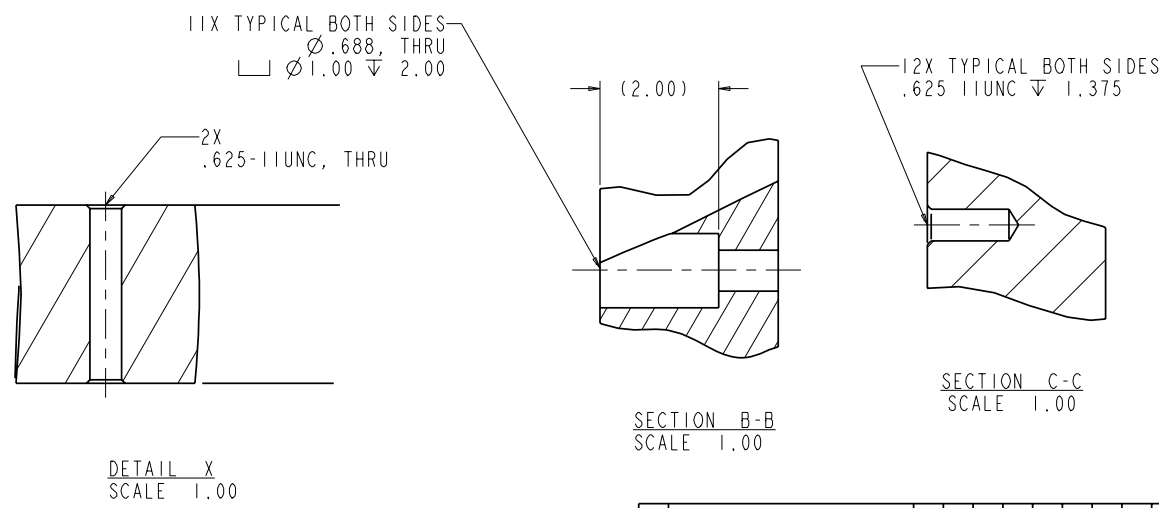
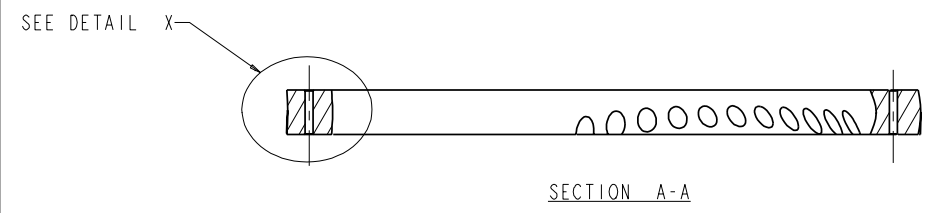
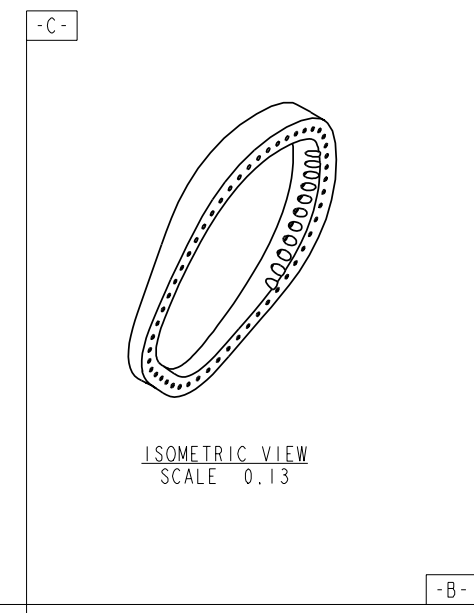
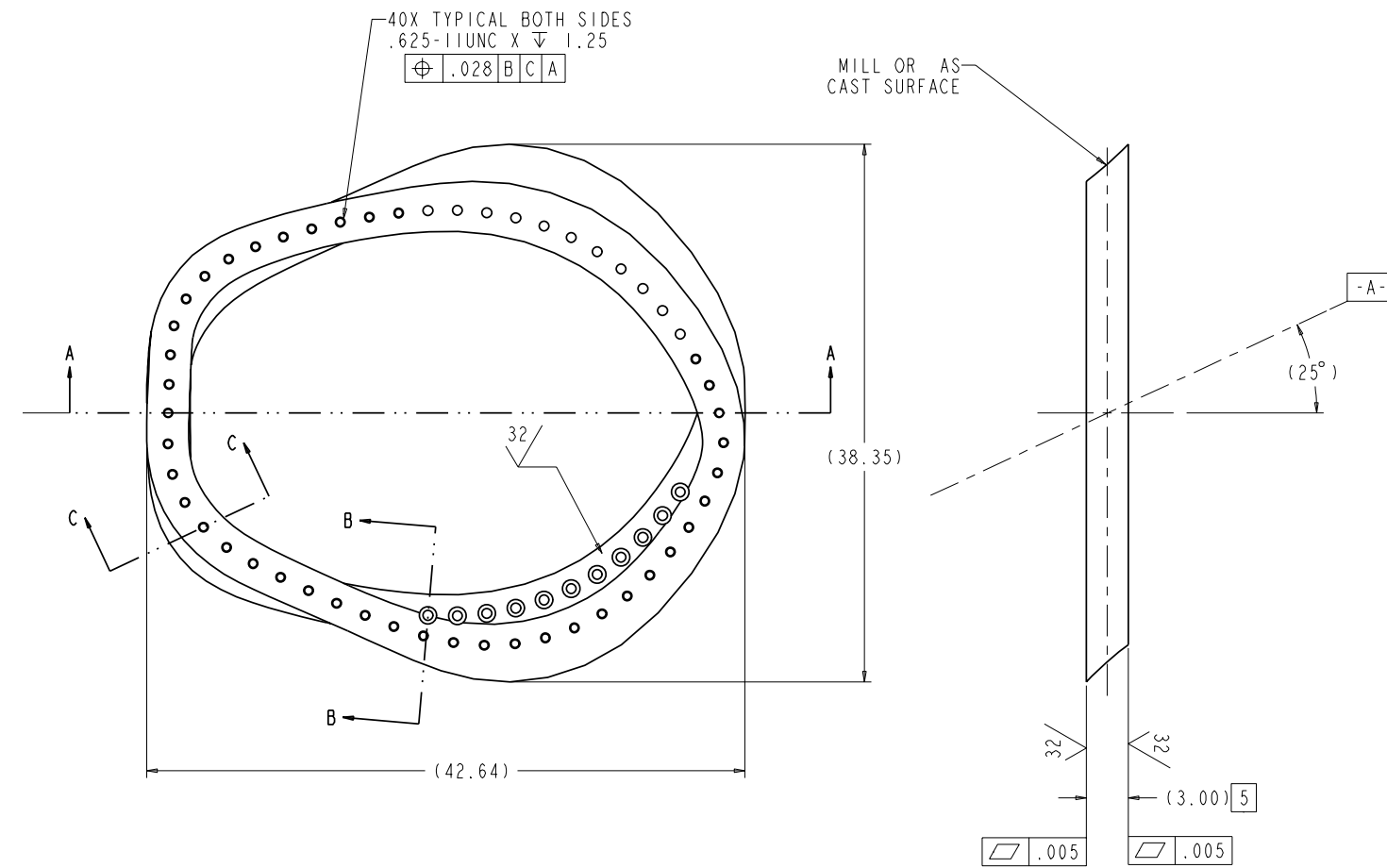


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  2. DIMENSION ARE IN INCHES.
  3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
  4. GEOMETRY OF VACUUM VESSEL SPACER IS DEFINED IN CAD MODELS/FILES SEI21-019.PRT.ASM, SEI20-001.ASM, AND SEI20-002.ASM.
  5. MEASURE AND MACHINE TO FIT AT ASSEMBLY, SEI20-001.
  6. HELIUM LEAK TEST SHALL SHOW NO DETECTABLE LEAK WITH DETECTOR SENSITIVITY SET AT  $1.0 \times 10^{-9}$  STD-CC/SEC.
  7. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.



① SCALE: .25

WEIGHT = 362.8 LBS

PRELIMINARY  
 FOR INFORMATION ONLY

AR	CAGE CODE	PART OR IDENTIFYING NO	SPACER	UNS N06625		
SEI20-002			NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			PARTS LIST			

QUALITY VERIFICATION	MECHANICAL AND STRUCTURAL	REFERENCE ORNL DA-G05
303 MATERIAL WELD TEST REPORT		X
305 MATERIAL SEALER TEST		X
326 SPECIAL MATERIAL INSPECTION REPORT		X
205 MANUFACTURING INSPECTION AND TEST PLAN		X
312 HELIUM DETECTOR AND TEST PLAN		X
321 HELIUM AND BAKING INSPECTION REPORT		X
322 HEAT TREAT REPORT (REQUIRED)		X
310 LEAK TEST REPORT		X
315 CLEANING CERT		X
318 DEVIATION REQUEST		X
319 NONCONFORMANCE REPORT		X
323 OPTOMETRICAL REPORT		X
330 FUNCTIONAL TEST REPORT		X
100 DOCUMENTATION		X

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DATE	ORNL	DATE	DOE	DATE	DA	CV	EC	EE	EM	JE	N	PD	SE	ST	XAD	PES
A	GEN REVISION																								

SCALE NOTED	DESIGNER	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED	P. L. GORANSON	12/02
FRACTIONS ±.01		
XX DECIMALS ±.005		
XXX DECIMALS ±.0015		
ANGLES ±0°15'		
BREAK SHARP EDGES .06 MAX		
FINISH UNLESS OTHERWISE SPECIFIED		

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
1.4	XX	XX	1	1	XX	U	
RELEASE LEVEL	SEI21-019						
WIP							

SEI21-019