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NEXT USED ASSEMBLY

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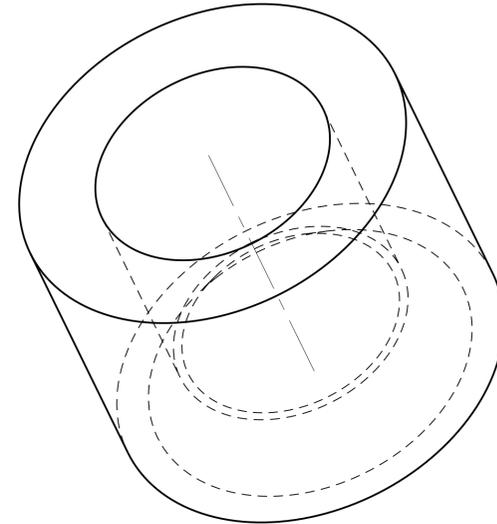
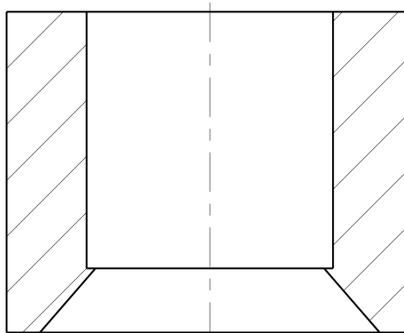
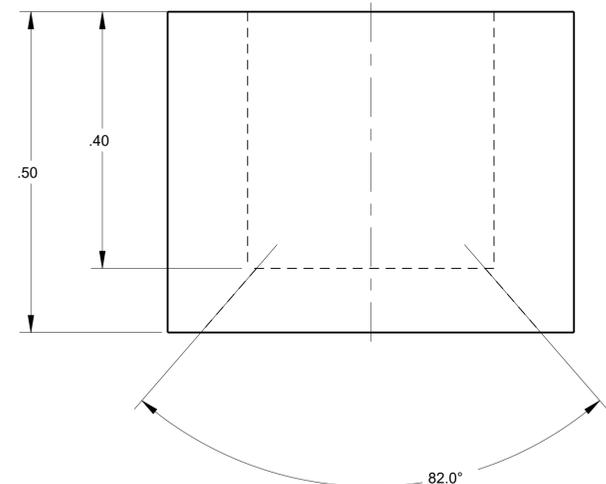
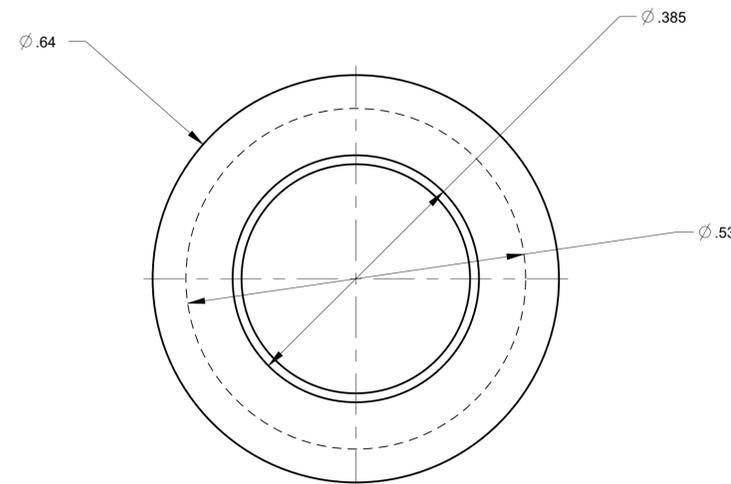
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APPROVAL BLOCK

REV	DESCRIPTION OF CHANGE	DES	CHK	ENG	TL	GL	VER	DATE
0	ORIGINAL ISSUE							

NOTES:

1. TO BE MANUFACTURED FROM MCMASTER 84995K25 OR EQUIVALENT



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SINTERED BORON NITRIDE		---	
MATERIAL		SPECIFICATION	
UNITS: INCHES DEFAULT TOLERANCES $X.XX \pm 01$ $X.XXX \pm .005$ ANGULAR $\pm .5^\circ$			
BREAK ALL SHARP EDGES EXCEPT AS NOTED: $.060$ MAX SURFACE ROUGHNESS: 125 U.N.O.		HFIR INSTRUMENTS POWDER TIP-TOP CANS BN BOTTOM SHIELD, INCH	
DRAFTING STD: ASME Y14.100 D & T: ASME Y14.5 WELD SYMBOLS: AWS A2.4		DRAWING NUMBER	REV
		BN_BOTTOM_SHIELD	
THIRD ANGLE PROJECTION		SIZE	WEIGHT
		D	0 LB
		SCALE	SHEET
		7:1	1 of 1

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NEXT USED ASSEMBLY

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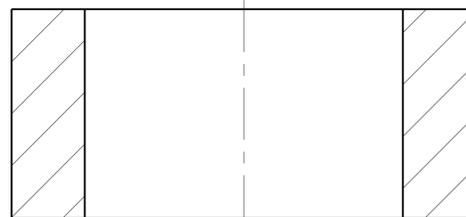
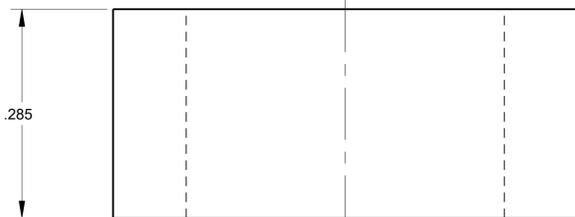
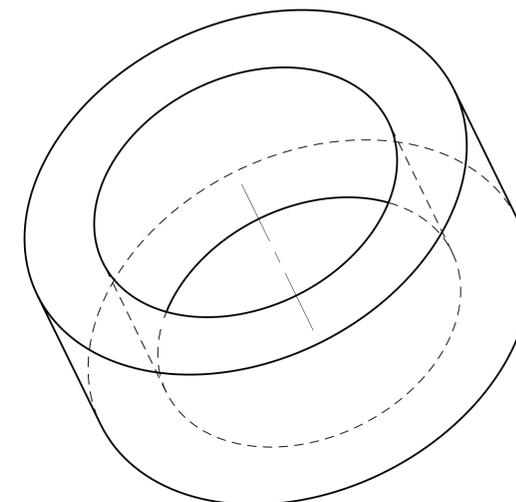
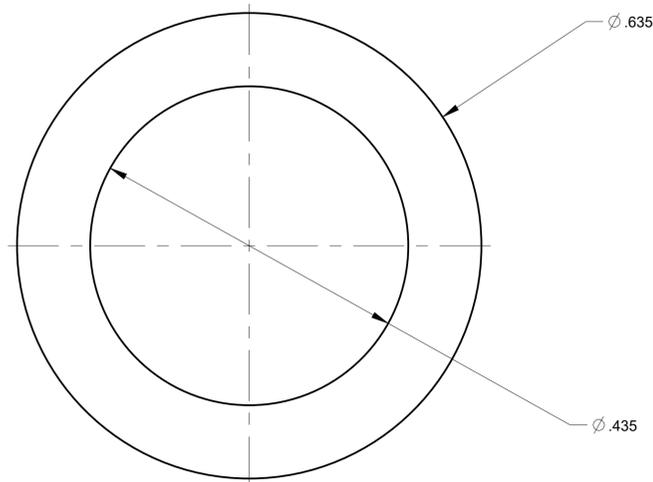
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APPROVAL BLOCK

REV	DESCRIPTION OF CHANGE	DES	CHK	ENG	TL	GL	VER	DATE
0	ORIGINAL ISSUE							

NOTES:

1. TO BE MANUFACTURED FROM MCMASTER 84995K25 OR EQUIVALENT



SECTION X-X

SINTERED BORON NITRIDE		---	
MATERIAL		SPECIFICATION	
UNITS: INCHES DEFAULT TOLERANCES X.XX ± 01 X.XXX ± .005 ANGULAR ± .5°		 HIGH FLUX ISOTOPE REACTOR SPALLATION NEUTRON SOURCE	
BREAK ALL SHARP EDGES EXCEPT AS NOTED: .060 MAX SURFACE ROUGHNESS: 125 U.N.O.			
DRAFTING STD: ASME Y14.100 D & T: ASME Y14.5 WELD SYMBOLS: AWS A2.4		HFIR INSTRUMENTS POWDER TIP-TOP CANS BN COUPLING SHIELD, INCH	
THIRD ANGLE PROJECTION 		DRAWING NUMBER BN_COUPLING_SHIELD	REV
SIZE	SCALE	WEIGHT	SHEET
D	8:1	0 LB	1 of 1

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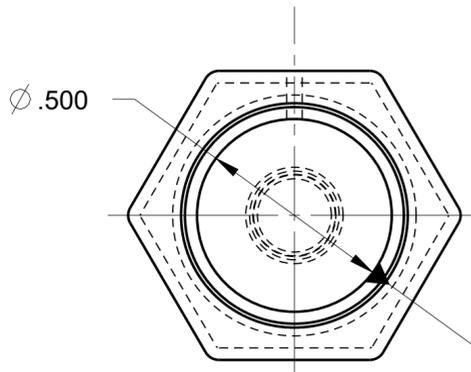
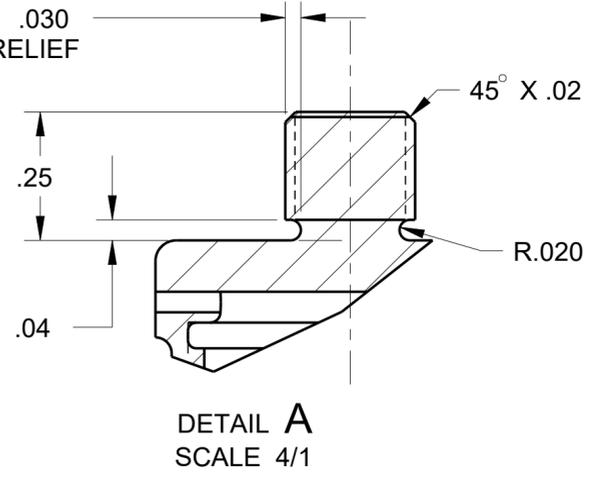
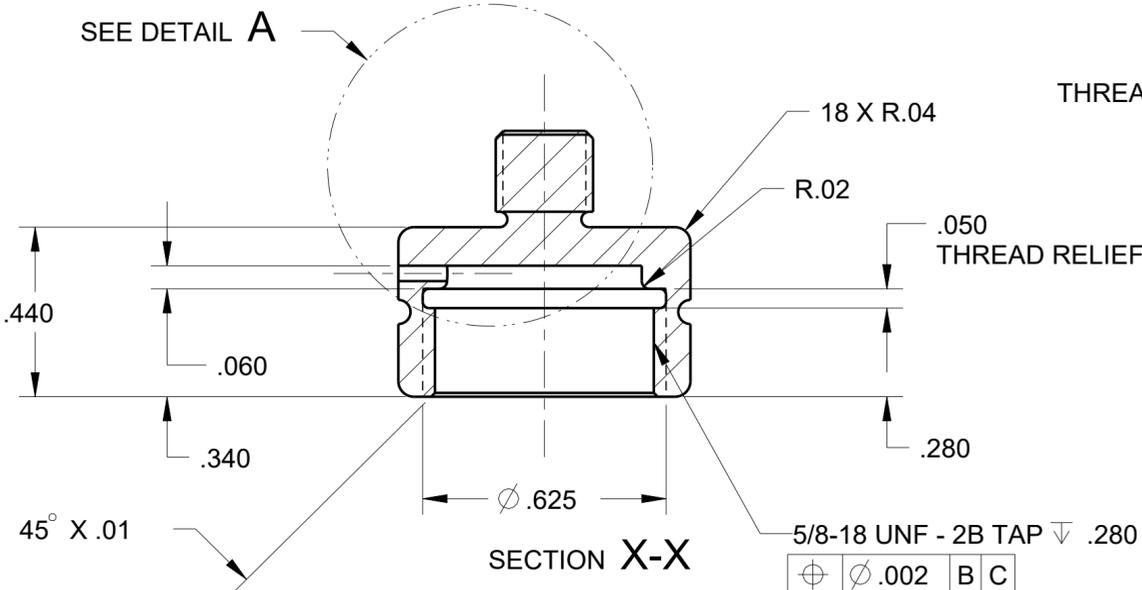
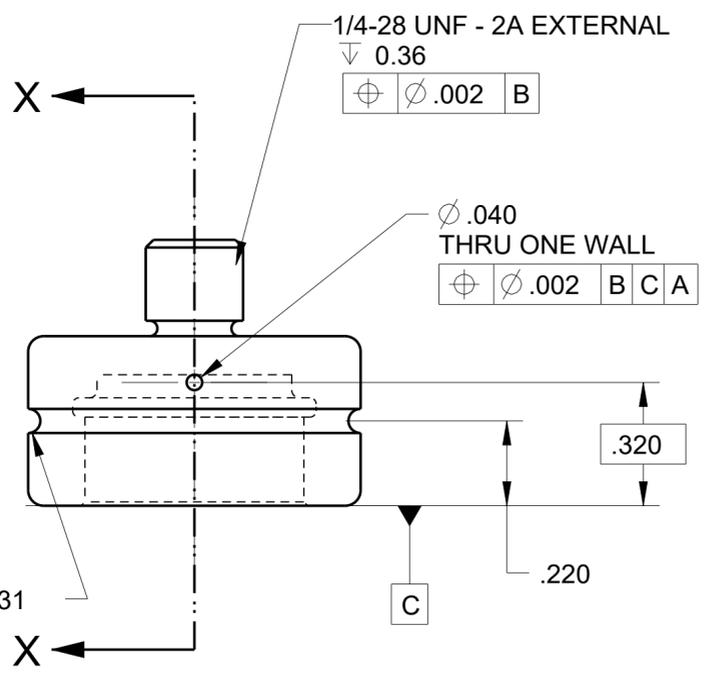
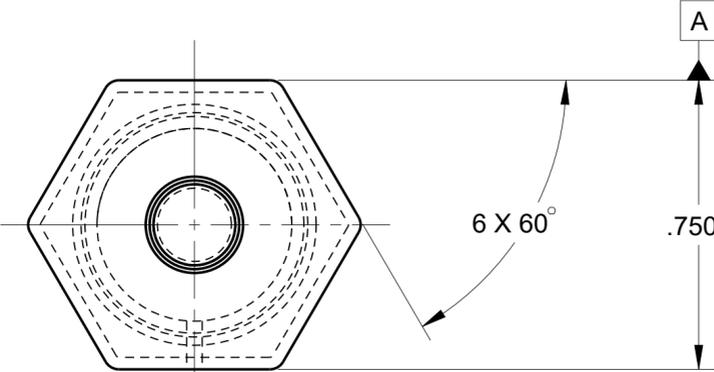
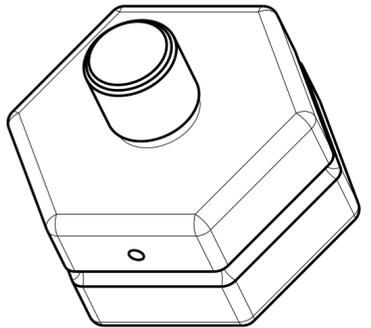
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REVISIONS											
REV	TYPE	DESCRIPTION OF CHANGE	DES	DET	CK	ENG	TL	GL	CE	VER	DATE
0		ORIGINAL ISSUE									

NOTES:
1. PARTS MUST BE DEBURRED IN A TUMBLER PRIOR TO MACHINING THREADS



110 COPPER	ASTM B187	0.046 LBS
MATERIAL	SPECIFICATION	WEIGHT

PART INFORMATION

QUALITY VERIFICATION	DOCUMENTS REQUIRED	APPLICABLE
	MATERIAL MILL TEST REPORT	
	LEAK TEST REPORT	
	CLEANING CERT	
	WELD / BRAZE INSPECTION REPORT	
	HEAT TREAT REPORT (W/CHART)	
	DIMENSIONAL REPORT	
	MATERIAL SELLER CERT	
	FUNCTIONAL TEST REPORT	
	DEVIATION REQUEST	X
	NONCONFORMANCE REPORT	X

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

APPROVALS	
DESIGNER M. COCHRAN	DATE 06/04/2020
DETAILER M. COCHRAN	DATE 06/04/2020
CHECKER	DATE
ENGINEER	DATE
TEAM LEAD	DATE
GROUP LEAD	DATE
CHIEF ENGR	DATE
VERIFIER	DATE

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DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725
OAK RIDGE, TENNESSEE
NEUTRON SCIENCES

SAMPLE ENVIRONMENT HB2A QUICK CAN SMALL LID		
SIZE	DRAWING NUMBER	REV
3/1	CHFIRHB2A-04-M8U-79HB-A074_TB0	1 of 1
SCALE	CAD MODEL	MODEL REV SHEET
3/1	HFIRHB2A-04-M8U-79HB-A074_TB	1 of 1

THIRD ANGLE PROJECTION	QA REP	DATE
NEXT USED ASSEMBLIES		

CONTROL SYSTEM 4
RELEASE
SNS PROCEDURE NFDD-ENG-001

THIS DRAWING PREPARED ON Pro/ENGINEER

DWG NO CHFIRHB2A-04-M8U-79HB-A074_TB 5th 1

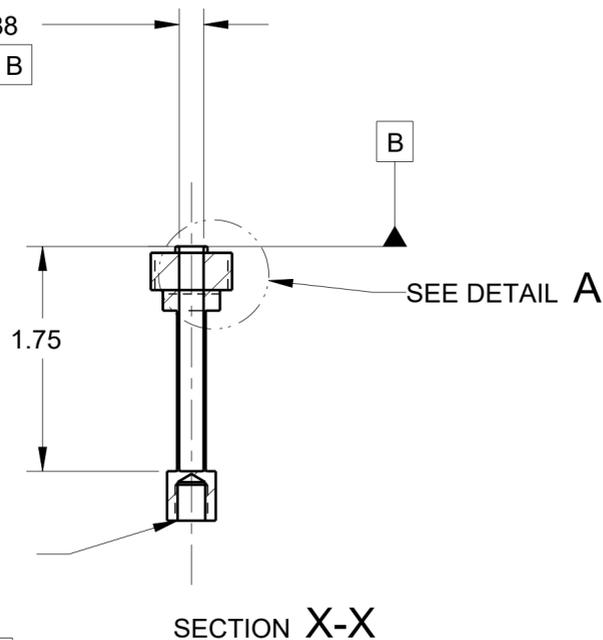
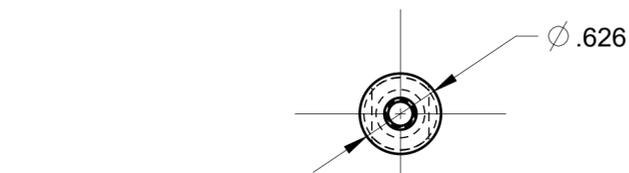
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REVISIONS

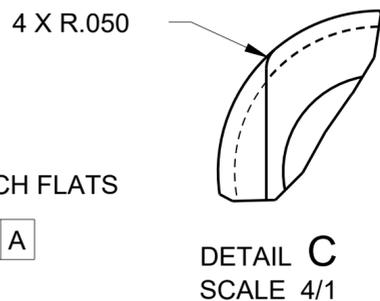
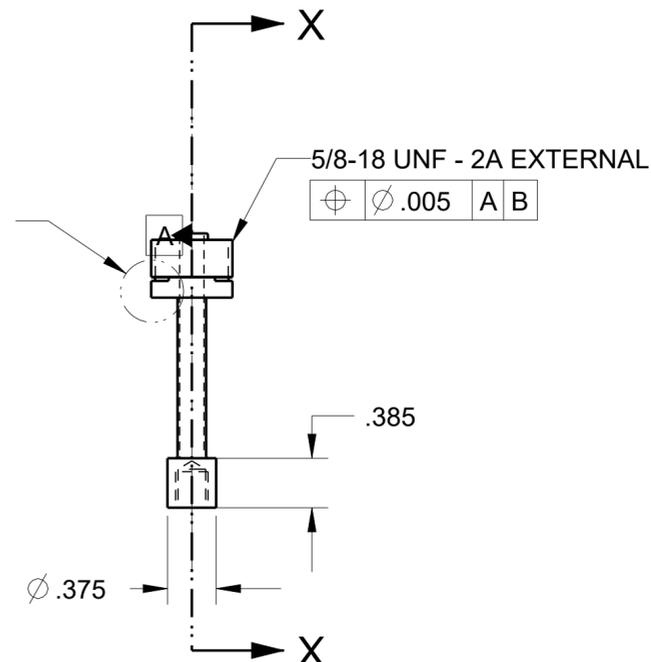
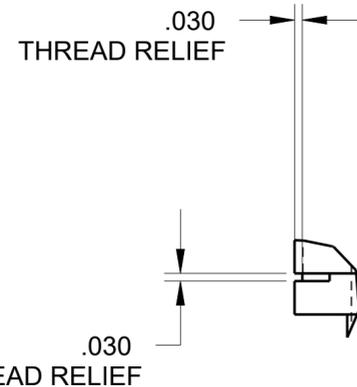
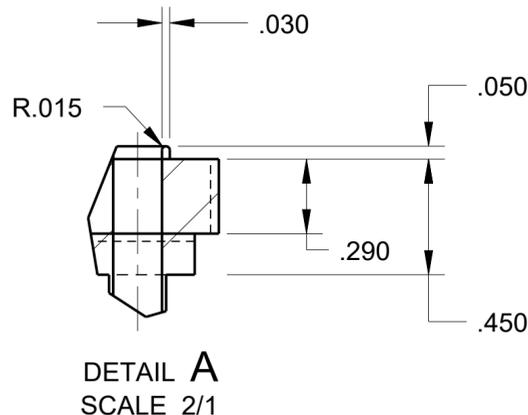
REV	TYPE	DESCRIPTION OF CHANGE	DES	DET	CK	ENG	TL	GL	CE	VER	DATE
0		ORIGINAL ISSUE									

NOTES:

1. PARTS MUST BE DEBURRED IN A TUMBLER PRIOR TO MACHINING THREADS



SECTION X-X



SEE DETAIL C

110 COPPER AND 6061-T6	ASTM B187 AND ASTM B221	.014 LBS
MATERIAL	SPECIFICATION	WEIGHT

PART INFORMATION

QUALITY VERIFICATION	
DOCUMENTS REQUIRED	APPLICABLE
MATERIAL MILL TEST REPORT	
LEAK TEST REPORT	
CLEANING CERT	
WELD / BRAZE INSPECTION REPORT	
HEAT TREAT REPORT (W/CHART)	
DIMENSIONAL REPORT	
MATERIAL SELLER CERT	
FUNCTIONAL TEST REPORT	
DEVIATION REQUEST	X
NONCONFORMANCE REPORT	X
HFIRHB2A-04-M8U-79HBA-076	QA REP
NEXT USED ASSEMBLIES	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 M COCHRAN	DATE 07/19/2019
DETAILER M COCHRAN	DATE 07/19/2019
CHECKER	DATE
ENGINEER	DATE
TEAM LEAD	DATE
GROUP LEAD	DATE
CHIEF ENGR	DATE
VERIFIER	DATE
CONTROL SYSTEM 4	RELEASE
SNS PROCEDURE NFDD-ENG-001	

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 OAK RIDGE, TENNESSEE

NEUTRON SCIENCES

**SAMPLE ENVIRONMENT
 HB2A QUICK CAN
 .188 ID CAN**

SIZE	DRAWING NUMBER	REV
	CHFIRHB2A-04-M8U-79HB-A078_TT0	
SCALE 1/1	CAD MODEL HFIRHB2A-04-M8U-79HB-A078 TT	MODEL REV SHEET 1 of 1

THIS DRAWING PREPARED ON Pro/ENGINEER

DWG NCFIRHB2A-04-M8U-79HB-A078_TT 1

