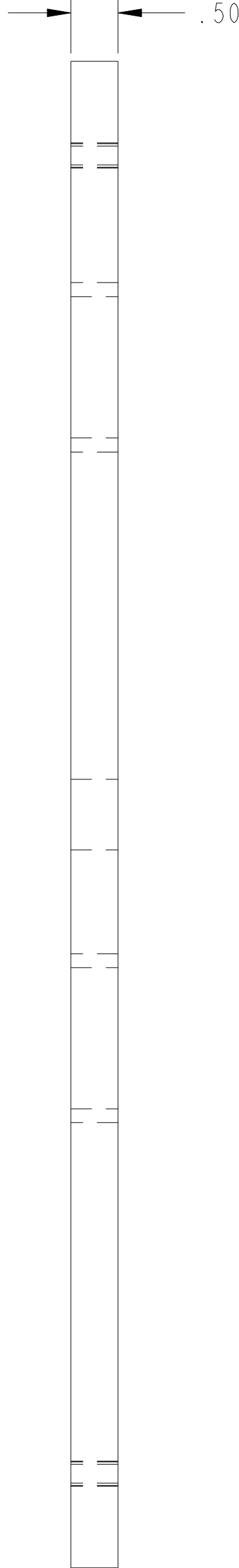


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REVISIONS											
REV	TYPE	DESCRIPTION OF CHANGE							DES	DET	CK
0									ENG	TL	GL
									CE	VER	DATE



SCALE 1/4

6061 T6 ALUMINUM		ASTM B209		18 LBS	
MATERIAL		SPECIFICATION			WEIGHT
PART INFORMATION					
ARE IN INCHES		APPROVALS		THIS DRAWING IS THE PROPERTY OF	
STANDARD: ASME Y14.100		DESIGNER: S ROY		OAK RIDGE NATIONAL LABORATORY	
DIMENSIONS AND TOLERANCING IN INCHES WITH ASME Y14.5M.2009		DATE: 4/28/2014		DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725	
SCALE: DRAWING		CHECKER: S ROY		OAK RIDGE, TENNESSEE	
TOLERANCES		DATE: 4/28/2014		NEUTRON SCIENCES	
ANGULAR		ENGINEER		N3He EXPERIMENT	
± .5°		TEAM LEAD		SPIN FLIPPER	
BURRS AND EDGES: .060		GROUP LEAD		MOUNTING BASE	
FINISHNESS: 125 RMS MAX		CHIEF ENGR		SIZE: DRAWING NUMBER	
ANGLE PROJECTION		VERIFIER		E FUND13N3HE10M8U8713A003	
CONTROL SYSTEM		RELEASE		REV 0	
SNS PROCEDURE		SCALE 3/4		CROSS MODEL FUND13N3HE10M8U8713A003	
NDD-ENG-001		MODEL REV SHEET 0		1 of 1	
THIS DRAWING PREPARED ON Pro/ENGINEER					

QUALITY VERIFICATION	
DOCUMENTS REQUIRED	APPLICABLE
MATERIAL MILL TEST REPORT	
LEAK TEST REPORT	
CLEANING CERT	
WELD J BRACE INSPECTION REPORT	
HEAT TREAT REPORT (W/CHART)	
DIMENSIONAL REPORT	
MATERIAL SELLER CERT	
FUNCTIONAL TEST REPORT	
DEVIATION REQUEST	
NONCONFORMANCE REPORT	
QA REP	DATE

NEXT USED ASSEMBLIES	
FUND13N3HE10M8U8713A001	QA REP
	DATE

DIMENSIONS ARE IN INCHES DRAFTING STANDARD: ASME Y14.100 DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH ASME Y14.5M.2009 DO NOT SCALE DRAWING	
DEFAULT TOLERANCES	
LINEAR	ANGULAR
X.XX ±.01	±.5°
X.XXX ±.005	
REMOVE ALL BURRS AND BREAK SHARP EDGES: .060 SURFACE ROUGHNESS: 125 RMS MAX	
THIRD ANGLE PROJECTION	

APPROVALS	
DESIGNER: S ROY	DATE: 4/28/2014
CHECKER: S ROY	DATE: 4/28/2014
ENGINEER:	DATE:
TEAM LEAD:	DATE:
GROUP LEAD:	DATE:
CHIEF ENGR:	DATE:
VERIFIER:	DATE:
CONTROL SYSTEM:	RELEASE:
SNS PROCEDURE:	4

NFDD-ENG-001