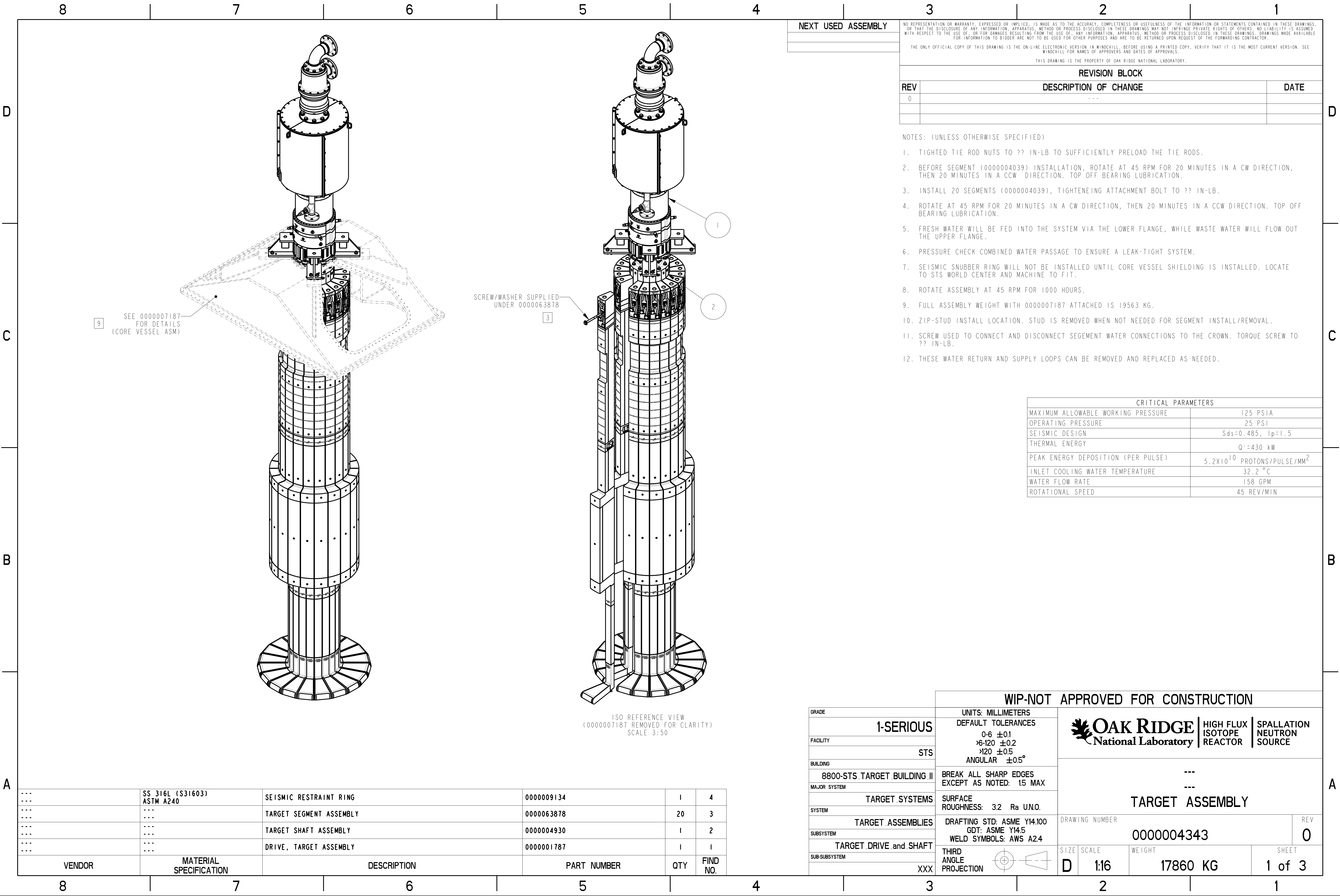
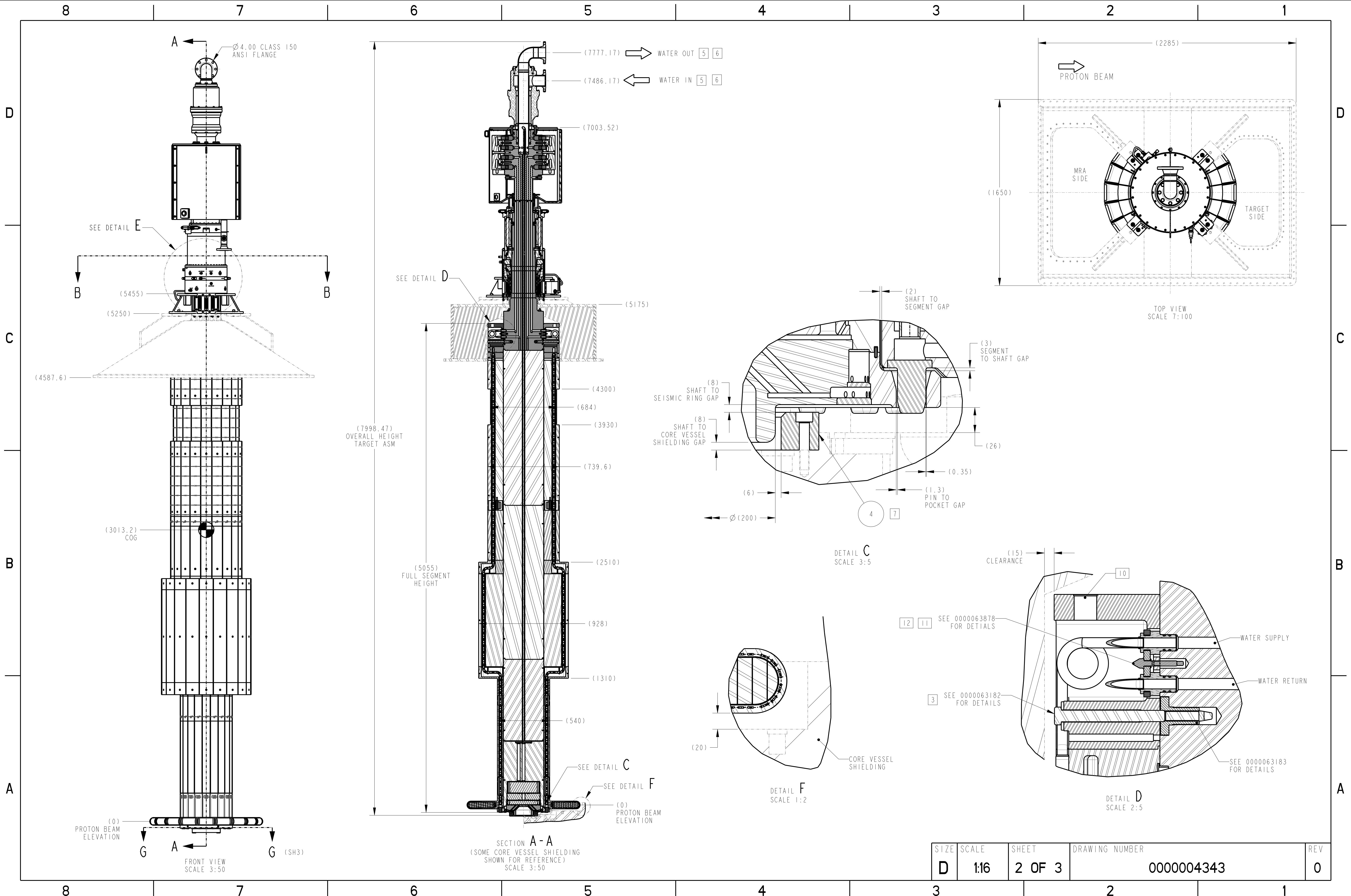
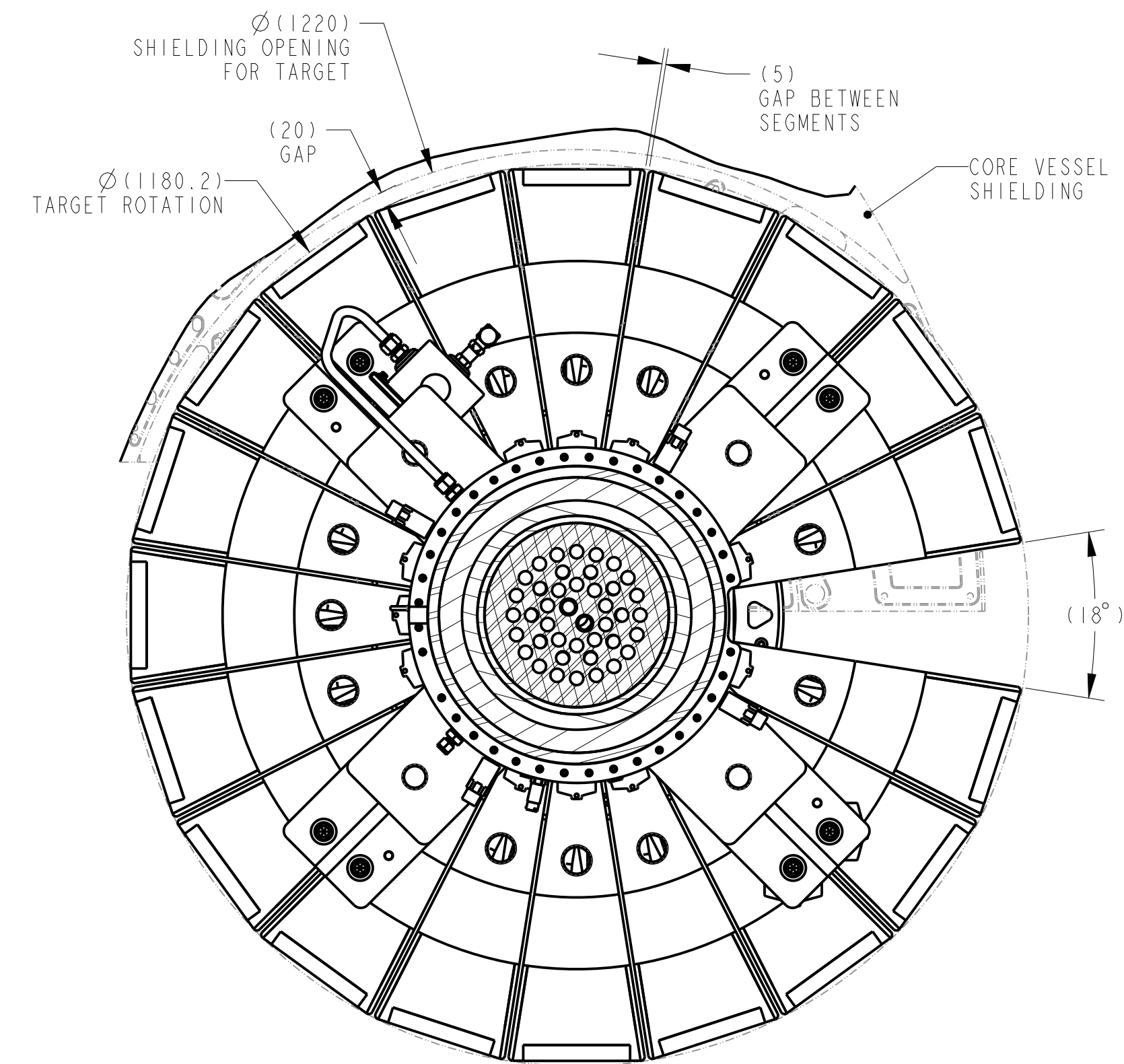
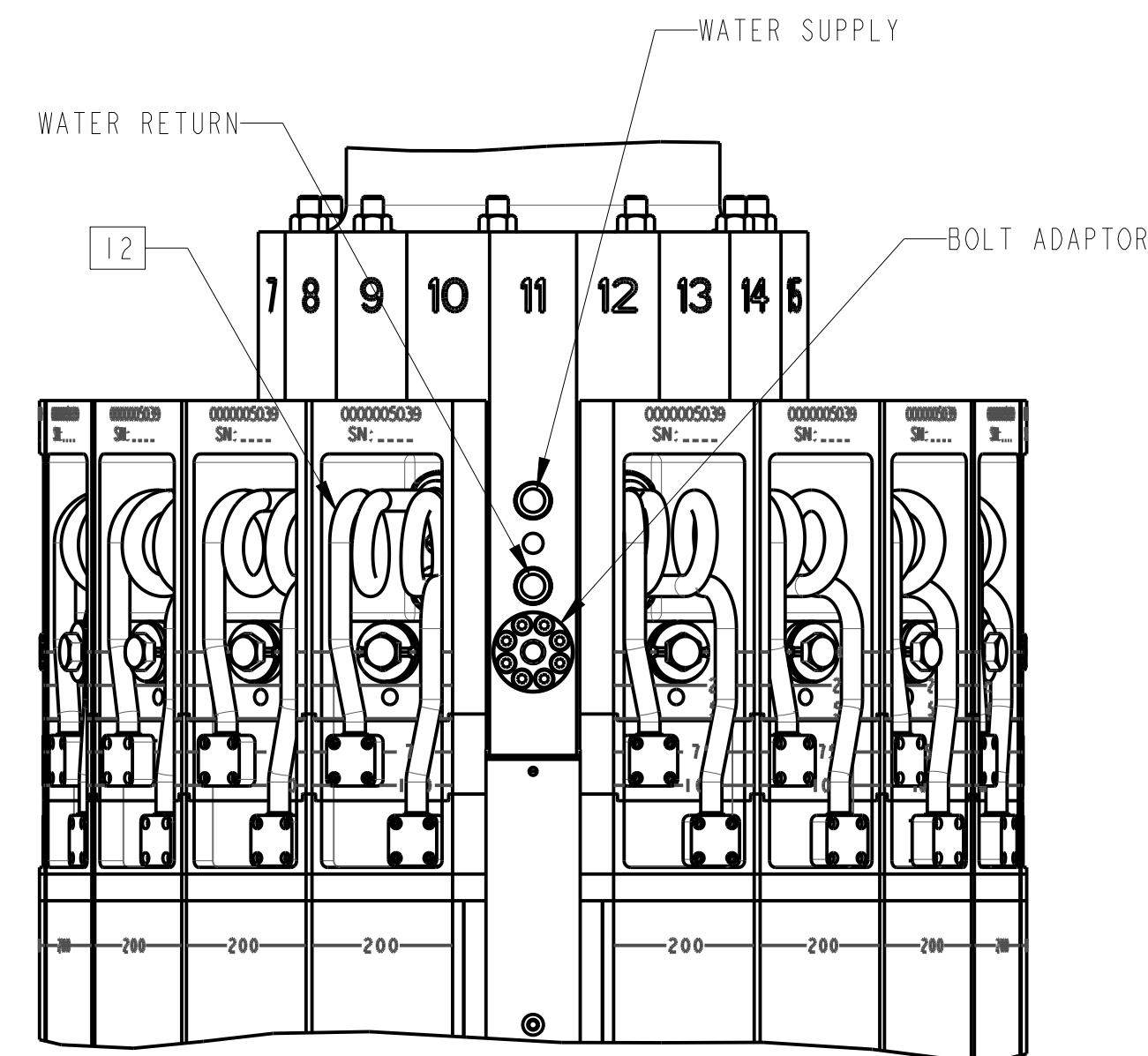
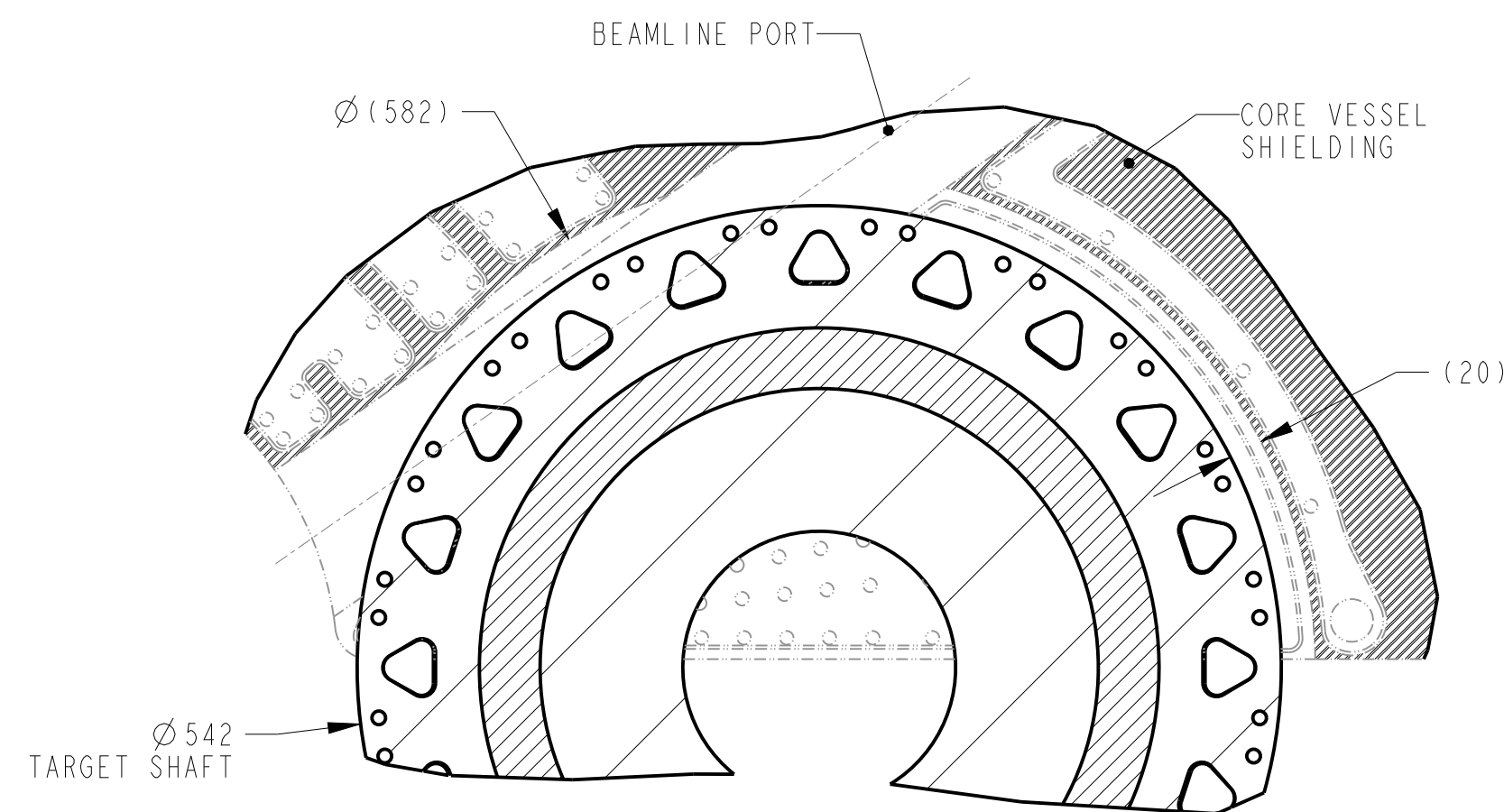
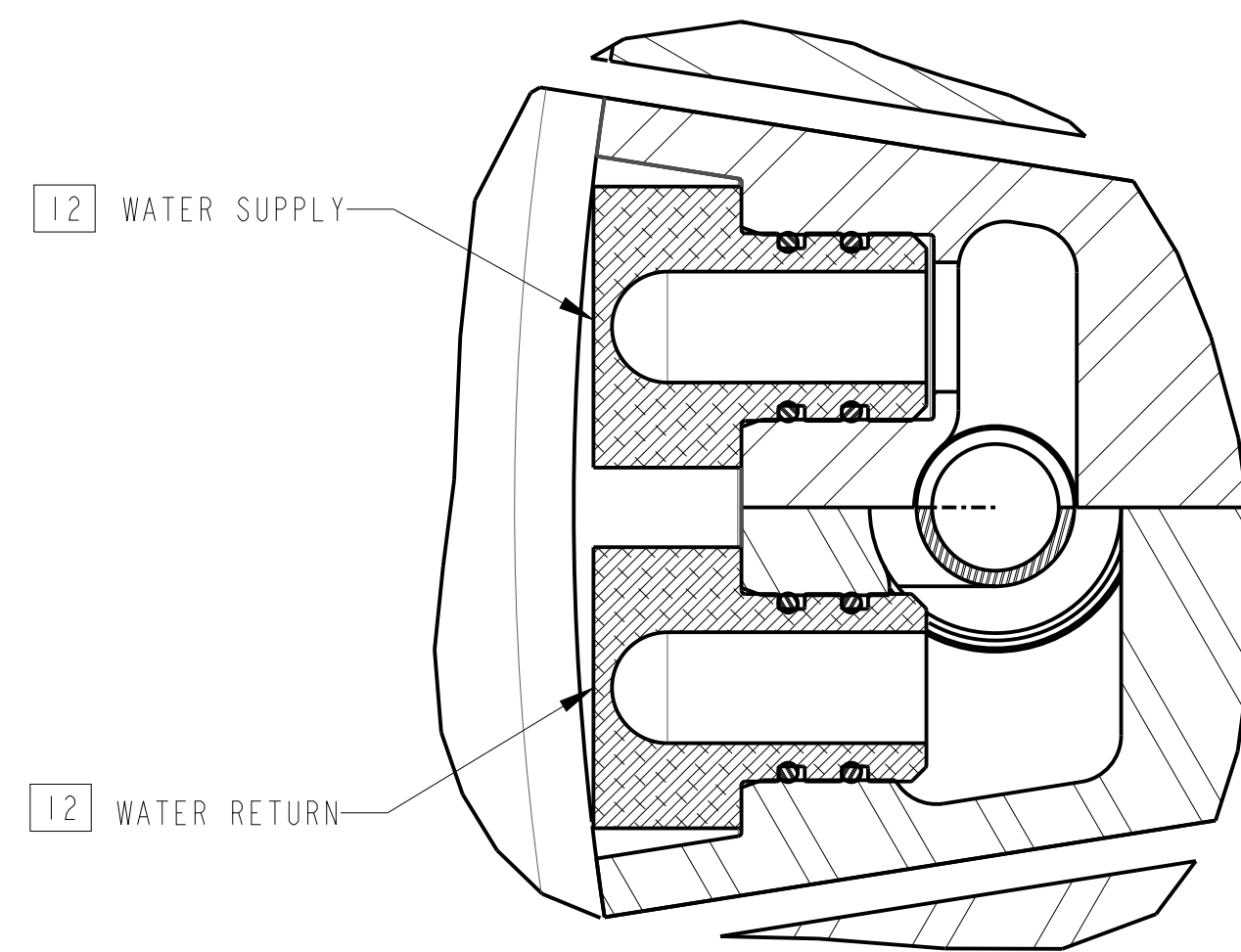
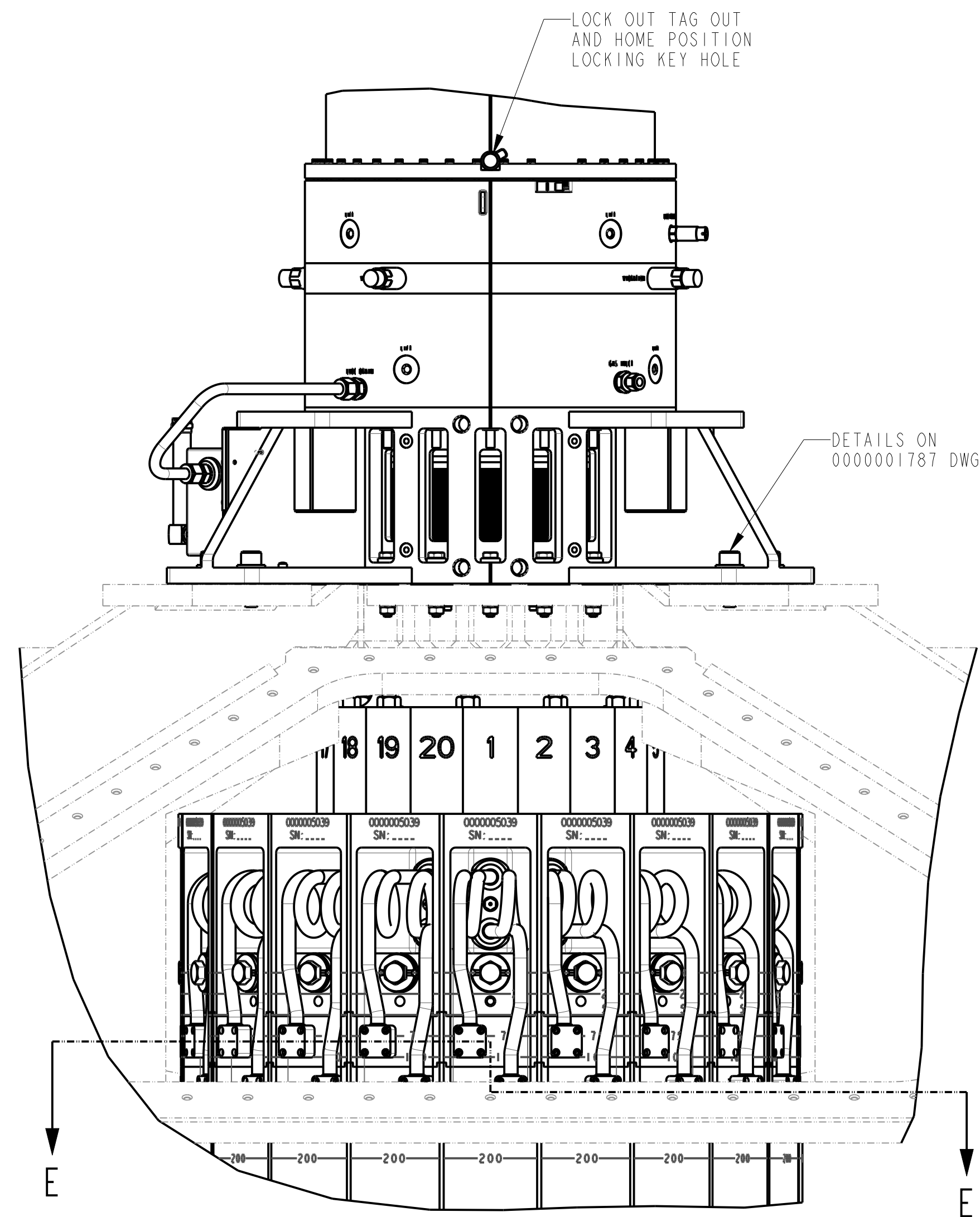






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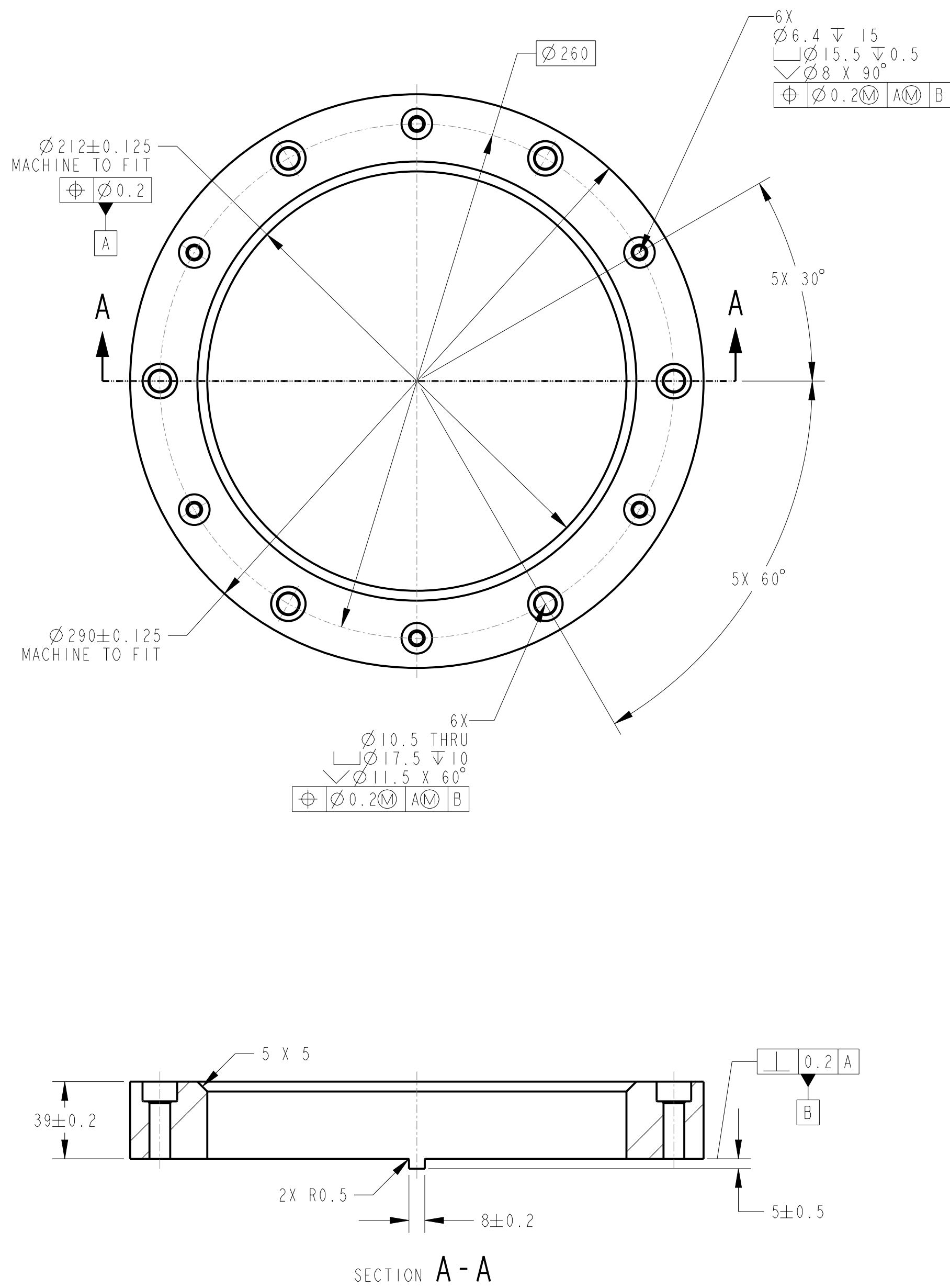
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D	1:16	3 OF 3	0000004343	0

D

C

B

A



NEXT USED ASSEMBLY

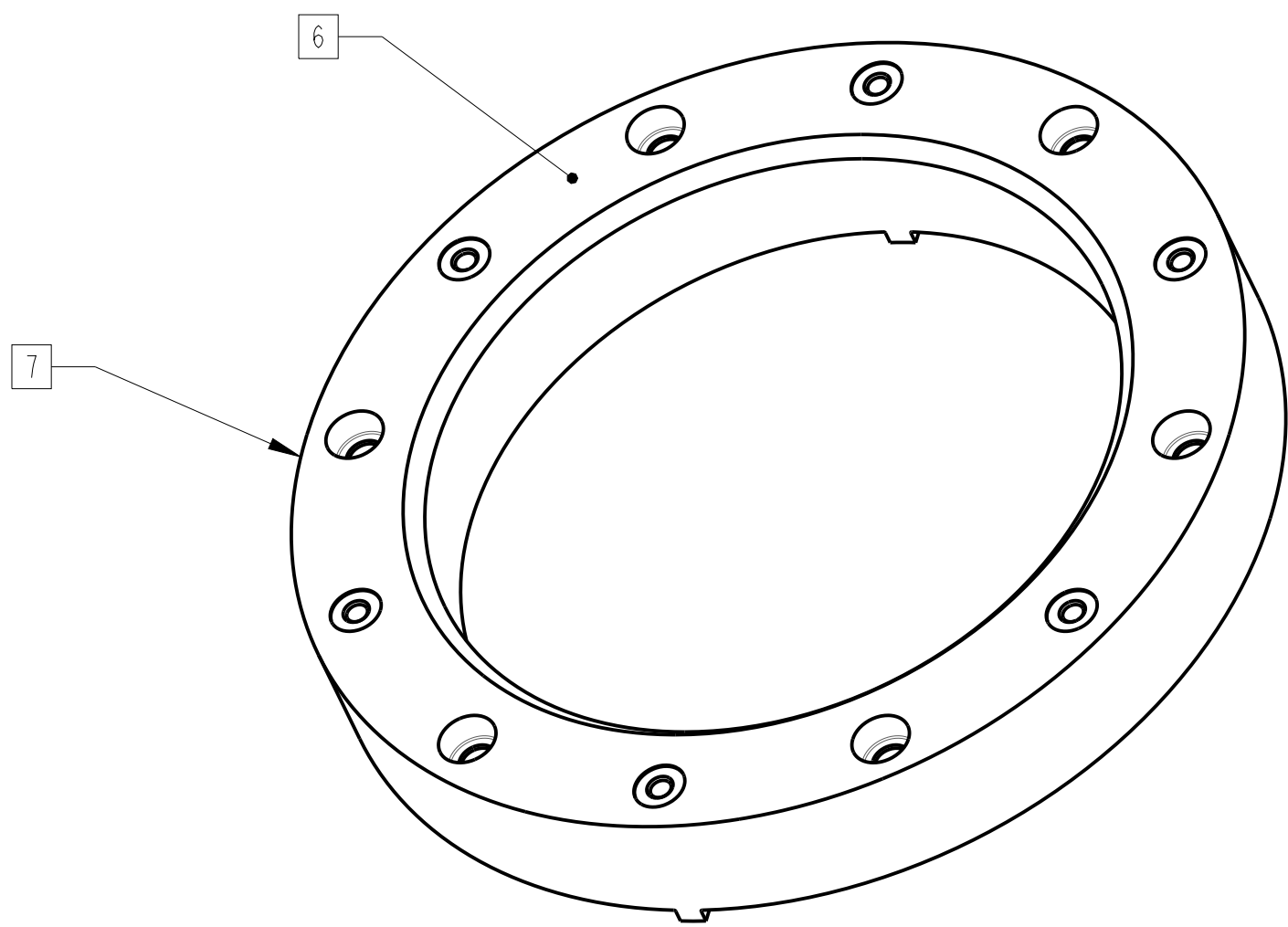
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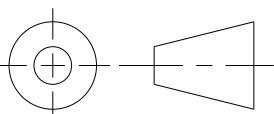
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NOTES: (UNLESS OTHERWISE SPECIFIED)

- UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS BASIC.
- USE SULFUR FREE CUTTING OIL ONLY.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES TO A MAXIMUM OF 0.5.
- ALL INSIDE CORNERS TO BE R0.5 MAX.
- PART TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
- MARK PART NUMBER AND REVISION IN THE FORMAT 00000XXXXX REV X PER SAE AS478 OR EQUIVALENT. MARKING METHOD IS TO BE MECHANICAL ENGRAVING METHOD 3A OR 3B. CHARCTERS ARE TO BE 5mm HIGH AND ARIAL (OR EQUIVALENT). MARKING TO BE LOCATED APPROXIMATELY WHERE SHOWN.
- DO NOT MACHINE PART UNTIL THE LOWER SHIELD BLOCKS IN THE CORE VESSEL HAVE BEEN INSTALLED, AND THE LOCATION HAS BEEN SURVEYED TO ALIGN THE TARGET ASSEMBLY SHAFT TO THE MRA.



WIP-NOT APPROVED FOR CONSTRUCTION				
SS 316L (S31603)			ASTM A240	
MATERIAL			SPECIFICATION	
UNITS: MILLIMETERS DEFAULT TOLERANCES 0-6 ±0.1 >6-120 ±0.2 >120 ±0.5 ANGULAR ±0.5°			 OAK RIDGE National Laboratory HIGH FLUX ISOTOPE REACTOR SPALLATION NEUTRON SOURCE	
BREAK ALL SHARP EDGES EXCEPT AS NOTED: 15 MAX				
SURFACE ROUGHNESS: 3.2 Ra UNO.				
DRAFTING STD: ASME Y14.100 GDT: ASME Y14.5 WELD SYMBOLS: AWS A2.4			SEISMIC RESTRAINT RING	
THIRD ANGLE PROJECTION			DRAWING NUMBER	
			0000009134	
SIZE			WEIGHT	
D 1:2			9 KG	
SCALE			SHEET	
			1 of 1	
REV			0	

D

C

B

A