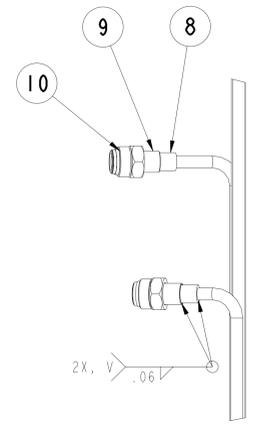
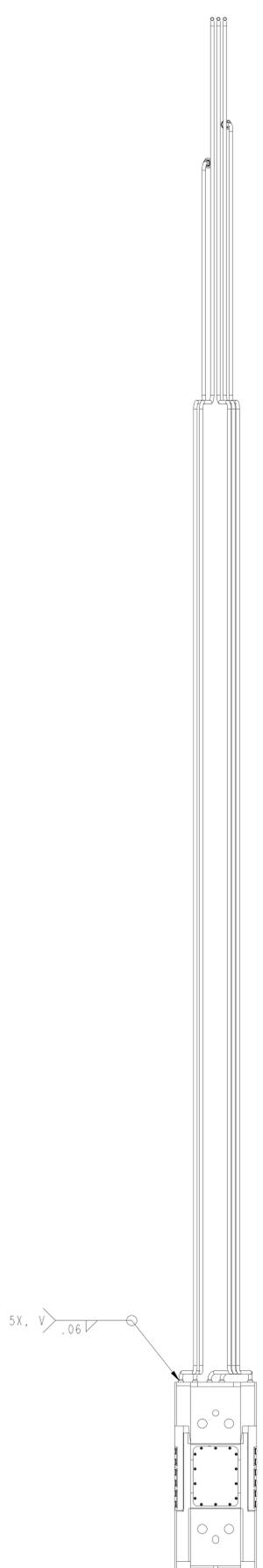
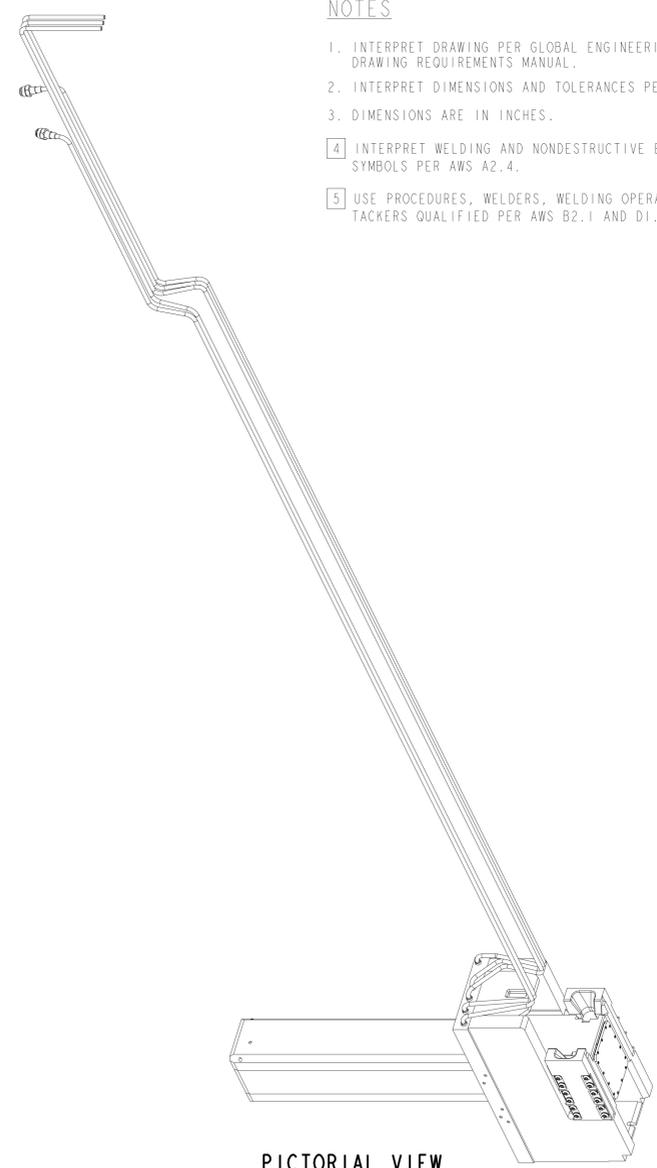


FRONT VIEW
SCALE 0.125



DETAIL X
SCALE 0.375



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 AND D1.1.

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
2	SS-12-VCR-4	MALE NUT	STAINLESS STEEL	---	10
2	SS-12-VCR-3	SOCKET WELD GLAND	STAINLESS STEEL	---	9
2	SS-12-MTW-8-8TSW	REDUCING ADAPTER	STAINLESS STEEL	---	8
1	107030600M8E8700A204-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	7
1	107030600M8E8700A203-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	6
1	107030600M8E8700A202-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	5
1	107030600M8E8700A201-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	4
1	107030600M8E8700A200-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	3
1	107030600M8E8700A114-1	SINGLE C V INSERT W/ ALIGNMENTS	---	---	2
1	107030600M8E8700A112-1	LOWER SINGLE C V INSERT W/TUBING	---	---	1

PARTS LIST

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE SNS-TS-G002

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)	-
318	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

WEIGHT: APPROX. 1,085 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...
SNS PROCEDURES-TS-G001

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
00A	3	ISSUE FOR COMMENT AND INFORMATION	SMR				02/02			

SCALE AS NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS 1/2
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES OR MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES: DMW/MEP 01/02
DRW: M.E. PHILLIPS 01/02
DATE: 02/02

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 FACILITY CORE VESSEL INSERTS LOWER SINGLE C V INSERT W/TUBING

BLDG 8700 FL 1 SHT 2 OF 2 CLASS U
REV 00A

107030600M8E8700A112

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

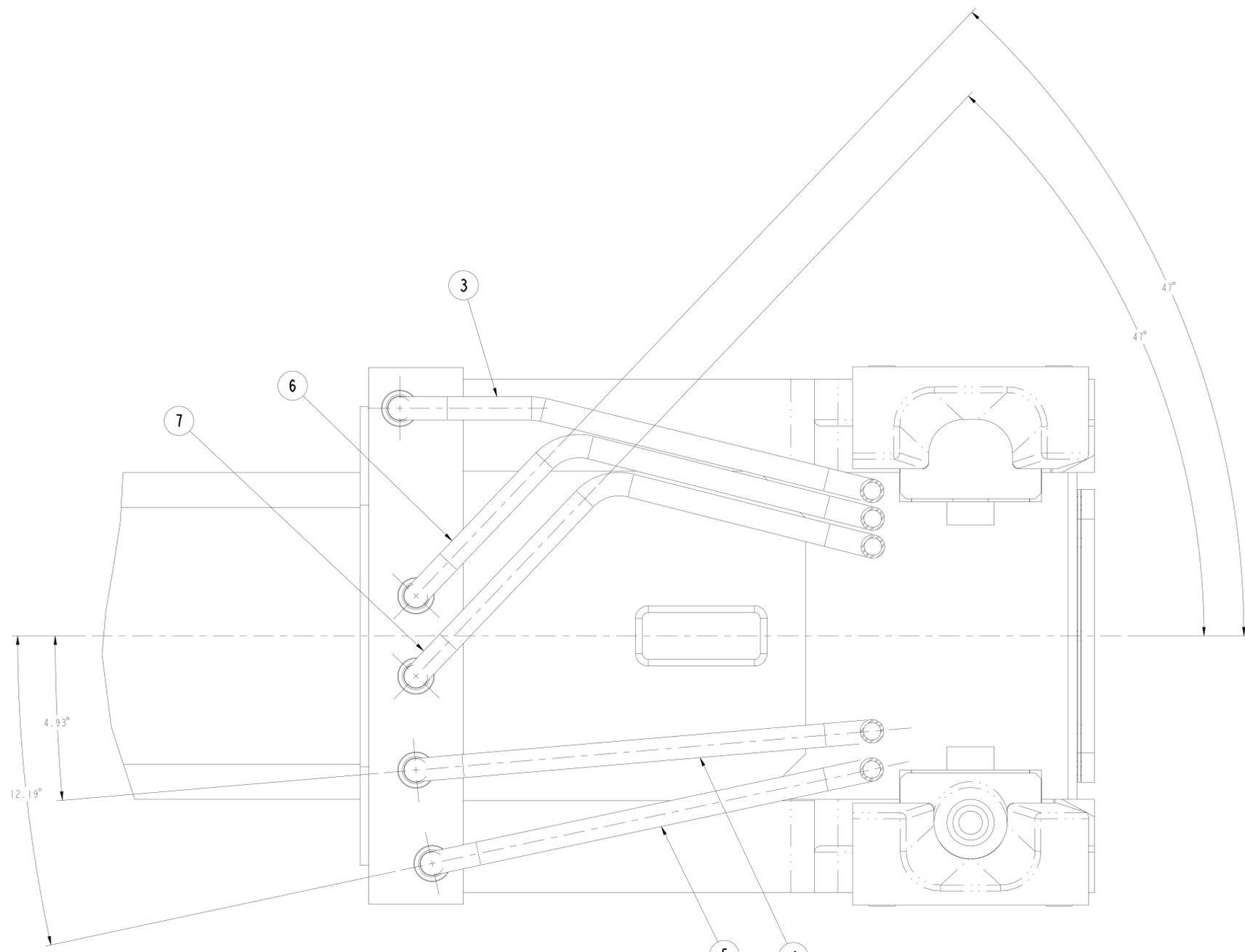
C

B

B

A

A



SECTION A-A
SCALE 1:1.000

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	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	FACILITY CORE VESSEL INSERTS			
XXX DECIMALS ±.005	LOWER SINGLE C V INSERT W/TUBING			
ANGLES ±0°15'	BLDG			
BREAK SHARP EDGES .06 MAX	8700			
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	FL	SHT	OF	CLASS
	IST	2	2	U
	107030600M8E8700A112			REV
				00A

107030600M8E8700A112

8

7

6

5

4

3

2