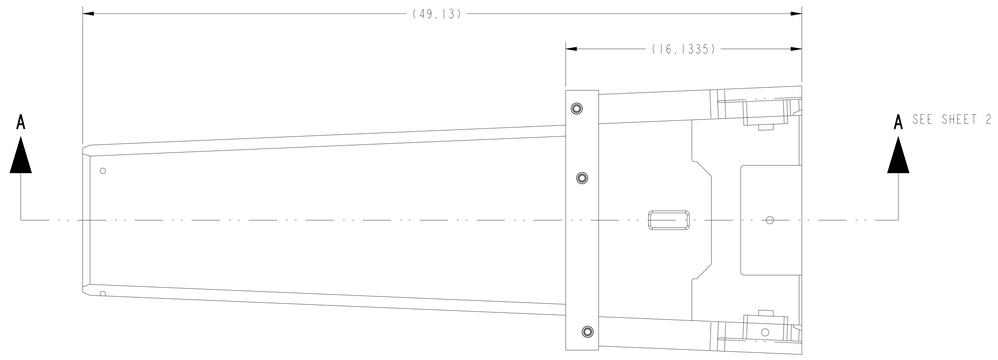
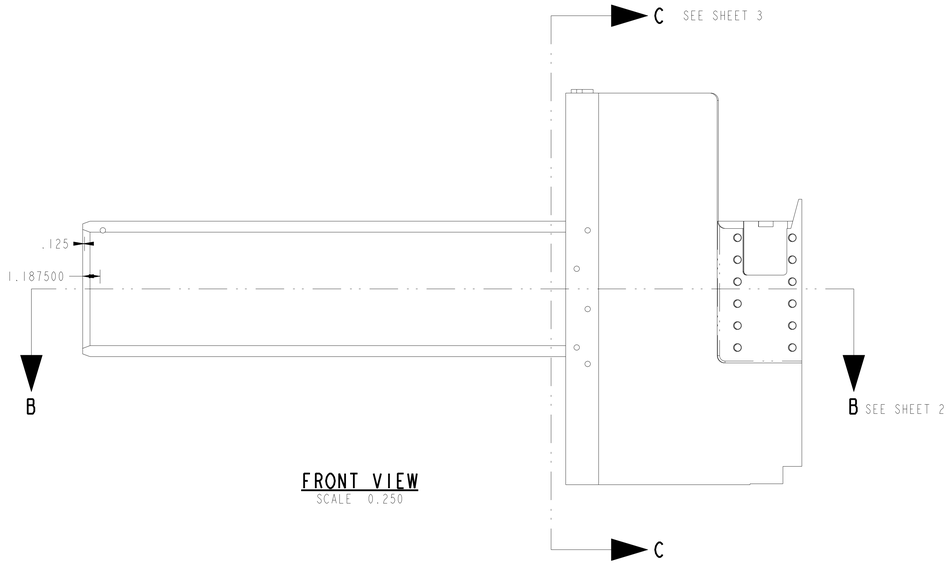
NOTES

1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. INTERPRET WELDING AND NONDESTRUCTIVE EXAMINATION SYMBOLS PER AWS A2.4.
5. USE PROCEDURES, WELDERS, WELDING OPERATORS AND TACKERS QUALIFIED PER AWS B2.1 AND D1.1.
6. DIMENSIONAL STABILITY OF CORE VESSEL INSERT WELDMENT (FIND NO. 1) SHALL BE MAINTAINED THROUGH ALL MACHINING OPERATIONS. SELLER SHALL STRESS RELIEF CORE VESSEL INSERT WELDMENT BY HEAT-TREATING AS REQUIRED TO ACCOMPLISH STABILITY. ALL DIMENSIONS APPLY AFTER STRESS RELIEF.
7. CORE VESSEL INSERT WELDMENT (FIND NO. 1) SHALL BE NICKEL PLATED 0.0005 TO 0.0008 THICK. DIMENSIONS APPLY AFTER PLATING.
8. OPTIONAL CONSTRUCTION METHODS SHALL BE ALLOWED PER APPROVAL OF BUYER. SOME OPTIONAL METHODS ARE LISTED SUCH AS:

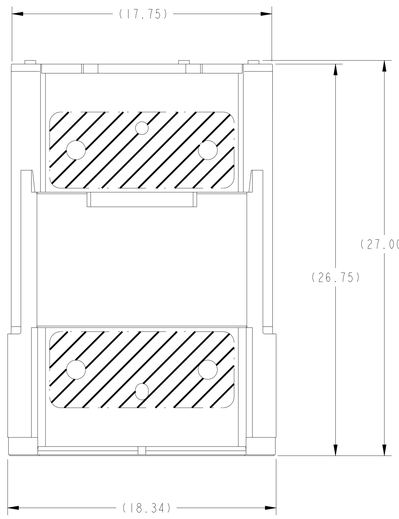
   a) ONE PIECE CONSTRUCTION.
   b) CONSTRUCTION FROM RECTANGULAR TUBING.
   c) CONSTRUCTION FROM FORGING.

9. RECESS PLUGS, FIND NOS. 9 THRU 13, APPROXIMATELY 1/8" DEEP AND THEN PLUG WELD INTO PLACE.





FRONT VIEW
SCALE 0.250



9		2		107030600M8E8700A104-13	PLUG, .38 DIA. x 2.94 LG.	STAINLESS STEEL	316L	13
9		2		107030600M8E8700A104-12	PLUG, .38 DIA. x 2.43 LG.	STAINLESS STEEL	316L	12
9		10		107030600M8E8700A104-11	PLUG, .38 DIA. x .94 LG.	STAINLESS STEEL	316L	11
9		8		107030600M8E8700A104-10	PLUG, .38 DIA. x 1.06 LG.	STAINLESS STEEL	316L	10
9		2		107030600M8E8700A104-9	PLUG, .38 DIA. x 7.94 LG.	STAINLESS STEEL	316L	9
		3		107030600M8E8700A104-8	TUBING NIPPLE	STAINLESS STEEL	316L	8
		1		107030600M8E8700A104-7	LEFT GUIDE PLATE	STAINLESS STEEL	316L	7
		1		107030600M8E8700A104-6	BOTTOM GUSSET	STAINLESS STEEL	316L	6
		1		107030600M8E8700A104-5	TOP GUSSET	STAINLESS STEEL	316L	5
		1		107030600M8E8700A104-4	RIGHT GUIDE PLATE	---	---	4
		1		107030600M8E8700A104-3	FLANGE PLATE	STAINLESS STEEL	316L	3
		1		107030600M8E8700A104-2	SOLID PLUG	STAINLESS STEEL	316L	2
4 5 6 7 8		1		107030600M8E8700A104-1	MULTI C V INSERT PLUG WLDMNT	---	---	1
107030600M8E8700A103	-	CAGE CODE		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

NEXT ASSEMBLY

PARTS LIST

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE SNS-QA-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 (W/CHART)	-
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

WEIGHT: APPROX. 2,278 LBS.

PRELIMINARY

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THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM 3
SNS PROCEDURE SNS-TS-G001

REV	CHANGE TYPE	CHANGE CONTROL SYSTEM	CHANGE REQUEST NUMBER	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE	PJ
00A	—	3	—	ISSUE FOR COMMENT AND INFORMATION	SMR				11/01				

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

DRAWING APPROVALS		DATE
DES	DMW/MEP	11/01
DRW	M.E.PHILLIPS	11/01
CHK	:	:
L3	:	:
L2	:	:
:	T.E. FORNEK	11/01
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:

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Oak Ridge, Tennessee

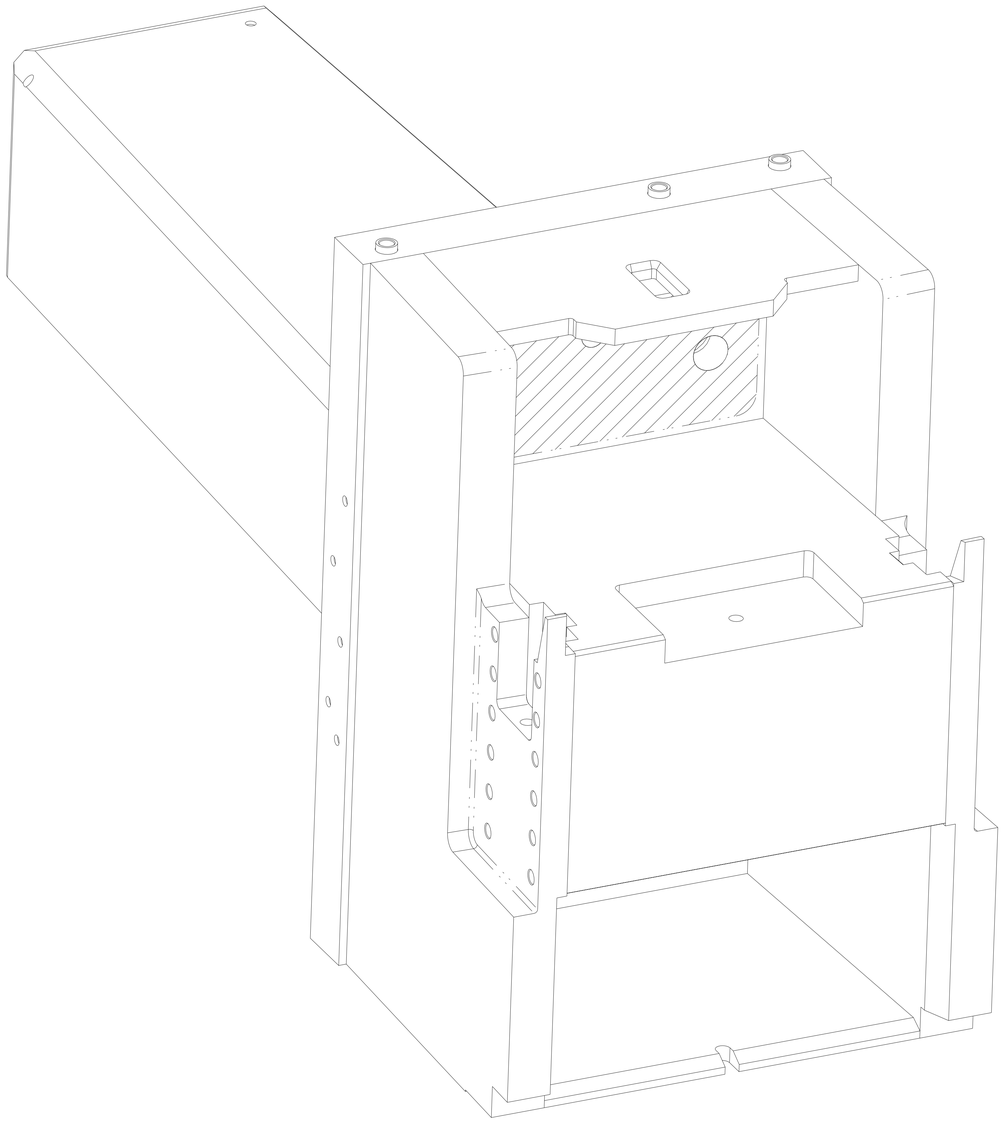
SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
MULTI CORE VESSEL INSERT
MULTI C.V. INSERT PLUG WELDMENT

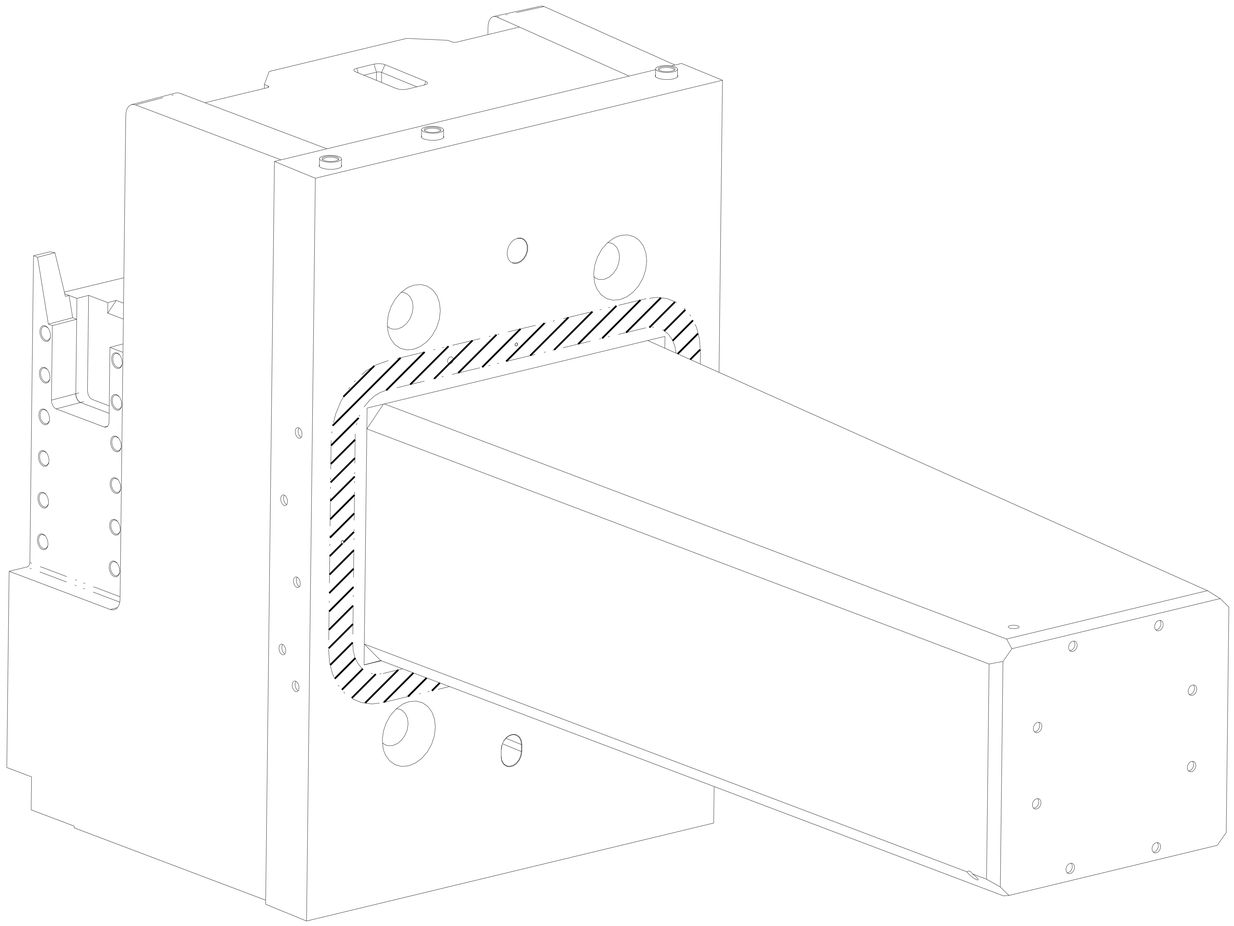
BLDG	FL	SHT	OF	CLASS
8700	IST	1	11	U

107030600M8E8700A104 REV 00A

107030600M8E8700A104 B



FRONT PICTORIAL VIEW
SCALE 0.500



REAR PICTORIAL VIEW
SCALE 0.500

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PRELIMINARY

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

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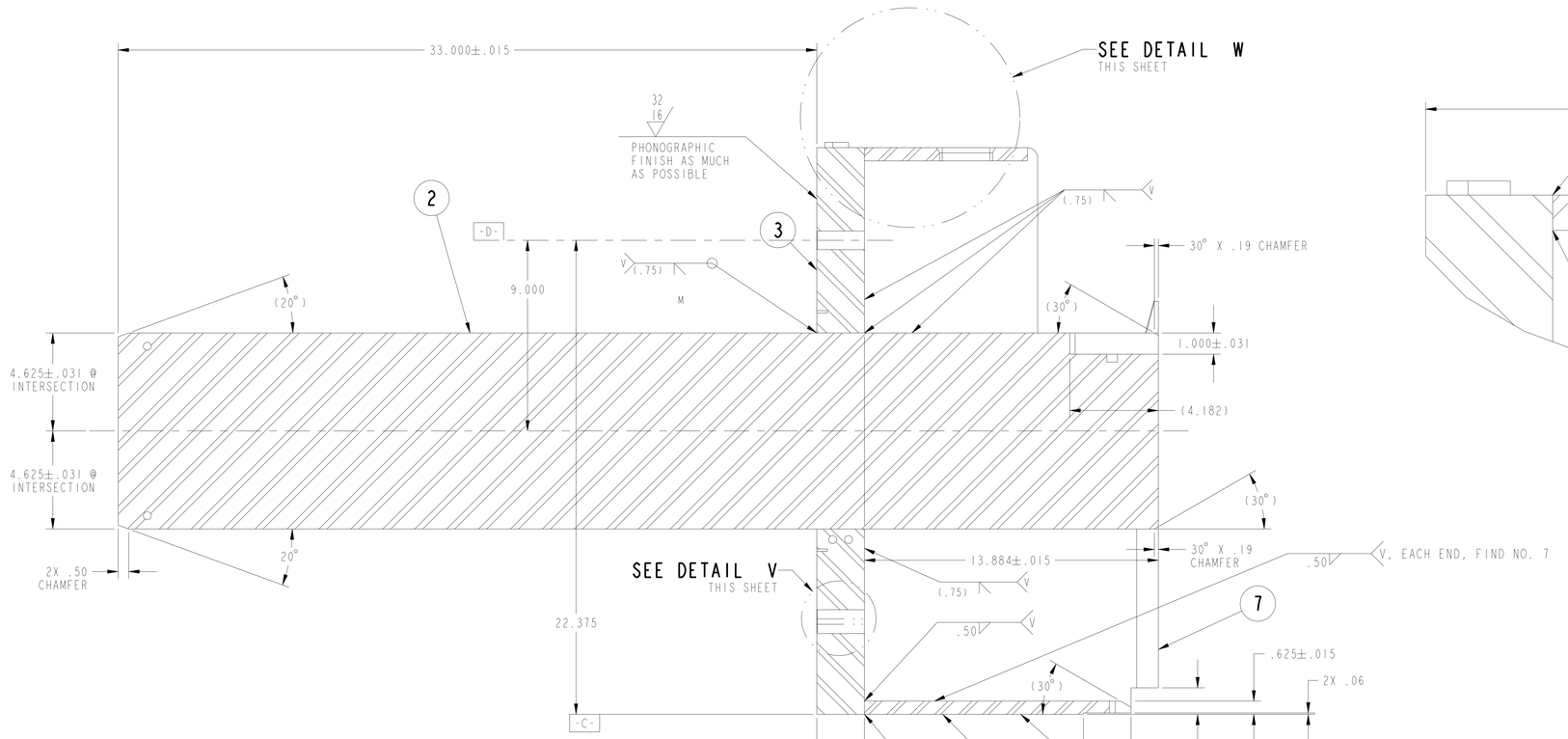
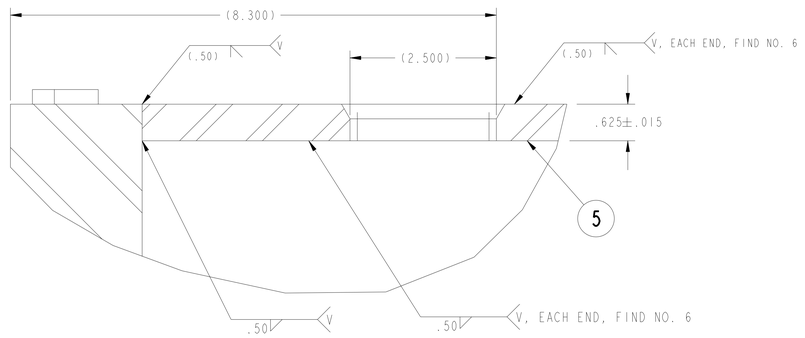
BLDG	FL	SHT	OF	CLASS
8700	1ST	2	11	U

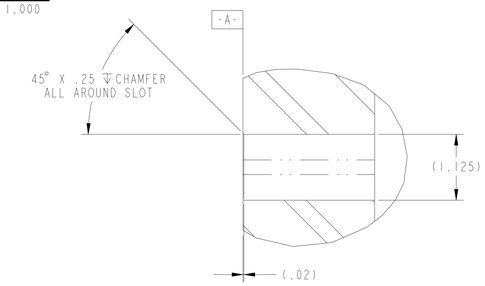
I07030600M8E8700A104 REV 00A

I07030600M8E8700A104

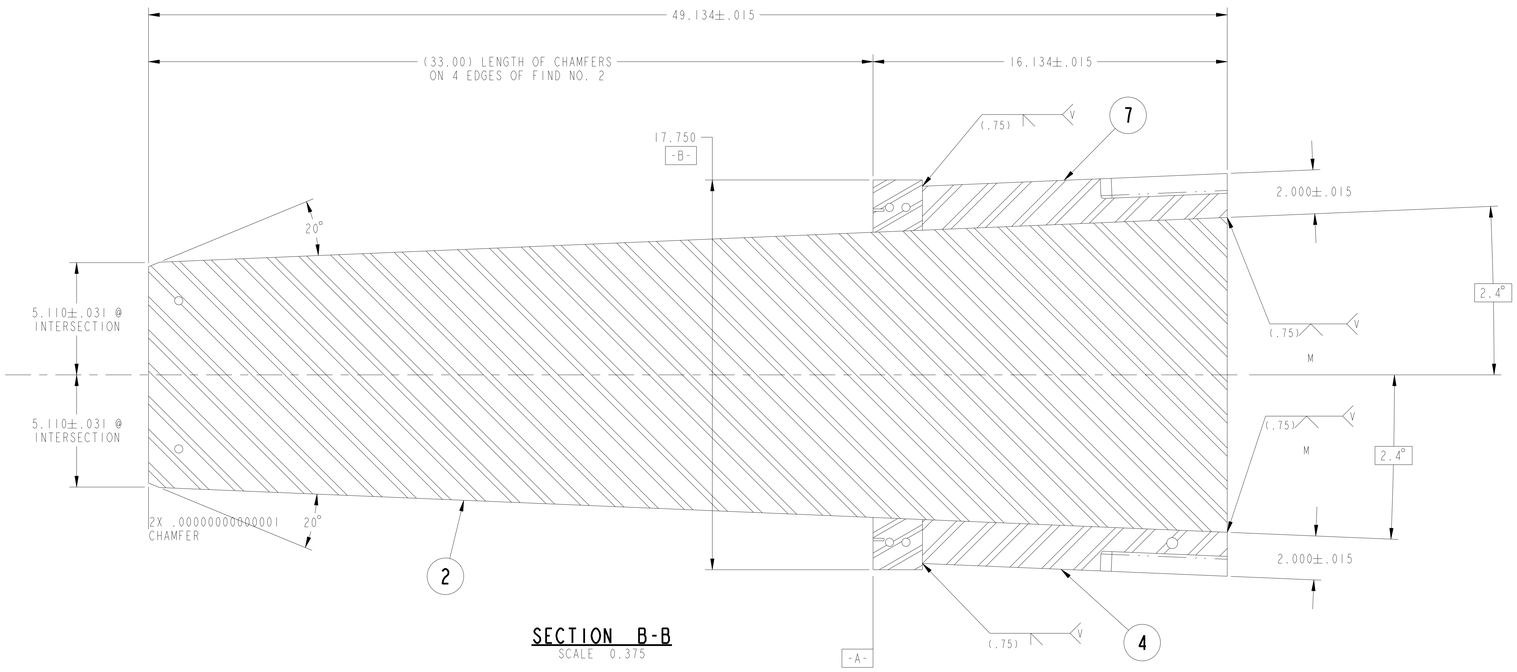




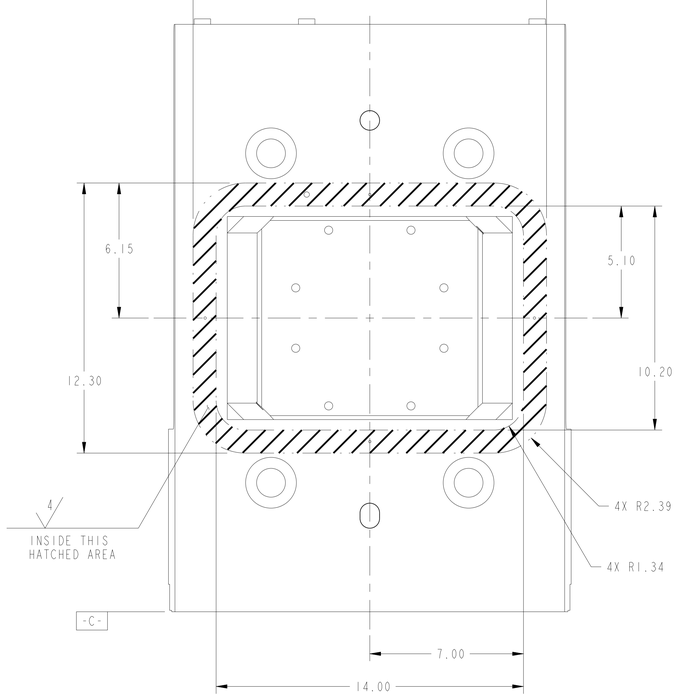
DETAIL W
SCALE 1.000



DETAIL V
SCALE 1.000
SEE SECTION C-C ON SHEET 3



SECTION B-B
SCALE 0.375



LEFT END VIEW
SCALE 0.375

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PRELIMINARY

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

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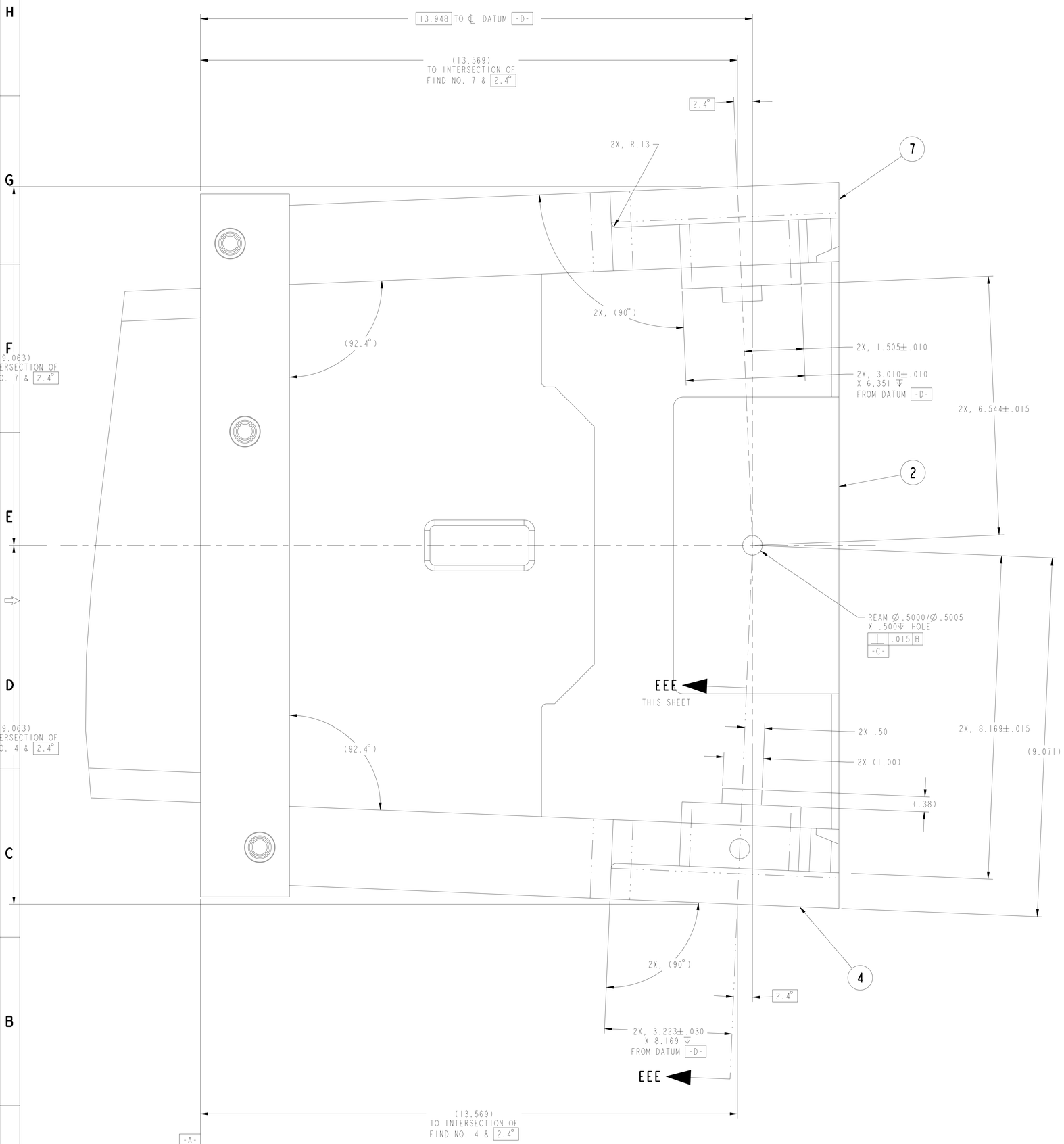
MULTI CORE VESSEL INSERT
MULTI C.V. INSERT PLUG WELDMENT

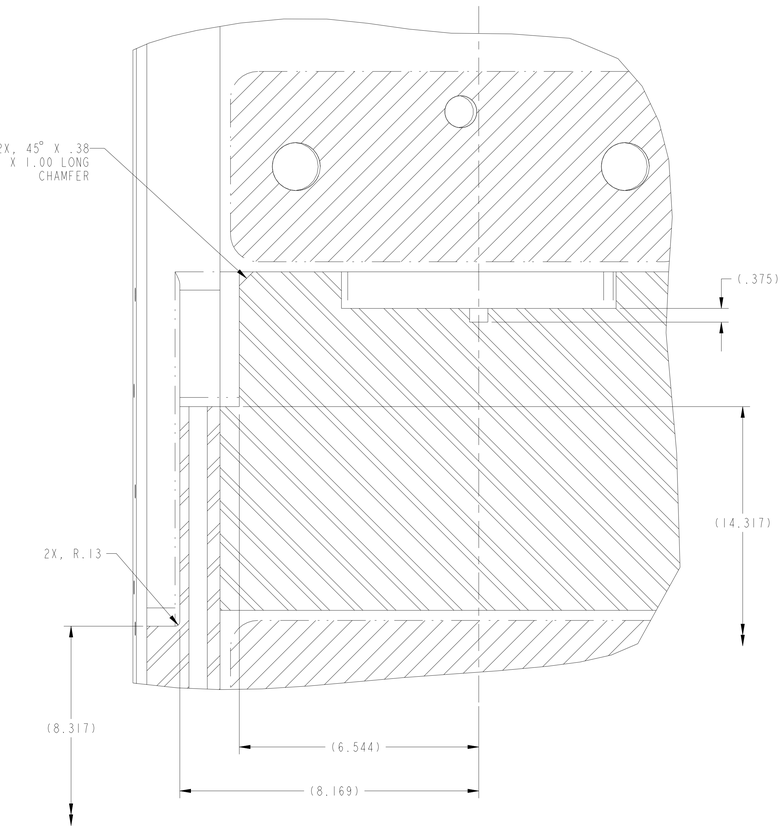
BLDG	FL	SHT	OF	CLASS
8700	1ST	3	11	U

I07030600M8E8700A104 REV. 00A

I07030600M8E8700A104



PARTIAL TOP VIEW
SCALE 1.000



SECTION EEE-EEE
SCALE 0.625

PRELIMINARY

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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

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MULTI C.V. INSERT PLUG WELDMENT

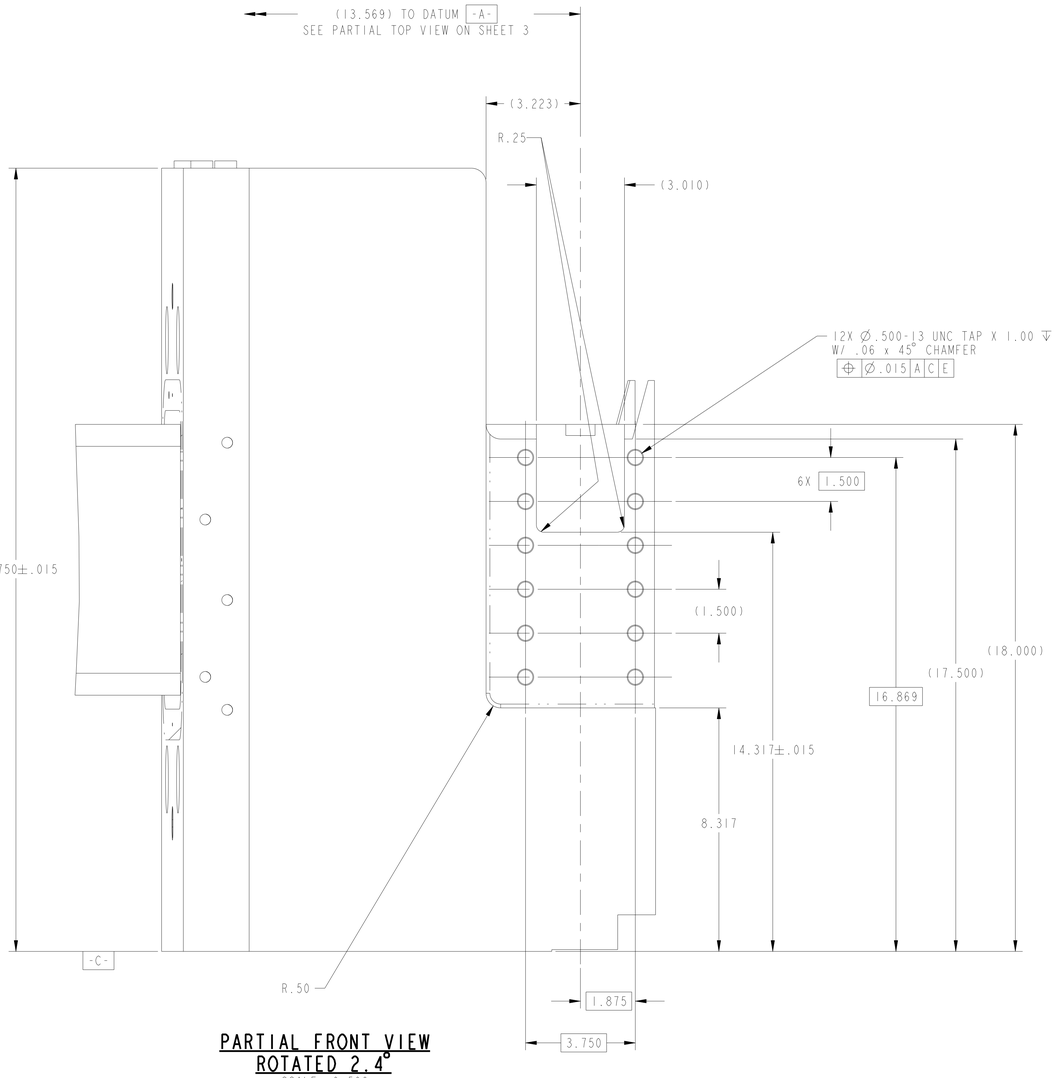
BLDG	TL	SHT	OF	CLASS
8700	1ST	4	11	U

I07030600M8E8700A104 REV 00A

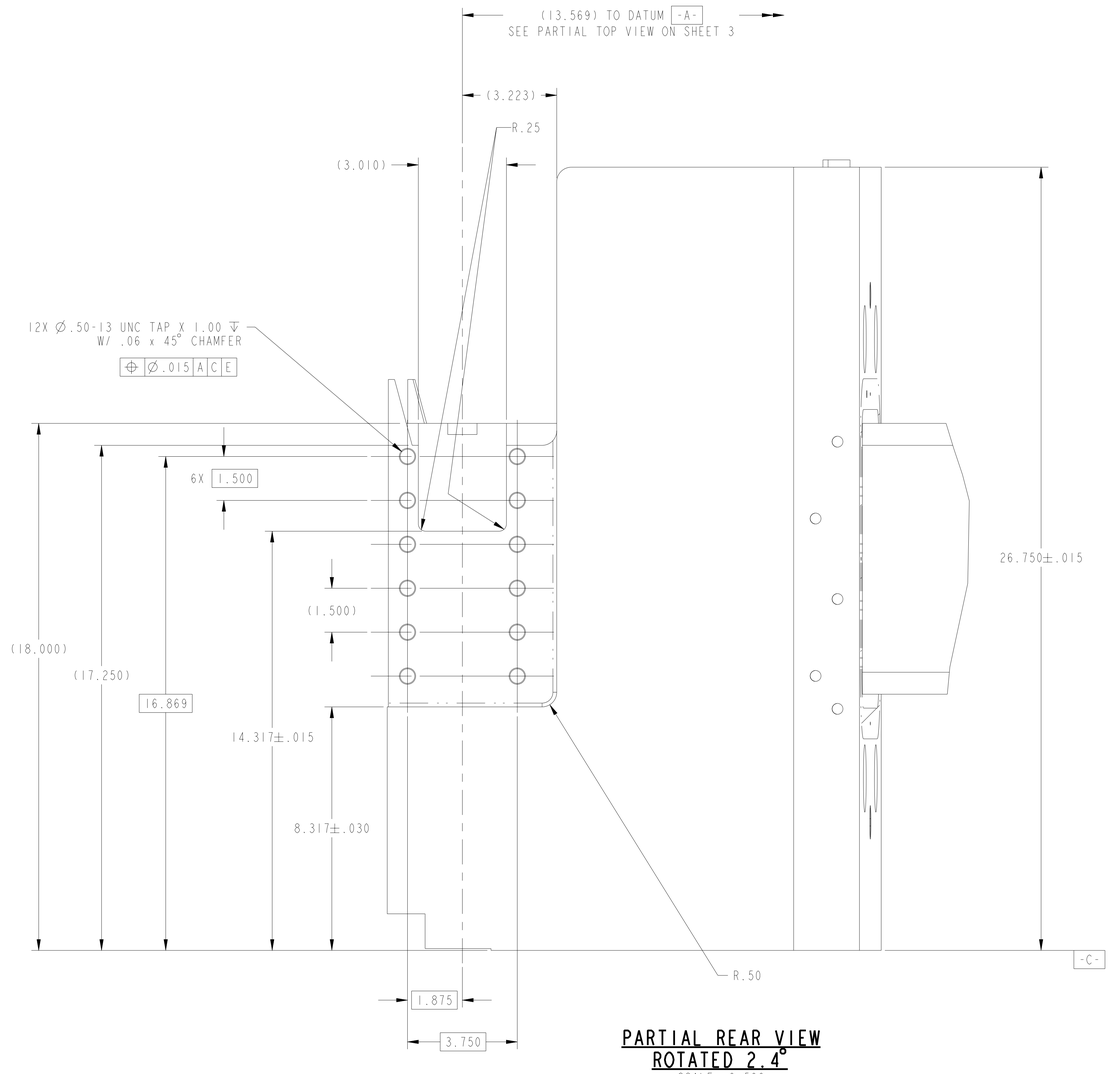
I07030600M8E8700A104

NOTES

SEE SHEET 1 FOR NOTES AND MATERIAL LIST.



PARTIAL FRONT VIEW
ROTATED 2.4°
SCALE 0.500



PARTIAL REAR VIEW
ROTATED 2.4°
SCALE 0.500

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PRELIMINARY

SCALE AS NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
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BLDG	FL	SHT	OF	CLASS
8700	1ST	5	11	U

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107030600M8E8700A104

NOTES

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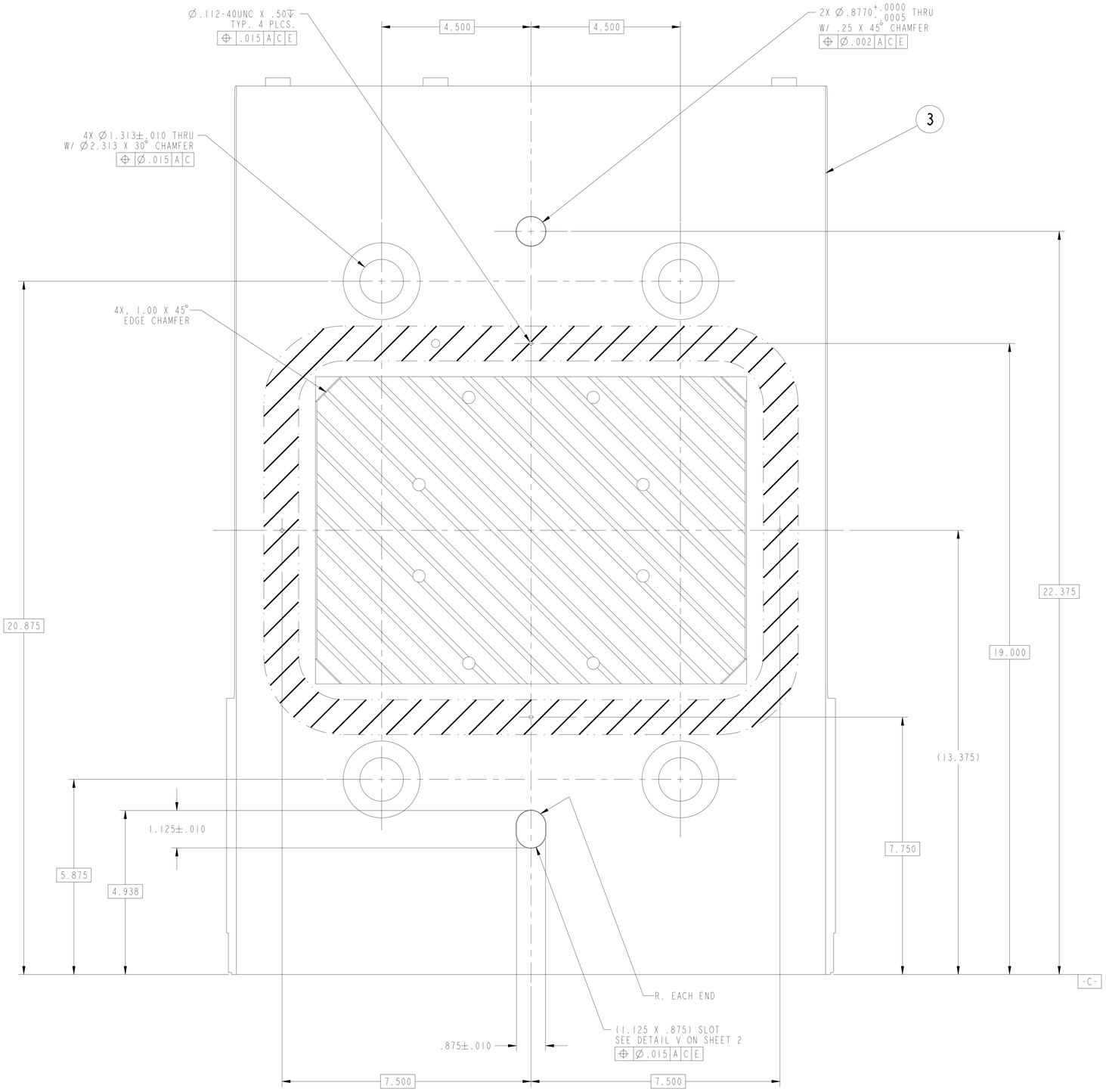
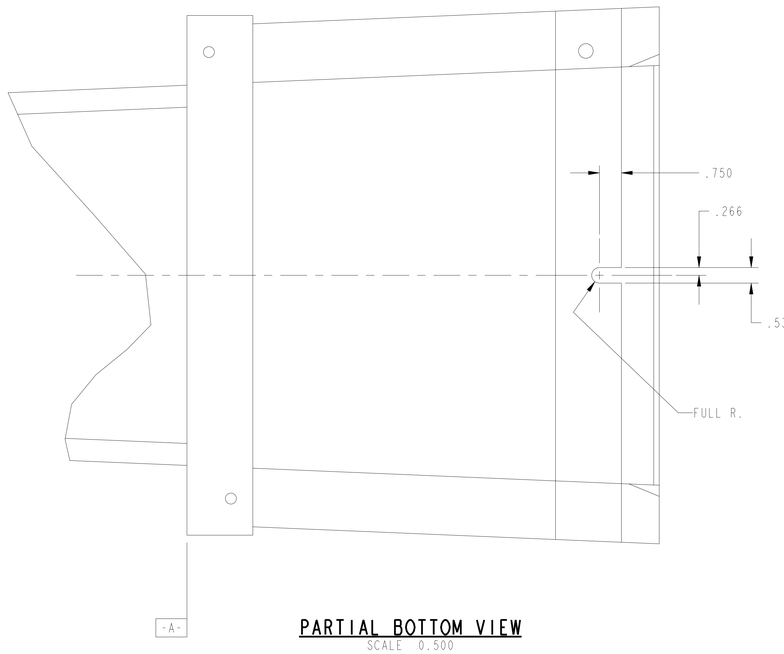


SECTION C-C
SCALE 0.75



PARTIAL BOTTOM VIEW
SCALE 0.500

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PRELIMINARY

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

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BLDG	FL	SHT	OF	CLASS
8700	IST	6	11	U

I07030600M8E8700A104 REV 00A

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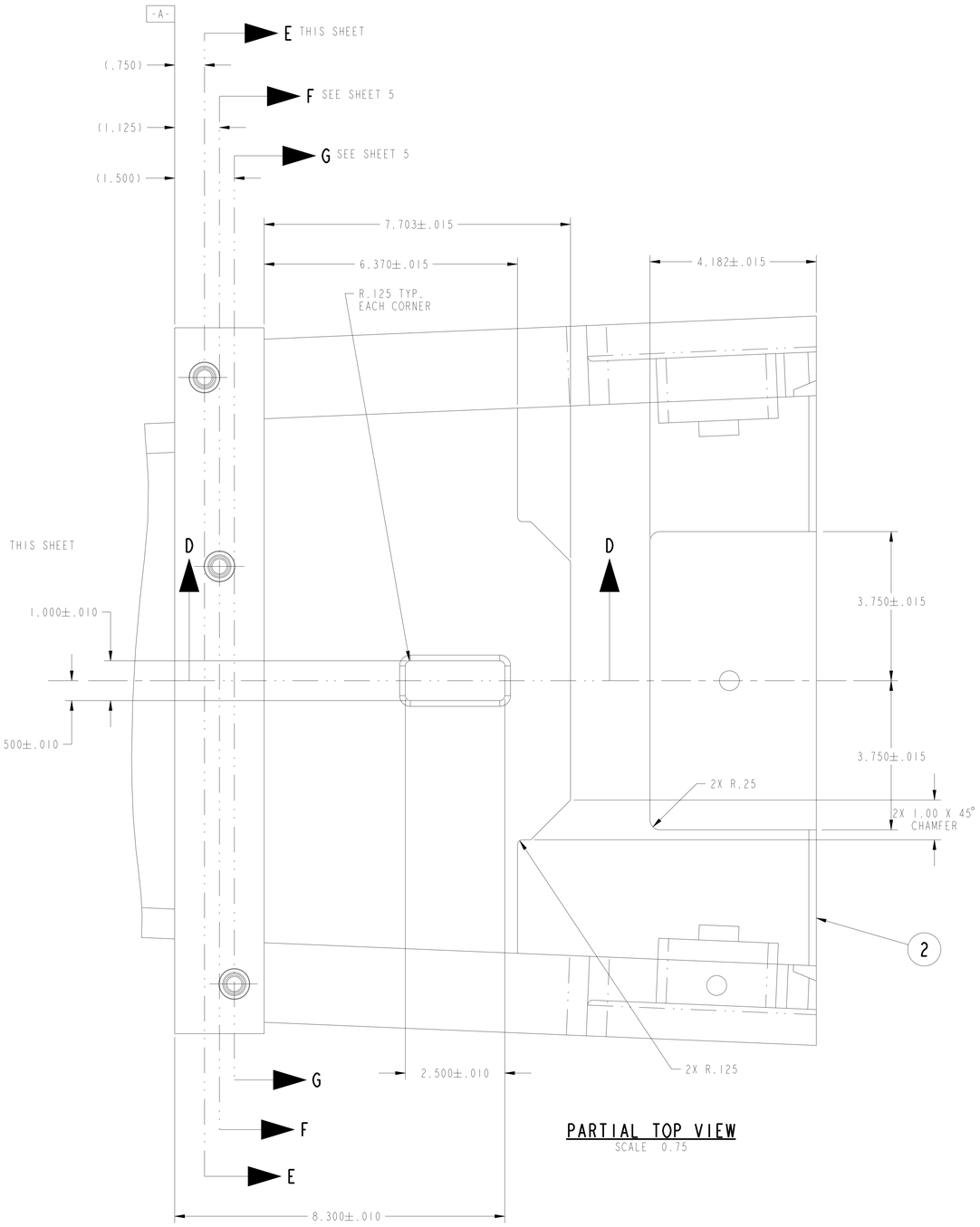

PARTIAL TOP VIEW
SCALE 0.75

NOTES

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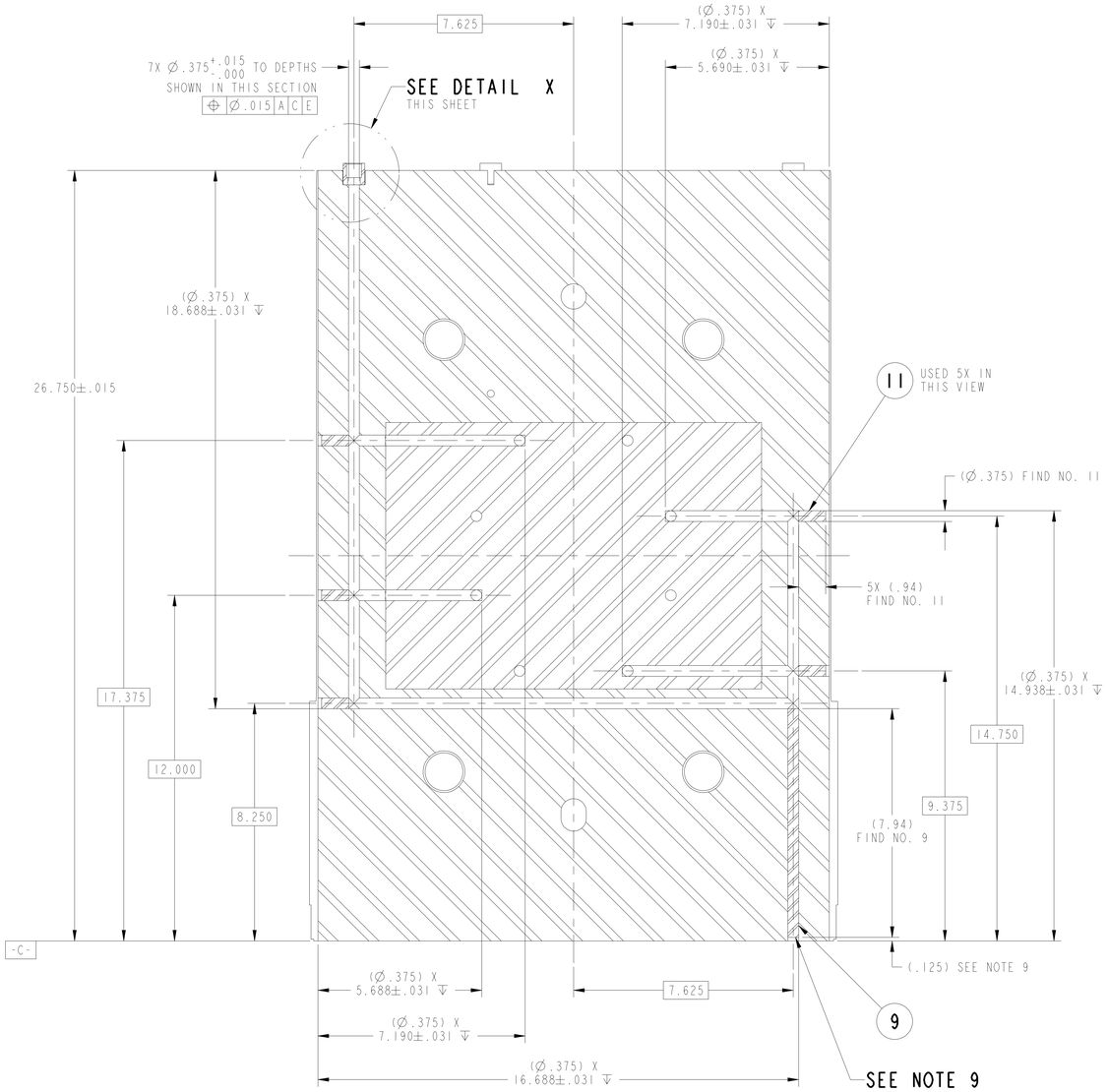
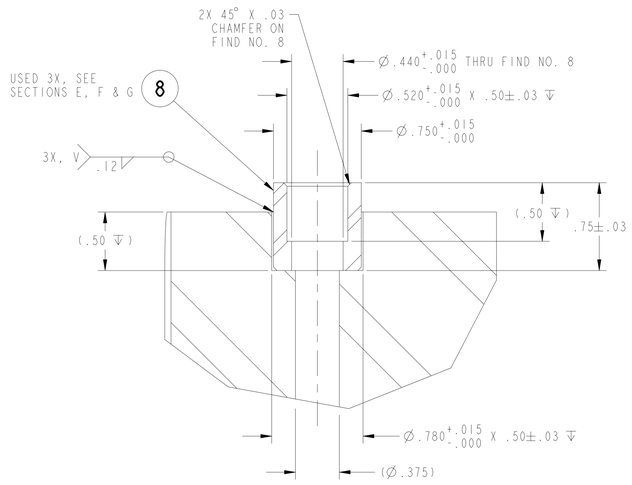
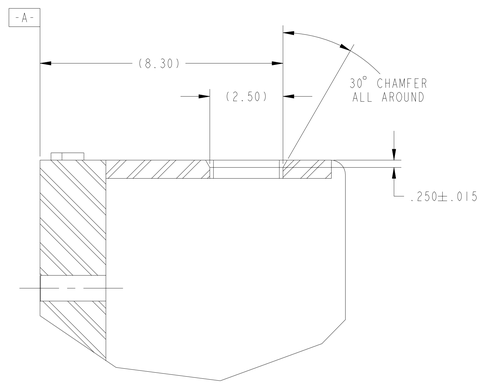


SECTION E-E
SCALE 0.500



DETAIL X
SCALE 2.000



SECTION D-D
SCALE 0.500

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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

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MULTI CORE VESSEL INSERT
MULTI C.V. INSERT PLUG WELDMENT

BLDG	FL	SHT	OF	CLASS
8700	1ST	7	11	U

I07030600M8E8700A104 REV 00A

I07030600M8E8700A104

NOTES

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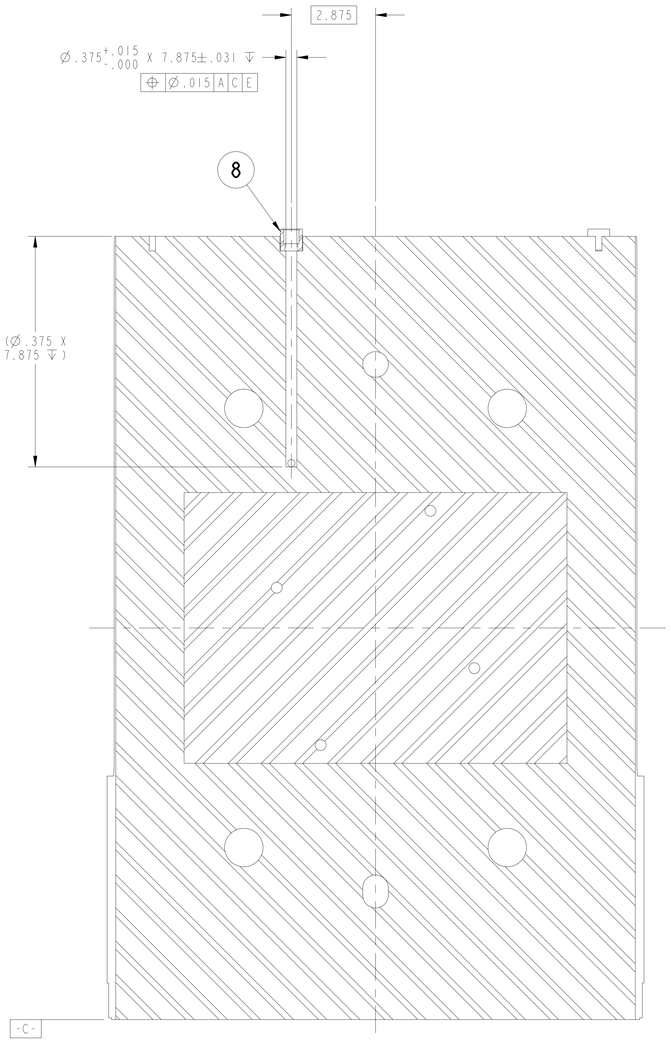
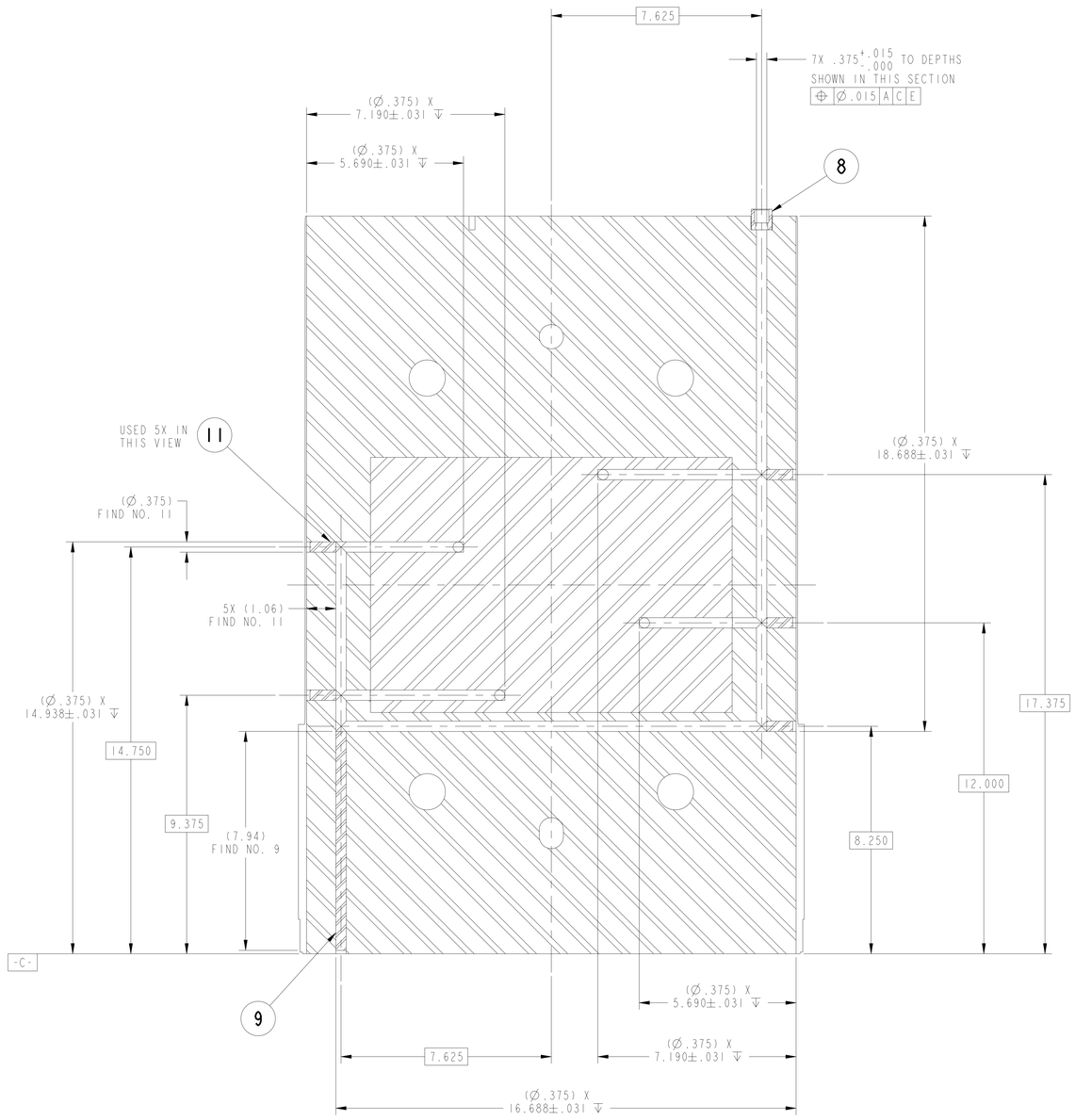


SECTION F-F
SCALE 0.500



SECTION G-G
SCALE 0.500

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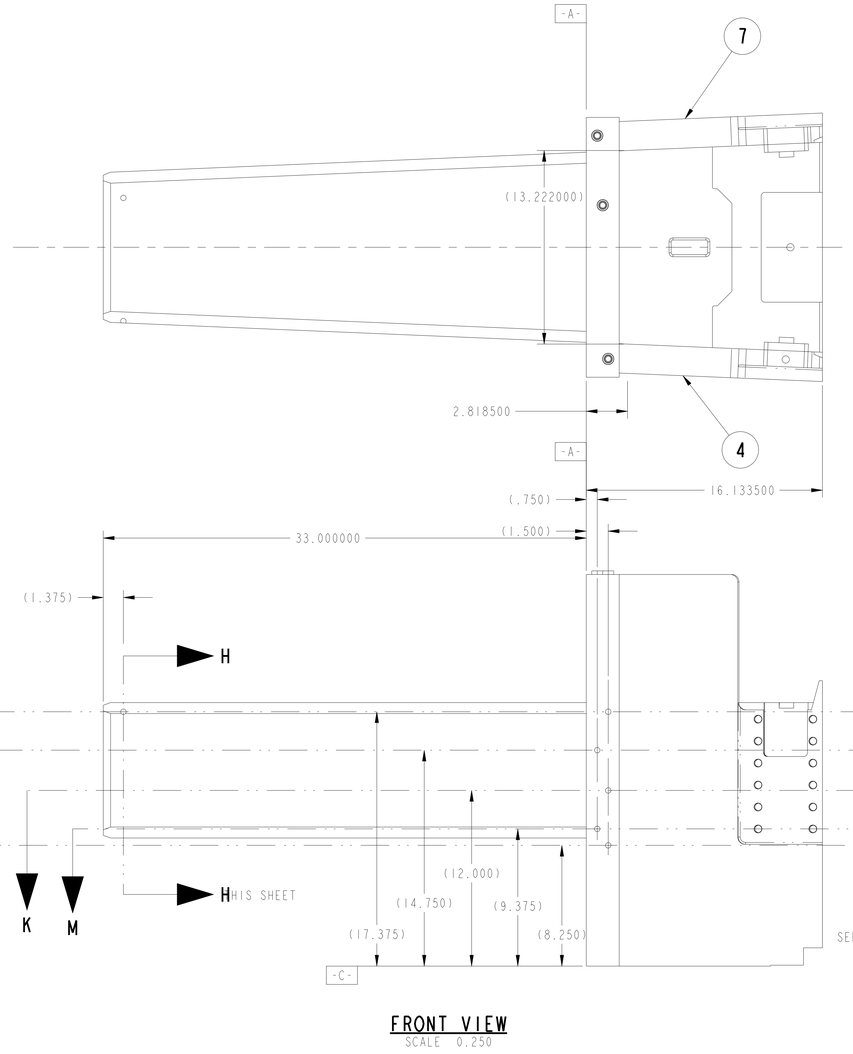
PRELIMINARY

SCALE AS NOTED	ornl Oak Ridge National Laboratory
TOLERANCES UNLESS OTHERWISE SPECIFIED	operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee
FRACTIONS :	SNS Spallation Neutron Source
XX DECIMALS ±.01	SPALLATION NEUTRON SOURCE PROJECT
XXX DECIMALS ±.005	MULTI CORE VESSEL INSERT
ANGLES ±0°15'	MULTI C.V. INSERT PLUG WELDMENT
BREAK SHARP EDGES .06 MAX	BLDG 8700 | FL 1ST | SHT 8 | OF 11 | CLASS U
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	107030600M8E8700A104 REV 00A

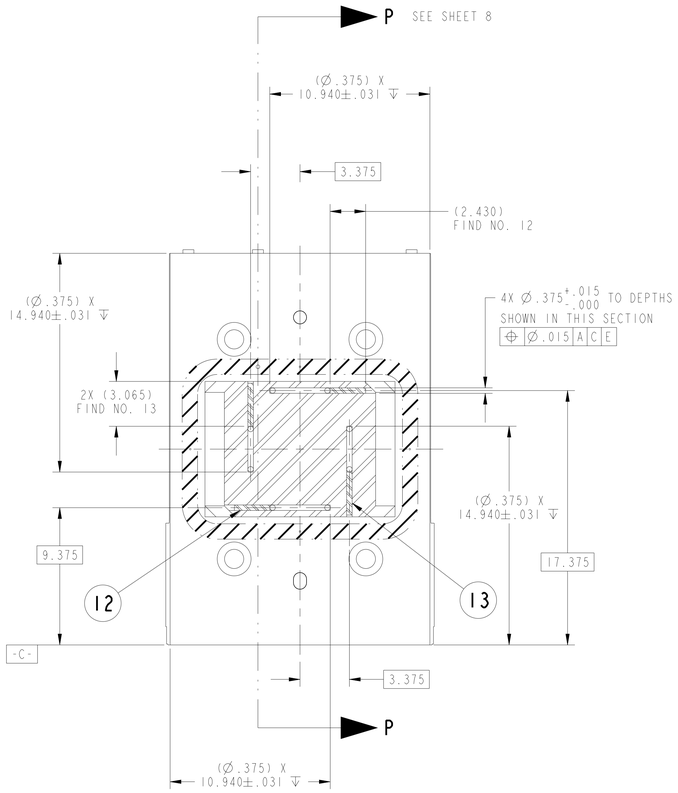
107030600M8E8700A104

NOTES

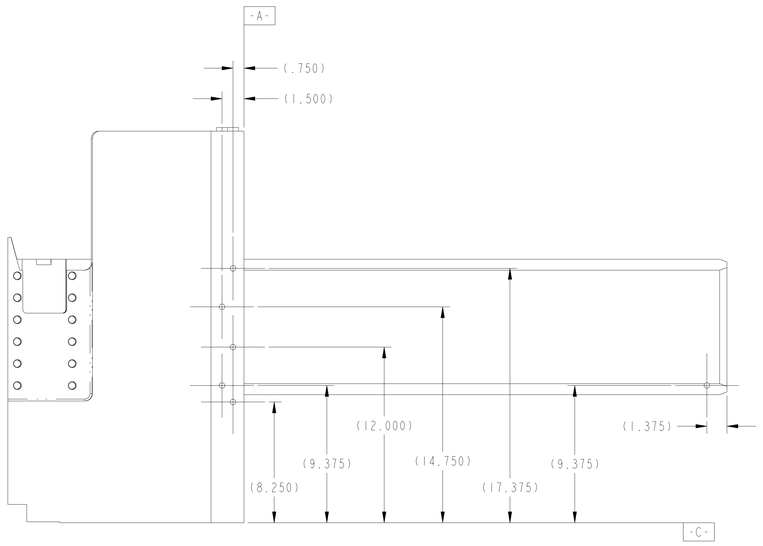
SEE SHEET 1 FOR NOTES AND MATERIAL LIST.



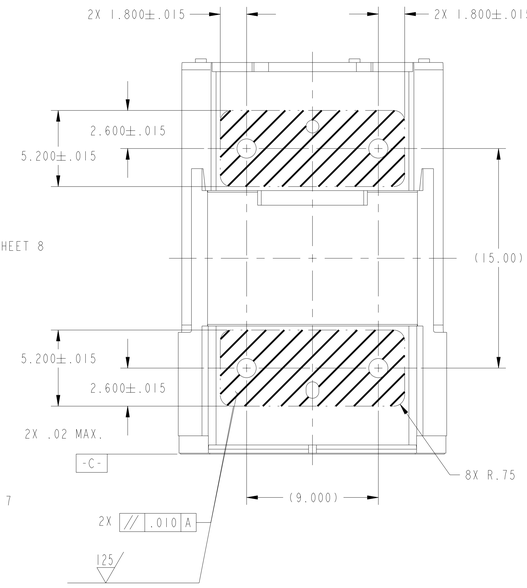
FRONT VIEW
SCALE 0.250



SECTION H-H
SCALE 0.250



BACK VIEW
SCALE 0.250



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P THIS DRAWING PRODUCED ON PRO-ENGINEER

PRELIMINARY

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

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Oak Ridge, Tennessee
SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
MULTI CORE VESSEL INSERT
MULTI C.V. INSERT PLUG WELDMENT

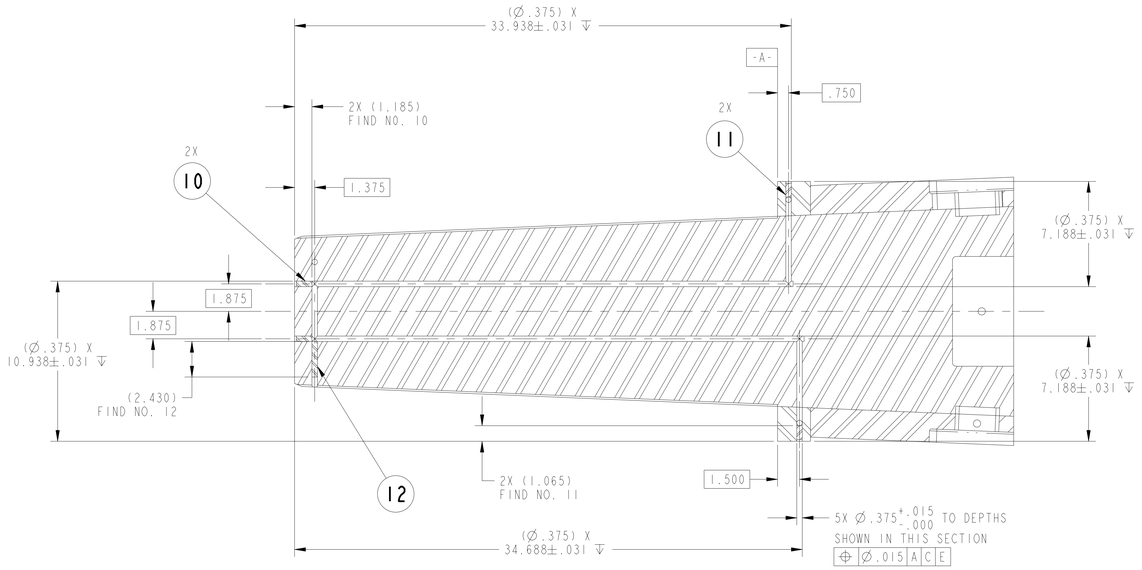
BLDG	FL	SHT	OF	CLASS
8700	1ST	9	11	U

I07030600M8E8700A104 REV 00A

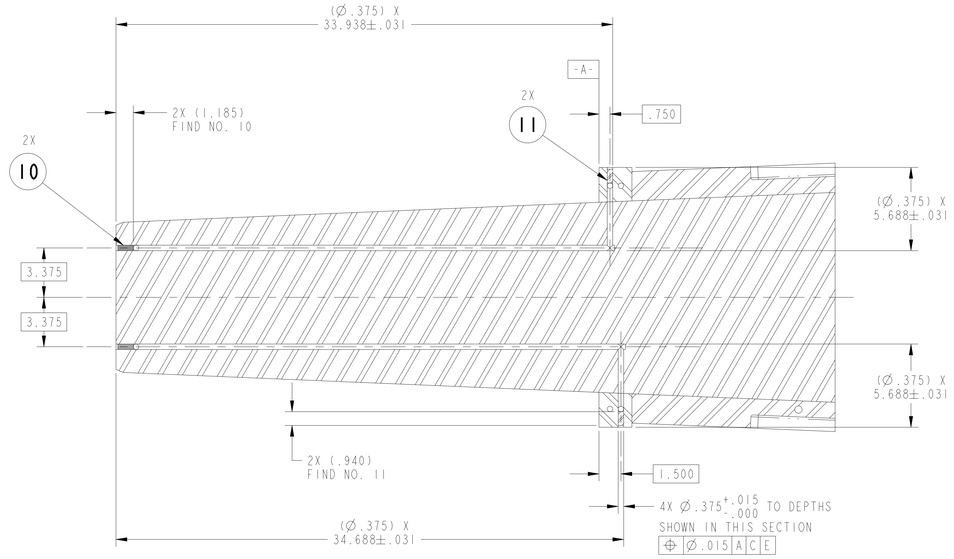
I07030600M8E8700A104

NOTES

SEE SHEET 1 FOR NOTES AND MATERIAL LIST.



SECTION J-J
SCALE 0.250



SECTION K-K
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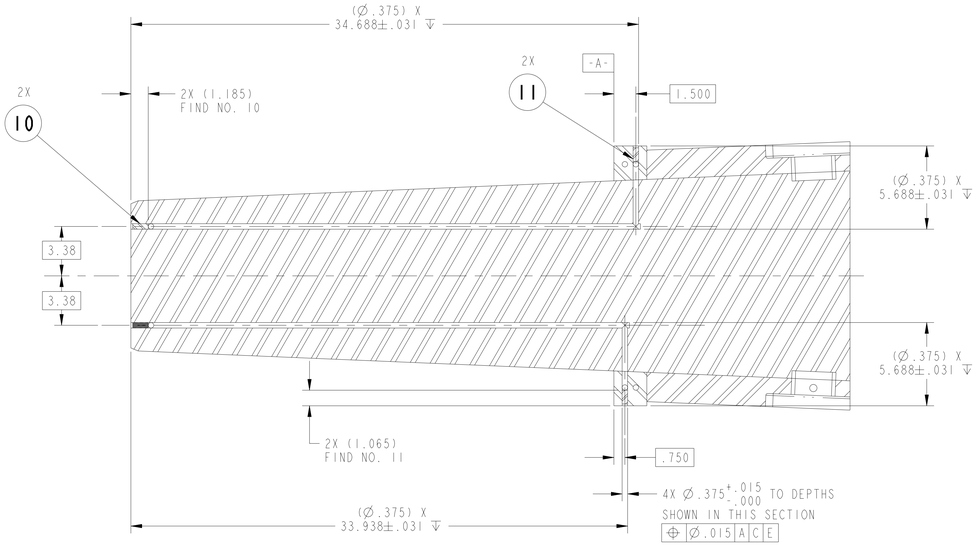

SECTION L-L
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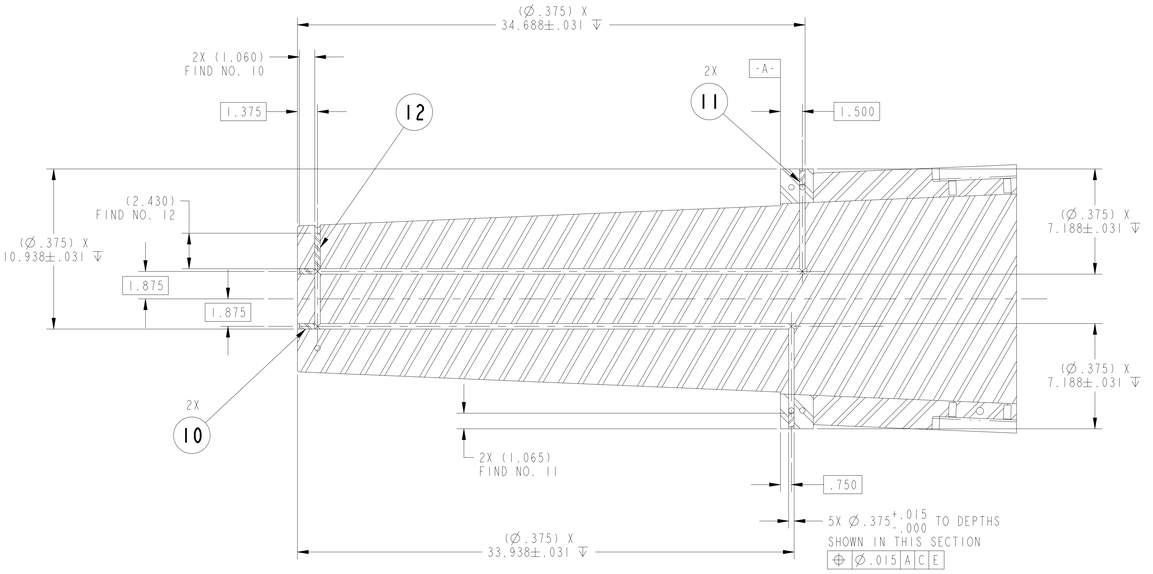

SECTION M-M
SCALE 0.250

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PRELIMINARY

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

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Oak Ridge, Tennessee
SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
MULTI CORE VESSEL INSERT
MULTI C.V. INSERT PLUG WELDMENT

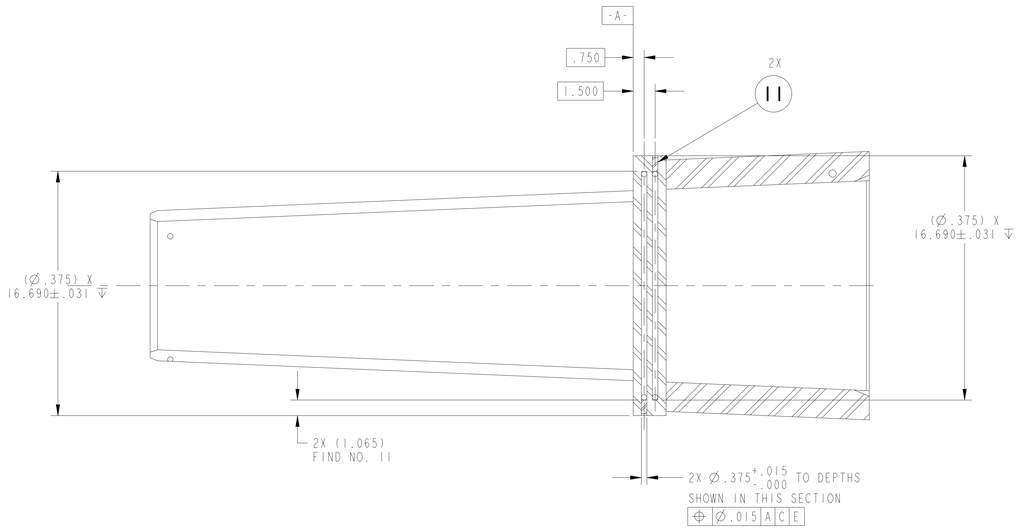
BLDG	FL	SHT	OF	CLASS
8700	1ST 10	11		U

107030600M8E8700A104 REV 00A

107030600M8E8700A104

NOTES

SEE SHEET 1 FOR NOTES AND MATERIAL LIST.



SECTION N-N
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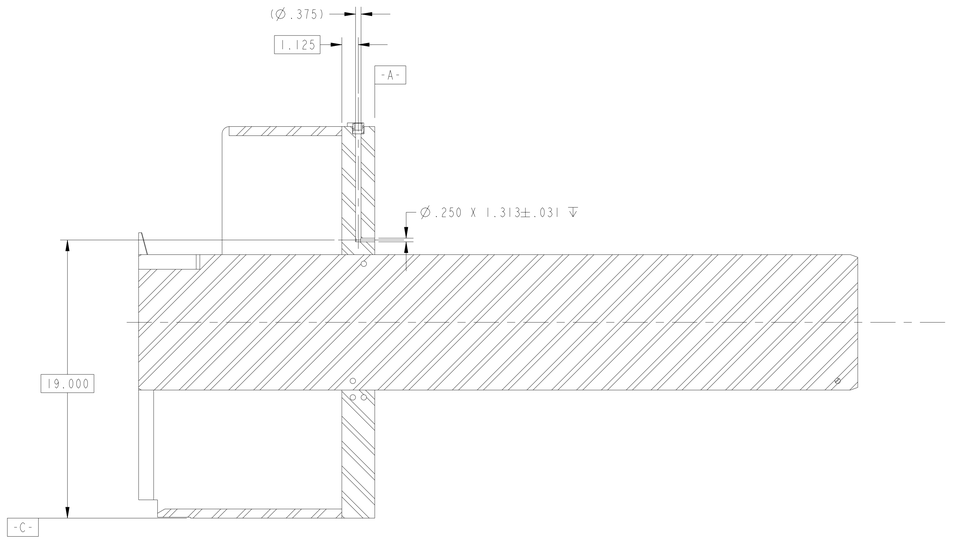
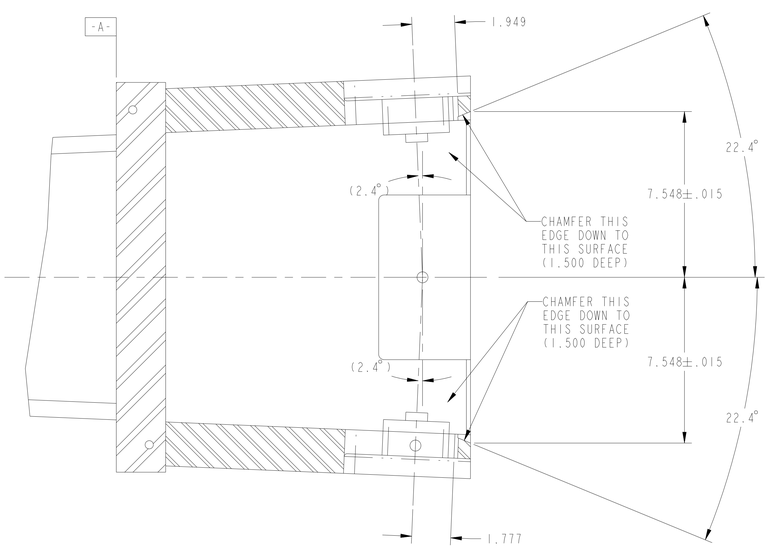


SECTION P-P
SCALE 0.250



SECTION X-X
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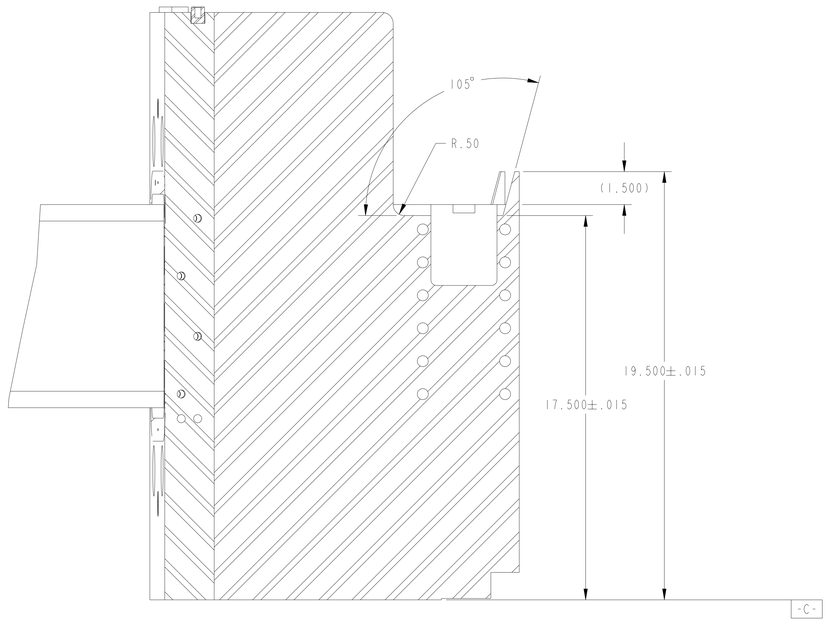

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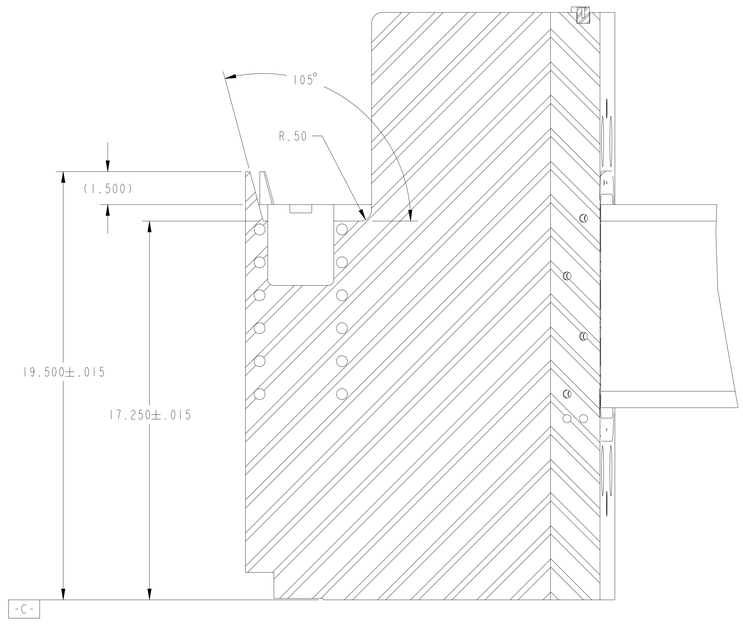

SECTION QQ-QQ
SCALE 0.375

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SCALE AS NOTED	ornl Oak Ridge National Laboratory
TOLERANCES UNLESS OTHERWISE SPECIFIED	operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee
FRACTIONS :	SNS Spallation Neutron Source
XX DECIMALS ±.01	SPALLATION NEUTRON SOURCE PROJECT
XXX DECIMALS ±.005	MULTI CORE VESSEL INSERT
ANGLES ±0°15'	MULTI C.V. INSERT PLUG WELDMENT
BREAK SHARP EDGES .06 MAX	BLDG 8700 · FL 1ST 11 · SHT OF 11 · CLASS U
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	107030600M8E8700A104 · REV 00A

107030600M8E8700A104