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
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DETAIL B
SCALE 1:3

WELD NUTS
8X FOR EACH CONNECTOR PLATE ASSY
7 PLCS.

SEC A-A

SECTION A-A

SCALE 1:12

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SEC A-A

SECTION A-A

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WELD NUTS
8X FOR EACH CONNECTOR PLATE ASSY
7 PLCS.
7. **MATERIAL CERTIFICATIONS REQUIRED**

6. ALL WELDS SHALL BE DYE PENETRANT INSPECTED IN ACCORDANCE WITH AWS D1.6

5. WELDING & INSPECTIONS SHALL BE PERFORMED OF SHEET METAL WRAPPED AROUND PANEL 6

4. PANELS 8, 9 & 10 CAN BE MADE AS ONE PIECE

3. ALL BEND 90° UNLESS NOTED OTHERWISE

2. ALL BENDS SHARP UNLESS NOTED OTHERWISE

1. ALL WELDS MUST BE WATERTIGHT

**NOTES**

1. ALL WELDS MUST BE WATERTIGHT
2. ALL BENDS SHARP UNLESS NOTED OTHERWISE
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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
6. FORMED ANGLES 1/4
7. BREAK SHARP CORNERS AND REMOVE ALL BURRS
8. WHOLE NUMBERS AND FRACTIONS 1/16
9. X DECIMALS .030
10. XX DECIMALS .010
11. XXX DECIMALS .005
UNLESS OTHERWISE NOTED

SHEET 2 of 4

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

REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

MERIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
SECONDARY CONTAINMENT BASE WELDMENT

ө4.00 THRU NEAR SIDE ONLY 0.250 LP
ө5.00 THRU NEAR SIDE ONLY
ө5.00 THRU NEAR SIDE ONLY SEE DETAIL C
ө5.500 BC NEAR SIDE ONLY SEE DETAIL C
ө4.500 BC 4X .266 THRU DETAIL C
 Section G-G

DETAIL B SCALE 1 : 9
RING TO BE FLUSH WITH INSIDE OF WALL

DETAIL A SCALE 1 : 6

DETAIL C SCALE 1 : 5

DETAIL D SCALE 1 : 5

DETAIL E SCALE 1 : 5

DETAIL F SCALE 1 : 9

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203-HJT-0701

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NUCLEAR SCIENCE & TECHNOLOGY DIVISION
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REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION
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_REMOTE SYSTEMS GROUP_
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1. MATERIAL CERTIFICATIONS REQUIRED

MATERIAL: LEXAN - 1/2"

SECONDARY CONTAINMENT ASSY
SECONDARY CONTAINMENT TOP COVER

MERIT EXPERIMENT
NUCLEAR SCIENCE & TECHNOLOGY DIVISION
REMOTE SYSTEMS GROUP
UNLESS OTHERWISE NOTED
OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN
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8. XXX DECIMALS .005
9. X DECIMALS .030
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
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<td>BAR, 1.00 x 2.00 x 42.00 AL - 6061-T6511, ASTM B-221</td>
<td>42.00</td>
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<tr>
<td>2</td>
<td>1</td>
<td>DRAWN SEAMLESS TUBE, 8.00 OD x 1&quot; WALL AL - 6061-T6, ASTM B-210</td>
<td>12.00</td>
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<tr>
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<td>PLATE, 4.00 x 6.00 x .50 AL - 6061-T6511, ASTM B-221</td>
<td>6.00</td>
</tr>
</tbody>
</table>

UNLESS OTHERWISE NOTED:
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 16. BREAK SHARP CORNERS AND REMOVE ALL BURRS
6. WHOLE NUMBERS AND FRACTIONS 1/16
7. X DECIMALS .030
8. XX DECIMALS .010
9. XXX DECIMALS .005

DRAWING PRODUCED ON SOLIDWORKS
1. Welding & Inspections shall be performed in accordance with AWS D.1.2
2. All welds shall be dye penetrant inspected
3. Material certifications required
NOTES

1. WELDING & INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

<table>
<thead>
<tr>
<th>ITEM</th>
<th>DOWNSTREAM/QTY</th>
<th>NAME</th>
<th>MATERIAL</th>
<th>DESCRIPTION</th>
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<tr>
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<td>HX-SHC.5.025-20X0.750-75-N</td>
<td>SS - 18-8</td>
<td>.016 X .160</td>
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<td>NON RETURN STYLE</td>
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<td>Swagelok Tube Fitting Connector SU-4VC-R-4-400-1.4 Swagelok Company_1882-5-3859</td>
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<td>SWAGE BLOK TUBE FITTING CONNECTOR</td>
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<tr>
<td>5</td>
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<td>Nuts Caps and Plugs SU-4VC-R-1.4 Swagelok Company_1882-5-3859</td>
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<td>NUTS CAPS AND PLUGS</td>
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<tr>
<td>4</td>
<td>1</td>
<td>Short Tube But Welded, Fractional SU-4VC-R-1.4 Swagelok Company_1882-5-3859</td>
<td>--</td>
<td>SHORT TUBE BUTT WELD FRACTIONAL</td>
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<tr>
<td>3</td>
<td>1</td>
<td>window gasket hjt</td>
<td>1/16 IN NUT</td>
<td>SHEET 50A</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>double window tubing hjt</td>
<td>5/8, 304L, ASTM A269</td>
<td>OD X 0.22</td>
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<tr>
<td>1</td>
<td>1</td>
<td>Double window hjt</td>
<td>--</td>
<td>4.00 OD X 2.00</td>
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</table>

ITEM DESCRIPTION

1. WELDING & INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.6
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

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

REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

MERIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
DBL WINDOW MONITORED - DOWNSTREAM

CAD FILE: 203-HJ-T-0700
PREV ASSY: 203-HJ-T-0700
SCALE: 1/2
SHEET: 1 of 3
REV: A

DRAWING APPROVALS
DATE

C 203-HJ-T-0706
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
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

MATERIAL: 1/16" BUNA-N SHEET, 50A
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
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
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

UNLESS OTHERWISE NOTED
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 .016
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

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TWO SLITウィンドウ HJT 203-HJT-0700 1 of 1

DOUBLE WINDOW WELDMENT - UPSTREAM

ITEM NO. QTY. DESCRIPTION MATERIAL LENGTH
1 1 PIPE, 2.00 OD SCH 40 SS - 304L PIPE 1.00
2 2 SHEET, 1.95 OD x .05 THK Ti - 6AL-4V, ASTM GRADE 5 Ti N/A
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

MATERIAL: SS - 304L, ASTM A-240

OAK RIDGE NATIONAL LABORATORY
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REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

MERIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
HYDRAULICS CONNECTOR PLATE

THIRD-ANGLE PROJECTION

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

MATERIAL CERTIFICATIONS REQUIRED

DES: V GRAVES 01/06/2006
ENG: V GRAVES 01/06/2006

CAD FILE: 203-HJ-T-0730
SCALE: 1:1
SHEET: 1 of 1
DRAWING NO.: 203-HJ-T-0731
REV: A

203-HJT-0731
8X 6.00
Ø 5.50 BC
8X .266 THRU ALL
8X 45.0°
2X Ø 1.10 THRU
1.386
.574
.574
1.386

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MATERIAL: 1/16" BUNA-N SHEET, 50A

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1/16
6. FLUSH ALL RABBETS AND RECESS ALL RABBETS 3/16 INCHES
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005

NOTE: UNLESS OTHERWISE NOTED

1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M

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REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION
MERRIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
CONNECTOR PLATE GASKET

DRAWING APPROVALS
DATE

C
203-MJT-0732
### Notes

1. **Material Certifications Required**

<table>
<thead>
<tr>
<th>ITEM</th>
<th>Extraction/QTY</th>
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<tr>
<td>5</td>
<td>8</td>
<td>HX-SHCS 0.25-20x0.75x0.75-N</td>
<td>SS-18-8</td>
<td>.38 x .3-16 SHCS</td>
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<tr>
<td>4</td>
<td>1</td>
<td>Instrumentation Quick-Connects - QC Series SS-OC6-D1.400 1 3/8&quot; Swagelok Bulkhead Tube Fitting</td>
<td>N/A</td>
<td>INSTRUMENTATION QUICK-CONNECTS - QC SERIES</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>connector plate gasket</td>
<td>1/16&quot; BUNA-N SHEET</td>
<td>50A M-C MASTERCARR 48B72100-203-HJT-0732 1</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>extraction tube hjt</td>
<td>SS-304L, ASTM A-269 TUBE, .375 OD X .035 WALL</td>
<td>203-HJT-0742 1</td>
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<tr>
<td>1</td>
<td>1</td>
<td>extraction plate</td>
<td>SS-304L, ASTM A-240 PLATE, 6 x 0 THK</td>
<td>203-HJT-0741 1</td>
</tr>
</tbody>
</table>

---

**third-angle projection**

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**remote systems group**

NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**MERIT EXPERIMENT**

SECONDARY CONTAINMENT ASSY

EXTRACTION ASSY

**cad file**

CONNECTOR PLATE ASSY HJT 203-HJT-0700 1

**drawing approval**

DATE

203-HJT-0740

---

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 .1875 FM FORMED ANGLES**
6. **Formed angles .1875 FM FORMING OR FORMING CORNER**
7. **Angle all bearing and radius all burrs**
8. **Whole numbers and fractions 1/16**
9. **X decimals .030**
10. **XX decimals .010**
11. **XXX decimals .005**
   
   Unless otherwise noted
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

MATERIAL: SS - 304L, ASTM A-240

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Agreements. This drawing is property of
ORNL and must be returned upon
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contract DE-AC05-00OR22725 Oak Ridge, TN

REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION
MERIT EXPERIMENT
SECONDARY CONTAINMENT ASSY
EXTRACTION CONNECTOR PLATE

CAD FILE
CONNECTOR PLATE HT
PREV ASSY
203-HJ-T-0730
SCALE
1:1
SHEET
1 of 3
DATE
01/06/2006
DRAWING APPROVALS
C
203-HJ-T-0741

UNLESS OTHERWISE NOTED
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 BASE FORMED ANGLES 16. BREAK SHARP CORNERS AND REMOVE ALL BURRS
6. WHOLE NUMBERS AND FRACTIONS 1/16
7. X DECIMALS .030
8. XX DECIMALS .010
9. XXX DECIMALS .005

1. MATERIAL CERTIFICATIONS REQUIRED

MATERIAL: SS - 304L, ASTM A-240

THRU ALL

BC

1.500

.590 THRU

.266 THRU ALL

.600

.550 BC

8X 45.0°
MATERIAL: SS - 304L, ASTM A-240

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED
<table>
<thead>
<tr>
<th>ITEM</th>
<th>NAME</th>
<th>MATERIAL</th>
<th>DESCRIPTION</th>
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<tr>
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<td>Instrumentation-Quick-Connect- QC Series, SS-6-QC6-100, 3/8 Swagelok Bulkhead Fitting</td>
<td>N/A</td>
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<tr>
<td>5</td>
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<td>U-Series, SS/316 Tube Weld 1/2&quot; or 3/4&quot; Swagelok Company, Casteled with PartSpec: _2Q34_8_A4461</td>
<td>N/A</td>
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<tr>
<td>4</td>
<td>8</td>
<td>HX-SHC.5, 0.25-20x0.75-0.75-N</td>
<td>3/8 X 5-16 SCH.5 N/A</td>
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<tr>
<td>3</td>
<td>1</td>
<td>connector plate gasket flt</td>
<td>1/16&quot; BUNA-N SHEET: 50A McMASTER-CARR #8715A279 203-HJ T-0732</td>
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<tr>
<td>2</td>
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<td>vacuum port tubing flt</td>
<td>SS-304L ASM A-269 VACUUM PORT TUBING 203-HJ T-0762</td>
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<tr>
<td>1</td>
<td>1</td>
<td>drain plate</td>
<td>SS-304L ASM A-240 PLATE, 6 x 0 THK 203-HJ T-0761</td>
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</tbody>
</table>

**NOTES**

1. MATERIAL CERTIFICATIONS REQUIRED

---

**UNLESS OTHERWISE NOTED**

1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5 M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1/4
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. DECIMALS 0.030
9. XXX DECIMALS 0.010

---

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

**REMOTE SYSTEMS GROUP**
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**MERIT EXPERIMENT**
SECONDARY CONTAINMENT ASSY
VACUUM ASSY

---

**DRAWING APPROVALS**

**DATE**

C 203-HJ T-0760
MATERIAL: SS - 304L, ASTM A-240

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

2. ALL DIMENSIONS ARE IN INCHES

3. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M

4. MACHINED FINISH 125 MICRO-INCHES RMS

5. CONCENTRICITY .010 TIR

6. MACHINED ANGLES 1/2 FORMED ANGLES

7. BREAK SHARP CORNERS AND REMOVE ALL BURRS

8. WHOLE NUMBERS AND FRACTIONS 1/16

9. X DECIMALS .030

10. XXX DECIMALS .000
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

ITEM   QTY.   NAME       MATERIAL DESCRIPTION DWG NO.
5      8      HEX SCREW 0.25-20x0.75x0.75-N SS - 304L, ASTM A-240 PLATE, 6 x 0 THK 203-HJT-0771
4      8      C-75 PHNE 0.112-40x0.25x0.25-N SS - 316 PAN HEAD MACHINE SCREW, 4-40 x 1/4 203-HJT-0732
3      2      20       AM PHN OL 97-4100 - SERIES 20 N/A
2      1      connector plate 1/16" BUNA-N SHEET, 50A McMASTER-CARR #86715K279 203-HJT-0772
1      1      electrical plate 304L, A-240 PLATE, 6 x 0 THK 203-HJT-0771

UNLESS OTHERWISE NOTED
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 FORMED ANGLES .010 TIR
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS
   1/16
   1/32
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005
MATERIAL: SS - 304L, ASTM A-240

1. MATERIAL CERTIFICATIONS REQUIRED
### NOTES

1. **MATERIAL CERTIFICATIONS REQUIRED**

### ITEMS

<table>
<thead>
<tr>
<th>ITEM</th>
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<th>MATERIAL</th>
<th>DESCRIPTION</th>
<th>DWG</th>
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<tr>
<td>4</td>
<td>HX-SHC 5.0x25-20x0.75x0.75 N</td>
<td>SS - 18-8</td>
<td>INSTRUMENTATION QUICK CONNECT QC SERIES 3/4-20x0.75</td>
<td>N/A</td>
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<td>3</td>
<td>connector plate gasket hjt</td>
<td>BUNA-N</td>
<td>U/15&quot; BUNA N SHEET 50A</td>
<td>203-HJT-0732</td>
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<tr>
<td>2</td>
<td>connector plate hjt</td>
<td>SS - 304L, ASTM A-240</td>
<td>PLATE, 6.00 x 1.3 THK</td>
<td>203-HJT-0780</td>
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</table>

**DIMENSIONS:**

- All dimensions are in inches.
- Interpret dimensions and tolerances per ASME Y14.5M.
- Machined finish 125 microinches RMS.
- Concentricity 0.010 TIR.
- Machined angles and formed angles.
- Break sharp corners and remove all burrs.
- Whole numbers and fractions.
- X decimals.

**SCALE:** 1:2

**REVISION:** A

**DRAWING NO.:** 203-HJT-0780

**SHEET:** 1 of 1

**OAK RIDGE NATIONAL LABORATORY**

REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**MERIT EXPERIMENT**
SECONDARY CONTAINMENT ASSY
HG INLET PLATE ASSY

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