Notes:

1. Welding & Inspections shall be performed in accordance with AWS D1.6
2. All welds shall be dye penetrant inspected
3. Material certifications required

Item No. QTY. Description Material Length

12 1 Plate, 43.95 x 1.38 x .25 SS - 304, ASTM A479 43.95
11 1 Plate, 2.63 x 2.75 x .25 SS - 304, ASTM A479 2.75
10 1 Plate, 1.88 x 3.00 x .25 SS - 304, ASTM A479 3.00
9 1 Plate, 1.88 x 3.00 x .25 SS - 304, ASTM A479 3.00
8 1 Plate, 1.88 x 3.00 x .25 SS - 304, ASTM A479 3.00
7 1 Plate - 1.38" x 43.79" x .25" THK SS - 304, ASTM A479
6 1 Plate - 3.50" x 8.25" x .25" THK SS - 304, ASTM A479
5 1 Plate - 3.50" x 8.25" x .25" THK SS - 304, ASTM A479
4 1 Plate - 5.57" x 43.79" x .25" THK SS - 304, ASTM A479
3 1 Plate - 5.57" x 43.79" x .25" THK SS - 304, ASTM A479
2 1 Plate - 8.25" x 9.50" x .25" THK SS - 304, ASTM A479
1 1 Plate - 6.50 x 12.25 x .25 SS - 304, ASTM A479 12.25

Remote Systems Group
NUFACT HG JET EXPERIMENT
Primary Tube Assy
Primary Tube Weldment

Material:

- SS - 304, ASTM A479

Length:

- 43.95
- 3.25
- 3.00
- 2.75
- 12.25
NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENTRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005 UNLESS OTHERWISE NOTED

OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

NUFACT HG JET EXPERIMENT
PRIMARY TUBE ASSY
PRIMARY TUBE WELDMENT

V GRAVES 06/05/2005
T OQUIN 06/05/2005
V GRAVES 06/05/2005

1/4-28 UNF - 2B .125
12X .213 .150
1/4-28 UNF - 28 .125

PORTSIDE
NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED