

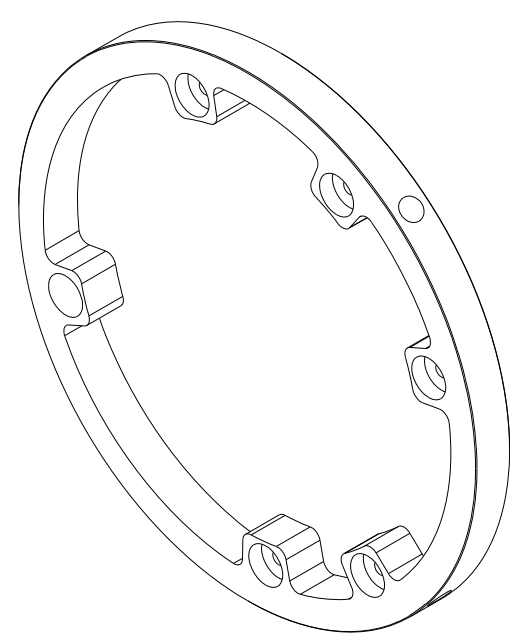
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REVISIONS

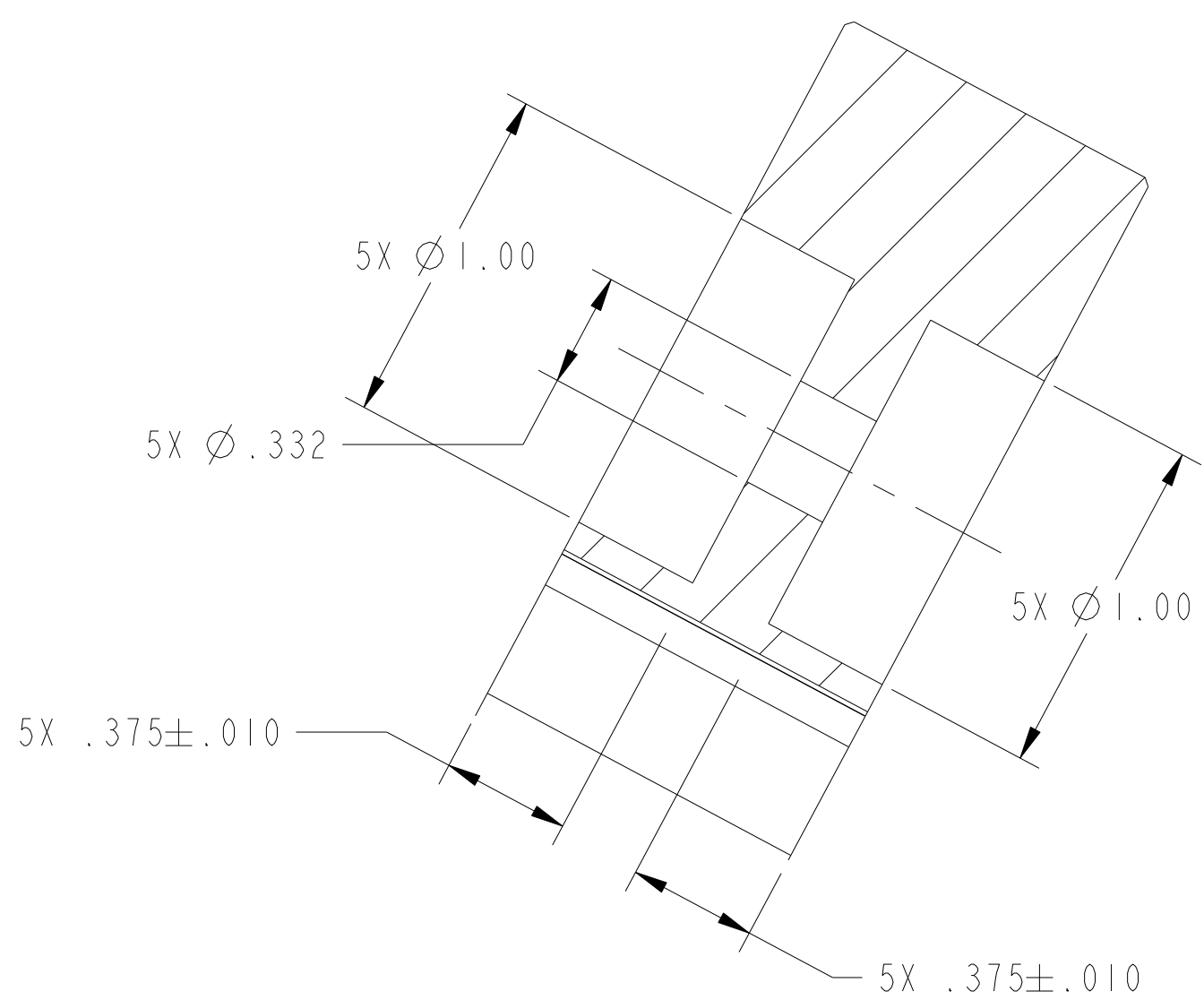
[illegible]

NOTES:

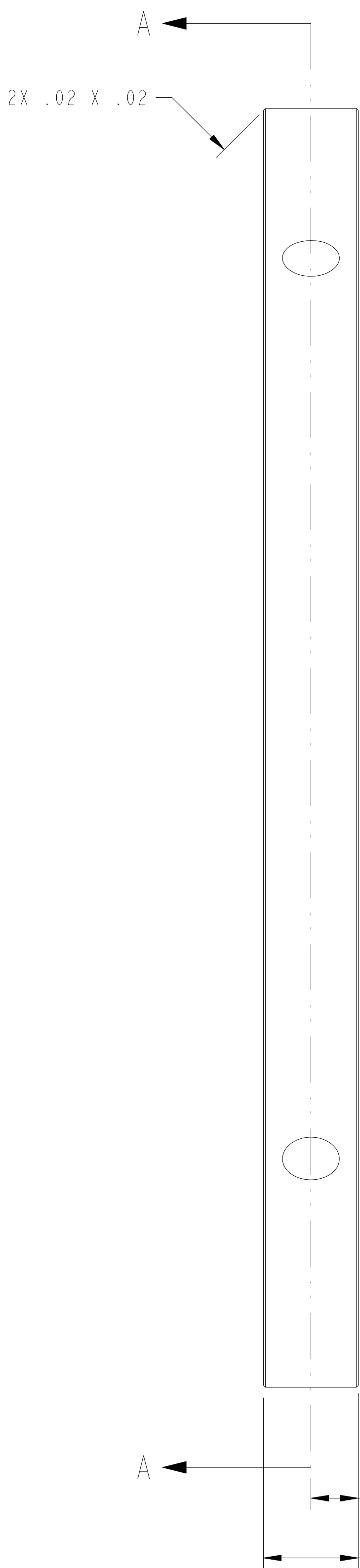
1.



SCALE 1/4



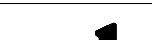



SECTION B-B
SCALE 2/1

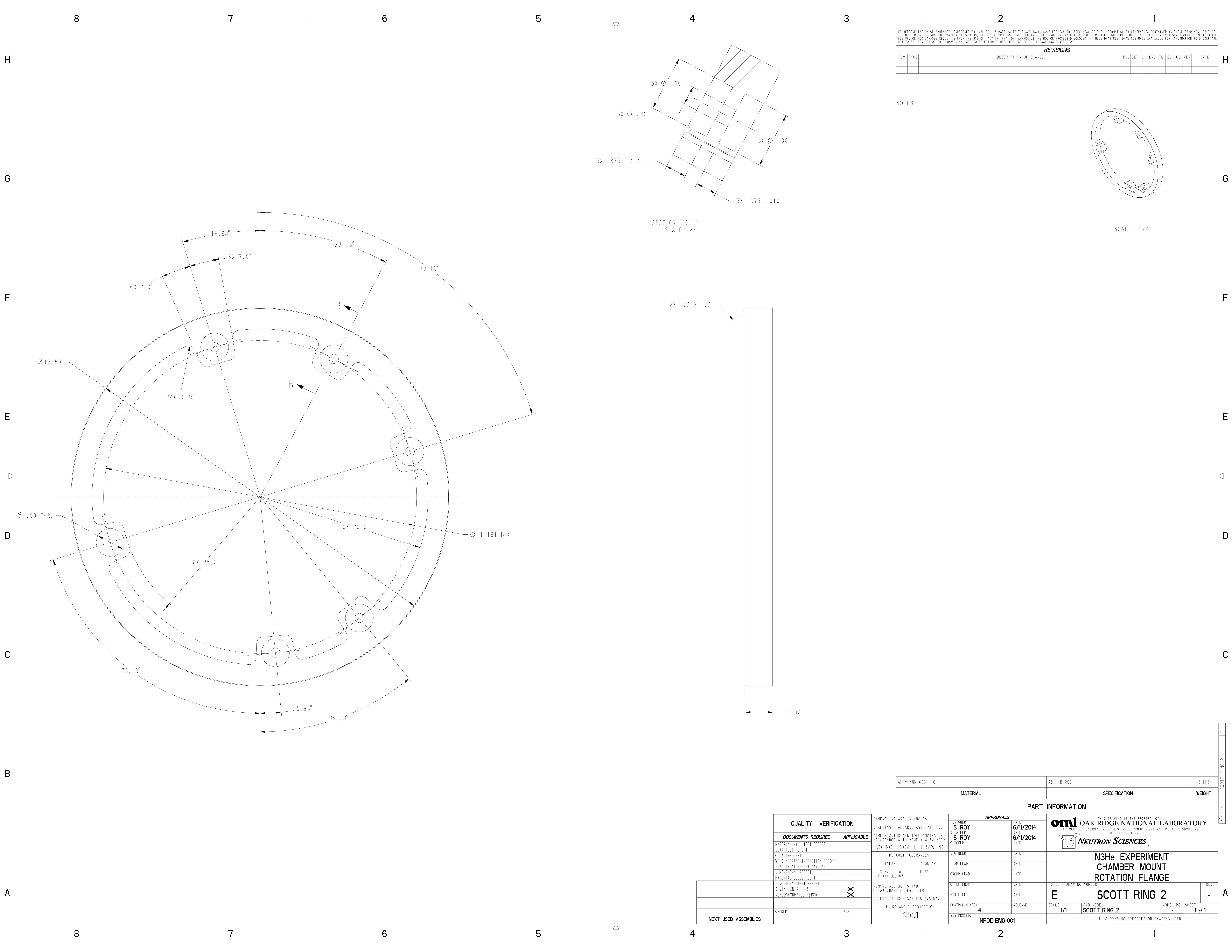


SECTION A-A

ALUMINUM 6061 T6	ASTM B 209	3 LBS
MATERIAL	SPECIFICATION	WEIGHT

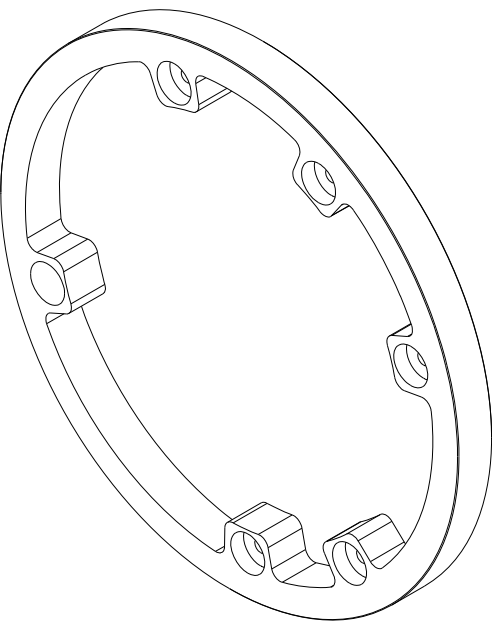
PART INFORMATION

QUALITY VERIFICATION		DIMENSIONS ARE IN INCHES		APPROVALS		 THIS DRAWING IS THE PROPERTY OF OAK RIDGE NATIONAL LABORATORY DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 OAK RIDGE, TENNESSEE		
DOCUMENTS REQUIRED		APPLICABLE		DESIGN: S ROY DATE: 6/11/2014 CHECKER: S ROY DATE: 6/11/2014		 NEUTRON SCIENCES		
MATERIAL MILL TEST REPORT		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		ENGINEER		DATE		
LEAK TEST REPORT				TEAM LEAD		DATE		
CLEANING CERT				GROUP LEAD		DATE		
WELD / BRACE INSPECTION REPORT				CHIEF ENGR		DATE		
HEAT TREAT REPORT (WICHART)				VERIFIER		DATE		
DIMENSIONAL REPORT		REMOVE ALL BURRS AND BREAK SHARP EDGES: .060 SURFACE ROUGHNESS: 125 RMS MAX		CONTROL SYSTEM		RELEASE		
MATERIAL SELLER CERT		THIRD ANGLE PROJECTION		SWS PROCEDURE		SCALE		
FUNCTIONAL TEST REPORT				NFDD-ENG-001		1/1		
DEVIATION REQUEST						TCD MODEL: SCOTT RING		REV
NONCONFORMANCE REPORT						MODEL REV SHEET: -		
GA REP		DATE				THIS DRAWING PREPARED ON Pro/ENGINEER		1 of 1



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

NOTES:
1.



SCALE 1/4

ALUMINUM 6061 T6			ASTM B 209			3 LBS		
MATERIAL			SPECIFICATION			WEIGHT		
PART INFORMATION								
ARE IN INCHES			APPROVALS			<div><div>THIS DRAWING IS THE PROPERTY OF OAK RIDGE NATIONAL LABORATORY DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 OAK RIDGE, TENNESSEE</div><div> NEUTRON SCIENCES</div></div>		
DESIGNED: S ROY			DATE: 6/11/2014					
STANDARD: ASME Y14.100			DATE: 6/11/2014					
CHECKED: S ROY			DATE: 6/11/2014					
TOLERANCING: IN WITH ASME Y14.5M-2009			DATE: 6/11/2014					
SCALE: DRAWING			DATE: 6/11/2014					
MULT TOLERANCES			DATE: 6/11/2014					
ANGULAR			DATE: 6/11/2014					
01 ± .5°			DATE: 6/11/2014					
005			DATE: 6/11/2014					
BURRS AND EDGES: .060			DATE: 6/11/2014			SIZE: DRAWING NUMBER		
FINISHNESS: 125 RMS MAX			DATE: 6/11/2014			REV		
ANGLE PROJECTION			DATE: 6/11/2014			E		
CONTROL SYSTEM			RELEASE			SCALE		
SNS PROCEDURE			RELEASE			1/1		
NFDD-ENG-001			RELEASE			CAD MODEL		
NFDD-ENG-001			RELEASE			SCOTT RING 2		
NFDD-ENG-001			RELEASE			MODEL REV SHEET		
NFDD-ENG-001			RELEASE			- 1 of 1		
NFDD-ENG-001			RELEASE			THIS DRAWING PREPARED ON Pro/ENGINEER		