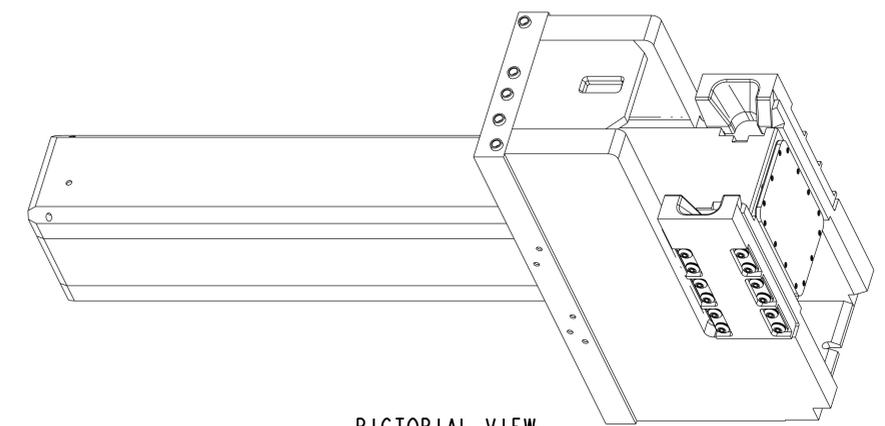
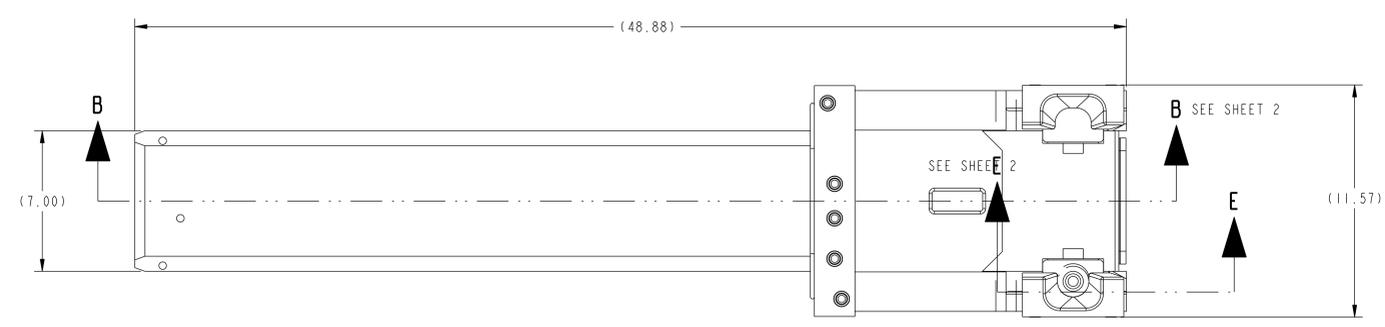
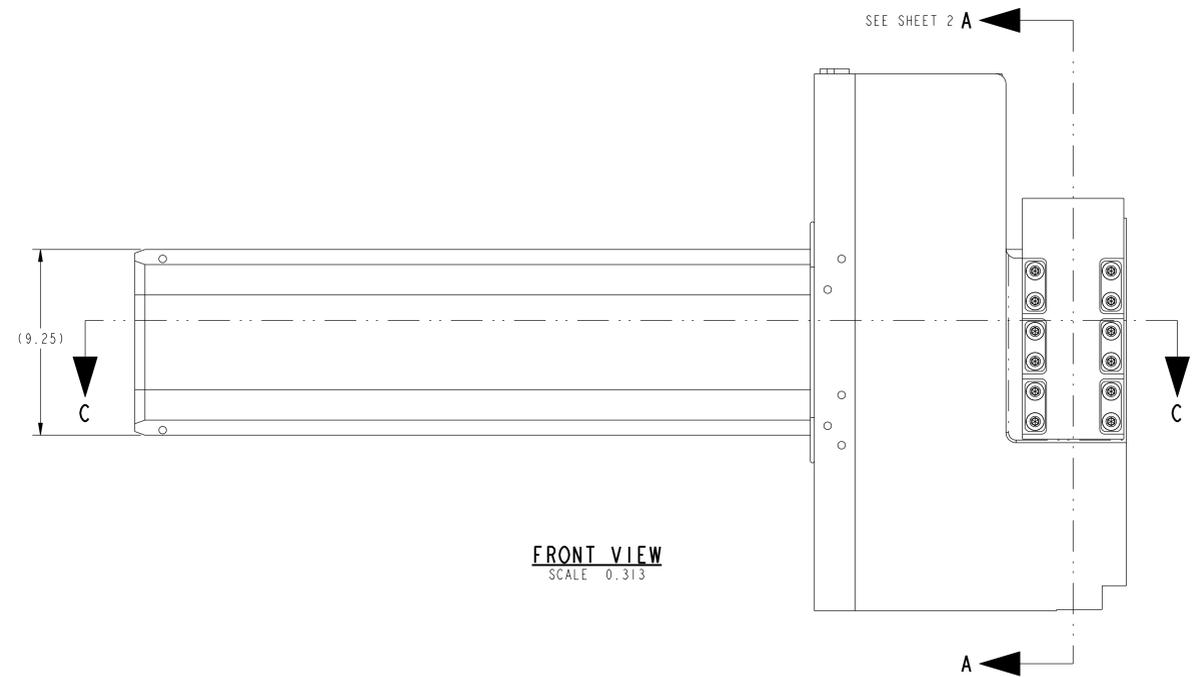


NOTES

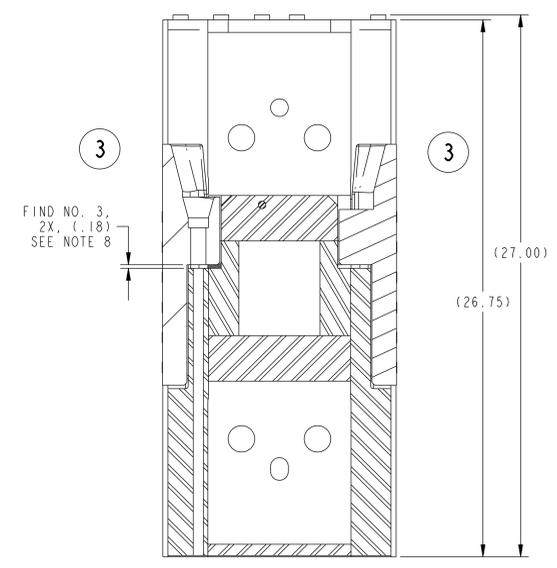
1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. BUTTON HEAD CAPSCREWS, FIND NO. 10, SHALL BE INSTALLED WITH LOCTITE, FIND NO. 12, IN ACCORDANCE WITH LOCTITE PROCEDURES AND TIGHTENED TO 35 IN.-LBS.
5. FLAT HEAD CAP SCREWS, FIND NO. 11, SHALL BE INSTALLED WITH LOCTITE, FIND NO. 12, IN ACCORDANCE WITH LOCTITE PROCEDURES AND TIGHTENED TO 35 IN.-LBS.
6. UNBRAKO DIV/SPS TECHNOLOGIES, 4444 LEE RD. CLEVELAND OHIO 44128
7. LOCTITE CORPORATION, 1001 TROUT BROOK CROSSING, ROCK HILL, CT. 06067-3910.
8. GUIDE LOWER SHIM THICKNESS SHALL BE DETERMINED AT FINAL ASSEMBLY.
9. BALL GUIDE SHIM THICKNESS SHALL BE DETERMINED AT FINAL ASSEMBLY.



PICTORIAL VIEW
SCALE 0.250



FRONT VIEW
SCALE 0.313



SECTION A-A

QTY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
28	T3585-3C380	#10-24" UNC HELI-CAL SCR LOCK INS	STAINLESS STEEL	SS 18-8	16
28	72531-3C-10U	LHCS #10-24UNC X .625 LG.	ALLOY STEEL	AISI 4140	15
2	107030600M8E8700A149-1	SINGLE INSERT WINDOW	ALUMINUM	6061-T6	14
2	107030600M8E8700A148-1	SINGLE INSERT GASKET	ALUMINUM	1100-T0	13
1	271-LOCTITE	RETAINING COMPOUND	PURCHASED	---	12
4	16990-94C-8U	FHCS #4-40 UNC X 0.50" LG	ALLOY STEEL	AISI 4140	11
1	107030600M8E8700A173-1	SINGLE C V INS GSRT ASSY	---	---	8
1	107030600M8E8700A115-1	SINGLE C V INSERT W/ WINDOW	---	---	2
1	107030600M8E8700A114-1	SINGLE C V INSERT W/ ALIGNMENTS	---	---	1

PARTS LIST

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO
30.3	MATERIAL MILL TEST REPORT	-
32.5	MATERIAL SELLER CERT	-
32.6	SPECIM MATERIAL INSPECTION REPORT	-
20.5	WELDING, INSPECTION AND TEST PLAN	-
31.2	FIELD INSPECTION AND TEST PLAN	-
32.1	WELD AND BRAZE INSPECTION REPORT	-
32.2	HEAT TREAT REPORT (W/CHART)	-
31.8	LEAK TEST REPORT	-
31.5	CLEANING CERT	-
31.8	DEVIATION REQUEST	-
31.9	NONCONFORMANCE PROCESS	-
32.3	DIMENSIONAL REPORT	-
33.0	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE SNS-TS-6002

APPROXIMATE WEIGHT: 1,185 LBS.

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
THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM.---3---
SNS PROCEDURES:TS-6001

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
3	11/01	ISSUED FOR COMMENT AND INFORMATION	SMR							

SCALE AS NOTED	DES	DMW/SMR	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW	S.M. ROGERS	11/01
FRACTIONS	CHK		
XX DECIMALS ±.01	L3		
XXX DECIMALS ±.005	L2		
ANGLES ±0'15"			
BREAK SHARP EDGES OR MAX FINISH 125 RMS UNLESS OTHERWISE SPECIFIED			

QA REP DATE

ORNL 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
SINGLE CORE VESSEL INSERT
SINGLE C V INSERT W/ ALIGNMENTS**

BLDG 8700 FL SHT 1 OF 2 CLASS U

107030600M8E8700A114

107030600M8E8700A114

A

8

7

6

5

4

3

2

NEXT ASS'Y:

I FINAL ASS'Y:

H

G

F

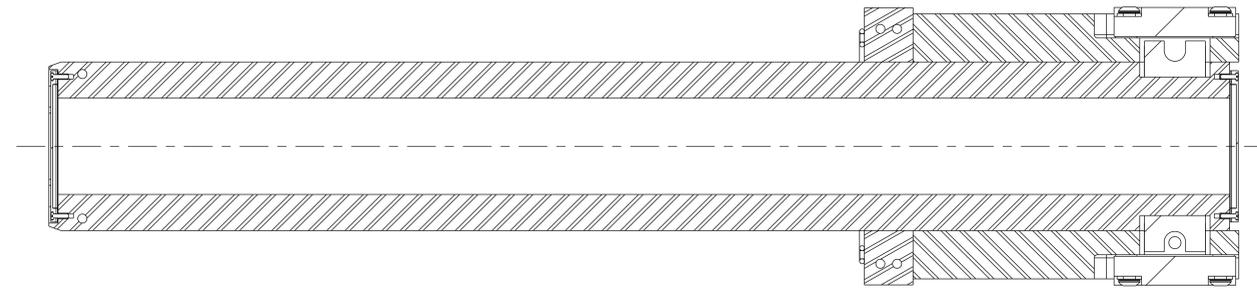
E

D

C

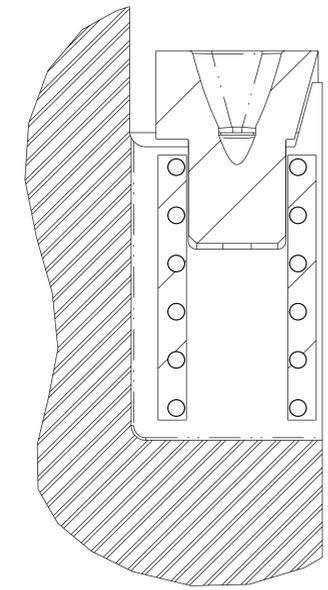
B

A

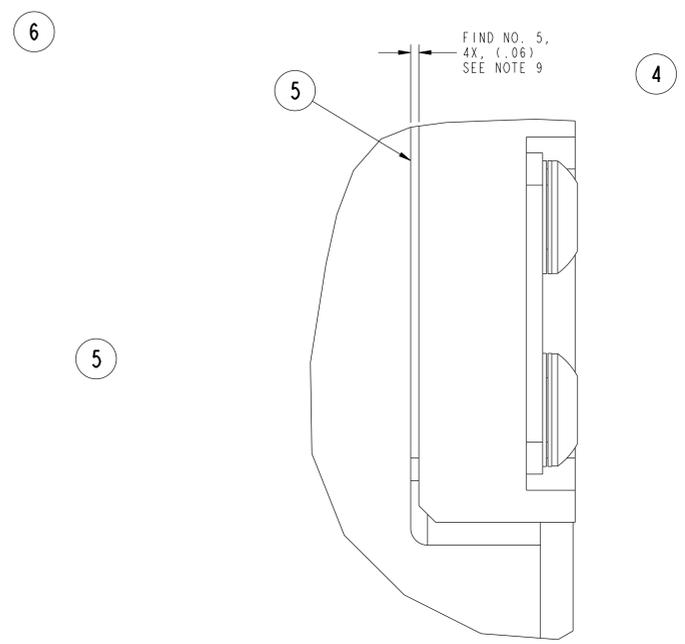


SECTION C-C

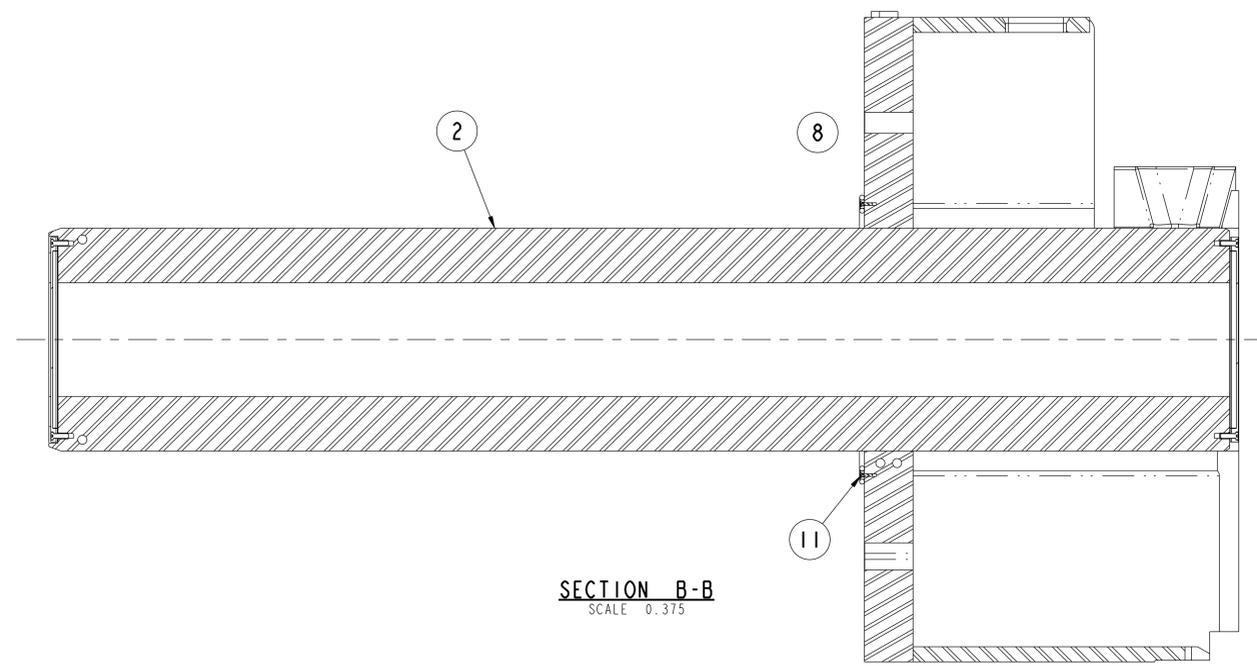
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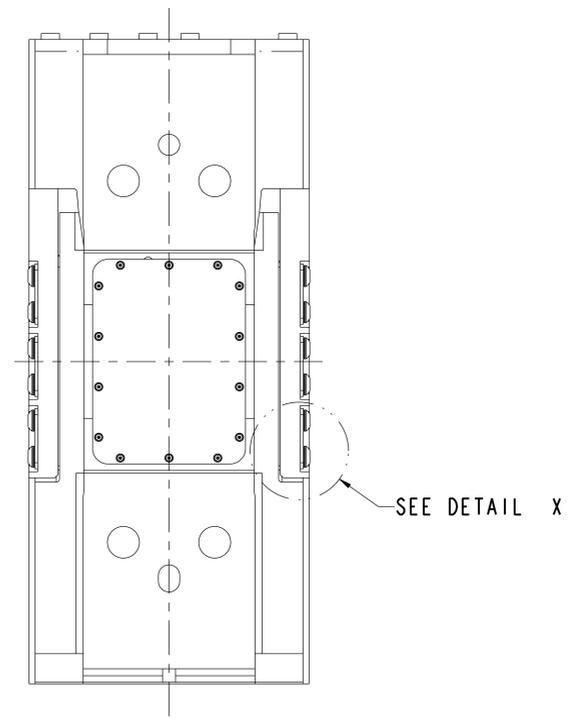
PARTIAL SECTION E-E
SCALE 0.500



DETAIL X
SCALE 2.000



SECTION B-B
SCALE 0.375



SEE DETAIL X

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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

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 SINGLE CORE VESSEL INSERT SINGLE C V INSERT W/ ALIGNMENTS	
BLDG	FL
8700	IST 2 2 U
107030600M8E8700A114	
REV	ROC

107030600M8E8700A114

8

7

6

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4

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2

A