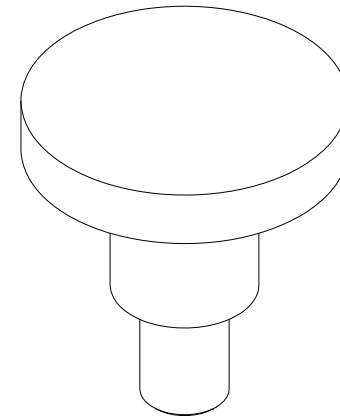
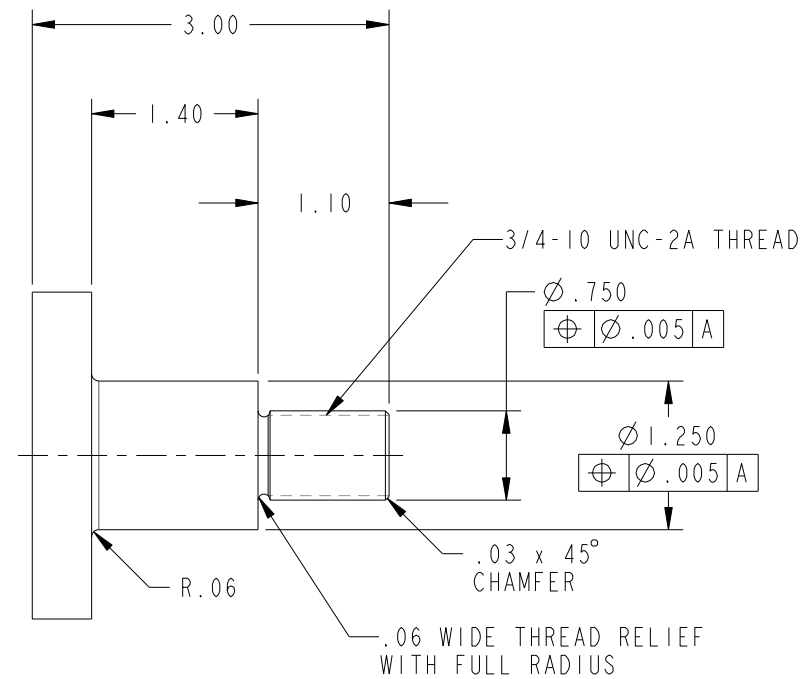
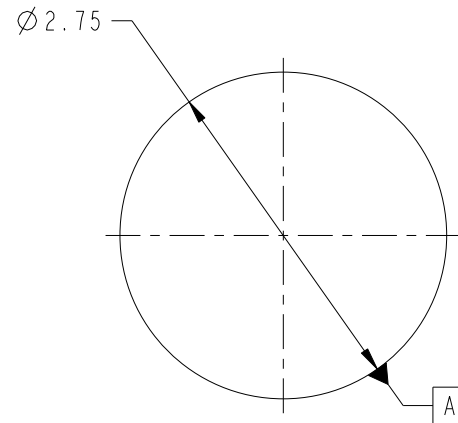










REVISIONS						
REV	TYPE	DESCRIPTION OF CHANGE	BY	CHK	APPR	DATE
0		INITIAL RELEASE	BL	KP		03/2010



- NOTES:
1. CLEAN AND HANDLE PER SNS SPECIFICATION 104110000-TS0001, LATEST REVISION.
  2. SILVER PLATE THREADED AREA PER QQ-S-365D, AMS2410 OR EQUIVALENT.  
ALTERNATE: DICRONITE PER DOD-L-85645, TYI.
  3. FABRICATE IN ACCORDANCE WITH SNS STATEMENT OF WORK 104110000-SW0002, LATEST REVISION.

304 STN STL	ASME SA240-304	1 LBS	
MATERIAL	SPECIFICATION	WEIGHT	CAGE

## PART INFORMATION

QUALITY VERIFICATION		DIMENSIONS ARE IN INCHES		APPROVALS		<div><div></div><div>THIS DRAWING IS THE PROPERTY OF <b>OAK RIDGE NATIONAL LABORATORY</b> DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 OAK RIDGE, TENNESSEE</div></div> <div><div></div><div><b>SPALLATION NEUTRON SOURCE</b></div></div> <div><div><b>HIGH BETA CRYOMODULE</b> <b>VACUUM VESSEL ASSEMBLY</b> <b>3/4-10 LOCKDOWN STUD</b></div></div>					
DOCUMENTS REQUIRED	APPLICABLE	DRAFTING STANDARD: ASME Y14.100		DESIGNER <b>B. LANG</b>	DATE <b>04/17/09</b>	<div>SIZE</div> <div><b>C</b></div>			<div>DRAWING NUMBER</div> <div><b>104110000-M8U-8200-A252</b></div>		REV <b>0</b>
MATERIAL MILL TEST REPORT		DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH ASME Y14.5M, 1994		DETAILER <b>S.E. HAMBLÉN</b>	DATE <b>03/2010</b>						
LEAK TEST REPORT		DO NOT SCALE DRAWING		CHECKER <b>K. POTTER</b>	DATE <b>03/2010</b>						
CLEANING CERT		DEFAULT TOLERANCES		ENGINEER	DATE						
WELD / BRAZE INSPECTION REPORT		LINEAR                      ANGULAR X.X ±0.1                      ±0.5° X.XX ±0.03 X.XXX ±0.010		GROUP LEAD	DATE	<div>SCALE</div> <div><b>1.000</b></div>			<div>CAD MODEL</div> <div><b>104110000-M8U-8200-A252</b></div>		SHEET <b>1 of 1</b>
HEAT TREAT REPORT (W/CHART)		REMOVE ALL BURRS AND BREAK SHARP EDGES: <b>0.060</b>		CHIEF ENGR	DATE				<div>THIS DRAWING PREPARED ON Pro/ENGINEER</div>		
DIMENSIONAL REPORT		SURFACE ROUGHNESS: <b>125 RMS MAX</b>		VERIFIER	DATE						
MATERIAL SELLER CERT		THIRD ANGLE PROJECTION		VERIFIER	DATE						
FUNCTIONAL TEST REPORT		<div></div>		CONTROL SYSTEM <b>4</b>	RELEASE <b>WIP</b>	<div>SNS PROCEDURE</div> <div><b>NFDD-ENG-001</b></div>					
DEVIATION REQUEST				QA REP					DATE		
NONCONFORMANCE REPORT											
	</										

DWG NO.	10410000-M8U-8200-A252	SH	1
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