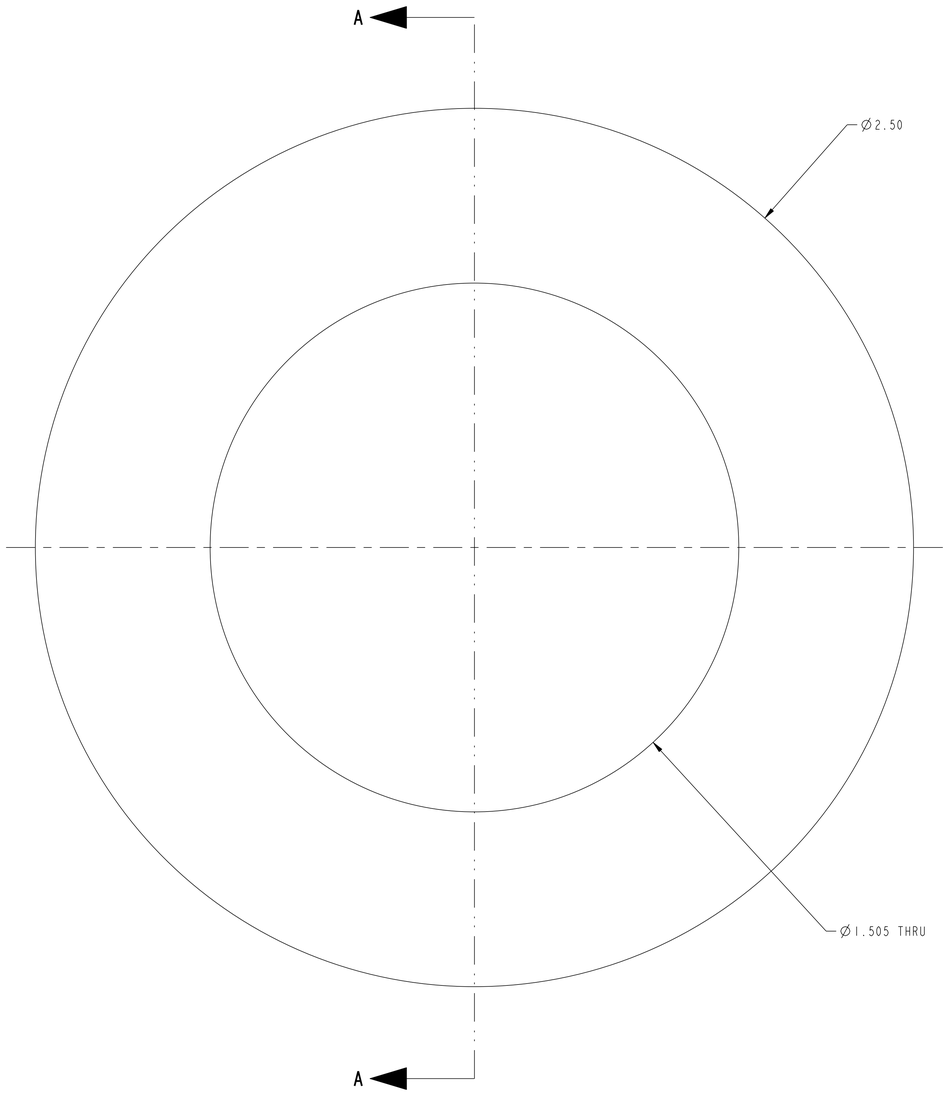
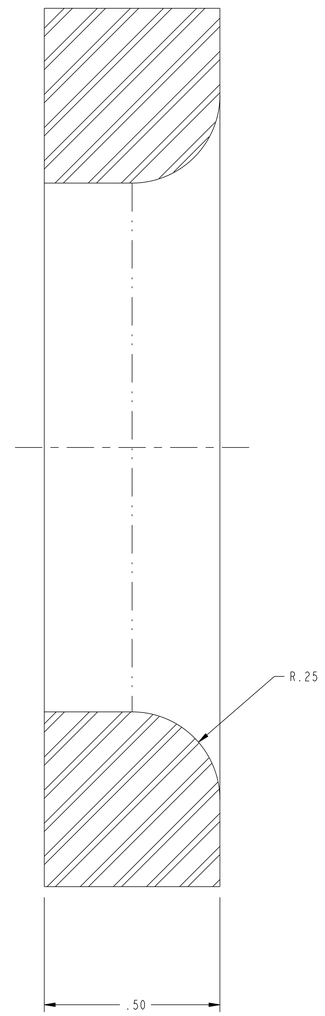
NEXT ASS'Y: FINAL ASS'Y:

NOTES

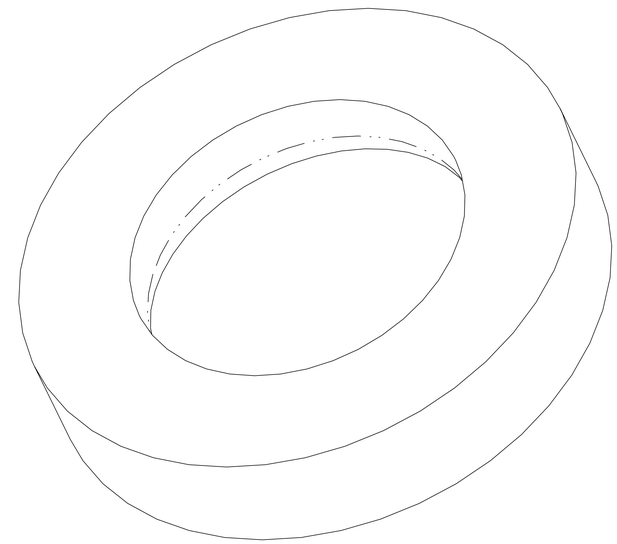
1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M.
3. DIMENSIONS ARE IN INCHES.
4. REAR BALL COLLAR SHALL BE THROUGH HARDENED TO RC 38 TO 42.
5. REAR BALL COLLAR SHALL BE NICKEL PLATED 0.0003 TO 0.0008 THICK.



PLAN VIEW
SCALE 6.000



SECTION A-A



PICTORIAL VIEW
SCALE 4.000

4 5	1		107030600M8E8700A157-1	REAR BALL COLLAR	ALLOY STEEL	AISI 4140	1
107030600M8E8700A000 -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

107030600M8E8700A157

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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	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				02/02				

REVISION OR ISSUE PURPOSE — REVISION APPROVALS

SCALE AS NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 32 RMS UNLESS OTHERWISE SPECIFIED

DES	DMW/MEP	02/02
DRW	S.M.ROGERS	02/02
CHK	:	:
L3	:	:
L2	:	:
:	T.E. FORNEK	02/02
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:
:	:	:
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
DEMONSTRATION VERIFICATION STAND
REAR BALL COLLAR

BLDG	FL	SHT	OF	CLASS
8700	1ST	1	1	U

107030600M8E8700A157 REV 00A