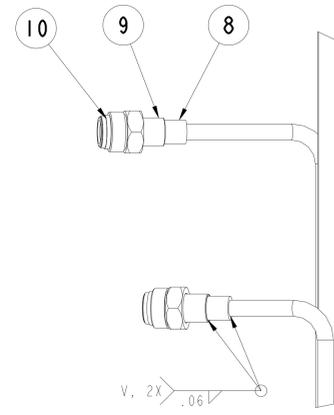
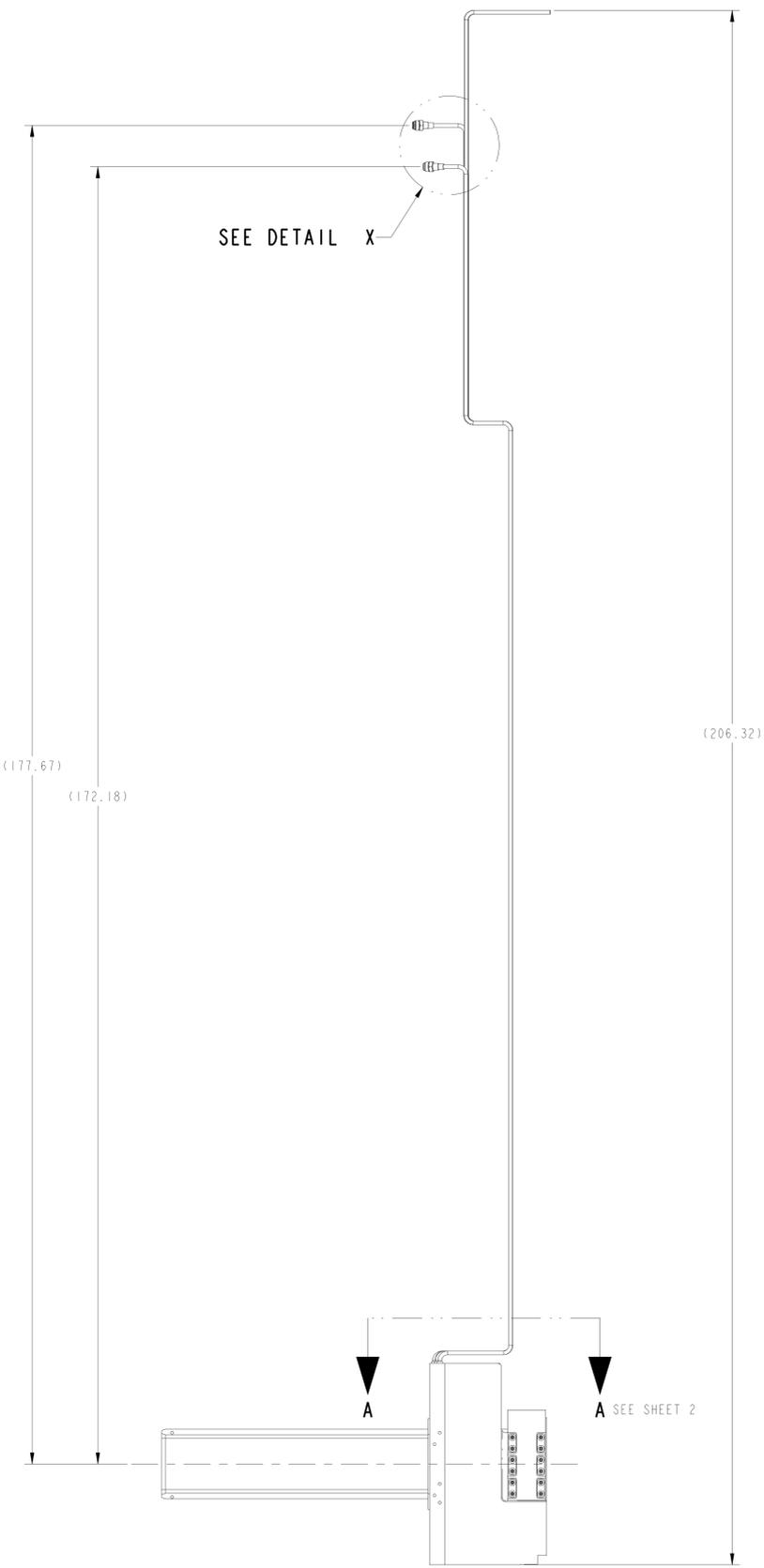
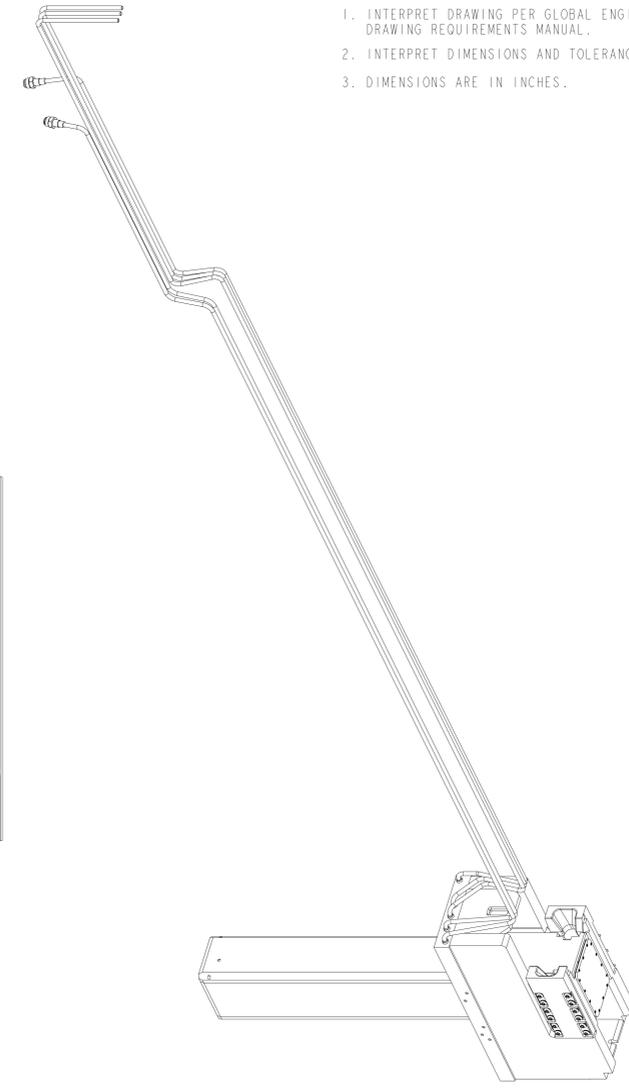




TOP VIEW  
SCALE 0.125



DETAIL X  
SCALE 0.500



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.

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	107030600M8E8700A167-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	7
1	107030600M8E8700A166-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	6
1	107030600M8E8700A161-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	5
1	107030600M8E8700A160-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	4
1	107030600M8E8700A159-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	ASTM A269	3
1	107030600M8E8700A125-1	SINGLE C.V.I. INSTRUMENTED ASSY	---	---	2
1	107030600M8E8700A124-1	SINGLE C V INSERT W/ TUBING	---	---	1

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	WELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (W/CRIT)	-
318	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	-
330	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

QUALITY VERIFICATION  
MECHANICAL AND STRUCTURAL  
REFERENCE SNS-TS-G002

**PRELIMINARY**

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**P** THIS DRAWING PRODUCED ON PRO-ENGINEER  
THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM.---3---  
SNS PROCEDURES-SNS-TS-G001

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
00A	---	3	---	---	---	---	02/02	---	---	---

SCALE AS NOTED  
TOLERANCES UNLESS OTHERWISE SPECIFIED  
FRACTIONS ±.01  
XX DECIMALS ±.005  
XXX DECIMALS ±.0015  
ANGLES ±0°15'  
BREAK SHARP EDGES OR MAX  
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES: DMW/MEP 07/01  
DRW: M.E. PHILLIPS 07/01  
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 INSERT W/TUBING ASSY  
BLDG 8700 FL 1 SHT 2 OF 2 CLASS U  
REV 00A  
107030600M8E8700A124

107030600M8E8700A124

CLASS U  
REV 00A

8

7

6

5

4

3

2

NEXT ASS'Y:

FINAL ASS'Y:

H

H

G

G

F

F

E

E

D

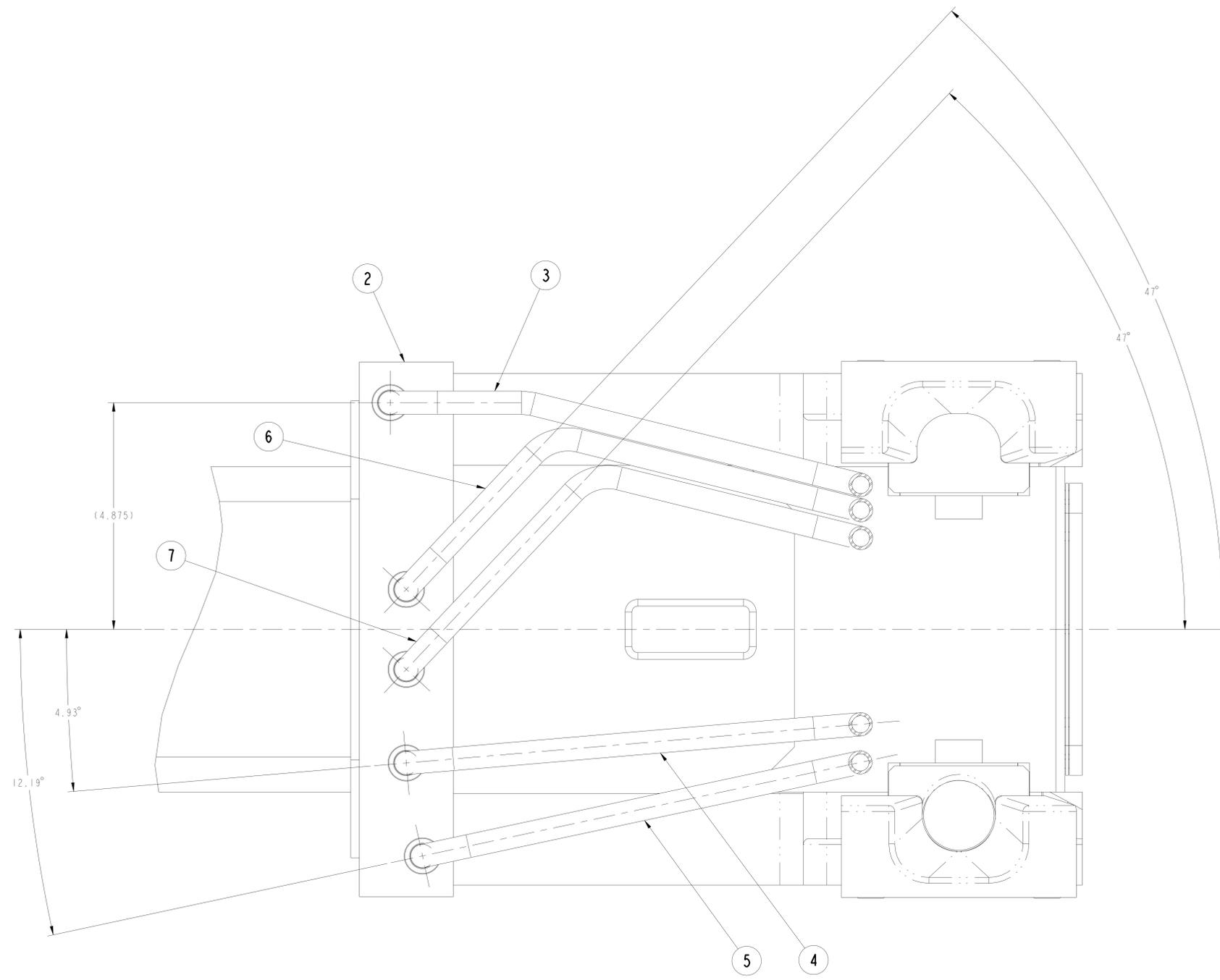
D

C

C

B

B



**SECTION A-A**  
SCALE 1:000

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**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	SINGLE C V INSERT W/TUBING ASSY			
ANGLES ±0°15'	BLDG			
BREAK SHARP EDGES .06 MAX	FL			
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	SHT			
	OF			
	CLASS			
	8700	IST	2	2
				U
				REV
				00A
	107030600M8E8700A124			

107030600M8E8700A124

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