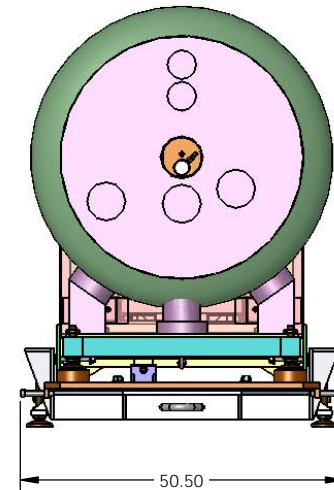
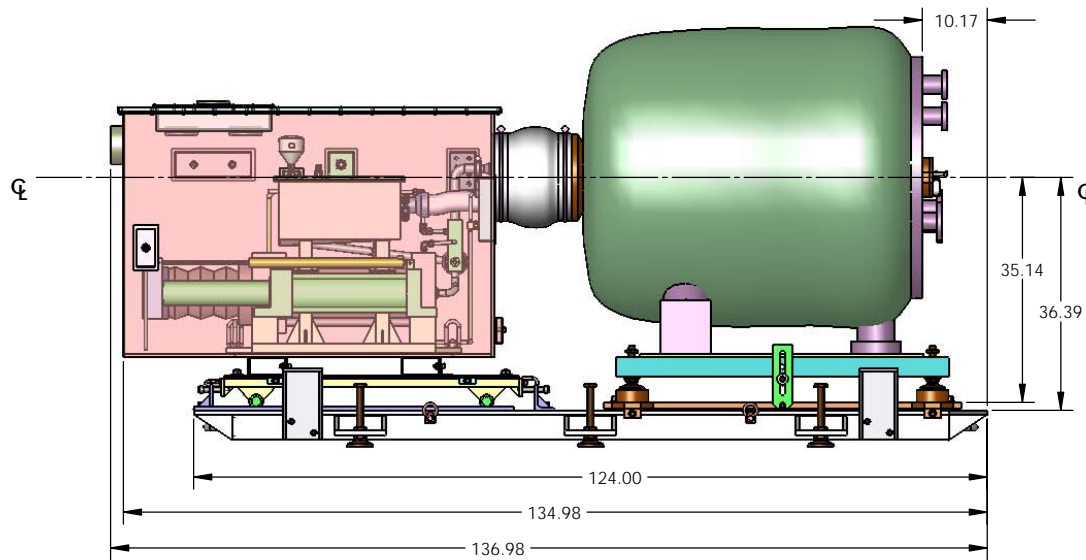
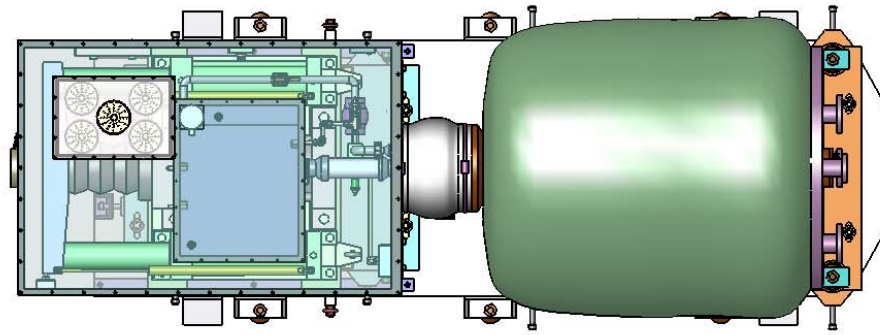


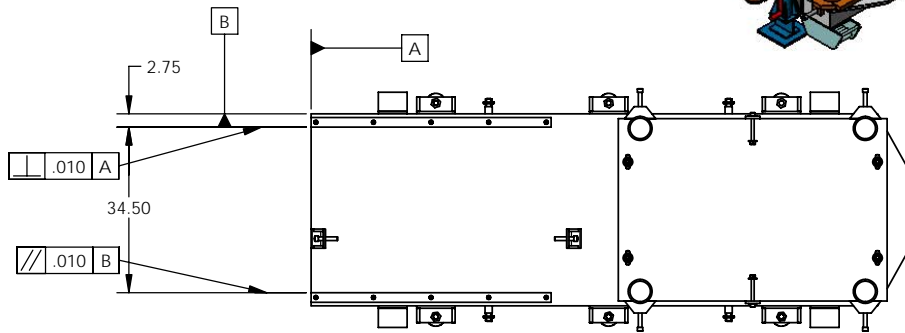
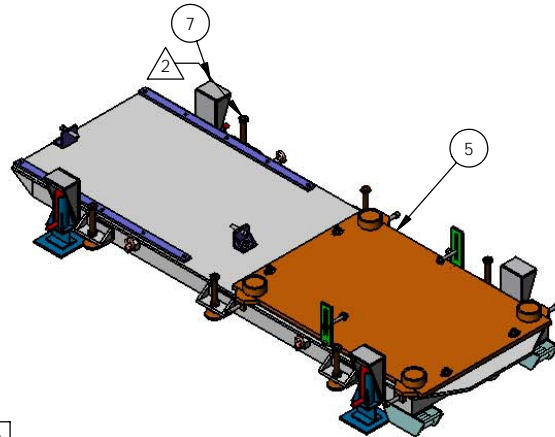
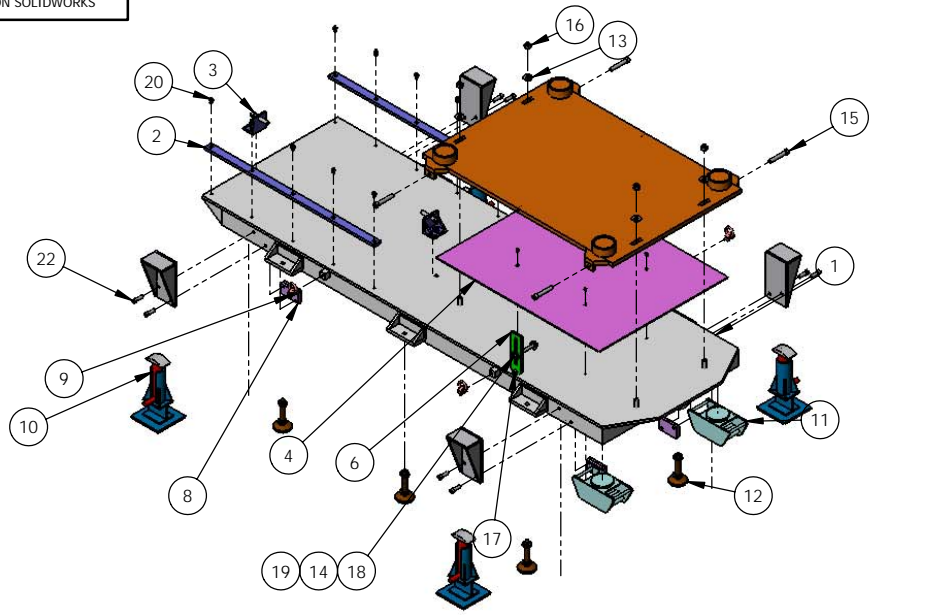
ITEM	for dwg with carrier/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
6	1	target transporter assy hjt	---	TRANSPORTER BASEPLATE ASSY	203-HJT-0200
5	1	magnet assy hjt	---	PROVIDED BY M.I.T.	---
4	1	hg delivery system hjt	---	HG DELIVERY SYSTEM	203-HJT-0500
3	1	magnet end support hjt	---	USED TO RAISE MAGNET END	203-HJT-0400
2	1	cart assy hjt	---	TARGET CART ASSY	203-HJT-0300
1	1	common base assy hjt	---	---	203-HJT-0100

<p>THIRD-ANGLE PROJECTION</p>	<p>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.</p>		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES FORMED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</p>		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>			
DES	V GRAVES	06/04/2005	<p>NUFACT HG JET EXPERIMENT</p>			
DRW	T OQUIN	06/04/2005				
CHK						
ENG	V GRAVES	06/04/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			COMMON BASE LOADED HJT	---	1:16	1 of 2
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0001	9b	

1. MATERIAL CERTIFICATIONS REQUIRED



<p>THIRD-ANGLE PROJECTION</p>	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.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
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DES	V GRAVES	06/04/2005	<p>NUFACT HG JET EXPERIMENT</p>			
DRW	T OQUIN	06/04/2005				
CHK						
ENG	V GRAVES	06/04/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			COMMON BASE LOADED HJT	---	1:15	2 of 2
			SIZE	DWG NO.		REV
			C	203-HJT-0001		9b
DRAWING APPROVALS		DATE				



TOP VIEW

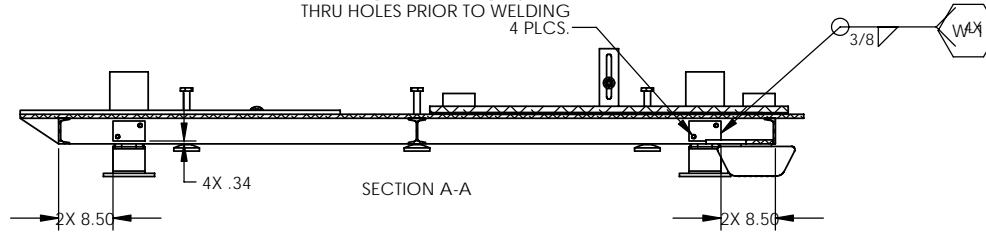
NOTES

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	CSBOLT 0.3125-18x0.625x0.625-S-N	SS - 18-8	FHMS - 5/16-18 UNC x 5/8	N/A
20	10	HX-SHCS 0.5-13x0.625x0.625-N	SS - 18-8	SHCS - 1/2-13 x .63	N/A
19	2	HHNUT 0.6250-11-D-N	SS - 18-8	HEX NUT - 5/8-11 UNC	N/A
18	2	HX-SHCS 0.625-11x6x2.25-N	SS - 18-8	SHCS - 5/8-11 x 6.00	N/A
17	2	HX-SHCS 0.625-11x1x1-N	SS - 18-8	SHCS - 5/8-11 x 1.00	N/A
16	4	HHNUT 0.7500-10-D-N	SS - 18-8	HEX NUT - 3/4-10 UNC	N/A
15	4	HX-SHCS 0.75-16x4.5x4.5-N	SS - 18-8	SHCS - 3/4-16 x 4.50	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 hoist ring	ALLOY STEEL	MCMMASTER CARR 29525183	N/A
8	4	hyd jack backplate hjt	CRS - 1018	PLATE, 3.125 X 5.000 X 1.000	203-HJT-0134
7	4	hyd jack weldment hjt	CRS - 1018	HYD JACK WELDMENT	203-HJT-0131
6	2	magnet restraint plate hjt	AL - 6061 T6511, ASTM B-221	PLATE - 3" X 8" X .50"	203-HJT-0114
5	1	magnet support plate hjt	AL - 6061 T651, ASTM B-209	MAGNET SUPPORT PLATE	203-HJT-0113
4	1	uhmw sheet hjt	UHMW	MCMMASTER CARR #8619K116	203-HJT-0112
3	2	cart anchor assy hjt	---	CART ANCHOR ASSY	203-HJT-0120
2	2	flat rail hjt	SS - 304L	BAR - 2" X 50" X 5/8	203-HJT-0111
1	1	base weldment hjt	AL - 6061 T6	BASE WELDMENT	203-HJT-0110

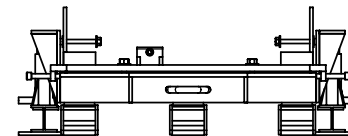
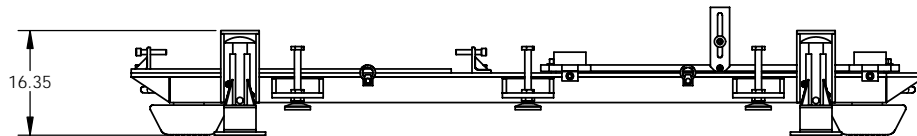
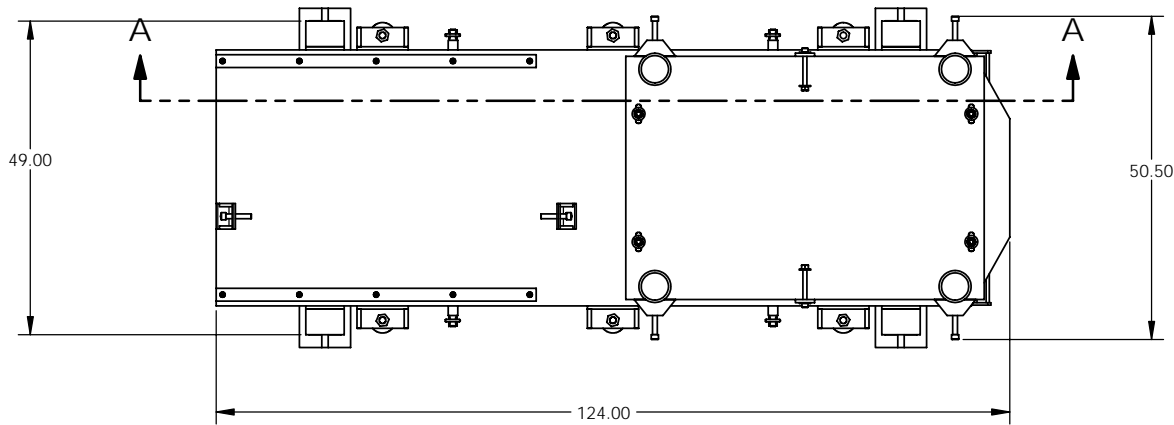
<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
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DES	V GRAVES	06/02/2005	<p align="center">NUFACT HG JET EXPERIMENT COMMON BASE ASSY</p>			
DRW	T OQUIN	06/02/2005				
CHK						
ENG	V GRAVES	06/02/2005				
QA			CAD FILE COMMON BASE ASSY HJT	PREV ASSY 203-HJT-0001	SCALE 1:20	SHEET 1 of 2
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0100	REV 8	

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



NOTES

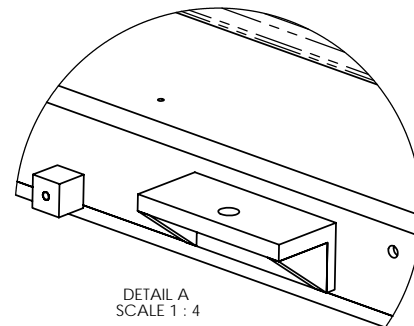
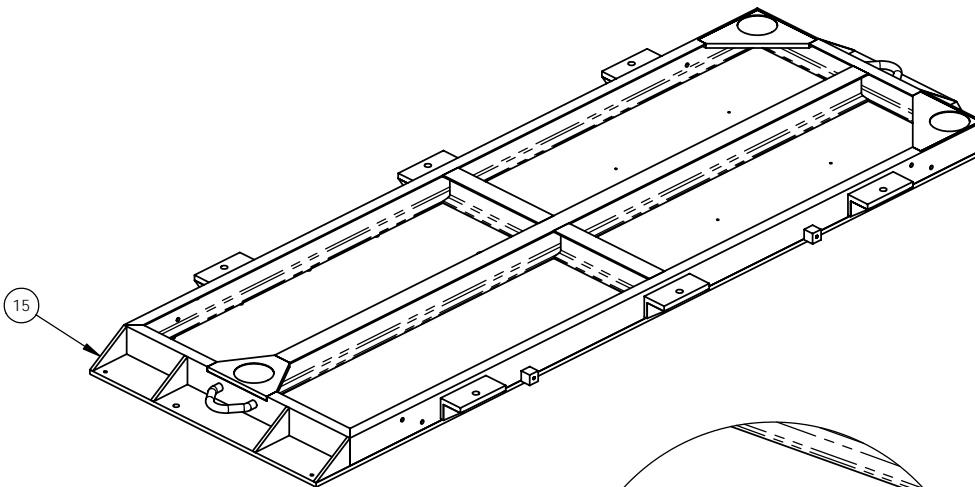
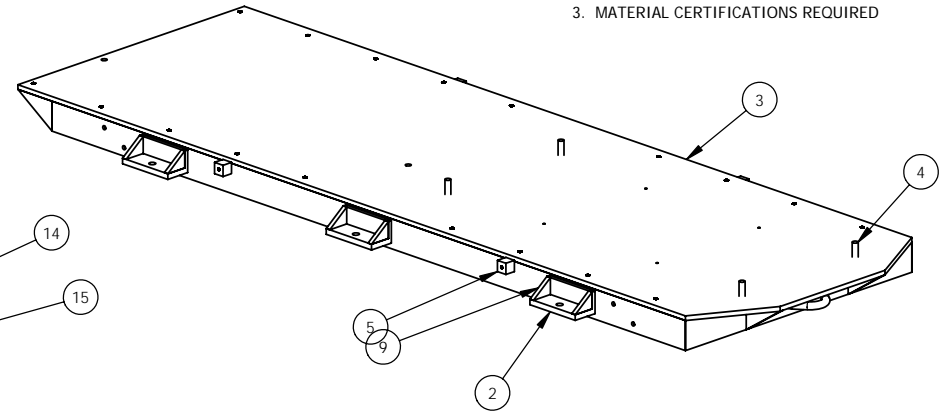
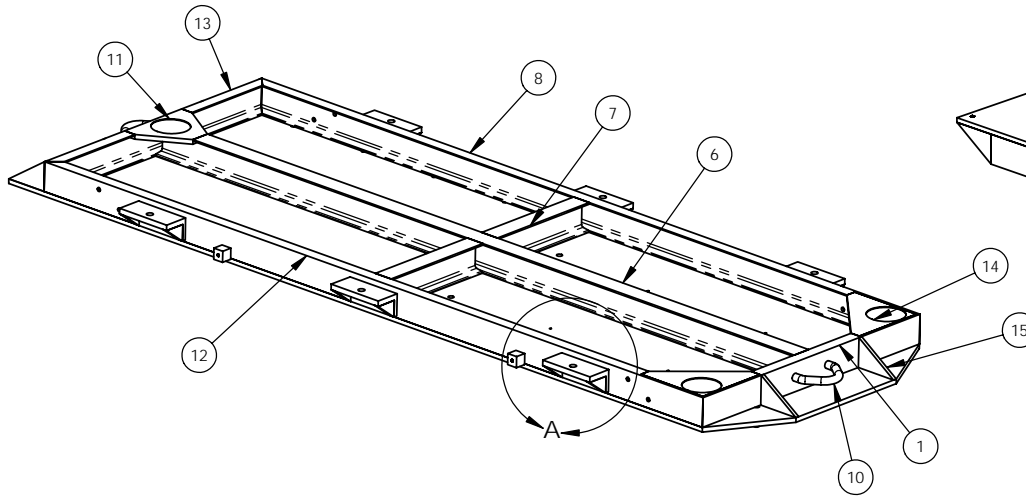
1. MATERIAL CERTIFICATIONS REQUIRED
2. TACK WELD NUTS ON ENDS OF JACK SCREWS AFTER ASSY



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DES	V GRAVES	06/02/2005	<p align="center">NUFACT HG JET EXPERIMENT COMMON BASE ASSY</p>			
DRW	T OQUIN	06/02/2005				
CHK						
ENG	V GRAVES	06/02/2005				
QA			CAD FILE COMMON BASE ASSY HJT	PREV ASSY 203-HJT-0001	SCALE 1:15	SHEET 2 of 2
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0100	REV 8	

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

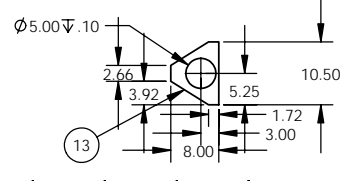
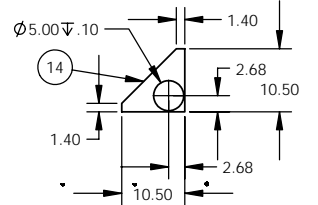
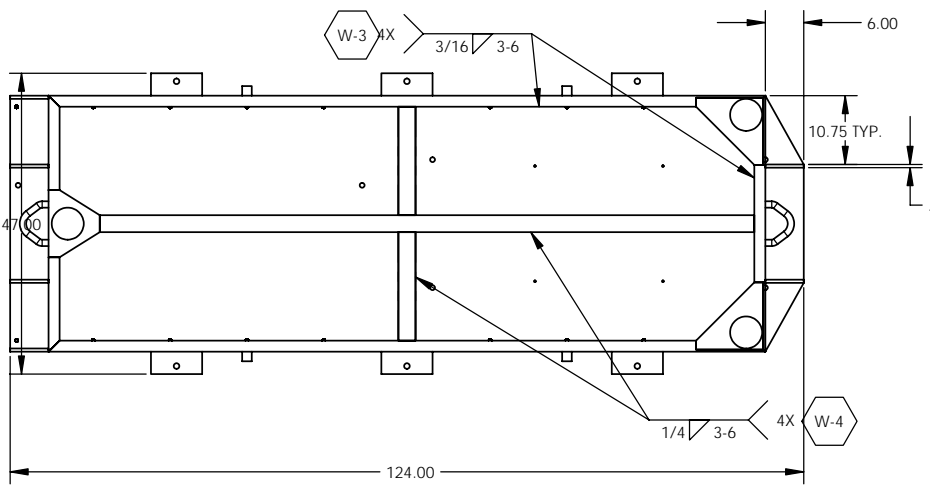
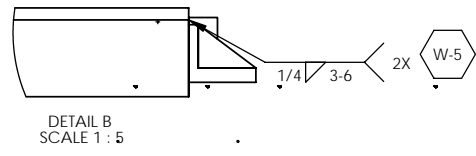
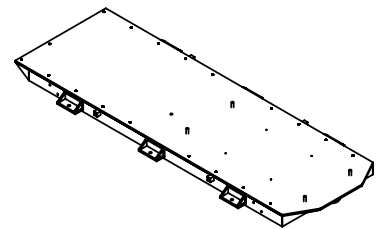
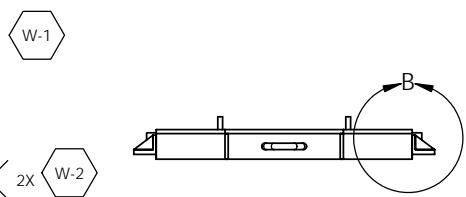
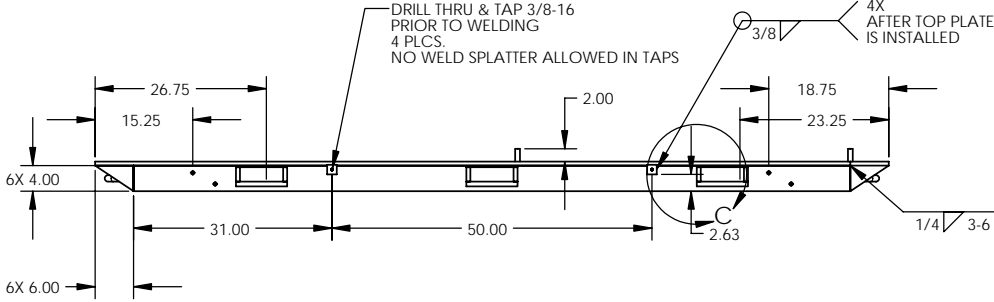
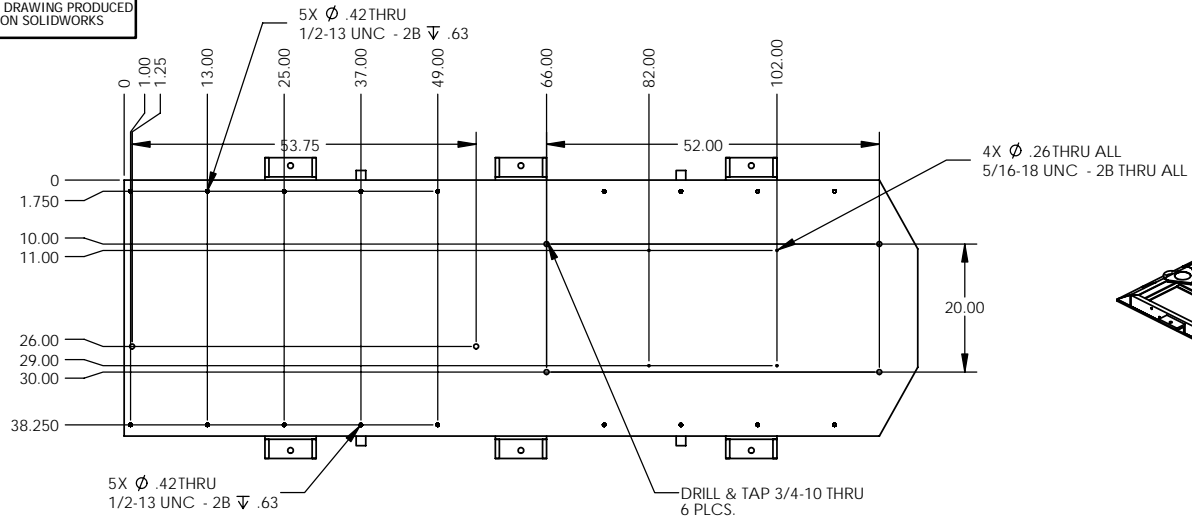


DETAIL A
SCALE 1 : 4

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
15	6	PLATE, 4.00 x 6.00 x .50	AL - 6061 T6511, ASTM B-221	---
14	2	PLATE, 10.50 x 10.50 x .63	AL - 6061 T6511, ASTM B-221	10.50
13	1	C CHANNEL, 4.00 X 1.72 X .32		40
12	1	C CHANNEL, 4.00 X 1.72 X .32		112
11	1	PLATE, 8.00 x 10.50 x .63	AL - 6061 T6511, ASTM B-221	10.50
10	2	ROUND, 1.00 OD x 11.00	AL - 6061 T6, ASTM B-211	11.00
9	12	PLATE - 2.50 X 3.00 X .63	AL - 6061 T6511, ASTM B-221	---
8	1	AMER STD "C", 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	112
7	2	AMER STD "I", 4.00 x 2.66 x .19	AL - 6061 T6, ASTM B-308	16.95
6	1	AMER STD "I", 4.00 X 2.66 X .19	AL - 6061 T6, ASTM B-308	108.56
5	4	BAR, 1.50 x 1.50 x 1.50	AL - 6061 T6511, ASTM B-221	1.50
4	4	STUD, 3/4-10 UNC	SS ALL-THREAD	2.625
3	1	PLATE, 40.00 x 124.00 x .63	AL - 6061 T6511, ASTM B-209	124.00
2	6	ANGLE - 3.00 X 3.50 X .50	AL - 6061 T6511, ASTM B-221	8.00
1	1	AMER STD "C", 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	40

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<p>DRAWING APPROVALS</p>		<p>DATE</p>		<p>CAD FILE BASE WELDMENT HJT</p> <p>PREV ASSY 203-HJT-0100</p> <p>SCALE 1:12</p> <p>SHEET 1 of 3</p>	
<p>SIZE C</p>		<p>DWG NO. 203-HJT-0110</p>		<p>REV 8</p>	

S THIS DRAWING PRODUCED ON SOLIDWORKS

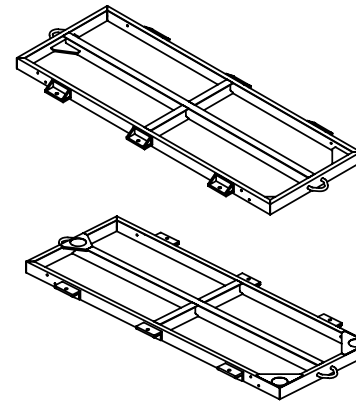
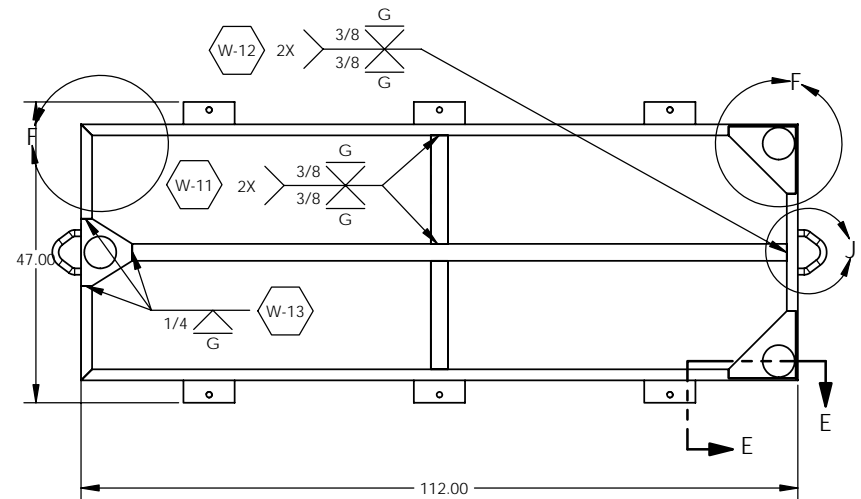
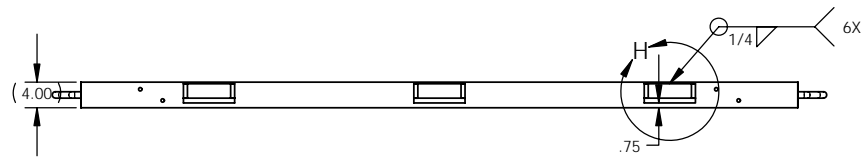
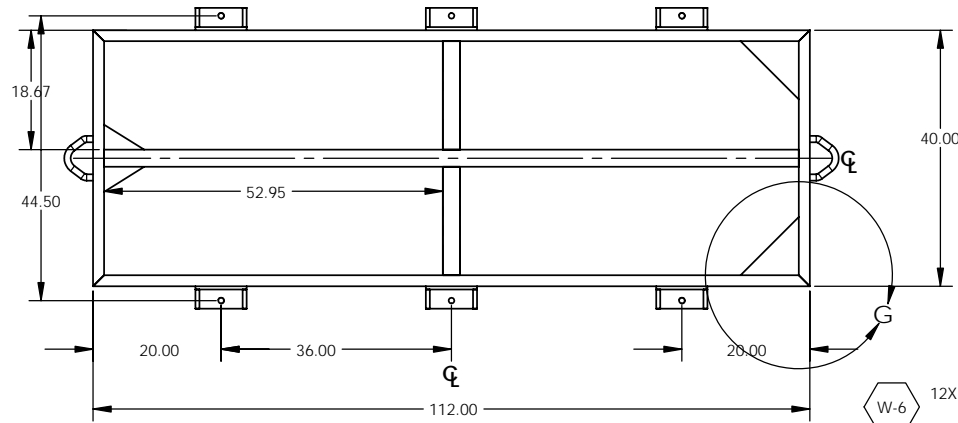


NOTES

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2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

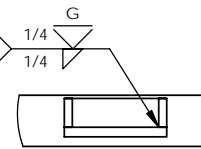
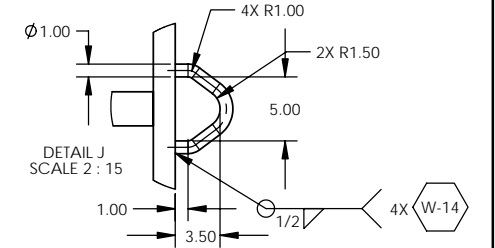
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<p>DES V GRAVES 06/02/2005</p> <p>DRW T OQUIN 06/02/2005</p> <p>CHK</p> <p>ENG V GRAVES 06/02/2005</p> <p>QA</p>		<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY BASE WELDMENT</p>		<p>CAD FILE BASE WELDMENT HJT</p> <p>PREV ASSY 203-HJT-0100</p> <p>SCALE 1:15</p> <p>SHEET 2 of 3</p>	
<p>DRAWING APPROVALS</p> <p>DATE</p>		<p>SIZE DWG NO. C 203-HJT-0110</p>		<p>REV 8</p>	

DWG NO. 203-HJT-0110



NOTES

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2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED

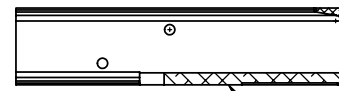
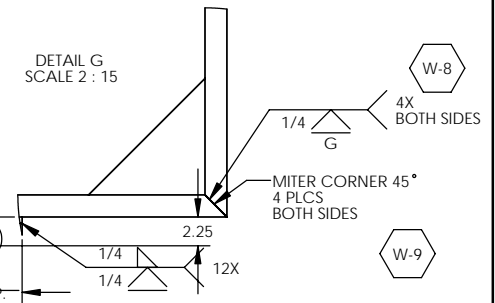


DETAIL H SCALE 2 : 15

5X 6X DRILL THRU TAP 1-8 UNC

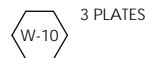


DETAIL G SCALE 2 : 15



SECTION E-E SCALE 1 : 5

SUPPORT PLATE FLUSH WITH CHANNELS 3 PLCS.



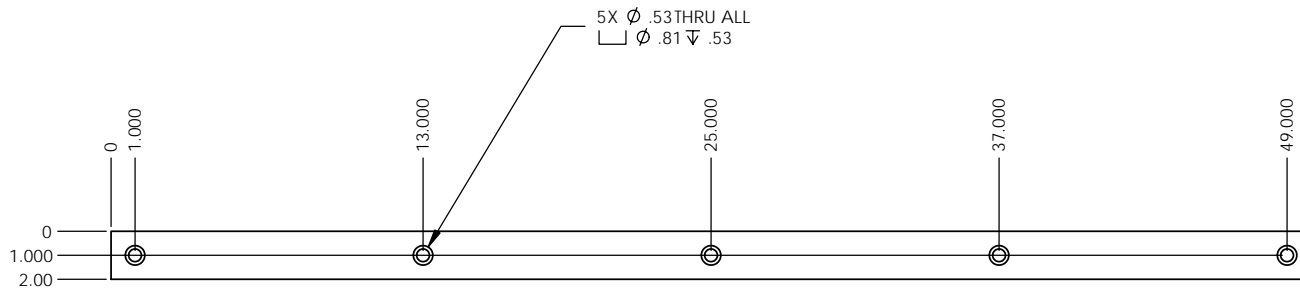
DETAIL F SCALE 2 : 15

CUT CHANNELS TO ACCEPT FLUSH MOUNTED GUSSETS 3 PLCS.

THIRD-ANGLE PROJECTION 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° 6. FORMED ANGLES ±1° 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS ±1/16 9. X DECIMALS ±.030 10. XX DECIMALS ±.010 11. XXX DECIMALS ±.005	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.			OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN		
	DES V GRAVES 06/02/2005 DRW T OQUIN 06/02/2005 CHK ENG V GRAVES 06/02/2005 QA	REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION			NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY BASE WELDMENT	
DRAWING APPROVALS		DATE	CAD FILE BASE WELDMENT HJT	PREV ASSY 203-HJT-0100	SCALE 1:10	SHEET 3 of 3
			SIZE C	DWG NO. 203-HJT-0110	REV 8	

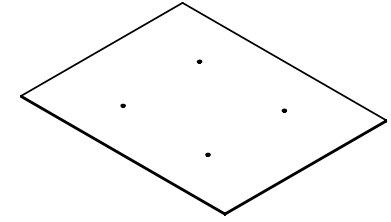
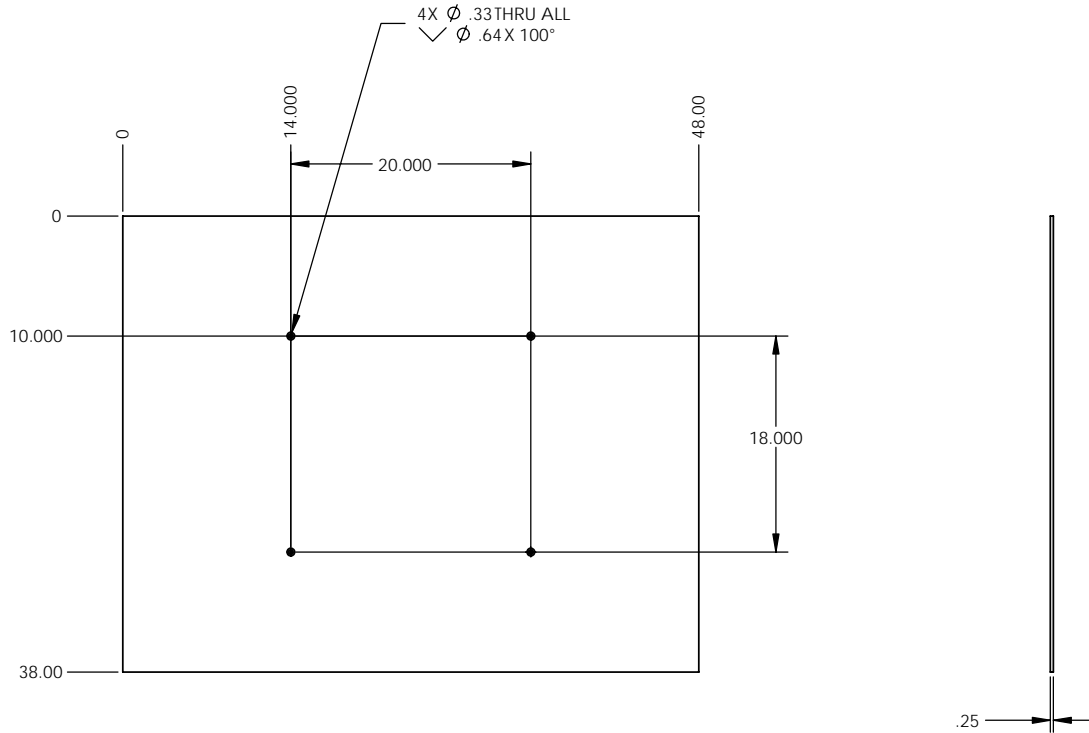
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



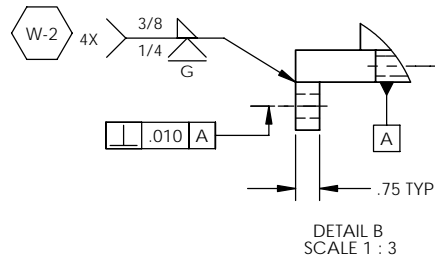
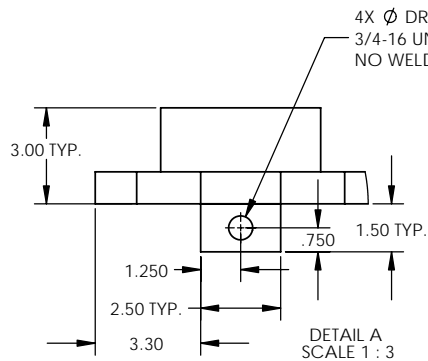
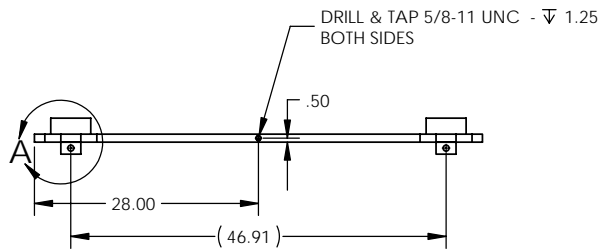
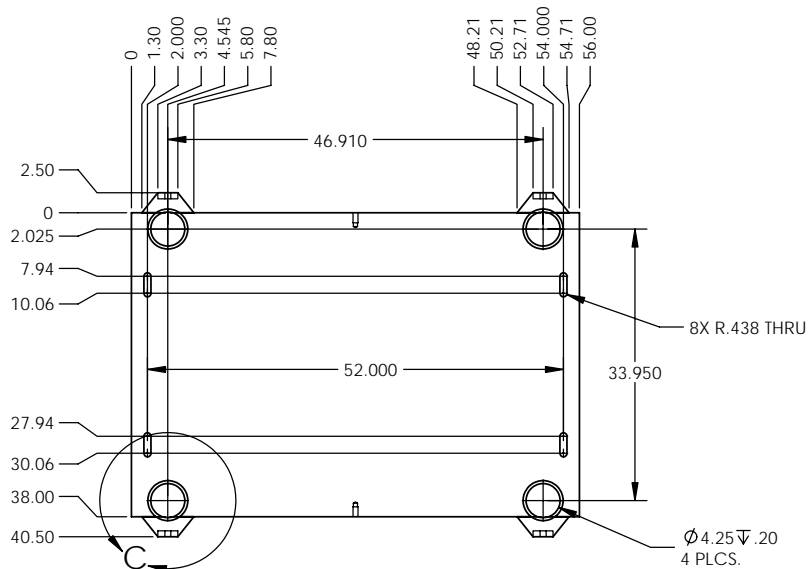
MATERIAL: SS - 304L

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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 $\pm 1/2^\circ$ 6. FORMED ANGLES $\pm 1^\circ$ 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS $\pm 1/16$ 9. X DECIMALS $\pm .030$ 10. XXX DECIMALS $\pm .010$ 11. XXXX DECIMALS $\pm .005$			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005 QA			<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY FLAT RAIL - COMMON BASEPLATE</p>		
DRAWING APPROVALS DATE			CAD FILE FLAT RAIL HJT	PREV ASSY 203-HJT-0100	SCALE 1:4
SIZE DWG NO. C			203-HJT-0111		SHEET 1 of 1 REV 3



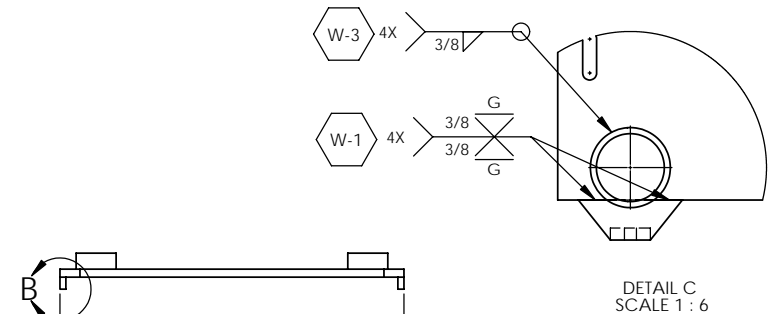
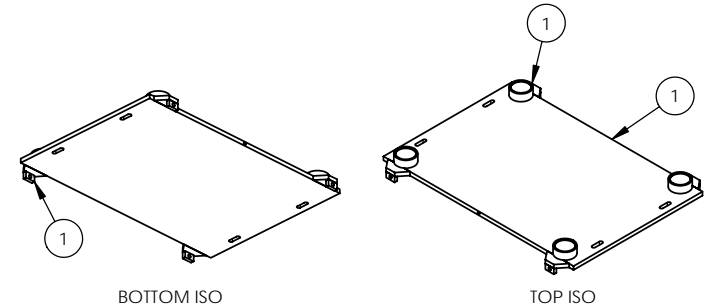
MATERIAL: UHMW

<p>THIRD-ANGLE PROJECTION</p>	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.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	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° 6. BREAK SHARP CORNERS AND REMOVE ALL BURRS 7. WHOLE NUMBERS AND FRACTIONS ±1/16 8. X DECIMALS ±.030 9. XXX DECIMALS ±.010 10. XXXX DECIMALS ±.005		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005	<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY MAGNET UHMW SHEET</p>		CAD FILE UHMW SHEET HJT SIZE C	PREV ASSY 203-HJT-0100 DWG NO. 203-HJT-0112	SCALE 1:8 SHEET 1 of 1 REV #
DRAWING APPROVALS		DATE			



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

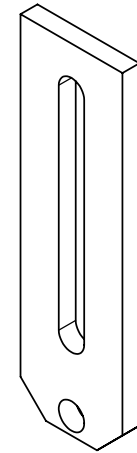
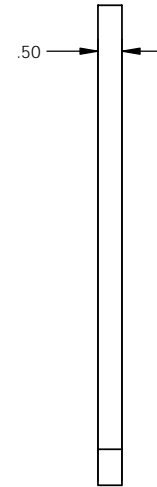
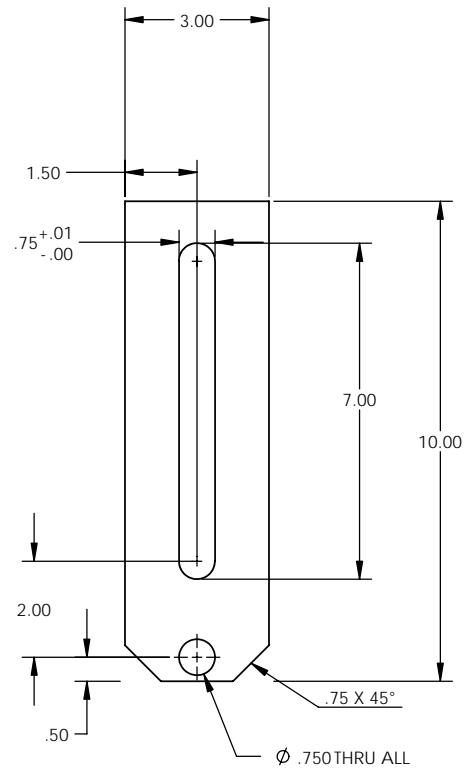


ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
4	4	ROUND, 5.00" OD x 2.00"	AL - 6061 T651, ASTM B-211	2.00"
3	4	PLATE, 6.50" x 2.50" x 1.00"	AL - 6061 T6511, ASTM B-221	6.50"
2	1	PLATE - 38.00" x 56.00" x 1.00"	AL - 6061 T651, ASTM B-209	56.00"
1	4	BAR, .75" x 1.50" x 2.50"	AL - 6061 T6511, ASTM B-221	2.50"

<p>THIRD-ANGLE PROJECTION</p>		<p>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.</p>		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. FORMED ANGLES ±1°</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>9. X DECIMALS ±.030</p> <p>10. XX DECIMALS ±.010</p> <p>11. XXX DECIMALS ±.005</p>		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY MAGNET SUPPORT PLATE WELDMENT</p>	
DES	V GRAVES	06/03/2005	CAD FILE	PREV ASSY	SCALE
DRW	T OQUIN	06/03/2005	MAGNET SUPPORT PLATE HJT	203-HJT-0100	1:12
CHK			SIZE	DWG NO.	SHEET
ENG	V GRAVES	06/03/2005	C	203-HJT-0113	1 of 1
DRAWING APPROVALS	DATE				REV
					1

NOTES

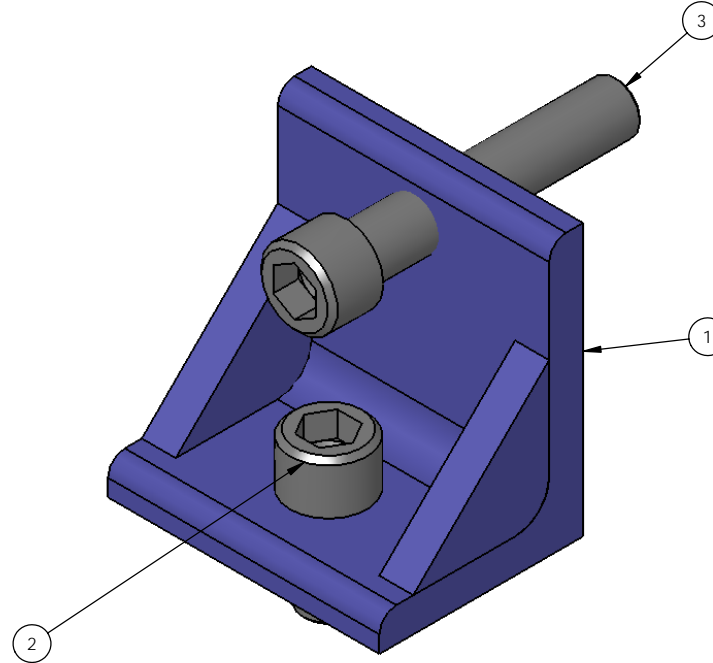
1. MATERIAL CERTIFICATIONS REQUIRED



MATERIAL: AL - 6061 T6511, ASTM B-221

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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° 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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005 QA			<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY MAGNET RESTRAINT PLATE</p>		
DRAWING APPROVALS DATE			CAD FILE MAGNET RESTRAINT PLATE HJT	PREV ASSY 203-HJT-0100	SCALE 1:2
SIZE DWG NO.			C	203-HJT-0114	SHEET 1 of 1 REV 1

NOTES
1. MATERIAL CERTIFICATIONS REQUIRED



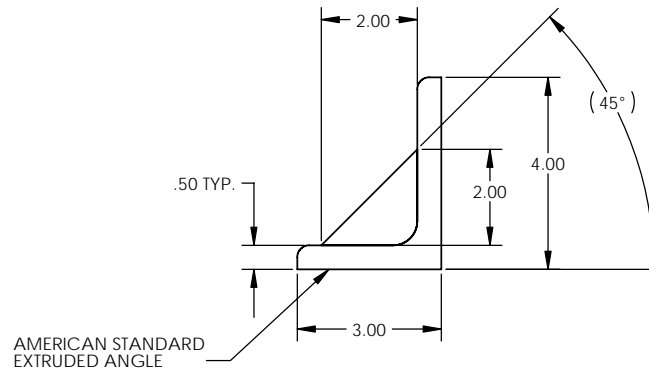
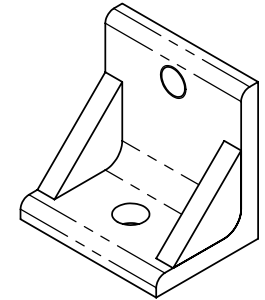
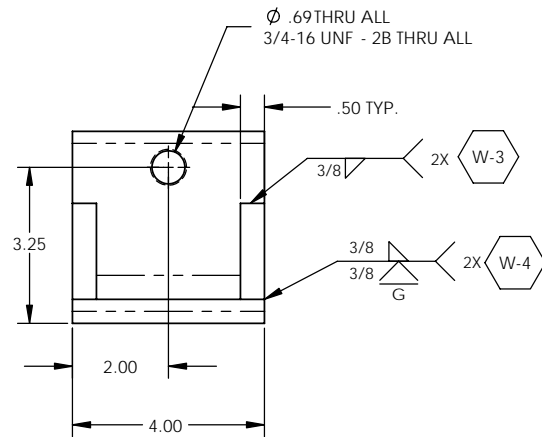
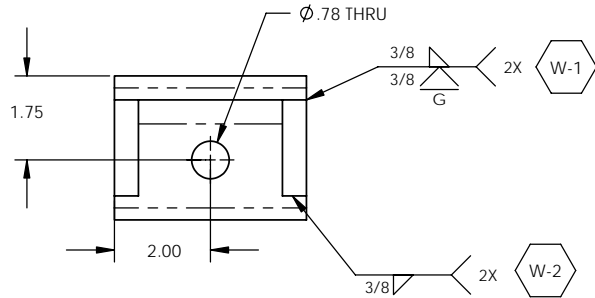
3	1	HX-SHCS 0.75-16x4x4-N	SS - 18-8	SHCS - 3/4-16 x 4.00	N/A
2	1	HX-SHCS 0.75-16x1.5x1 5-N	SS - 18-8	SHCS - 3/4-16 x 1.50	N/A
1	1	cart jacking plate hjt	AL - 6061 T6, ASTM B-308	AM STD ANGLE - 4" X 4"	203 HJT 0121
ITEM	QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	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° 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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		
DES	V GRAVES	05/19/2005	<p align="center">NUFACT HG JET TARGET EXPERIMENT COMMON BASEPLATE ASSY CART ANCHOR ASSY</p>			
DRW	T. OQUIN	05/19/2005				
CHK						
ENG	V GRAVES	05/19/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CART ANCHOR ASSY HJT	203-HJT-0100	1:1	1 of 1
			SIZE	DWG NO.		REV
				203-HJT-0120		5
DRAWING APPROVALS		DATE	C			

DWG NO. 203-HJT-0120

NOTES

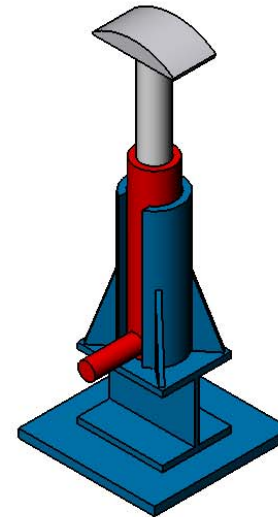
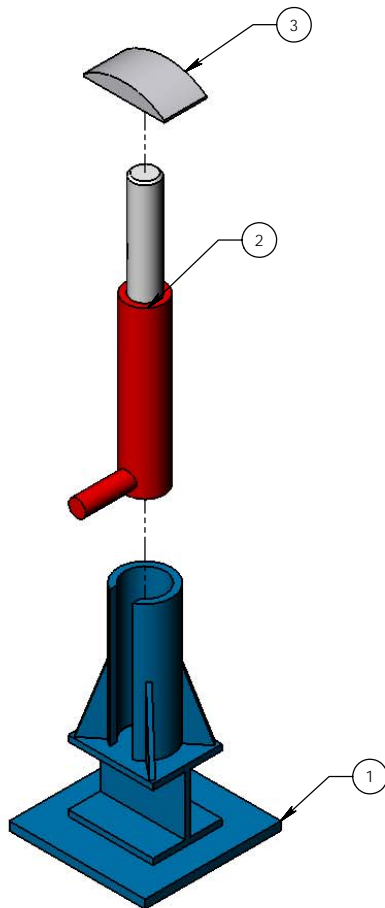
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



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		
		THIRD-ANGLE PROJECTION 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° 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 operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION			
					NUFACT HG JET TARGET EXPERIMENT CART ANCHOR ASSY CART JACKING WELDMENT	
		DES V GRAVES 05/19/2005 DRW T OQUIN 05/19/2005 CHK ENG V GRAVES 05/19/2005 QA	CAD FILE CART JACKING PLATE HJT	PREV ASSY 203 HJT 0120	SCALE 1:2	SHEET 1 of 1
		DRAWING APPROVALS	DATE	SIZE DWG NO. C 203 HJT 0121	REV 2	

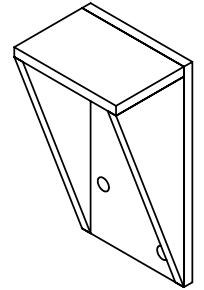
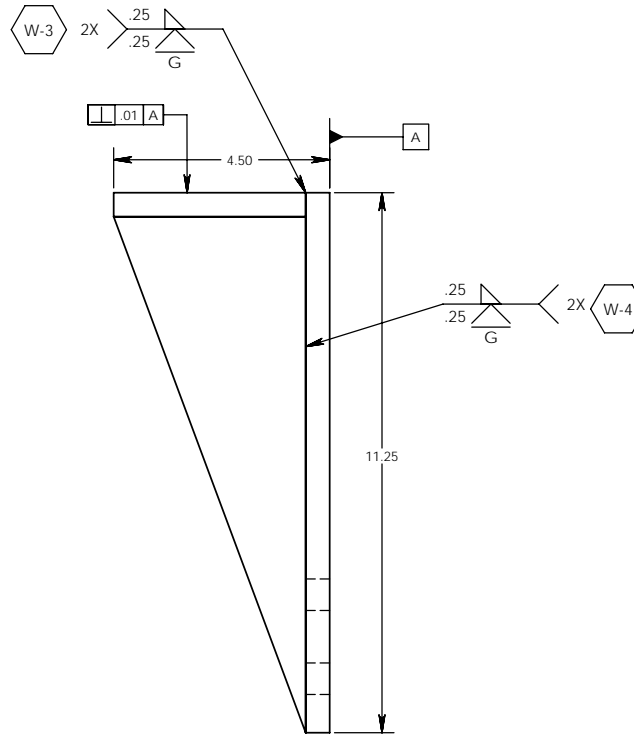
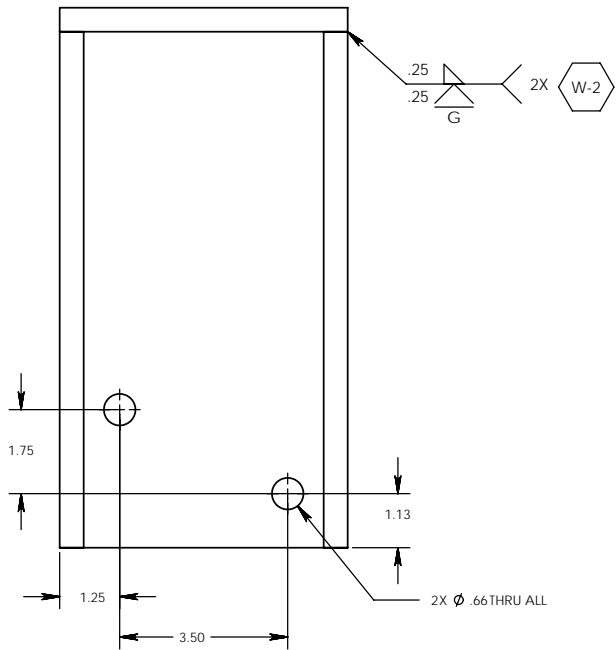
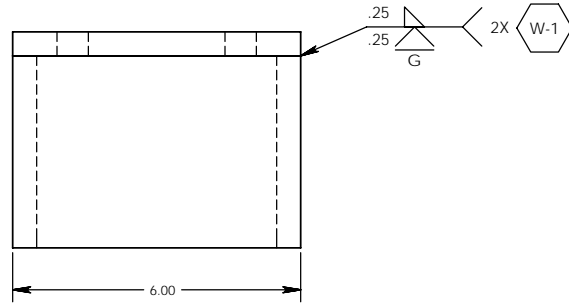
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



3	1	hyd jack rocker hjt	CRS - 1018	ROUND - 4.000" OD X 2.500	203-HJT-0133
2	1	hyd jack #2990T18 hjt		MCMMASTER-CARR #2990T18	N/A
1	1	hyd jack baseplate hjt	---	HYD JACK BASEPLATE WELDMENT	203-HJT-0132
ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	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° 6. FORMED ANGLES ±1° 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS ±1/16 9. X DECIMALS ±.030 10. XX DECIMALS ±.010 11. XXX DECIMALS ±.005			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		
DES	T. OQUIN	07/21/2005	<p align="center">NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY HYDRAULIC JACK ASSY</p>			
DRW	T. OQUIN	07/21/2005				
CHK						
ENG	T. OQUIN	07/21/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			HYDRAULIC JACK ASSY HJT	203-HJT-0100	1:4	1 of 1
			SIZE	DWG NO.		REV
			C	203-HJT-0130		0
DRAWING APPROVALS		DATE				



NOTES

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

3	2	PLATE, 4.00 x 10.75 x .50	CRS - 1018, ASTM A-108	10.75
2	1	PLATE, 4.00 x 6.00 x .50	CRS - 1018, ASTM A-108	4.00
1	1	PLATE, 6.00 x 11.25 x .50	CRS - 1018, ASTM A-108	11.25
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH

THIRD-ANGLE PROJECTION

- 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 FORMED ANGLES ±1/2°
 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

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DES	T. OQUIN	07/20/2005
DRW	T OQUIN	07/20/2005
CHK		
ENG	T. OQUIN	07/20/2005
QA		

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

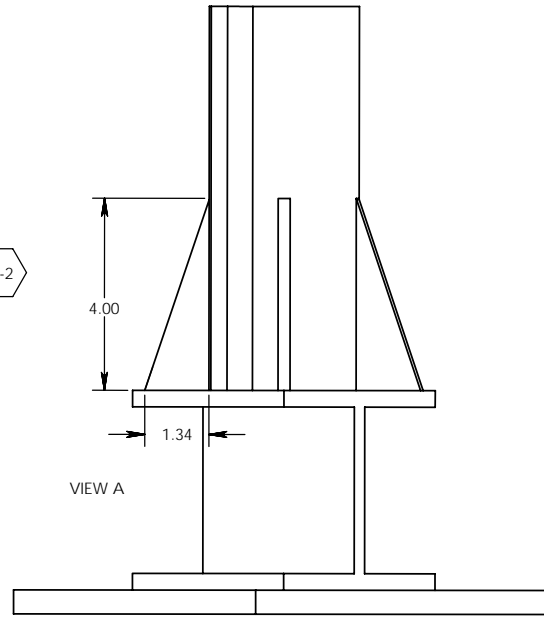
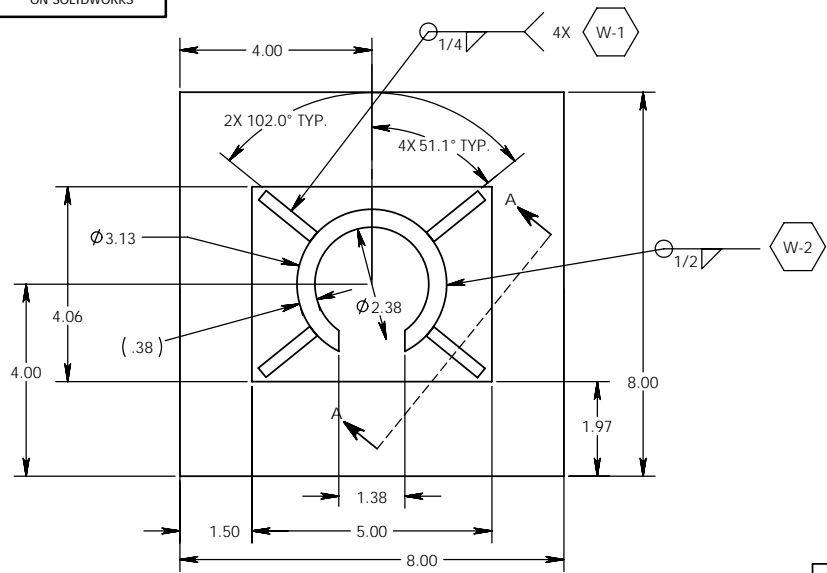
NSTB REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
HYD JACK WELDMENT**

CAD FILE	PREV ASSY	SCALE	SHEET
HYD JACK WELDMENT HJT	203-HJT-0100	1:2	1 of 1
SIZE	DWG NO.		REV
C	203-HJT-0131		2

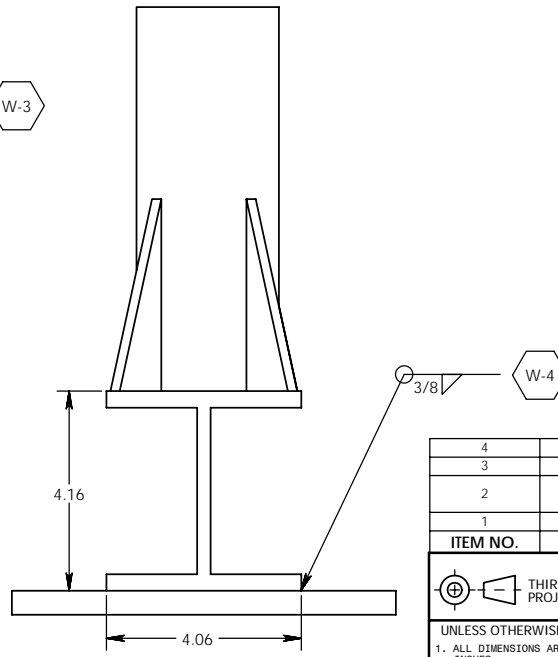
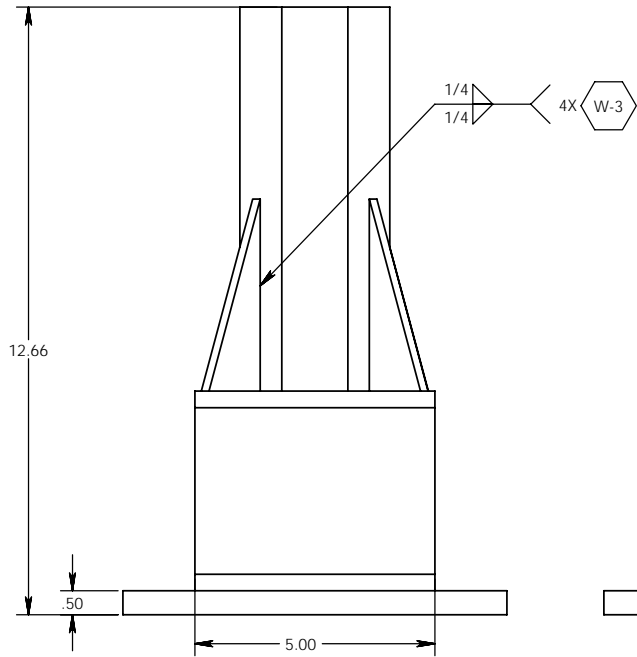
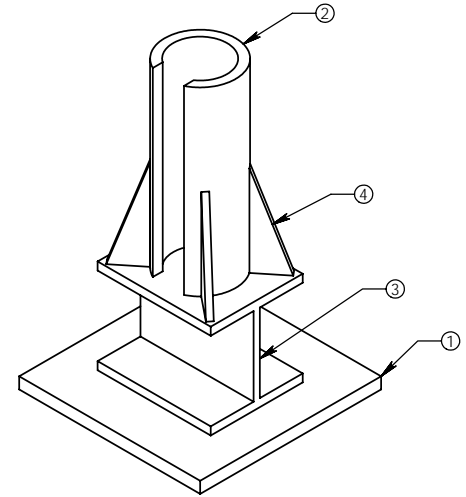
DRAWING APPROVALS DATE

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

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



ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
4	4	PLATE, 1.38 x 4.00 x .25	CRS - 1018, ASTM A-108	4.00
3	1	W-4x13	STEEL "W" BEAM, ASTM A-992	5.00
2	1	TUBE, D.O.M. - 3.13 OD x .38 WALL	STEEL - 1020, D.O.M. WELDED TUBE, ASTM A-513 TYPE 5	8.00
1	1	PLATE, 8.00 x 8.00 x .50	CRS - 1018, ASTM A-108	8.00

THIRD-ANGLE PROJECTION

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°
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

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DES	T. OQUIN	07/21/2005
DRW	T. OQUIN	07/21/2005
CHK		
ENG	T. OQUIN	07/21/2005
QA		

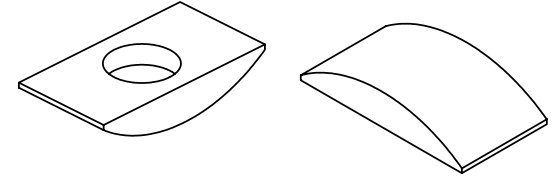
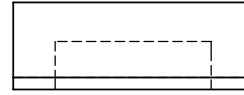
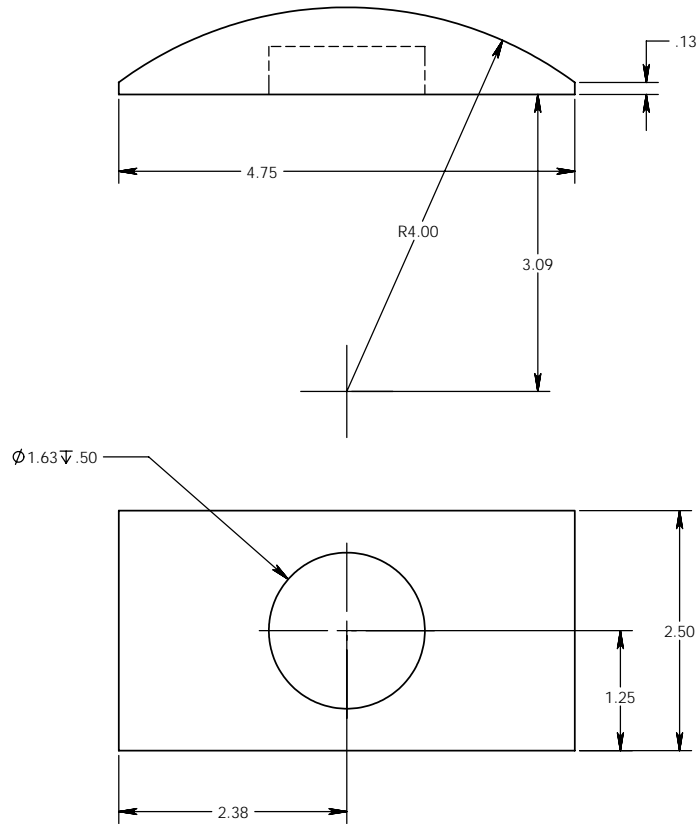
ORNL OAK RIDGE NATIONAL LABORATORY
operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN

NSTB REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**NUFACT HG JET EXPERIMENT
COMMON BASEPLATE ASSY
HYD JACK BASEPLATE WELDMENT**

CAD FILE	PREV ASSY	SCALE	SHEET
HYD JACK BASEPLATE HJT	203-HJT-0100	1:2	1 of 1
SIZE	DWG NO.	REV	#
C	203-HJT-0132		

NOTES
1. MATERIAL CERTIFICATIONS REQUIRED



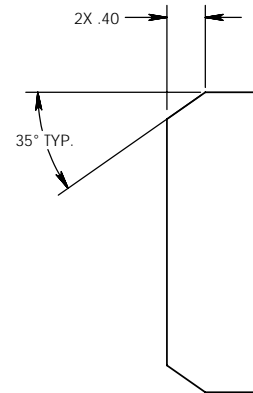
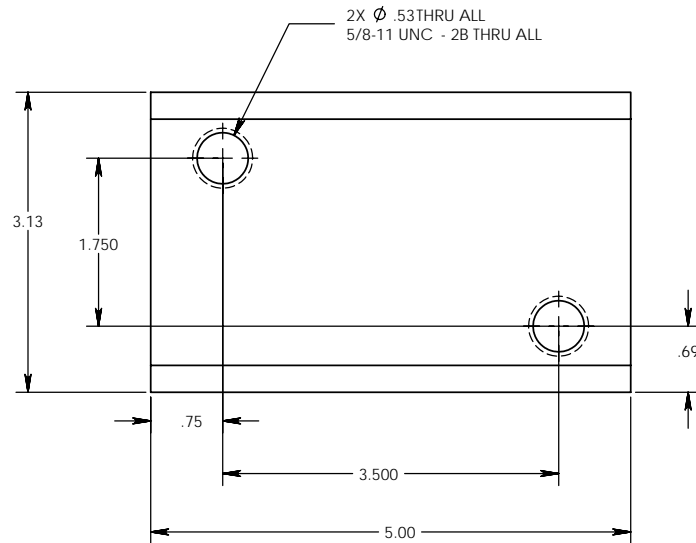
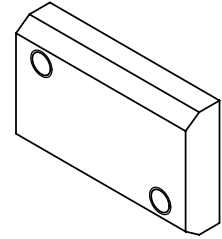
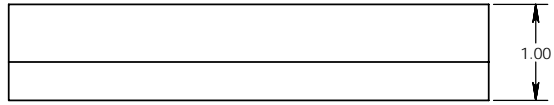
MATERIAL: CRS - 1018

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 07/21/2005 DRW T OQUIN 07/21/2005 CHK ENG V GRAVES 07/21/2005			<p>NUFACT HG JET EXPERIMENT COMMON BASEPLATE ASSY HYD JACK ROCKER</p>		
CAD FILE HYD JACK ROCKER HJT SIZE DWG NO. C			PREV ASSY 203-HJT-0100	SCALE 1:1	SHEET 1 of 1
DRAWING APPROVALS DATE			203-HJT-0133 REV #		

DWG NO. 203-HJT-0133

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

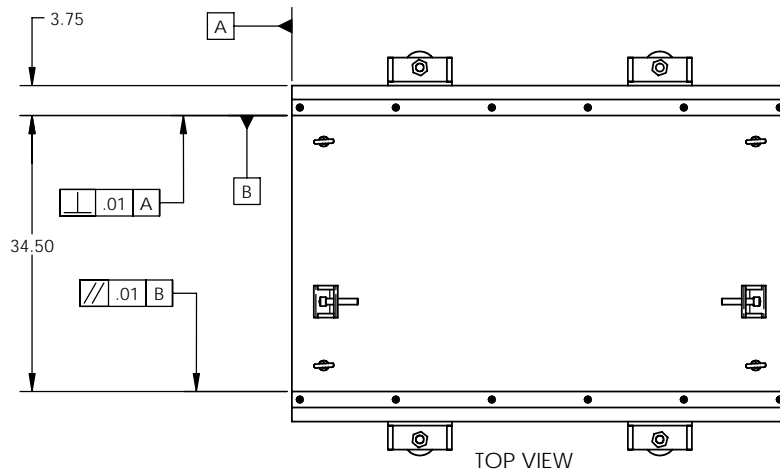
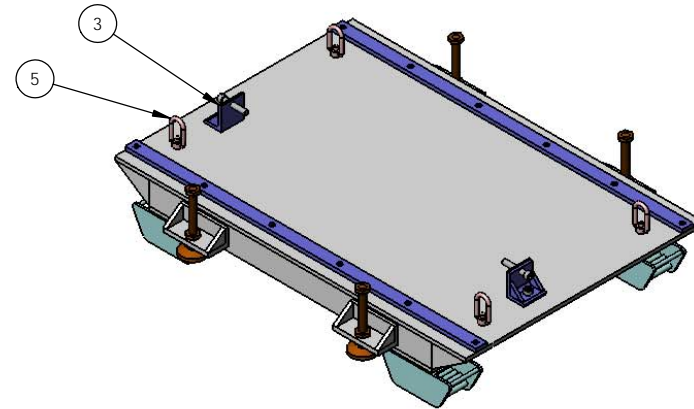
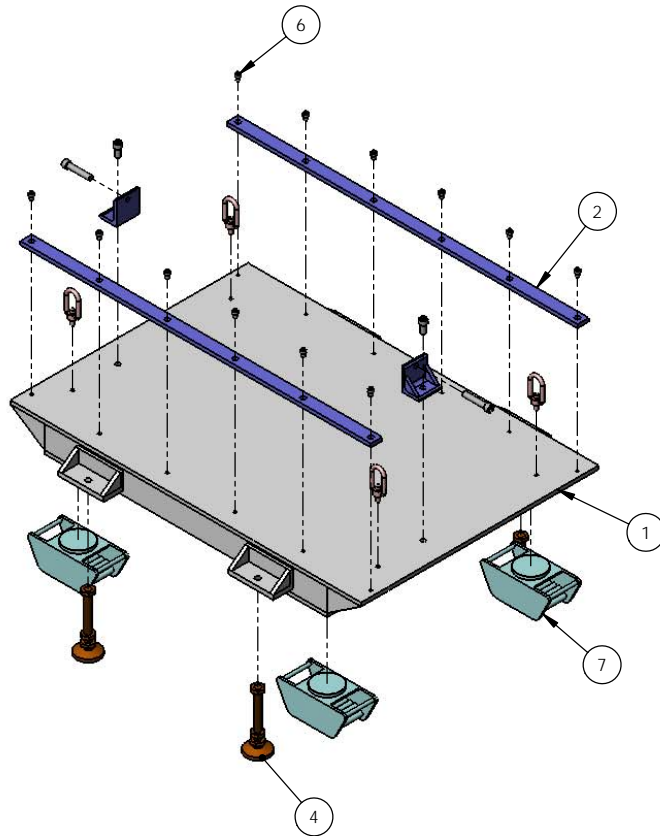


MATERIAL: CRS - 1018

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 07/25/2005 DRW T OQUIN 07/25/2005 CHK ENG V GRAVES 07/25/2005			<p>NUFACT HG JET EXPERIMENT COMMON BASE ASSY HYD JACK BACKPLATE</p>		
DRAWING APPROVALS DATE			CAD FILE HYD JACK BACKPLATE HJT	PREV ASSY 203-HJT-0100	SCALE 1:1
SIZE DWG NO.			203-HJT-0134		SHEET 1 of 1
#			#		REV #

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



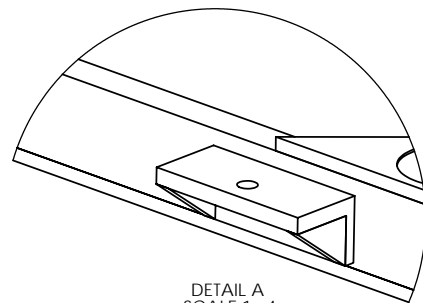
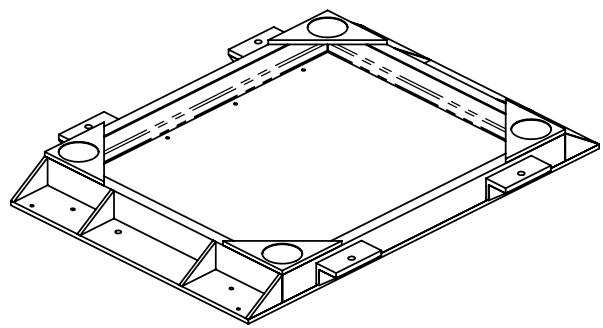
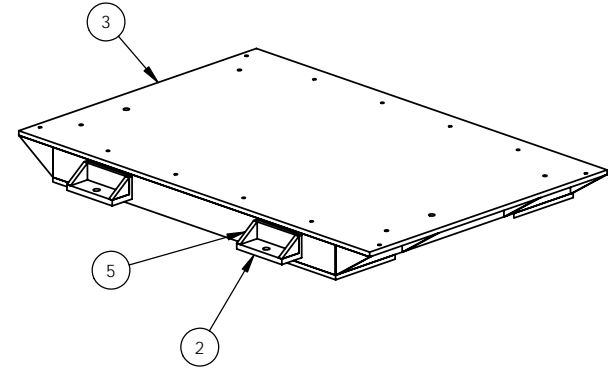
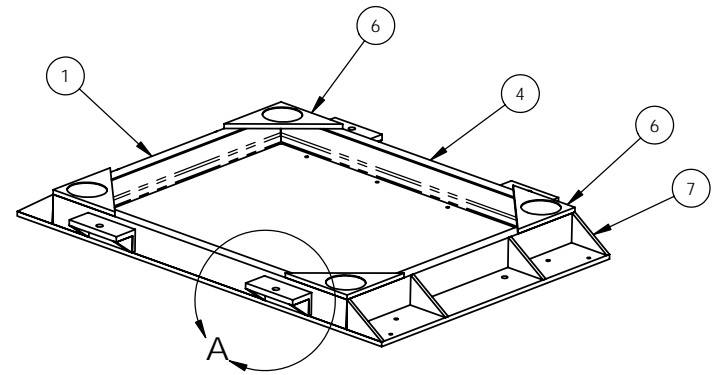
TOP VIEW

7	4	hilman hjt	---	HILMAN ROLLER #KRS-15-SLP	N/A
6	12	HX-SHCS 0.5-13x0.625x0.625-N	SS - 18-8	SHCS - 1/2-13 x .63	N/A
5	4	swivel hoist ring hjt	ALLOY STEEL - MACHINED	McMASTER-CARR #3145T23	N/A
4	4	leveling foot hjt	SS - 303	S & W MFG. CO., Bensenville, IL, Phone 888-538-3548, #SSW-5G	N/A
3	2	cart anchor assy hjt	---	CART ANCHOR ASSY	203-HJT-0120
2	2	flat rail hjt	SS - 304L	2" X 62" X 5/8" BAR	203-HJT-0202
1	1	base weldment hjt	AL - 6061 T6	BASE WELDMENT	203-HJT-0201
ITEM	with Hilmans/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p>	<p>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.</p>			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. FORMED ANGLES ±1°</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>9. X DECIMALS ±.030</p> <p>10. XX DECIMALS ±.010</p> <p>11. XXX DECIMALS ±.005</p>			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		
DES	V GRAVES	05/30/2005	<p>NUFACT HG JET EXPERIMENT TARGET TRANSPORTER ASSY</p>			
DRW	T OQUIN	05/30/2005				
CHK						
ENG	V GRAVES	05/30/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CARRIER BASE ASSY HJT	203-HJT-0001	1:12	1 of 1
			SIZE	DWG NO.		REV
			C	203-HJT-0200		#
DRAWING APPROVALS		DATE				

NOTES

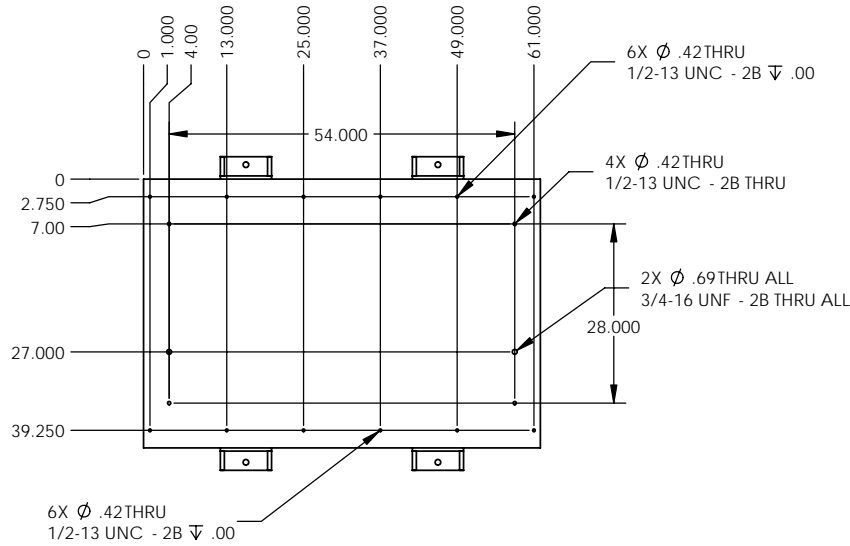
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



DETAIL A
SCALE 1 : 4

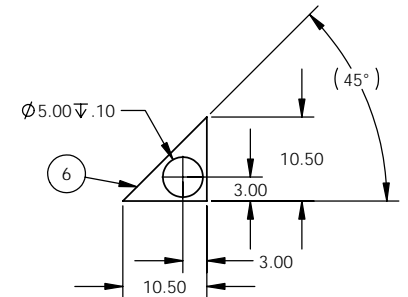
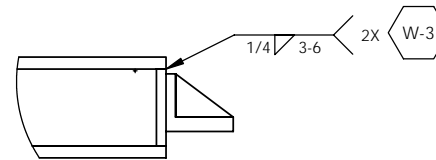
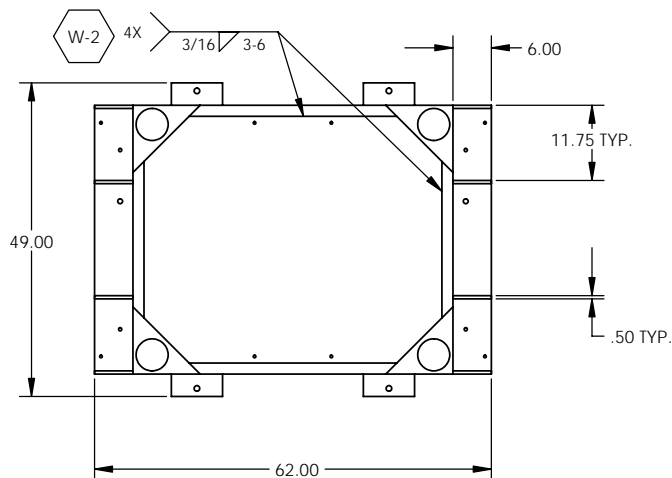
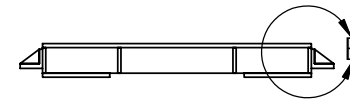
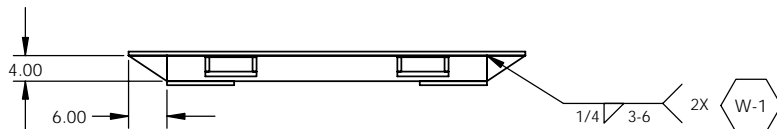
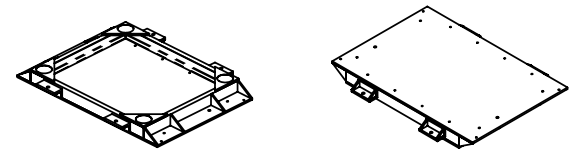
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
7	8	PLATE, 4.00 x 6.00 x .50	AL - 6061 T6511, ASTM B-221	---
6	4	PLATE, 10.50 x 10.50 x .63	AL - 6061 T651, ASTM B-209	---
5	8	PLATE - 2.50 X 3.00 X .63	AL - 6061 T6511, ASTM B-221	---
4	2	AMER STD "C", 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	50
3	1	PLATE, 42.00 x 62.00 x .63	AL - 6061 T651, ASTM B-209	62.00
2	4	ANGLE - 3.00 X 3.50 X .50	AL - 6061 T6511, ASTM B-221	8.00
1	2	AMER STD "C", 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	42

<p>THIRD-ANGLE PROJECTION</p>	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. FORMED ANGLES ±1°</p> <p>7. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>8. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>9. X DECIMALS ±.030</p> <p>10. XX DECIMALS ±.010</p> <p>11. XXX DECIMALS ±.005</p>		<p>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.</p>		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
	<p>DES V GRAVES 06/02/2005</p> <p>DRW T OQUIN 06/02/2005</p> <p>CHK</p> <p>ENG V GRAVES 06/02/2005</p> <p>QA</p>		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		<p>NUFACT HG JET EXPERIMENT TARGET TRANSPORTER ASSY TRANSPORTER BASE WELDMENT</p>			
<p>DRAWING APPROVALS</p>		<p>DATE</p>		<p>CAD FILE</p> <p>BASE WELDMENT HJT</p> <p>SIZE DWG NO.</p>	<p>PREV ASSY</p> <p>203-HJT-0200</p>	<p>SCALE</p> <p>1:12</p>	<p>SHEET</p> <p>1 of 3</p>	
<p>DRAWING APPROVALS</p>				<p>DATE</p>		<p>203-HJT-0201</p>		<p>REV</p> <p>8</p>



NOTES

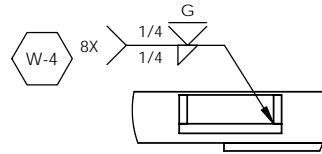
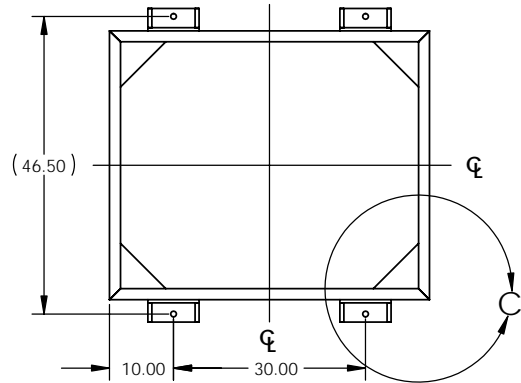
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



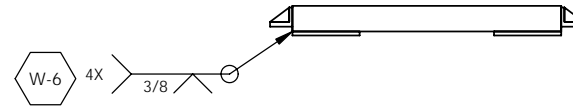
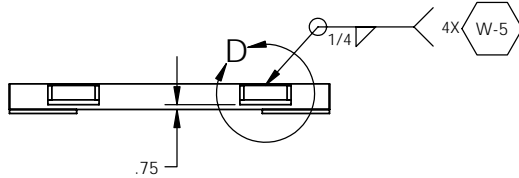
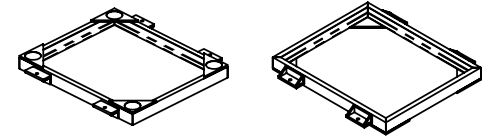
<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>			
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DES V GRAVES 06/02/2005 DRW T OQUIN 06/02/2005 CHK ENG V GRAVES 06/02/2005 QA	NUFAC HG JET EXPERIMENT TARGET TRANSPORTER ASSY TRANSPORTER BASE WELDMENT			CAD FILE BASE WELDMENT HJT	PREV ASSY 203-HJT-0200	SCALE 1:15	SHEET 2 of 3
DRAWING APPROVALS DATE		SIZE C	DWG NO. 203-HJT-0201		REV 8		

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

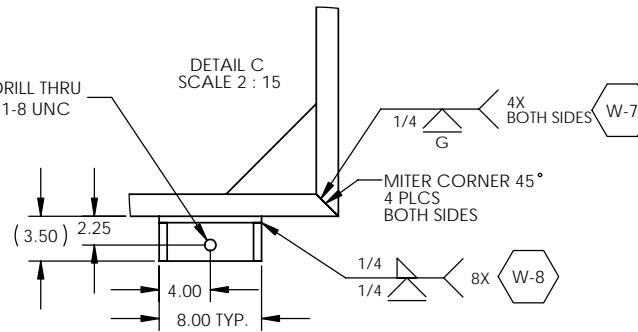


DETAIL D
SCALE 2 : 15

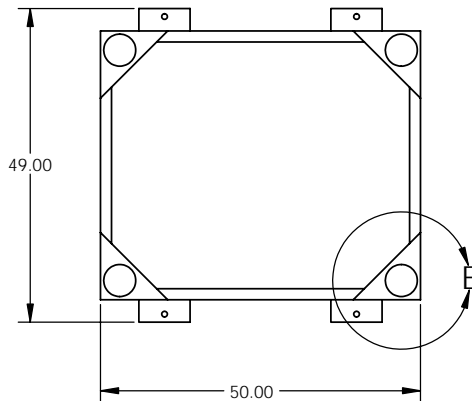


4X DRILL THRU
TAP 1-8 UNC

DETAIL C
SCALE 2 : 15



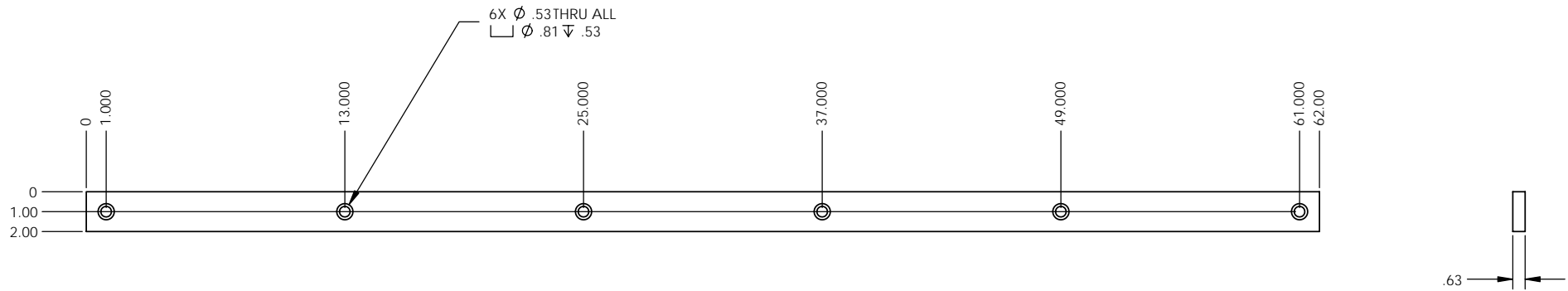
DETAIL E
SCALE 2 : 15



<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
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DES	V GRAVES	06/02/2005	<p>NUFACT HG JET EXPERIMENT TARGET TRANSPORTER ASSY BASE WELDMENT WELDMENT</p>			
DRW	T OQUIN	06/02/2005				
CHK						
ENG	V GRAVES	06/02/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			BASE WELDMENT HJT	203-HJT-0200	1:10	3 of 3
DRAWING APPROVALS			DATE	SIZE	DWG NO.	REV
				C	203-HJT-0201	8

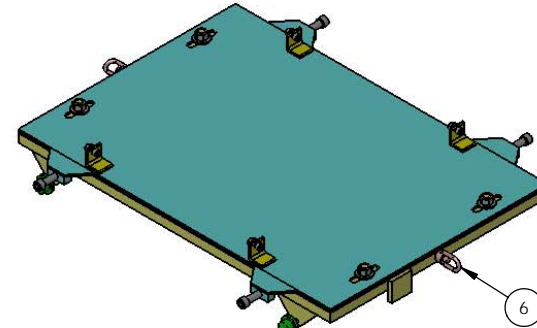
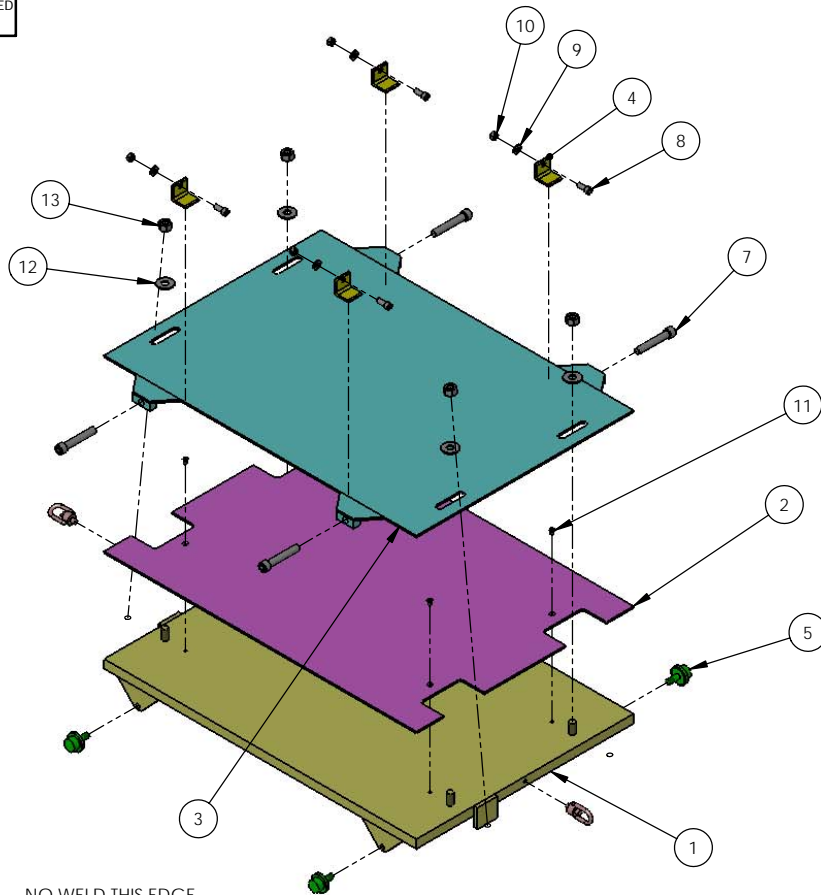
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



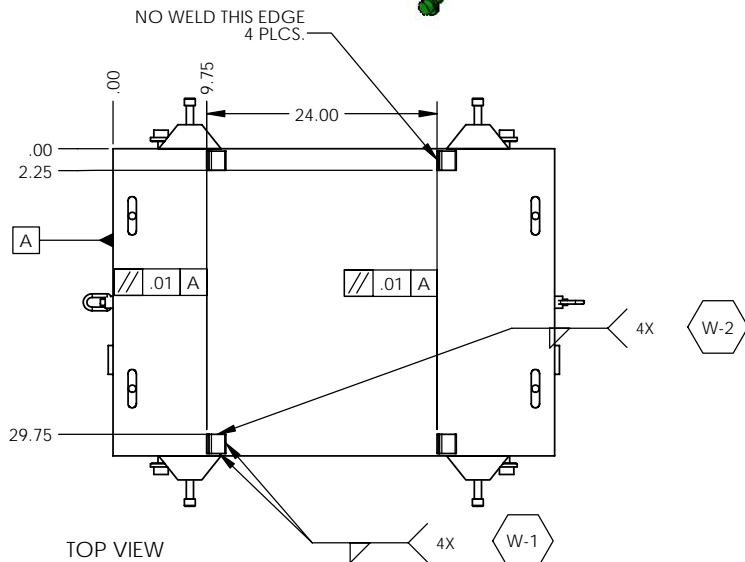
MATERIAL: SS - 304L

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
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DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005 QA			<p>NUFACT HG JET EXPERIMENT TARGET TRANSPORTER ASSY FLAT RAIL - TRANSPORTER ASSY</p>		
DRAWING APPROVALS DATE			CAD FILE FLAT RAIL HJT	PREV ASSY 203-HJT-0200	SCALE 1:4
SIZE DWG NO.			C	203-HJT-0202	SHEET 1 of 1 REV 3



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

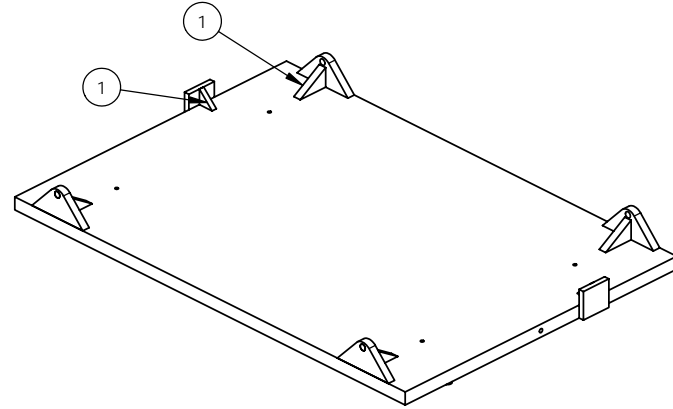
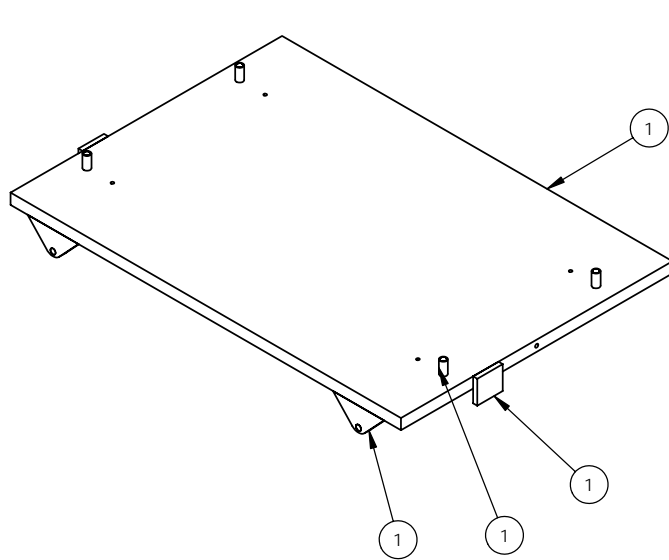


13	4	HHNUT 0.7500-10-D-N	SS - 18-8	HEX NUT - 3/4-10 UNC	N/A
12	4	FW 0.75	SS - 18-8	FLAT WASHER - 3/4"	N/A
11	4	CSBOLT 0.3125-18X0.625X0.625-S-N	SS - 18-8	FHMS - 5/16-18 UNC x 5/8	N/A
10	4	HNUT 0.5000-13-D-N	SS - 18-8	HEX NUT - 1/2-13 UNC	N/A
9	4	FW 0.5	SS - 18-8	FLAT WASHER - 1/2" NARROW	N/A
8	4	HX-SHCS 0.5-13x1.25x1.25-N	SS - 18-8	SHCS - 1/2-13 x 1.25	N/A
7	4	HX-SHCS 0.75-16x4.5x4.5-N	SS - 18-8	SHCS - 3/4-16 x 4.50	N/A
6	2	swivel hoist ring hjt	ALLOY STEEL - MACHINED	McMASTER-CARR #2949132	N/A
5	4	track roller hjt		mcmaster-carr 2091k33	
4	4	hg sys locating bkt hjt	AL - 6061 T6, ASTM B-308	AM STD AL ANGLE, 2" X 2" X 1/4"	203-HJT-0304
3	1	cart upper plate hjt	AL - 6061 T651, ASTM B-209	PLATE - 32" X 46" X 1/4"	203-HJT-0303
2	1	uhmw sheet hjt	UHMW	MCMaster CARR #8619K116	203-HJT-0302
1	1	cart lower plate hjt	AL - 6061 T651, ASTM B-209	PLATE - 32" X 46" X 1.25"	203-HJT-0301
ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p>	<p>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.</p>			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES FORMED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.000</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</p>			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		
DES	V GRAVES	06/03/2005	<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY</p>			
DRW	T OQUIN	06/03/2005				
CHK						
ENG	V GRAVES	06/03/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CART ASSY HJT	203-HJT-0001	1:10	1 of 1
			SIZE	DWG NO.		REV
			C	203-HJT-0300		4
DRAWING APPROVALS		DATE				

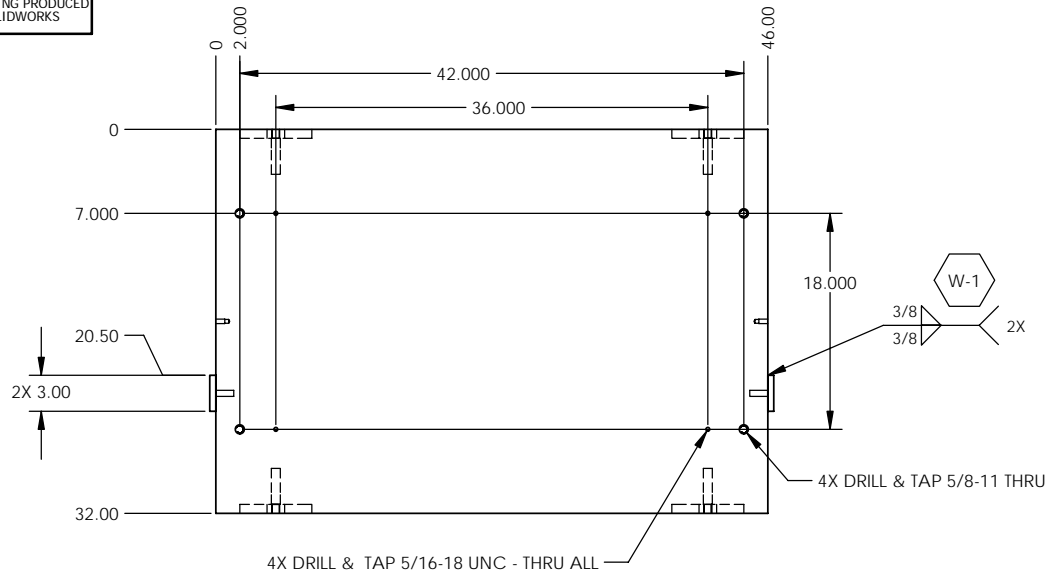
NOTES

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



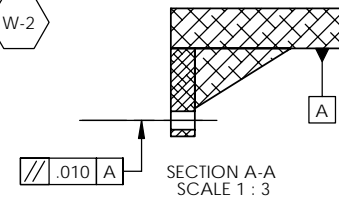
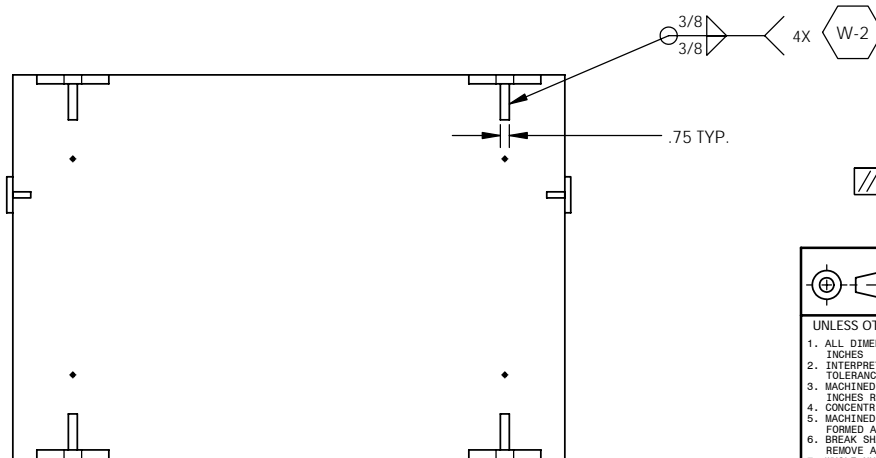
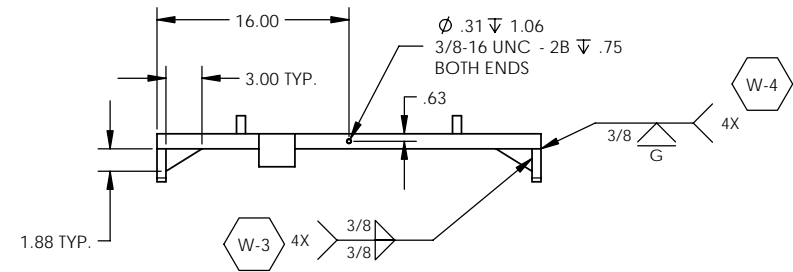
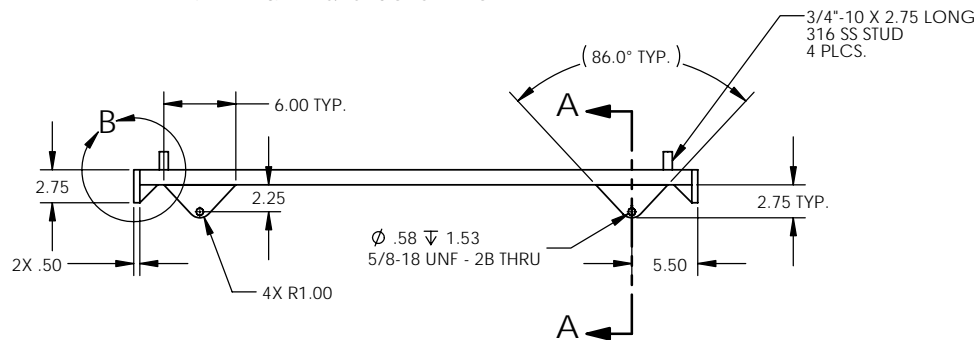
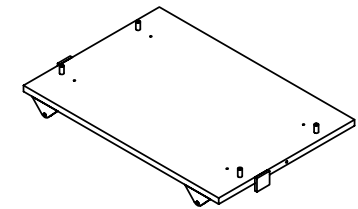
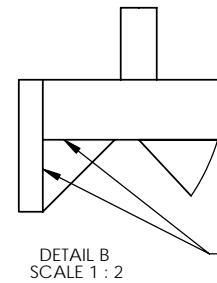
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
6	4	STUD, 3/4-10 UNC	SS - 8-18 ALL-THREAD	2.75"
5	1	PLATE, 32.00" x 46.00" x 1.25"	AL - 6061-T6511, ASTM B-209	46.00"
4	2	PLATE, 1.5" x 1.5" x .50"	AL - 6061 T6511, ASTM B-221	---
3	2	PLATE, 2.75" x 3.00" x .50"	AL - 6061 T6511, ASTM B-221	---
2	4	PLATE, 1.88" 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	---

<p>THIRD-ANGLE PROJECTION</p>	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES FORMED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND REMOVE ALL BURRS</p> <p>7. WHOLE NUMBERS AND FRACTIONS ±1/16</p> <p>8. X DECIMALS ±.030</p> <p>9. XX DECIMALS ±.010</p> <p>10. XXX DECIMALS ±.005</p>			<p>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.</p>		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>		
	<p>DES V GRAVES 06/03/2005</p> <p>DRW T OQUIN 06/03/2005</p> <p>CHK</p> <p>ENG V GRAVES 06/03/2005</p> <p>QA</p>	<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>		<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY CART LOWER PLATE WELDMENT</p>		<p>CAD FILE CART LOWER PLATE HJT</p>	<p>PREV ASSY 203-HJT-0300</p>	<p>SCALE 1:8</p>
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>SIZE DWG NO. C 203-HJT-0301</p>		<p>REV 0</p>			



NOTES

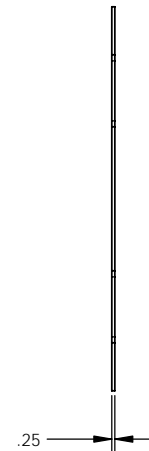
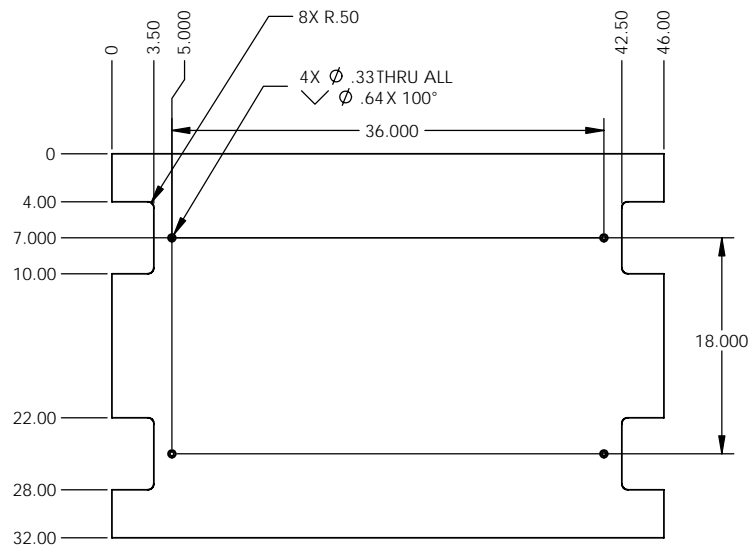
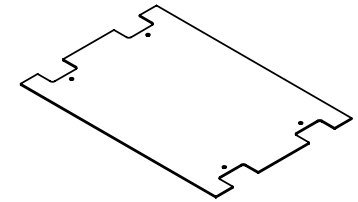
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
3. MATERIAL CERTIFICATIONS REQUIRED



<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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 FORMED ANGLES ±1/2° 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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005			<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY CART LOWER PLATE WELDMENT</p>		
DRAWING APPROVALS DATE			CAD FILE CART LOWER PLATE HJT	PREV ASSY 203-HJT-0300	SCALE 1:8
SIZE DWG NO.			SHEET 2 of 2		
C			203-HJT-0301		REV 0

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

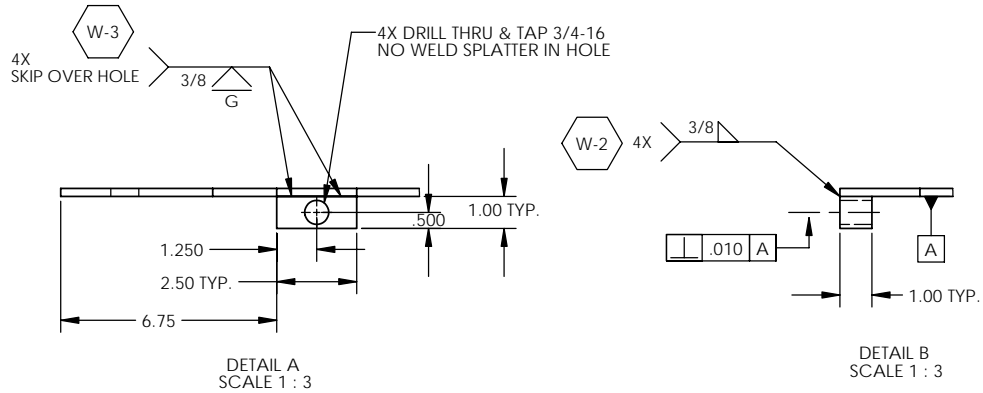
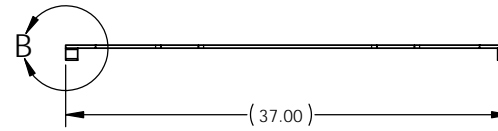
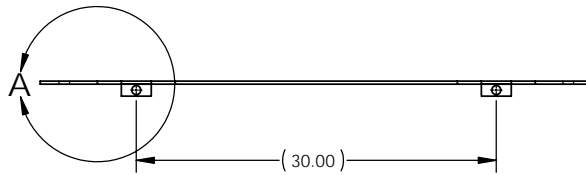
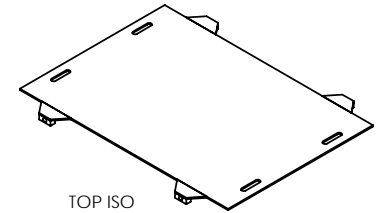
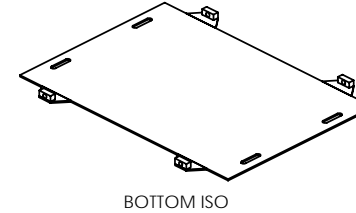
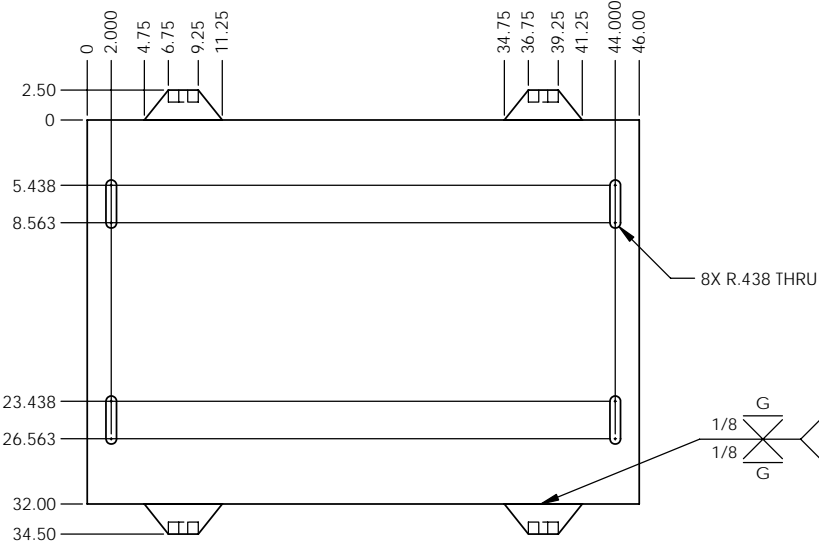


MATERIAL: UHMW

<p>THIRD-ANGLE PROJECTION</p>	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.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	<p>UNLESS OTHERWISE NOTED</p> <ol style="list-style-type: none"> 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 		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
<p>DES V GRAVES 06/03/2005</p> <p>DRW T OQUIN 06/03/2005</p> <p>CHK</p> <p>ENG V GRAVES 06/03/2005</p> <p>QA</p>		<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY CART UHMW SHEET</p>		<p>CAD FILE UHMW SHEET HJT</p>
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>PREV ASSY 203-HJT-0300</p>	<p>SCALE 1:8</p>
<p>SIZE C</p>		<p>DWG NO. 203-HJT-0302</p>	<p>SHEET 1 of 1</p>	<p>REV #</p>

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

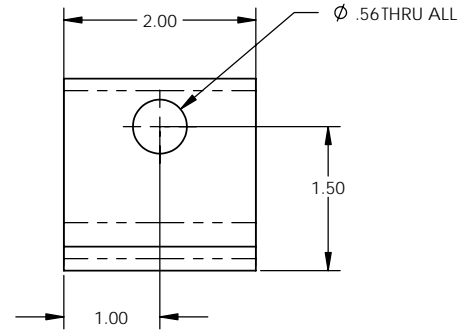
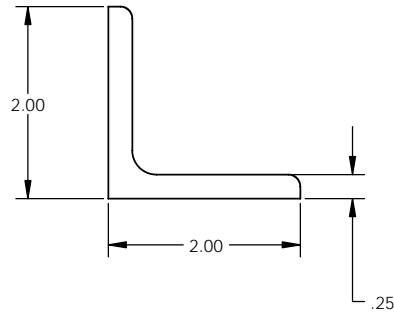
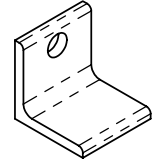


ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
3	4	PLATE, 1.00 x 1.00 x 2.50	AL - 6061 T6511, ASTM B-221	2.50
2	4	PLATE, 2.50 x 6.50 x .25	AL - 6061 T6511, ASTM B-221	6.50
1	1	PLATE, 32.00 x 46.00 x .25	AL - 6061-T651, ASTM B-209	46.00

<p>THIRD-ANGLE PROJECTION</p>	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.		<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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° 6. FORMED ANGLES ±1° 7. BREAK SHARP CORNERS AND REMOVE ALL BURRS 8. WHOLE NUMBERS AND FRACTIONS ±1/16 9. .X DECIMALS ±.030 10. .XX DECIMALS ±.010 11. .XXX DECIMALS ±.005		<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005 QA	<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY UPPER PLATE WELDMENT</p>		CAD FILE CART UPPER PLATE HJT	PREV ASSY 203-HJT-0300
DRAWING APPROVALS DATE	SIZE DWG NO.	SCALE 1:8	SHEET 1 of 1	REV #
C		203-HJT-0303		#

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



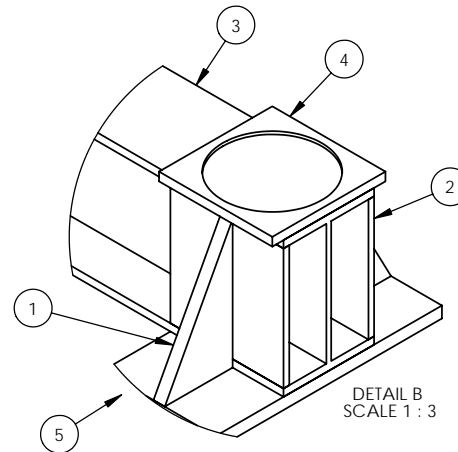
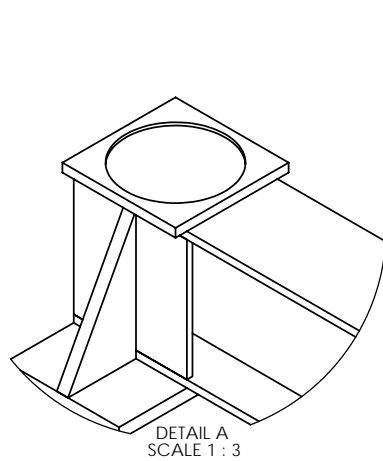
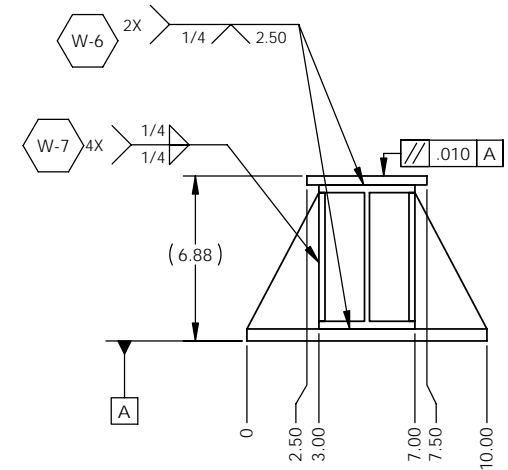
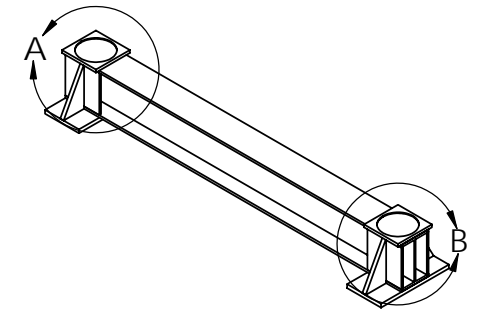
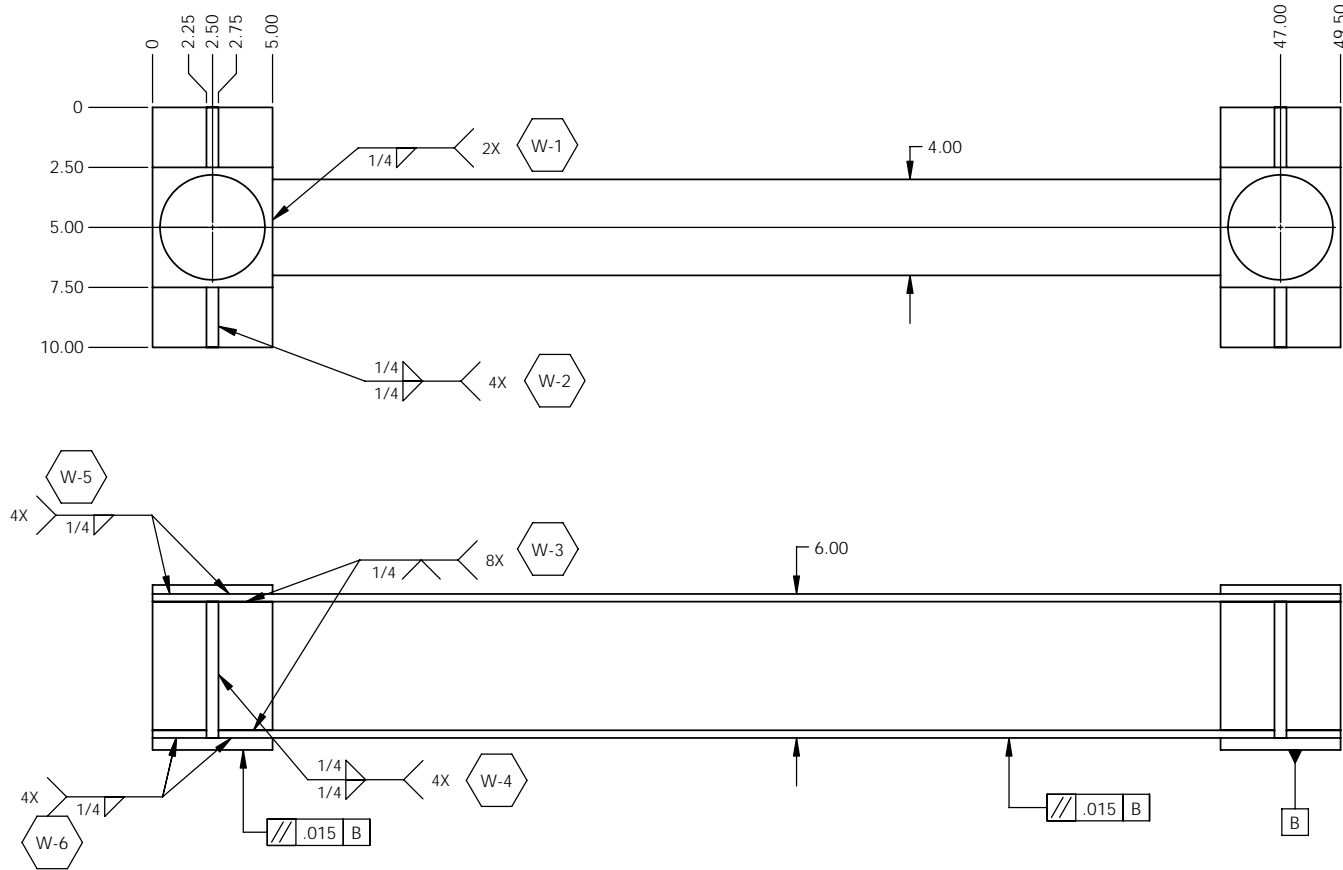
MATERIAL: AL - 6061 T6, ASTM B-308

<p>THIRD-ANGLE PROJECTION</p>	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.			<p>OAK RIDGE NATIONAL LABORATORY operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	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° 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			<p>REMOTE SYSTEMS GROUP NUCLEAR SCIENCE & TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005			<p>NUFACT HG JET EXPERIMENT TARGET CART ASSY HG SYS LOCATING BKT</p>		
CAD FILE HG SYS LOCATING BKT HJT			PREV ASSY 203-HJT-0300		SCALE 1:1
DRAWING APPROVALS DATE			SIZE DWG NO. C 203-HJT-0304		SHEET 1 of 1 REV 0

DWG NO. 203-HJT-0304

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



ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
5	2	PLATE, 5.00 x 10.00 x .50	AL 6061 T651, ASTM B-209	10.00
4	2	PLATE, 5.00 x 5.00 x .38	AL 6061 T651, ASTM B-209	5.00
3	1	I-BEAM, ALUM. ASSOC. 6.00 x 4.00 x .21	AL 6061-T6, ASTM B-308	49.50
2	4	PLATE, 5.68 x 5.00 x .25	AL 6061 T651, ASTM B-209	5.00
1	4	PLATE, 3.00 x 5.68x .50	AL 6061 T651, ASTM B-209	---

THIRD-ANGLE PROJECTION

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 FORMED ANGLES ±1/2°
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

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DES	V GRAVES	05/25/2005
DRW	T OQUIN	05/25/2005
CHK		
ENG	V GRAVES	05/25/2005
QA		

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

NSTB REMOTE SYSTEMS GROUP
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

NUFACT HG JET EXPERIMENT
MAGNET END SUPPORT WELDMENT

CAD FILE	PREV ASSY	SCALE	SHEET
MAGNET END SUPPORT HJT	203-HJT-0001	1:4	1 of 1
SIZE	DWG NO.		
	203-HJT-0400		