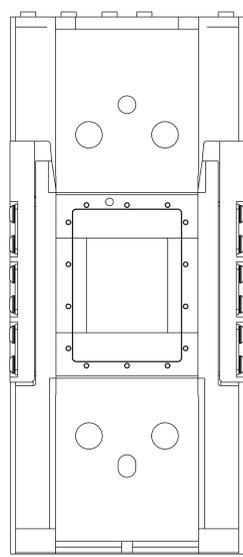
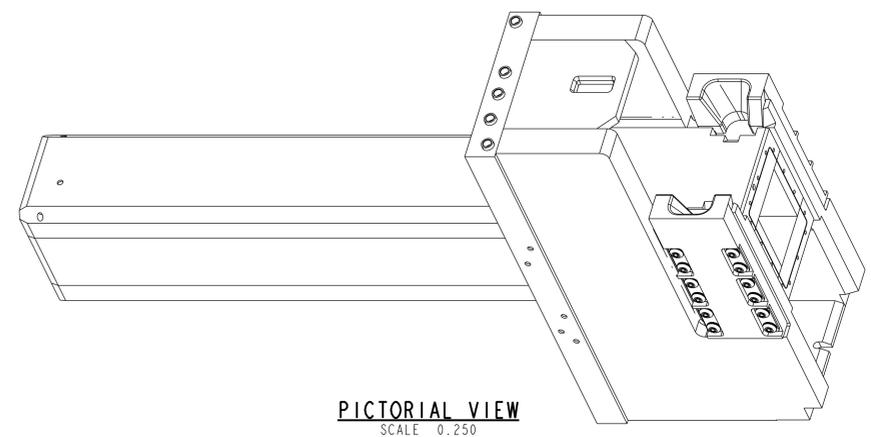
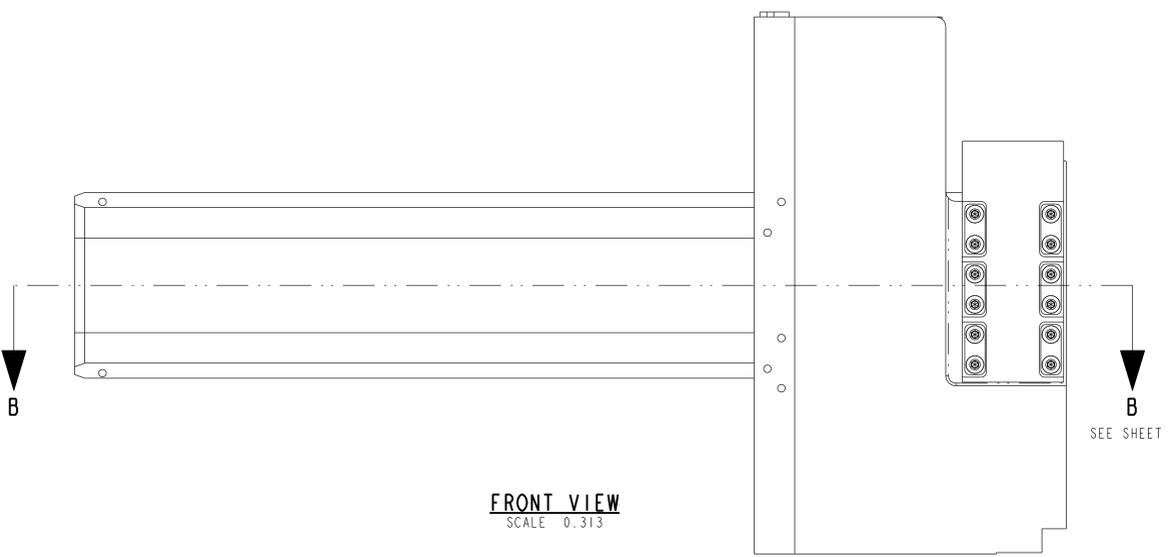


- NOTES**
- INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
 - INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
 - DIMENSIONS ARE IN INCHES.
 - LOW HEAD CAP SCREWS, FIND NO. 5, SHALL BE INSTALLED WITH LOCTITE, FIND NO. 7, IN ACCORDANCE WITH LOCTITE PROCEDURES AND TIGHTENED TO 35 IN.-LBS.
 - HELICOIL INSERTS, FIND NO. 6, SHALL BE INSTALLED PER HELICOIL SPECIFICATIONS.
 - UNBRAKO DIV/SPS TECHNOLOGIES, 4444 LEE RD. CLEVELAND OHIO 44128
 - HELICOIL INSERTS REPRESENTATIVE:
EMHART FASTENING TECHNOLOGIES-INDUSTRIAL USA
3703 ERIN BROOK DRIVE
NEW PORT RICHEY, FL. 34655-2901
(727)327-3678
 - LOCTITE CORPORATION, 1001 TROUT BROOK CROSSING, ROCK HILL, CT. 06067-3910.
 - TORQUE LOW HEAD CAP SCREWS, FIND NO. 5, PER NOTE 4. TORQUE SCREWS IN THE SEQUENCE SHOWN ON SHEET 2, IN THE LEFT & RIGHT END VIEWS.



REV	QTY	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
1	24	S300NA46CAM27835NCC								
	24	91074A133								
	12	107030600M8E8700A143-I								
	1	271-LOCTITE								
	1	107030600M8E8700A134-I								
	4	107030600M8E8700A133-I								
	1	107030600M8E8700A132-I								
	2	107030600M8E8700A129-I								
	1	107030600M8E8700A116-I								
	1	107030600M8E8700A115-I								

REV	QTY	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
1	1	107030600M8E8700A14								

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
24	S300NA46CAM27835NCC	BUTTON HEAD CAP SCREW	ALLOY STEEL	ASTM F835	10
24	91074A133	PERMANENT TIGHT LOCK WASHER	STEEL	--	9
12	107030600M8E8700A143-I	C.V.I. BACKING PLATE DETAIL	CARBON STEEL	ASTM A36	8
1	271-LOCTITE	RETAINING COMPOUND	PURCHASED	---	7
1	107030600M8E8700A134-I	LEFT SIDE BALL GUIDE	STAINLESS STEEL	316L	6
4	107030600M8E8700A133-I	BALL GUIDE SHIM	STAINLESS STEEL	316L	5
1	107030600M8E8700A132-I	RIGHT SIDE BALL GUIDE	STAINLESS STEEL	316L	4
2	107030600M8E8700A129-I	GUIDE LOWER SHIM	STAINLESS STEEL	316L	3
1	107030600M8E8700A116-I	SINGLE C V INSERT WELDMENT	---	---	2
1	107030600M8E8700A115-I	SINGLE C V INSERT W/ WINDOW	---	---	1

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/CHRT)	-
310	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	-
330	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

PRELIMINARY

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM. SNS-PROC-001

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

SCALE AS NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS: L2
XX DECIMALS: ±.01
XXX DECIMALS: ±.005
ANGLES: ±0'15"
BREAK SHARP EDGES OR MAX
FINISH: 125 RMS UNLESS OTHERWISE SPECIFIED

DES: DMW/SMR
DRW: S.M. ROGERS
CHK: :
L3: :
L2: :
T.E. FORNEK 11/01

QA REP: DATE: 11/01

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/ WINDOW**

BLDG: 8700 FL: 1 SHT: 2 OF: 2 CLASS: U
REV: 3

107030600M8E8700A115

8

7

6

5

4

3

2

NEXT ASS'Y:

FINAL ASS'Y:

H

H

G

G

F

F

E

E

D

D

C

C

B

B

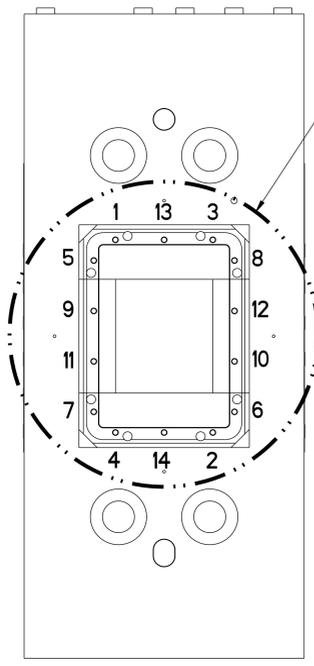
A

A

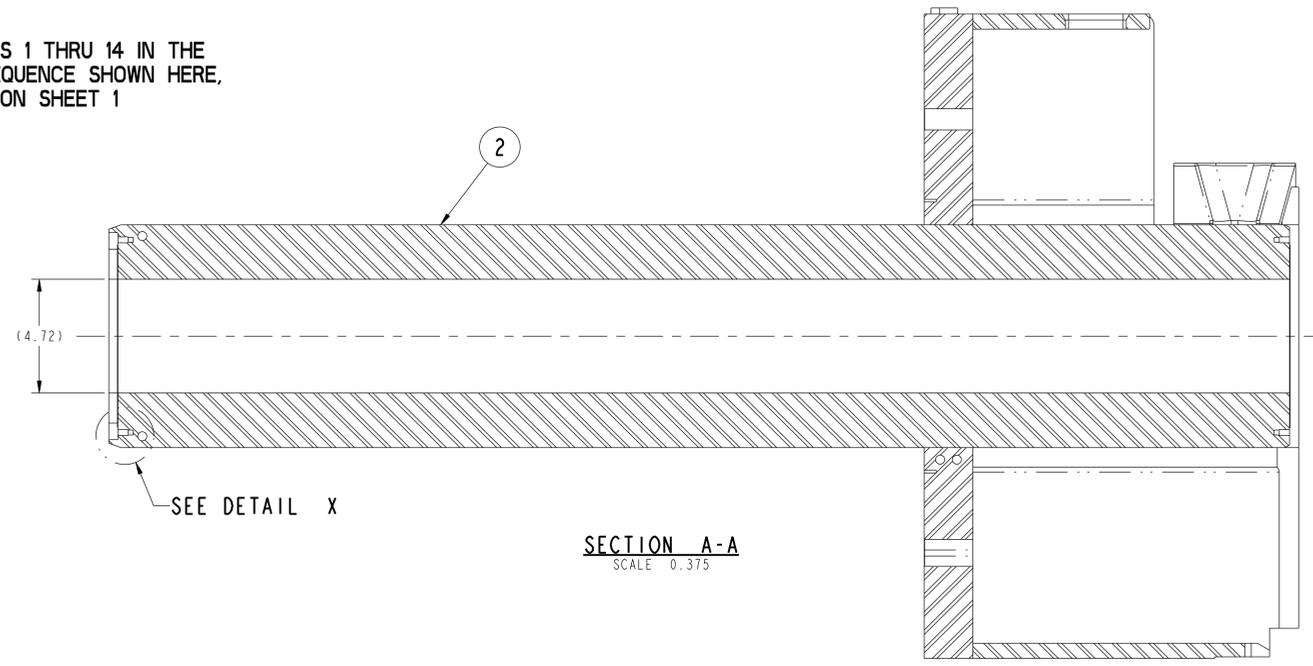
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TORQUE BOLTS 1 THRU 14 IN THE NUMBERED SEQUENCE SHOWN HERE, SEE NOTE 9 ON SHEET 1

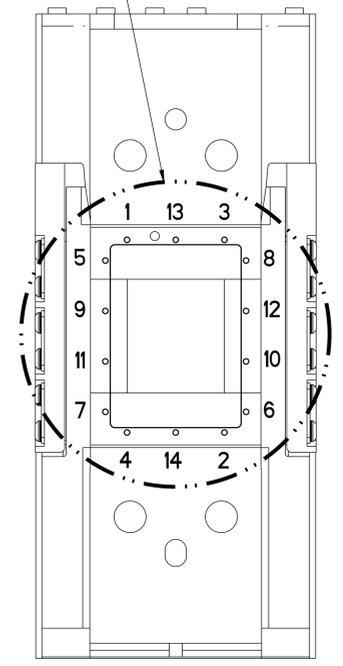
TORQUE BOLTS 1 THRU 14 IN THE NUMBERED SEQUENCE SHOWN HERE, SEE NOTE 9 ON SHEET 1



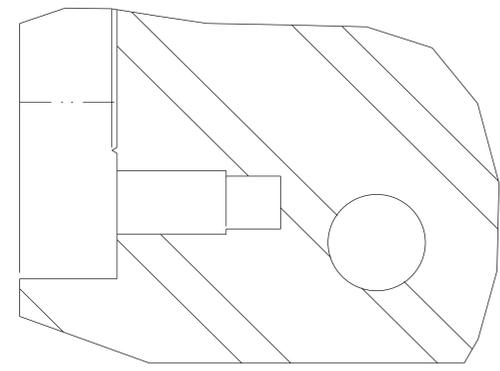
LEFT END VIEW



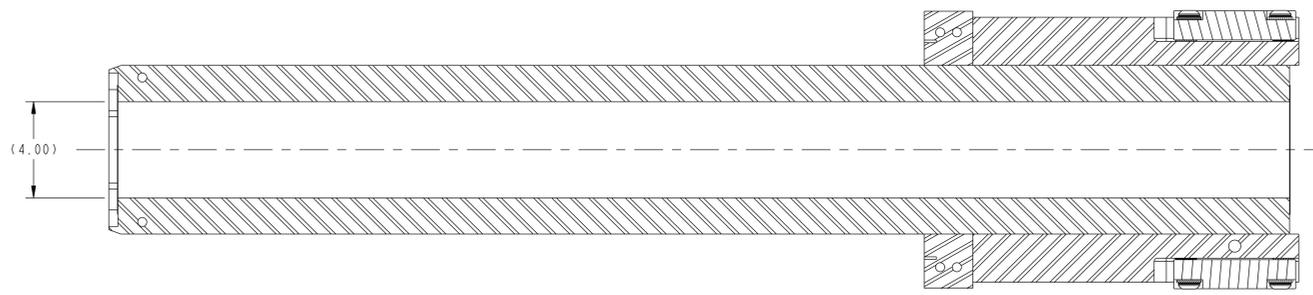
SECTION A-A
SCALE 0.375



RIGHT END VIEW



DETAIL X
SCALE 4.000



SECTION B-B
SCALE 0.375

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PRELIMINARY

SCALE AS NOTED	ORNL Oak Ridge National Laboratory operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee	
TOLERANCES UNLESS OTHERWISE SPECIFIED	Spallation Neutron Source	
FRACTIONS	SPALLATION NEUTRON SOURCE PROJECT	
XX DECIMALS ±.01	SINGLE CORE VESSEL INSERT	
XXX DECIMALS ±.005	SINGLE C V INSERT W/ WINDOW	
ANGLES ±0°15'	BLDG FL SHT OF CLASS	
BREAK SHARP EDGES .06 MAX	8700	IST 2 2 U
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	REV	
	107030600M8E8700A115	

8

7

6

5

4

3

2

ROC