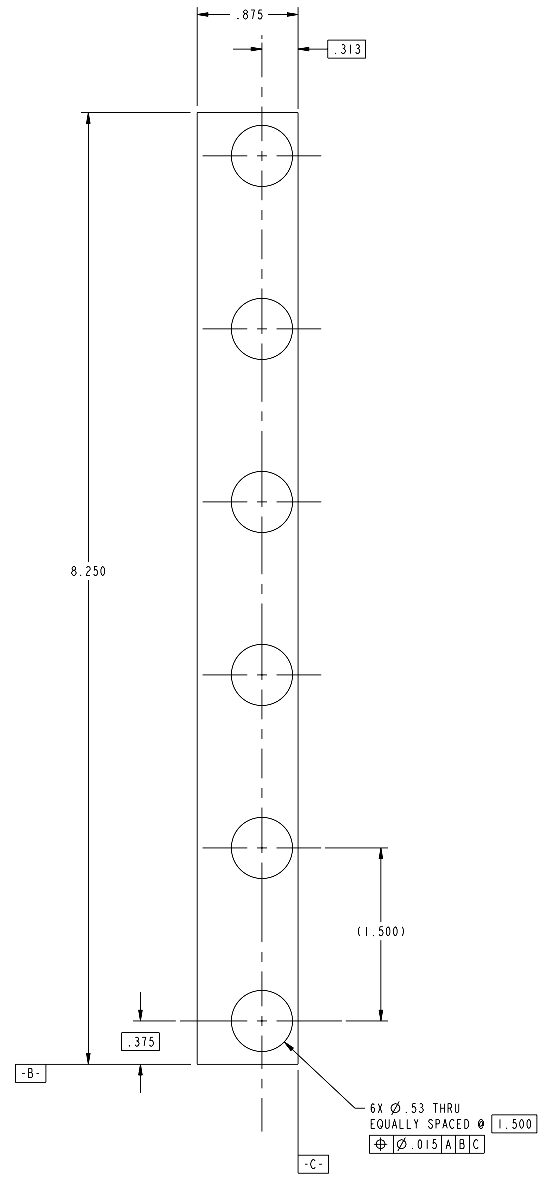
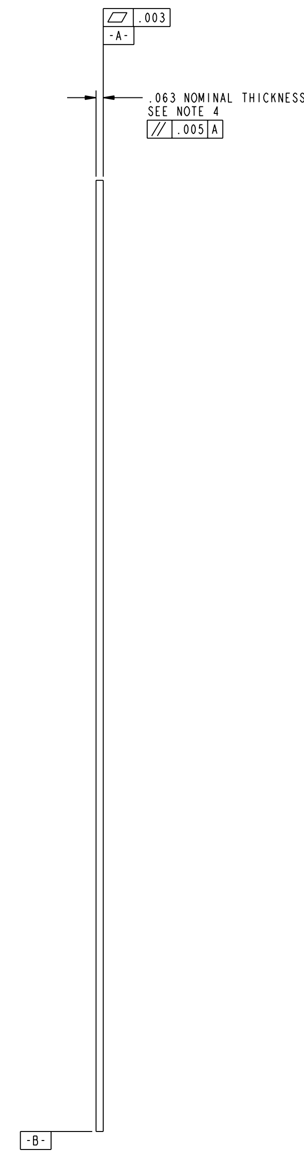
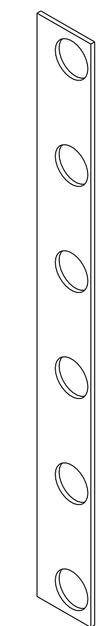
NOTES

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. [4] THE SHIM NOMINAL THICKNESS HAS BEEN DETERMINED BY THE PROE MODEL. THE SHIM THICKNESS WILL BE DETERMINED AT ASSEMBLY BY STARTING WITH A SHIM THAT IS .09 THICK AND MACHINING IT TO OBTAIN ASSEMBLY DIMENSIONS NECESSARY.



FRONT VIEW
SCALE 2.000





AUXILIARY VIEW
SCALE 1.500

4							1		107030600M8E8700A133-1	BALL GUIDE SHIM	STAINLESS STEEL	316L	1
	107030600M8E8700A125	107030600M8E8700A120	107030600M8E8700A114	107030600M8E8700A008	107030600M8E8700A003	107080100M8E8700A020	-1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
								← NEXT ASSEMBLY		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	SPECIAL MATERIAL INSPECTION REPORT	-
205	MANUFACTURING, INSPECTION, AND TEST PLAN	-
312	FIELD INSPECTION AND TEST PLAN	-
321	WELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (W/CHART)	-
310	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

QA REP .... DATE ....

RPE

REV. XX DATE XX/XX/XX

107030600M8E8700A133

PRELIMINARY

REV	CHANGE TYPE	CHANGE CONTROL SYSTEM	CHANGE REQUEST NUMBER	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE	PJ
00A	—	3	—	ISSUE FOR COMMENT AND INFORMATION	SMR				11/01				

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM 3
SNS PROCEDURE SNS-TS-G001

SCALE AS NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

DES	DMW/MEP	11/01
DRW	M.E.PHILLIPS	11/01
CHK	:	:
L3	:	:
L2	:	:
:	T.E. FORNEK	11/01
DRAWING APPROVALS		DATE

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
BALL GUIDE SHIM

BLDG	FL	SHT OF	CLASS
8700	1ST	1 1	U

107030600M8E8700A133 REV 00A