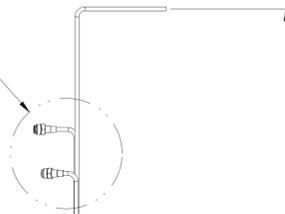
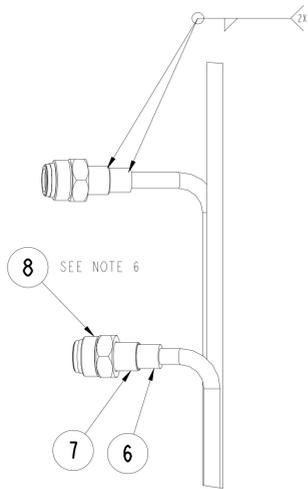




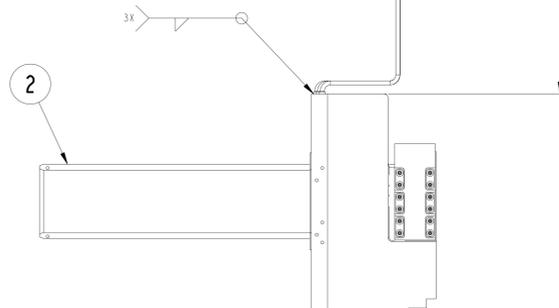
SEE DETAIL X



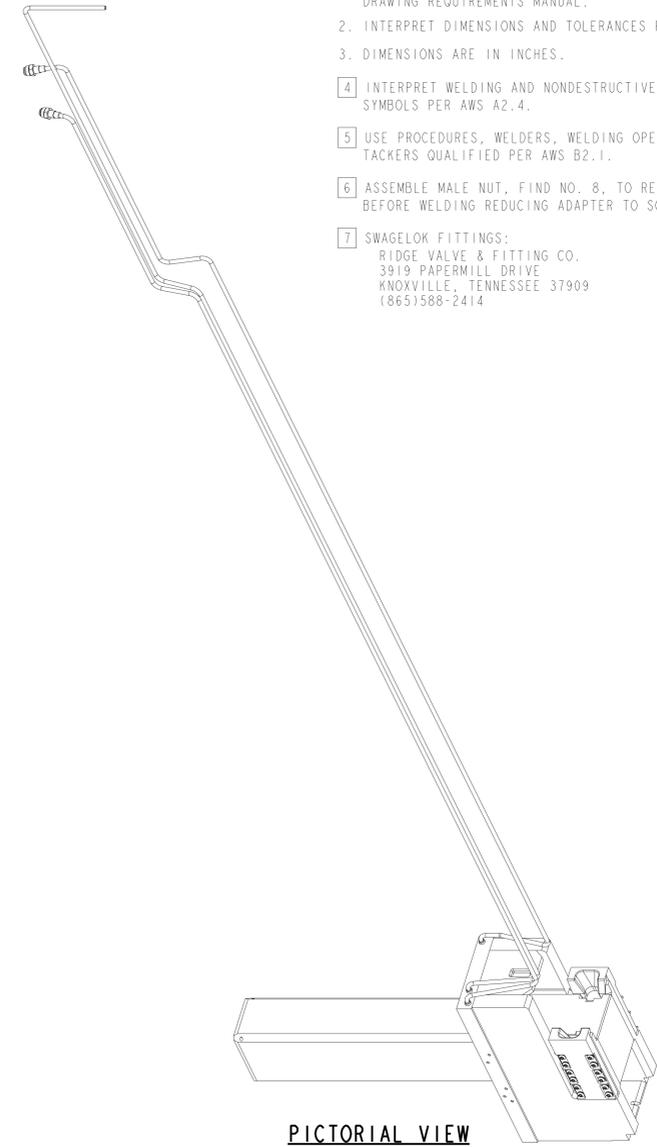
(193.94)



**DETAIL X**  
SCALE 0.500



**FRONT VIEW**  
SCALE 0.125



**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.
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

REV	DATE	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE	REVISION APPROVALS
6	7	2									
6	7	2									
6	7	2									
		1									
		1									
		1									
4	5	1									
4	5	1									

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
1070306008E8700A116	2	SS-12-VCR-4	MALE NUT	STAINLESS STEEL	8
	2	SS-12-VCR-3	SOCKET WELD GLAND	STAINLESS STEEL	7
	2	SS-12-MTW-8-8TSW	REDUCING ADAPTER	STAINLESS STEEL	6
	1	107030600M8E8700A202-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	5
	1	107030600M8E8700A201-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	4
	1	107030600M8E8700A200-1	CONNECTING TUBE DETAIL	SEAMLESS 304 SST x 0.035" WALL	3
	1	107030600M8E8700A120-1	SINGLE C V PLUG W/ ALIGNMENTS	---	2
	1	107030600M8E8700A118-1	SINGLE C V PLUG W/ TUBING ASSY	---	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	MELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (W/CRMT)	-
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 PROCEDURES-TS-G001

SCALE AS NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED:  
FRACTIONS: 1/2, 1/4, 3/8, 1/8, 3/16, 1/16  
XX DECIMALS ±.01  
XXX DECIMALS ±.005  
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

DES: T.E. FORNEK 02/02

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 SINGLE C V PLUG W/TUBING ASSY**

BLDG 8700 FL SHT 1 OF 2 U  
REV 00A

107030600M8E8700A118

107030600M8E8700A118

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

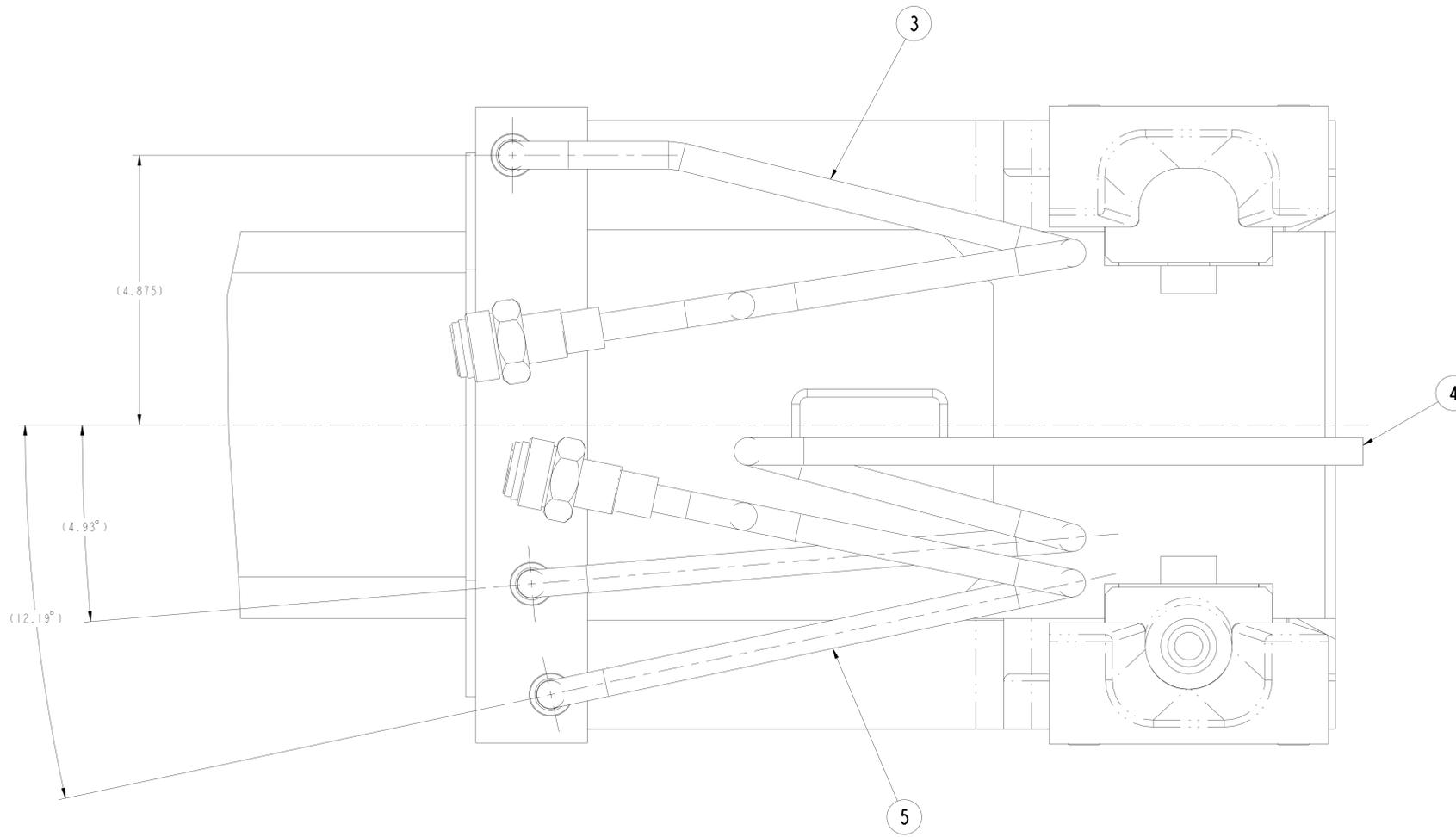
C

B

B

A

A



**PARTIAL TOP VIEW**  
SCALE 1.000

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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	<b>SPALLATION NEUTRON SOURCE PROJECT</b> <b>FACILITY CORE VESSEL INSERTS</b> <b>SINGLE C V PLUG W/TUBING ASSY</b>			
XX DECIMALS ±.01	BLDG	FL	SHT	OF
XXX DECIMALS ±.005	8700	1ST	2	2
ANGLES ±0°15'	CLASS	REV	U	
BREAK SHARP EDGES .06 MAX			00A	
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	107030600M8E8700A118			

107030600M8E8700A118

8

7

6

5

4

3

2

1