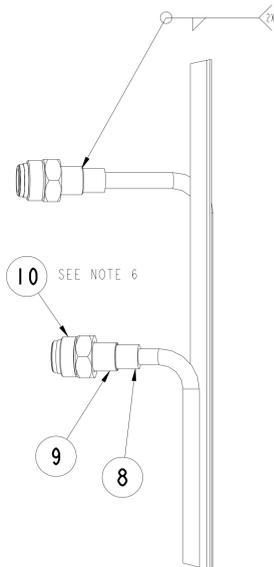
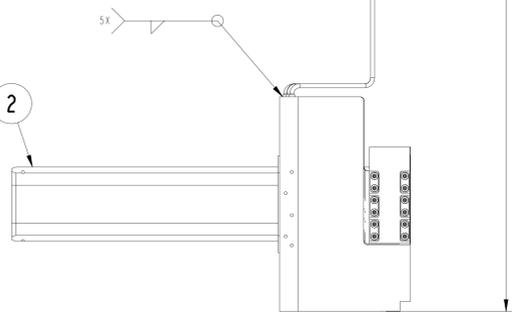


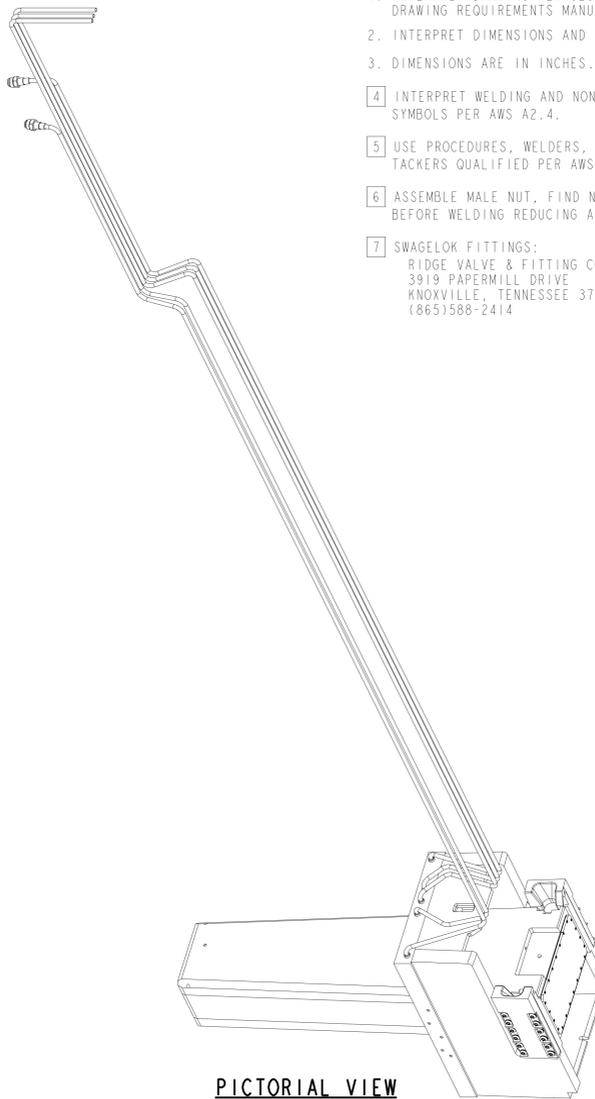
SEE DETAIL X



DETAIL X
SCALE 0.500



FRONT VIEW
SCALE 0.125



PICTORIAL VIEW
SCALE 0.125

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.
6. ASSEMBLE MALE NUT, FIND NO. 10, TO REDUCING ADAPTER, FIND NO. 9, BEFORE WELDING REDUCING ADAPTER TO SOCKET WELD GLAND, FIND NO. 8.
7. SWAGelok FITTINGS:
RIDGE VALVE & FITTING CO.
3919 PAPERMILL DRIVE
KNOXVILLE, TENNESSEE 37909
(865)588-2414

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
6	7	2								
6	7	2								
6	7	2								
		1								
		1								
		1								
		1								
		1								
4	5	1								
4	5	1								

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		MALE NUT	STAINLESS STEEL	---	10
		SOCKET WELD GLAND	STAINLESS STEEL	---	9
		REDUCING ADAPTER	STAINLESS STEEL	---	8
		CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	7
		CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	6
		CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	5
		CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	4
		CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	3
		MULTI C V INSERT W/ALIGNMENTS	---	---	2
		UPPER MULTI C V INSERT W/TUBING	---	---	1

PARTS LIST

WEIGHT: APPROX. 1,609 LBS.

PRELIMINARY

QUALITY VERIFICATION

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 (WHEN APPLICABLE)	-
318	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	-
330	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDERS ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM. SNS PROCEDURES-SNS-TS-600!

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
00A	---	3	---	---	---	---	02/02	---	---	---

SCALE AS NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED:
FRACTIONS: ±.01
XX DECIMALS ±.005
XXX DECIMALS ±.0015
ANGLES ±0'15"
BREAK SHARP EDGES OR MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES: DMW/MEP 07/01
M.E. PHILLIPS 07/01

T.E. FORNEK 02/02

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

Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
FACILITY CORE VESSEL INSERTS
UPPER MULTI C V INSERT W/TUBING

BLDG 8700 FL 1 SHT 2 OF 2 CLASS U

107030600M8E8700A107

8

7

6

5

4

3

2

NEXT ASS'Y:

I FINAL ASS'Y:

H

H

G

G

F

F

E

E

D

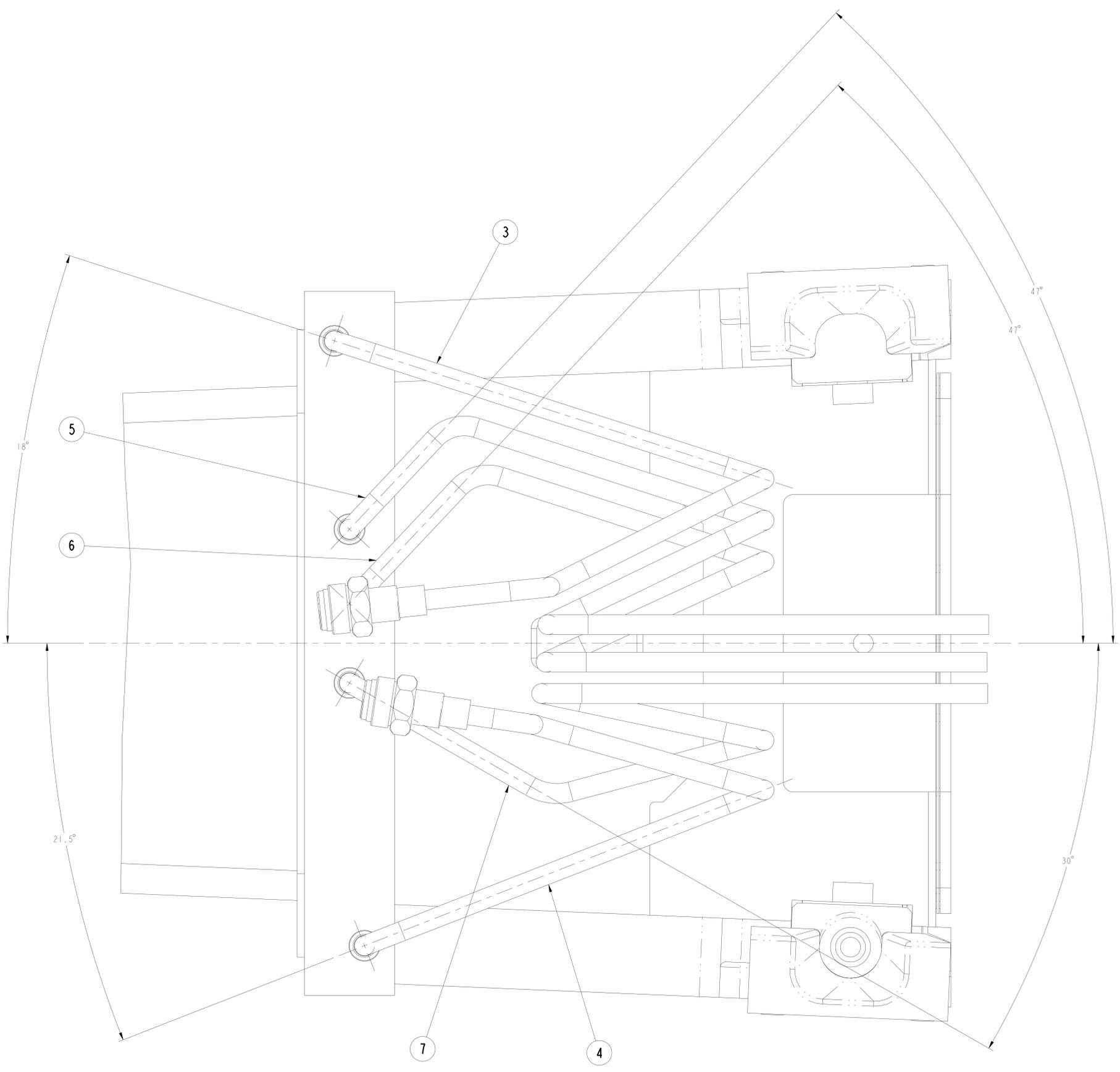
D

C

C

B

B



PARTIAL TOP VIEW
SCALE 1:1000

PRELIMINARY

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE AS NOTED	
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	± .01
XX DECIMALS	± .005
XXX DECIMALS	± .0015
ANGLES	± 0°15'
BREAK SHARP EDGES	.06 MAX
FINISH	125 RMS UNLESS OTHERWISE SPECIFIED

Oak Ridge National Laboratory operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee Spallation Neutron Source				
SPALLATION NEUTRON SOURCE PROJECT FACILITY CORE VESSEL INSERTS UPPER MULTI C V INSERT W/TUBING				
BLDG	FL	SHT	OF	CLASS
8700	1ST	2	2	U
107030600M8E8700A107				REV
				00A

107030600M8E8700A107

8

7

6

5

4

3

2

A