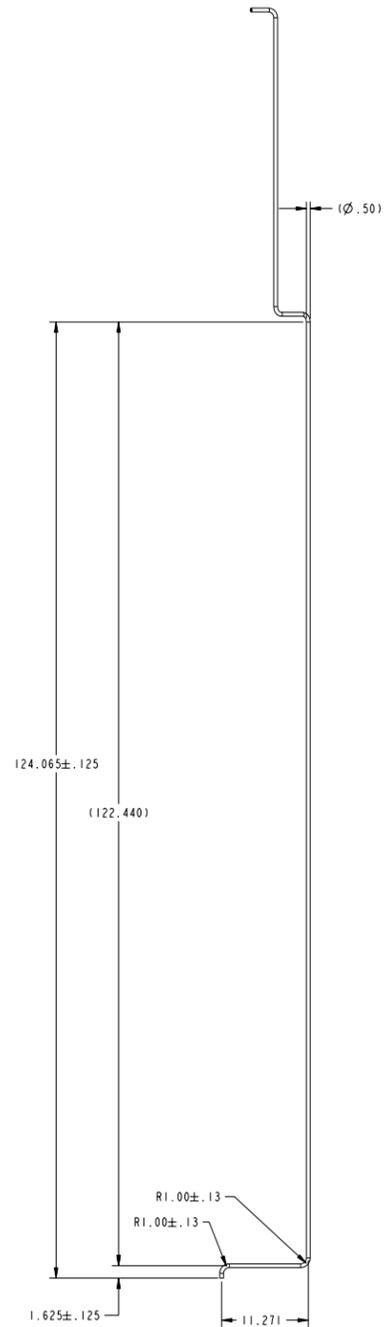
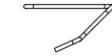


NOTES

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. TUBING IS APPROXIMATELY 82" LONG.

PLAN VIEW



SIDE VIEW
SCALE 0.140

PICTORIAL VIEW
SCALE 0.156

| CAGE CODE | PART OR IDENTIFYING NO | NOMENCLATURE OR DESCRIPTION | MATERIAL | SPECIFICATION | FINISH |
|----------------------|------------------------|-----------------------------|--------------------------------|---------------|--------|
| 107030600M8E8700A163 | | CONNECTING TUBE DETAIL | SEAMLESS 304 SST x 0.035" WALL | ASTM A269 | |

QUALITY VERIFICATION

| QA CLAUSE | DOCUMENTS REQUIRED | APPLICABLE TO PART NO |
|-----------|--|-----------------------|
| 303 | MATERIAL MILL TEST REPORT | - |
| 305 | MATERIAL SELLER CERT | - |
| 306 | SPECIAL MATERIAL INSPECTION REPORT | - |
| 205 | MANUFACTURING INSPECTION AND TEST PLAN | - |
| 312 | FIELD INSPECTION AND TEST PLAN | - |
| 321 | WELD AND WELD INSPECTION REPORT | - |
| 322 | WELD TREAT REPORT (REQUIRED) | - |
| 310 | LEAK TEST REPORT | - |
| 315 | CLEANING CERT | - |
| 318 | DEVIATION REQUEST | - |
| 319 | NONCONFORMANCE PROCESS | - |
| 323 | DIMENSIONAL REPORT | - |
| 330 | FUNCTIONAL TEST REPORT | - |
| 100 | DOCUMENTATION | - |

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: IS:0001

| REV | DATE | DESCRIPTION | BY | CHK | SECT | DEPT | DATE | PE | REQ | DOE |
|-----|------|-----------------------------------|-----|-----|------|------|-------|----|-----|-----|
| 00A | 3 | ISSUE FOR COMMENT AND INFORMATION | SMR | | | | 11/01 | | | |

| SCALE AS NOTED | DES | DATE |
|---------------------------------------|---------------|-------|
| TOLERANCES UNLESS OTHERWISE SPECIFIED | DMW/MEP | 11/01 |
| FRACTIONS | M.E. PHILLIPS | 11/01 |
| XX DECIMALS ±.01 | | |
| XXX DECIMALS ±.005 | | |
| ANGLES ±0°15' | T.E. FORNEK | 11/01 |
| BREAK SHARP EDGES .04 MAX | | |
| FINISH 125 UNLESS OTHERWISE SPECIFIED | | |

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

SNS Spallation Neutron Source

SPALLATION NEUTRON SOURCE PROJECT
SINGLE & MULTI CORE VESSEL INSERT
CONNECTING TUBE DETAIL

REV. XX DATE XX/XX/XX

107030600M8E8700A163