1. MATERIAL CERTIFICATIONS REQUIRED

NOTES
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED
2. TACK WELD NUTS ON ENDS OF JACK SCREWS AFTER ASSY

ITEM EXPLODED/QTY. NAME MATERIAL DESCRIPTION DWG
22 8 Socket Head Cap Screw AI SS - 18-8 SHCS - 5/8-11 x 2.00 N/A
21 4 CBOLT 0.3125-18x0.375x2.00 N/A
20 10 HK-SHC 5 0.5-13x0.625x0.625 N/A
19 2 HX-NUT 0.625-11-D N/A
18 2 HK-SHC 5 0.625-11x6.25 N/A
17 2 HK-SHC 5 0.625-11x1 N/A
16 4 HX-NUT 0.750-10-D N/A
15 4 HK-SHC 5 0.75-16x4.5x4.5 N/A
14 4 FW 0.625 SS - 18-8 FLAT WASHER - 5/8" N/A
13 4 FW 0.75 SS - 18-8 FLAT WASHER - 3/4" N/A
12 6 leveling foot hjt SS - 303 S & W MFG. CO., Bensenville, IL, Phone 888-538-3548, #SSW-5G N/A
11 3 hilman hjt --- HILMAN ROLLER #KRS-15-SLP N/A
10 4 hyd jack assy hjt --- --- 203-HJT-0130
9 4 sidemount swivel hold ring ALLOY STEEL MCMASTER CARR 29925285 N/A
8 4 hyd jack backplate hjt C5S - 1018 PLATE, 0.125 X 5 X 0.060 203-HJT-0134
7 4 hyd jack weldment hjt C5S - 1018 HYD JACK WELDMNT 203-HJT-0131
6 2 magnet restraint plate hjt AL - 6061 T611, ASIM B-221 PLATE - 3 1/2" X 8" X .060 203-HJT-0114
5 1 magnet support plate hjt AL - 6061 T611, ASIM B-209 MAGNET SUPPORT PLATE 203-HJT-0113
4 1 uhmw sheet hjt UHMW MCMASTER CARR #839245-116 203-HJT-0112
3 2 cart anchor assy hjt --- CARTANCHOR ASSY 203-HJT-0111
2 2 flat rail hjt SS - 304L BAR - 2" X 50" X 5/8 203-HJT-0110
1 1 base weldment hjt AL - 6061 T6 BASE WELDMENT 203-HJT-0110
NOTES
1. MATERIAL CERTIFICATIONS REQUIRED
2. TACK WELD NUTS ON ENDS OF JACK SCREWS AFTER ASSY

ALIGN TAPPED HOLES WITH THRU HOLES PRIOR TO WELDING 4 PLCS.

SECTION A-A

THIRD-ANGLE PROJECTION

DRAWING APPROVALS
This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements.

SCALE: 1:15

UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES .1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. XX DECIMALS .010
9. XXX DECIMALS .005 UNLESS OTHERWISE NOTED

REMOTO SYSTEMS GROUP
NUFACT HG JET EXPERIMENT
COMMON BASE ASSY

OAK RIDGE NATIONAL LABORATORY
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

DRAWING NO. 203-H T-0100
1. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
2. MATERIAL CERTIFICATIONS REQUIRED

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY.</th>
<th>DESCRIPTION</th>
<th>MATERIAL</th>
</tr>
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<tbody>
<tr>
<td>15</td>
<td>6</td>
<td>PLATE, 4.00 x 6.00 x .50</td>
<td>AL - 6061 T6511, ASTM B-221</td>
</tr>
<tr>
<td>14</td>
<td>2</td>
<td>PLATE, 10.50 x 10.50 x .63</td>
<td>AL - 6061 T6511, ASTM B-221</td>
</tr>
<tr>
<td>13</td>
<td>1</td>
<td>C CHANNEL, 4.00 x 1.72 x .32</td>
<td>AL - 6061 T6511, ASTM B-221</td>
</tr>
<tr>
<td>12</td>
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<td>C CHANNEL, 4.00 x 1.72 x .32</td>
<td>AL - 6061 T6511, ASTM B-221</td>
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<tr>
<td>11</td>
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<td>PLATE, 8.00 x 10.50 x .63</td>
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<td>10</td>
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<td>ROUND, 1.00 OD x 1.10</td>
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</tr>
<tr>
<td>9</td>
<td>12</td>
<td>PLATE, 2.50 x 3.00 x .63</td>
<td>AL - 6061 T6511, ASTM B-221</td>
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<tr>
<td>8</td>
<td>1</td>
<td>AMER SID &quot;C&quot;, 4.00 x 1.72 x .32</td>
<td>AL - 6061 T6511, ASTM B-308</td>
</tr>
<tr>
<td>7</td>
<td>2</td>
<td>AMER SID &quot;T&quot;, 4.00 x 2.66 x .19</td>
<td>AL - 6061 T6511, ASTM B-308</td>
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<tr>
<td>6</td>
<td>1</td>
<td>AMER SID &quot;T&quot;, 4.00 x 2.66 x .19</td>
<td>AL - 6061 T6511, ASTM B-308</td>
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<tr>
<td>5</td>
<td>4</td>
<td>BAR, 1.50 x 1.50 x 1.50</td>
<td>AL - 6061 T6511, ASTM B-308</td>
</tr>
<tr>
<td>4</td>
<td>4</td>
<td>STUD, 3/4-10 UNC</td>
<td>SS ALL-THREAD</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>PLATE, 12.00 x 24.00 x .63</td>
<td>AL - 6061 T6511, ASTM B-209</td>
</tr>
<tr>
<td>2</td>
<td>6</td>
<td>ANGLE - 3.00 x 3.50 x .50</td>
<td>AL - 6061 T6511, ASTM B-221</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>AMER SID &quot;C&quot;, 4.00 x 1.72 x .32</td>
<td>AL - 6061 T6511, ASTM B-308</td>
</tr>
</tbody>
</table>

DIFFERENCES IN UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES .1/2 FORMED ANGLES
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS

NOTES
1. WELDING & INSPECTIONS SHALL BE PERformed IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED
NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

SCALE 1:5
SECTION E-E
SUPPORT PLATE FLUSH
WITH CHANNELS

SCALE 2:15
DETAIL H
5X 6X DRILL THRU
TAP 1-8 UNC

SCALE 2:15
DETAIL G
SCALE 2:15
3 PLATES

DETAIL F
CUT CHANNELS TO ACCEPT
FLUSH MOUNTED GUSSETS
3 PLCS.

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Agreements. This drawing is property of
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request.

OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under
contract DE-AC05-00OR22725 Oak Ridge, TN

NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
BASE WELDMENT

UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005
   UNLESS OTHERWISE NOTED

SCALE 1:5
W-11
2X 3/8 3/8

SCALE 1:10
W-13
1/4

SCALE 2:15
DETAIL J
W-14
3 PLCS.

DETAL I
SCALE 2:15
3 PLATES
1/4

SCALE 2:15
W-9
4X 45° CUTHDI
BOTH SIDES

SCALE 2:15
W-7
1/4 1/4

SCALE 2:15
W-12
2X 3/8 3/8

SCALE 2:15
W-6
6X 1/4 1/4

SCALE 2:15
W-10
3 PLATES
1/4

NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

THIRD-ANGLE PROJECTION

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Work for Others Agreements and
Cooperative Research and Development
Agreements. This drawing is property of
ORNL and must be returned upon
request.
MATERIAL: UHMW

1. MATERIAL CERTIFICATIONS REQUIRED

UNLESS OTHERWISE NOTED:
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS

MATERIAL: UHMW

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
MAGNET UHMW SHEET

THIRD-ANGLE PROJECTION

Drawing prepared by ORNL

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Cooperative Research and Development
Agreements. This drawing is property of
ORNL and must be returned upon
request.

NOTE:

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

THRU ALL

4X .33 THRU ALL

4X .64X 100°

0

10.000

20.000

38.000

14.000

18.000

48.00

.25
NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

4 4 ROUND, 5.00" O.D x 2.00" AL - 6061 T651, ASMT-B-211 2.00"
3 4 PLATE, 6.50" x 2.50" x 1.00" AL - 6061 T651, ASMT-B-221 6.50"
2 1 PLATE - 38.00" x 56.00" x 1.00" AL - 6061 T651, ASMT-B-209 36.00"
1 4 BAR, .75" x 1.50" x 2.50" AL - 6061 T651, ASMT-B-221 2.50"

MATERIAL

UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES .010 A FORMED ANGLES .1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005

REFERENCES
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OAK RIDGE NATIONAL LABORATORY
NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
MAGNET SUPPORT PLATE WELDMENT

DRAWING APPROVALS
DATE
C
203-HJT-0113
1
1.0
NOTES
1. MATERIAL CERTIFICATIONS REQUIRED

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<th>MATERIAL</th>
<th>DESCRIPTION</th>
<th>DWG</th>
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<tr>
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<td>HX-SHCS 5.0-75-16x4x4-N</td>
<td>SS - 18-8</td>
<td>SHCS - 3/4-16 x 4.00 N/A</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>HX-SHCS 3.0-75-16x1.5x1.5-N</td>
<td>SS - 18-8</td>
<td>SHCS - 3/4-16 x 1.50 N/A</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>cart jacking plate hjt</td>
<td>AL - 6061 T6</td>
<td>ASTM B-308 AM STD ANGLE</td>
<td>203-HJT-0120</td>
</tr>
</tbody>
</table>

UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES .125" FORMED ANGLES .1" FORMED ANGLES
6. ALL BOLTS AND SCREWS ARE 5/16-18 UNLESS OTHERWISE NOTED
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .000

THIS DRAWING PRODUCED ON SOLIDWORKS

OAK RIDGE NATIONAL LABORATORY
NUFACT HG JET TARGET EXPERIMENT
COMMON BASEPLATE ASSY
CART ANCHOR ASSY

OA...

CART ANCHOR ASSY
203-HJT-0120
05/19/2005
05/19/2005
05/19/2005

DRAWING NO.
REV
DATE
SIZE
SCALE
SHEET
Dwg No.

OAK RIDGE NATIONAL LABORATORY
NUCLEAR SCIENCE & TECHNOLOGY DIVISION
REMOTE SYSTEMS GROUP
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN
contract DE-AC05-00OR22725

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This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.
2 1 AM STD ANGLE - 4.00 x 4.00 x .50 AL - 6061 T6, ASTM B-308 4.00
1 2 PLATE, 2 x 2 x .50 AL - 6061 T6511, ASTM B-221 --

| ITEM NO. | QTY. | DESCRIPTION               | MATERIAL         | LENGTH |
|----------|------|----------------------------|------------------|
| 2        | 1    | AM STD ANGLE - 4.00 x 4.00 x .50 | AL - 6061 T6, ASTM B-308 | 4.00   |
| 1        | 2    | PLATE, 2 x 2 x .50          | AL - 6061 T6511, ASTM B-221 | --     |

NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.1
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>QTY</th>
<th>DESCRIPTION</th>
<th>MATERIAL</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>2</td>
<td>PLATE, 4.00 x 10.75 x .50</td>
<td>CRS - 1018, ASTM A-108</td>
<td>10.75</td>
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<tr>
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<td>4</td>
<td>PLATE, 4.00 x 6.00 x .50</td>
<td>CRS - 1018, ASTM A-108</td>
<td>6.00</td>
</tr>
<tr>
<td>1</td>
<td>4</td>
<td>PLATE, 6.00 x 11.25 x .50</td>
<td>CRS - 1018, ASTM A-108</td>
<td>11.25</td>
</tr>
</tbody>
</table>

NOTES

1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005

OAK RIDGE NATIONAL LABORATORY
NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
HYD JACK WELDMENT

OAK RIDGE NATIONAL LABORATORY
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

THIS DRAWING PRODUCED ON SOLIDWORKS

OAK RIDGE NATIONAL LABORATORY
 Operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

THIRD-ANGLE PROJECTION

TRANSFER INFORMATION

- All dimensions are in inches.
- Interpret dimensions and tolerances per ASME Y14.5M.
- Machined finish 125 micro-inches RMS.
- Concentricity .010 TIR.
- Machined angles 1/2 formed angles 1.
- Break sharp corners and remove all burrs.
- Whole numbers and fractions 1/16.
- X decimals .030.
- XX decimals .010.
- XXX decimals .005.

OAK RIDGE NATIONAL LABORATORY
Operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

THIS DRAWING PRODUCED ON SOLIDWORKS
MATERIAL: CRS - 1018

THIRD-ANGLE PROJECTION

UNLESS OTHERWISE NOTED
1. ALL DIMENSIONS ARE IN INCHS
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK Sharp CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS

NOTES
1. MATERIAL CERTIFICATIONS REQUIRED
NOTES
1. MATERIAL CERTIFICATIONS REQUIRED

ITEM with Hilmans/QTY. NAME MATERIAL DESCRIPTION DWG
7 4 hitman hjt --- HUMAN ROLLER #KRG-15-SLP N/A
6 12 HX/SF-SS 0.5-13x.505x.625-N SS - 1/16-8 N/A
5 4 swivel hold ring hjt ALLOY STEEL - MACHINED N/A
4 4 leveling foot hjt SS - 303 S & W MFG. CO., N/A
3 2 cart anchor assy hjt CART ANCHOR ASSY 203-HJT-0120
2 2 Roll out hjt SS - 304L 2" X 62" X 5/8" BAR 203-HJT-0202
1 1 base weldment hjt AL - 6001 T6 BASE WELDMENT 203-HJT-0201
**NOTES**

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

---

**DETAIL A**

SCALE 1:4

---

**SCALE**

1:12

---

**BASE WELDMENT HJT 203-HJT-0200**

---

**DRAWING APPROVALS**

DATE

- 203-HJT-0201
NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

NOTES

1/4 4X W-5

DETAIL D SCALE 2 : 15

1/4 4X W-5

DETAIL C SCALE 2 : 15

MITER CORNER 45° 4 PLC'S BOTH SIDES

DETAIL E SCALE 2 : 15

4X DRILL THRU TAP 1-8 UNC

4X W-8

4X DRILL THRU TAP 1-8 UNC

4X W-8

SCALE 2 : 15

DETAIL D

DETAIL E

DETAIL C
3. MATERIAL CERTIFICATIONS REQUIRED

2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED IN ACCORDANCE WITH AWS D.1.2

1. WELDING & INSPECTIONS SHALL BE PERFORMED UNLESS OTHERWISE NOTED.

NOTES

ON SOLIDWORKS

DATE

QA

ENG CHK DRW DES

DRAWING APPROVALS

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OAK RIDGE NATIONAL LABORATORY

NUFACT HGT JET EXPERIMENT

TARGET CART ASSY

CART LOWER PLATE WELDMENT

OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

REMOTE SYSTEMS GROUP

NUCLEAR SCIENCE & TECHNOLOGY DIVISION

TARGET CART ASSY

CART LOWER PLATE WELDMENT

OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

DRAWING APPROVALS

DATE

C 203-HJT-0301

REV 0

1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
3. MACHINED FINISH 125 MICRO-INCHES RMS
4. CONCENTRICITY .010 TIR
5. MACHINED ANGLES 1/2 FORMED ANGLES 1
6. BREAK SHARP CORNERS AND REMOVE ALL BURRS
7. WHOLE NUMBERS AND FRACTIONS 1/16
8. X DECIMALS .030
9. XX DECIMALS .010
10. XXX DECIMALS .005

ITEM NO.  QTY.  DESCRIPTION  MATERIAL  LENGTH

6  4  STUD, 3/4-10 UNC  SS - 8-18 ALL-THREAD  2.75"
5  1  PLATE, 32.00" x 46.00" x 1.25" AL - 6061-T651, ASTM B-209  46.00"
4  2  PLATE, 1.5" x 1.5" x .50" AL - 6061 T6511, ASTM B-221 ---
3  2  PLATE, 2.75" x 3.00" x .50" AL - 6061 T6511, ASTM B-221 ---
2  4  PLATE, 1.88" x 3.00" x .75" AL - 6061 T6511, ASTM B-221 ---
1  4  PLATE, 2.75" x 6.00" x .75" AL - 6061 T6511, ASTM B-221 ---

SCALE 1:8

FUNCTIONS

DES  V GRAVES  06/03/2005

DRW  T COLUM

ENG  V GRAVES  06/03/2005
NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D1.2

2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED

3. MATERIAL CERTIFICATIONS REQUIRED
NOTES

1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

3 4 PLATE, 1.00 x 1.00 x 2.50 AL - 6061 T651, ASTM B-221 2.50
2 4 PLATE, 2.50 x 6.50 x .25 AL - 6061 T651, ASTM B-221 6.50
1 1 PLATE, 32.00 x 46.00 x .25 AL - 6061 T651, ASTM B-209 46.00

ITEM NO. QTY. DESCRIPTION MATERIAL LENGTH

W1

4X DRILL THRU & TAP 3/4-16 NO WELD SPLATTER IN HOLE

3/8 1/8 G

G

4X DRILL THRU & TAP 3/4-16 NO WELD SPLATTER IN HOLE

3/8

1.00 TYP.

0.010 A

0.010 A

THIRD-ANGLE PROJECTION

W-3

W-2

W-1

DETAIL A

SCALE 1:3

DETAIL B

SCALE 1:3

1.00 TYP.

1.00 TYP.

30.00

37.00
MATERIAL: AL - 6061 T6, ASTM B-308

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED