

8

7

6

5

4

3

2

NEXT ASS'Y:

I FINAL ASS'Y:

NOTES

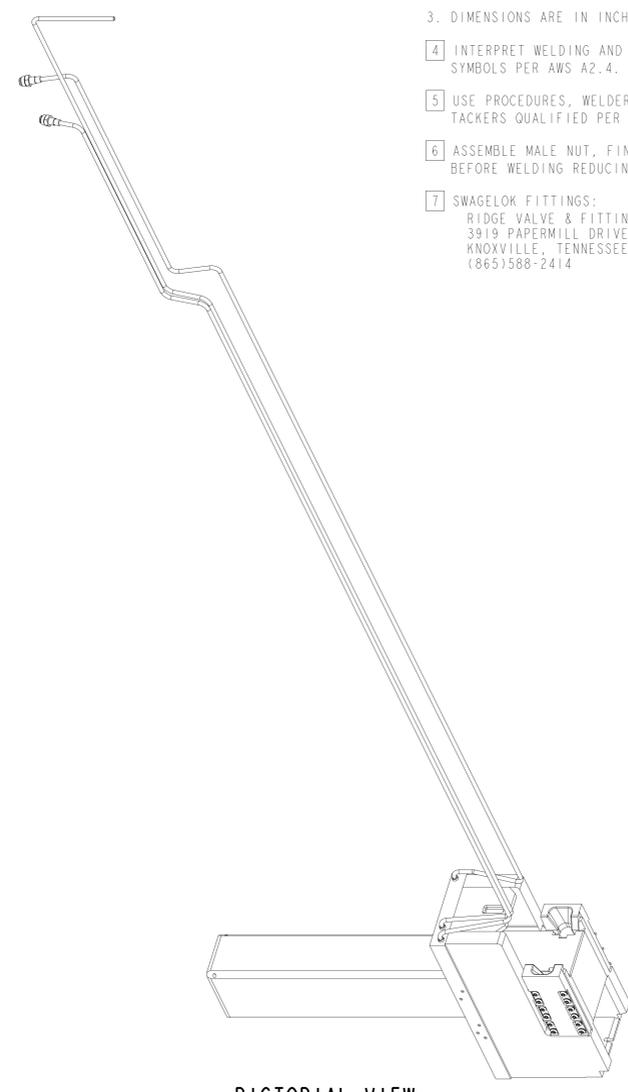
- 1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
- 2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
- 3. DIMENSIONS ARE IN INCHES.
- 4. INTERPRET WELDING AND NONDESTRUCTIVE EXAMINATION SYMBOLS PER AWS A2.4.
- 5. USE PROCEDURES, WELDERS, WELDING OPERATORS AND TACKERS QUALIFIED PER AWS B2.1.
- 6. ASSEMBLE MALE NUT, FIND NO. 8, TO REDUCING ADAPTER, FIND NO. 7, BEFORE WELDING REDUCING ADAPTER TO SOCKET WELD GLAND, FIND NO. 6.
- 7. SWAGelok FITTINGS:
RIDGE VALVE & FITTING CO.
3919 PAPERMILL DRIVE
KNOXVILLE, TENNESSEE 37909
(865)588-2414



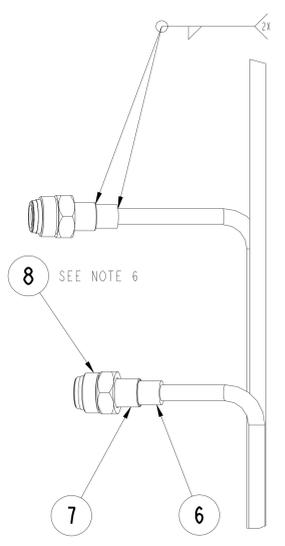
SEE DETAIL X



FRONT VIEW
SCALE 0.125



PICTORIAL VIEW
SCALE 0.125



DETAIL X
SCALE 0.500

REV	QTY	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
6 7	2	SS-12-VCR-4	MALE NUT	STAINLESS STEEL	---
6 7	2	SS-12-VCR-3	SOCKET WELD GLAND	STAINLESS STEEL	---
6 7	2	SS-12-MTW-8-8TSW	REDUCING ADAPTER	STAINLESS STEEL	---
	1	107030600M8E8700A161-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269 5
	1	107030600M8E8700A160-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269 4
	1	107030600M8E8700A159-I	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269 3
4 5	1	107030600M8E8700A120-I	SINGLE C V PLUG W/ ALIGNMENTS	---	---
4 5	1	107030600M8E8700A119-I	SINGLE C.V. PLUG W/TUBING	---	---

←
CAGE CODE
107030600M8E8700A118

←
PART OR IDENTIFYING NO
NEXT ASSEMBLY

←
NOMENCLATURE OR DESCRIPTION
MATERIAL
SPECIFICATION
FIND NO
PARTS LIST

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	MELD 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

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...XXXX...
SNS PROCEDURE...XXXX...

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

OR REP: 07/16/01
DES: DMW/MEP
DRW: M.E. PHILLIPS/07/16/01
OPERATED FOR THE DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 Oak Ridge, Tennessee
ORNL Spallation Neutron Source
SPALLATION NEUTRON SOURCE PROJECT
FACILITY CORE VESSEL INSERTS
SINGLE C.V. PLUG W/TUBING
BLDG 8700 FL 1 SHT 2 OF CLASS U
REV 000
107030600M8E8700A119

REV	CHG	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE

8

7

6

5

4

3

2

107030600M8E8700A119

A

8

7

6

5

4

3

2

NEXT ASS'Y:

FINAL ASS'Y:

H

H

G

G

F

F

E

E

D

D

C

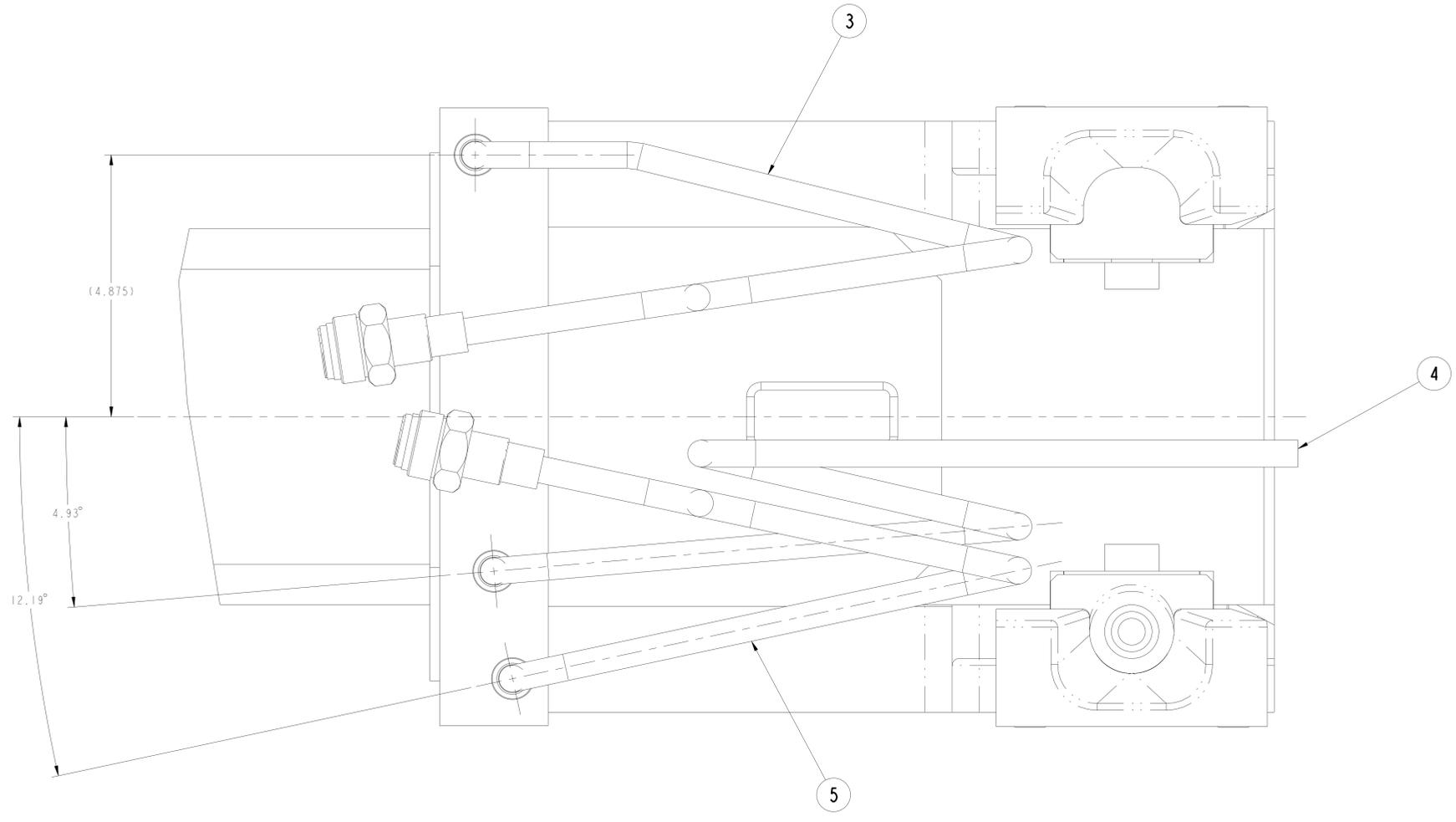
C

B

B

A

A



PARTIAL TOP VIEW
SCALE 1:1000

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

PRELIMINARY

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	:	
XX DECIMALS	± .01	
XXX DECIMALS	± .005	
ANGLES	± 0°15'	
BREAK SHARP EDGES	.06 MAX	
FINISH	125 RMS UNLESS OTHERWISE SPECIFIED	
	BLDG	FL
	8700	1ST
		2
		2
		U
		000
107030600M8E8700A119		

107030600M8E8700A119

8

7

6

5

4

3

2

1