AUX VIEW
TYP 1 PLACE

AUX VIEW
TYP 2 PLACES



TOP A UPSTREAM

VIEW D-D

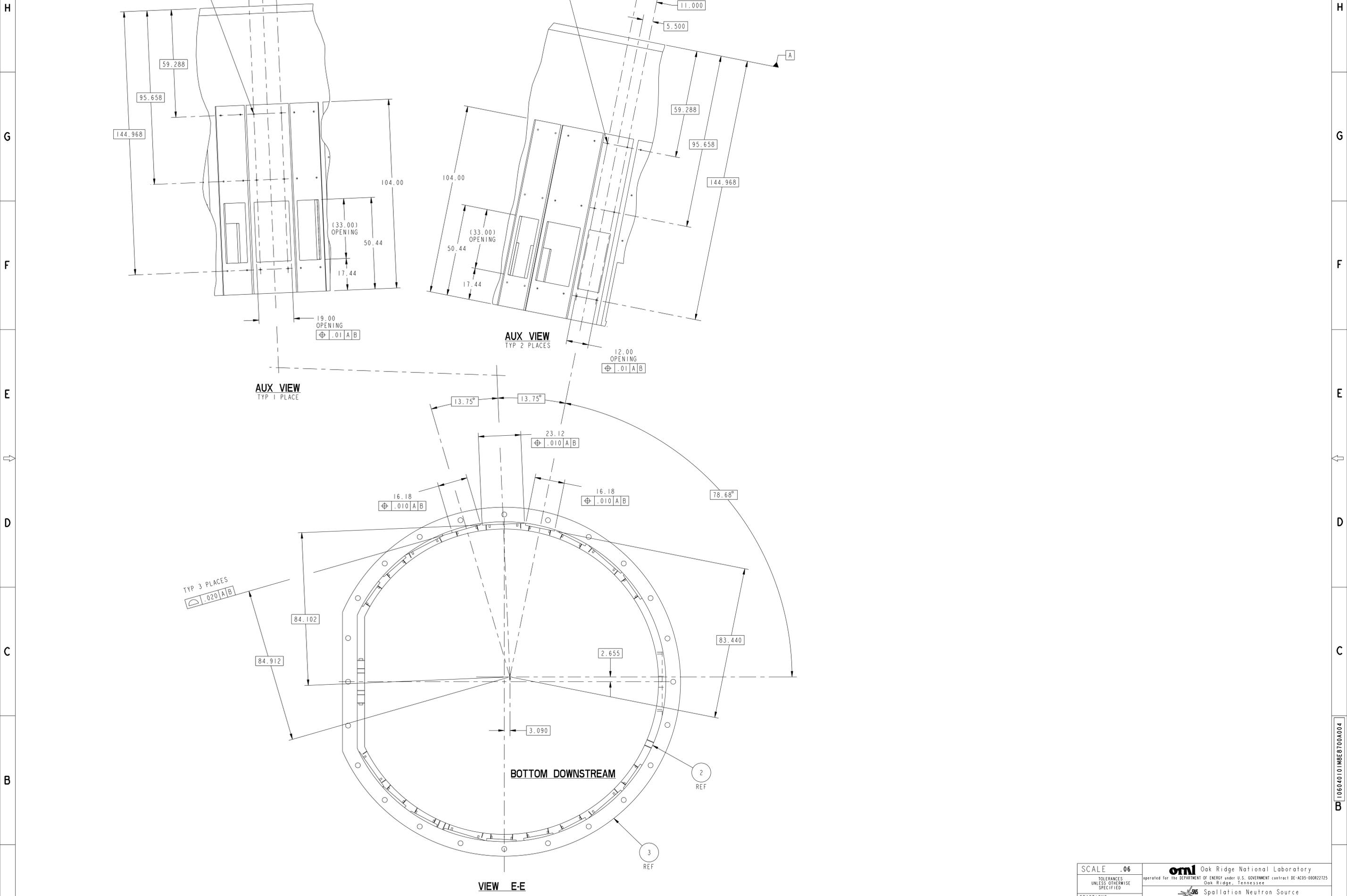


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TOLERANCES UNLESS OTHERWISE SPECIFIED	Spallation Neutron Source	
FRACTIONS : XX DECIMALS ±.02 XXX DECIMALS ±.005 ANGLES ±0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT	
	BLDG 8700	FL SHT OF CLASS 5 9 U
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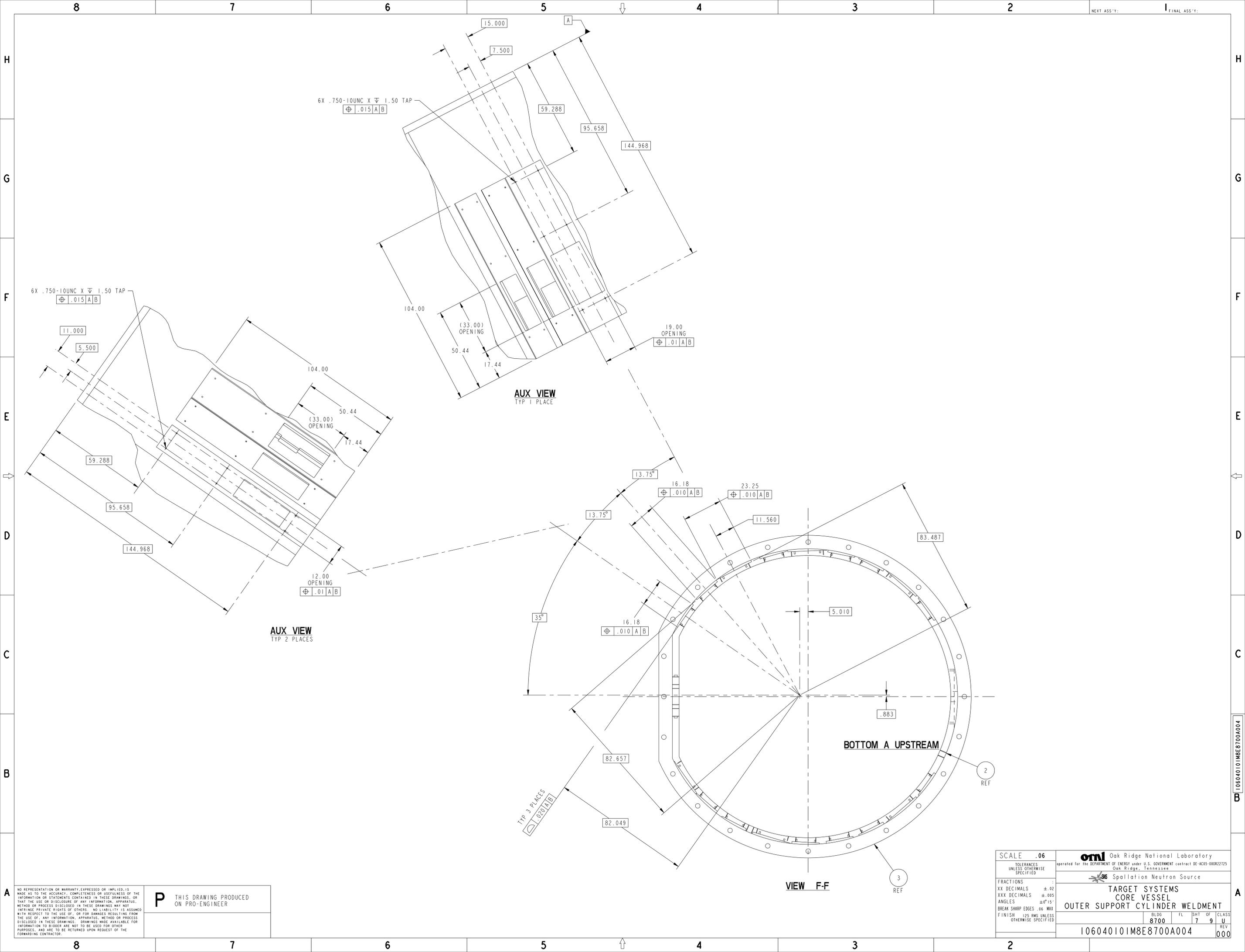
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TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTIONS : XX DECIMALS ± .02 XXX DECIMALS ± .005 ANGLES ± 0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	
TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT	
BLDG 8700 FL 6 SH 9 OF CLASS U 106040101M8E8700A004 REV 000	



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TOLERANCES UNLESS OTHERWISE SPECIFIED FRACTIONS : XX DECIMALS ±.02 XXX DECIMALS ±.005 ANGLES ±0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED		
TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT		BLDG FL SHT OF CLASS 8700 7 9 U
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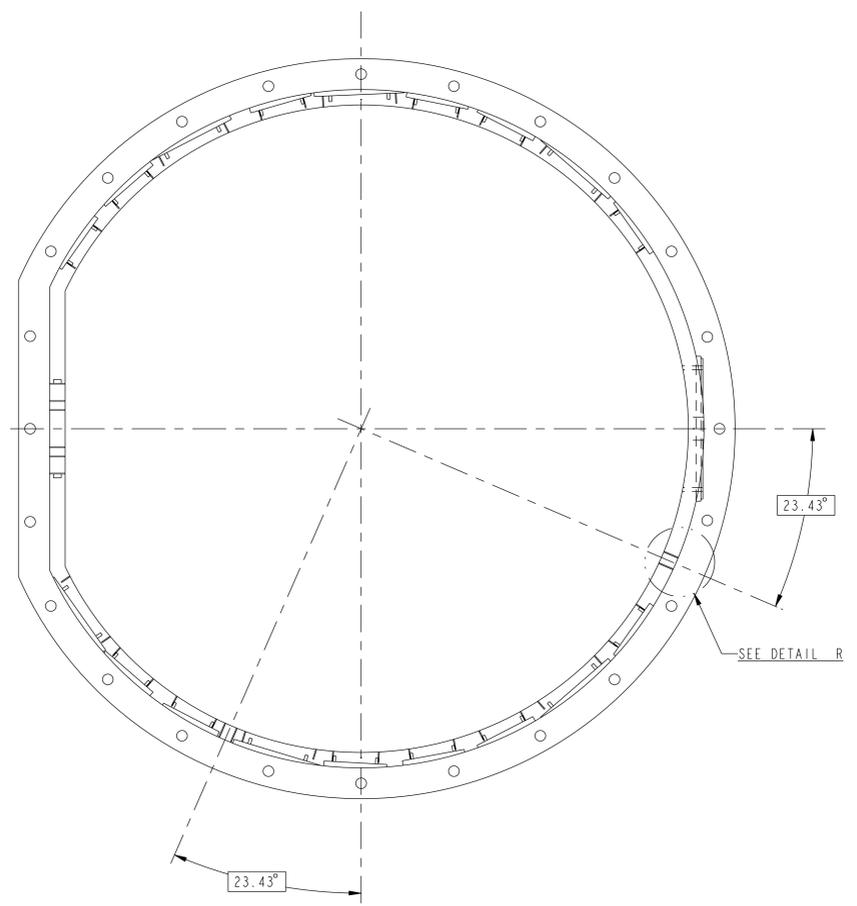
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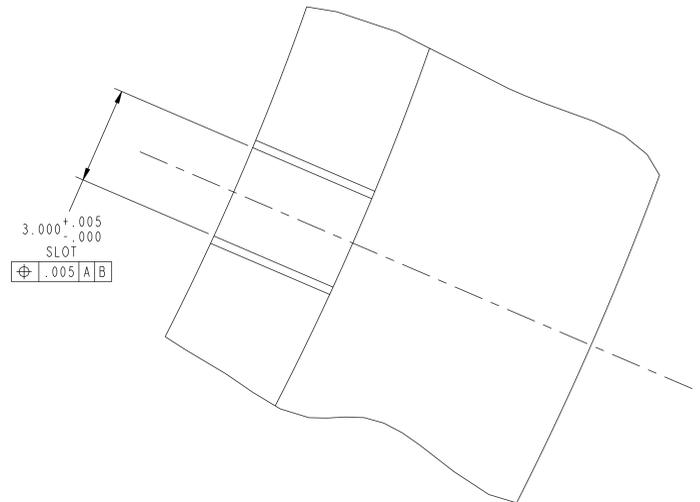
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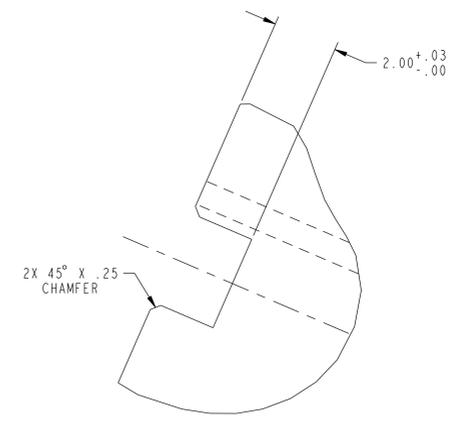
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VIEW G-G



DETAIL R
TYP 2 PLACES
SCALE 0.50



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TOLERANCES UNLESS OTHERWISE SPECIFIED	Spallation Neutron Source			
FRACTIONS : XX DECIMALS ± .02 XXX DECIMALS ± .005 ANGLES ± 0°15' BREAK SHARP EDGES .06 MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	TARGET SYSTEMS CORE VESSEL OUTER SUPPORT CYLINDER WELDMENT			
	BLDG	FL	SHT	OF CLASS
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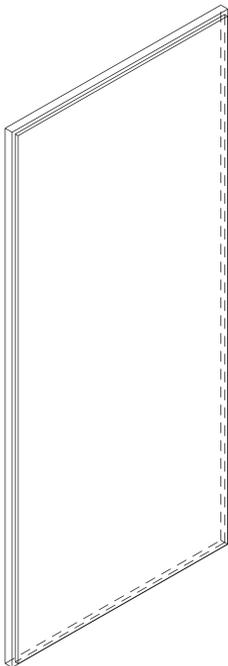
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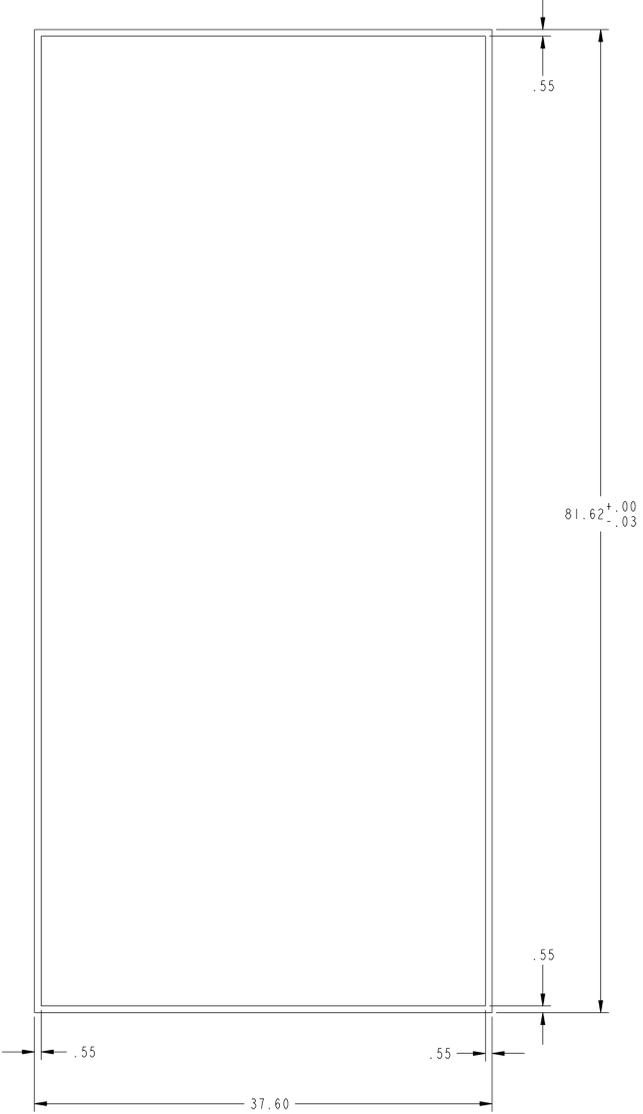
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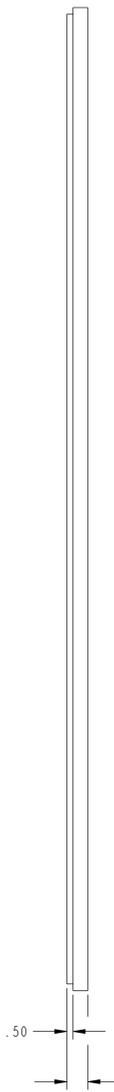


SCALE 0.13



4 TARGET PORT PLATE

SCALE 0.19



(1.72) SEE SHEET 1 AT ASSY. FOR MACHINING DETAILS

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TOLERANCES UNLESS OTHERWISE SPECIFIED	Spallation Neutron Source	
FRACTIONS :	TARGET SYSTEMS	
XX DECIMALS ± .02	CORE VESSEL	
XXX DECIMALS ± .005	OUTER SUPPORT CYLINDER WELDMENT	
ANGLES ± 0°15'		
BREAK SHARP EDGES .06 MAX		
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	BLDG	FL
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	106040101M8E8700A004	
	REV	000

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