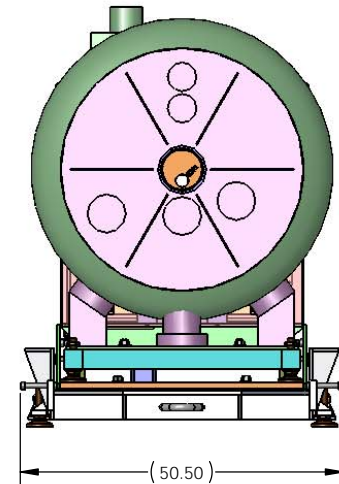
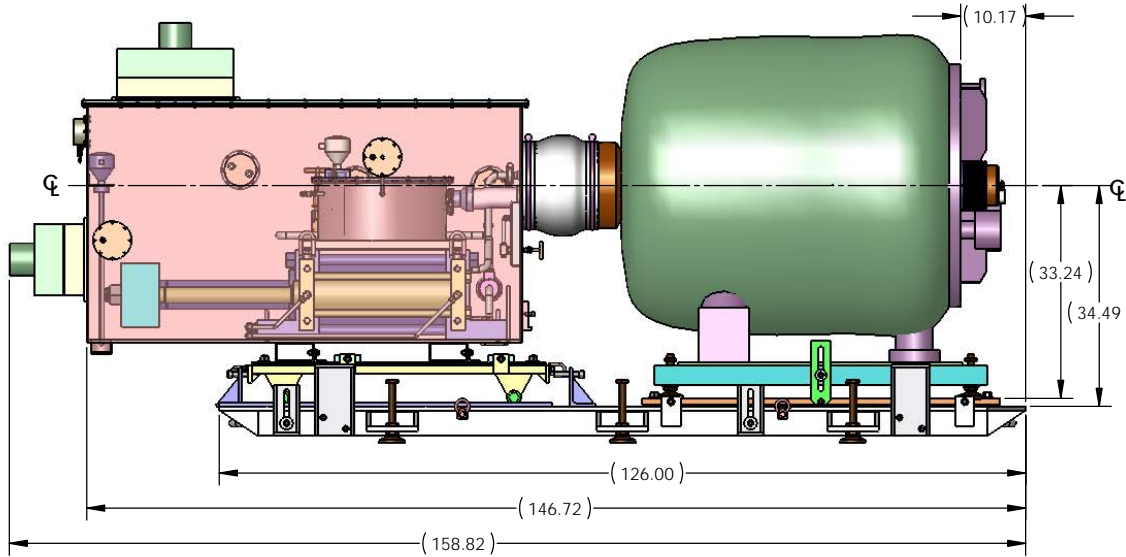
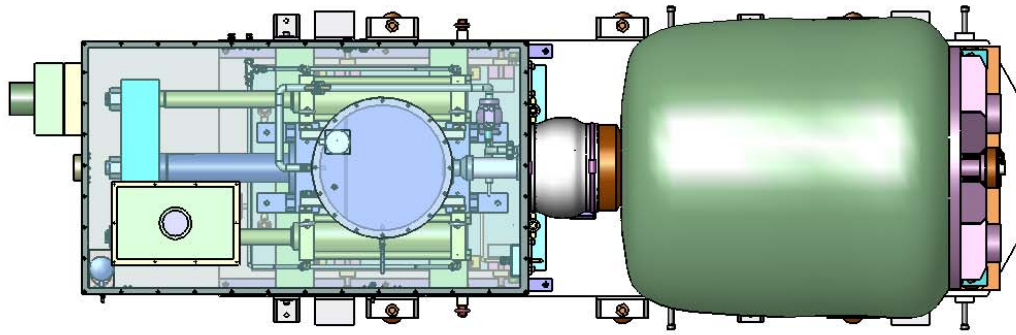


ITEM	for dwg with carrier/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
6	1	target transporter assy hjt	---	TRANSPORTER BASEPLATE ASSY	203-HJT-0200
5	1	magnet assy hjt	---	PROVIDED BY M.I.T.	---
4	1	hg delivery system hjt	---	HG DELIVERY SYSTEM	203-HJT-0500
3	1	magnet end support hjt	---	USED TO RAISE MAGNET END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

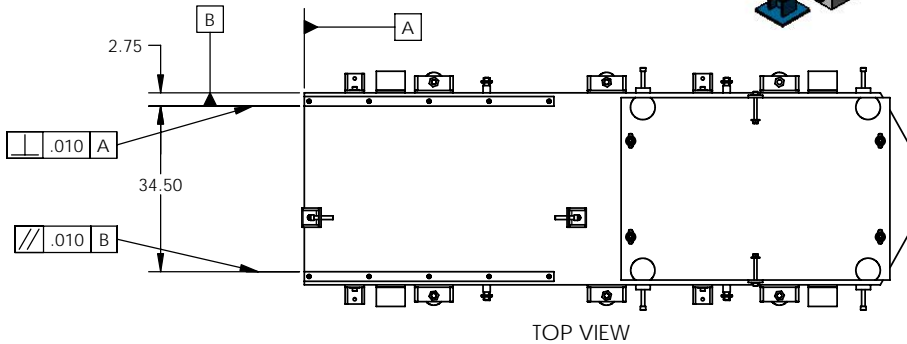
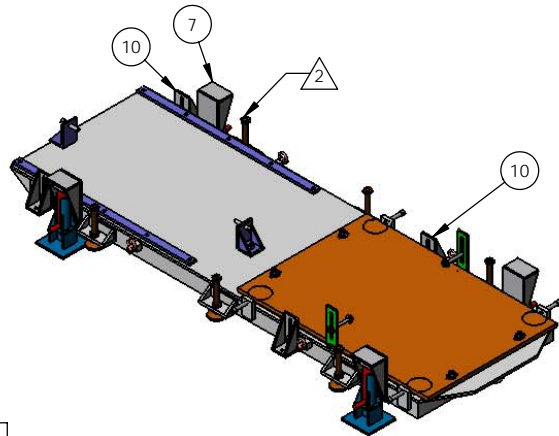
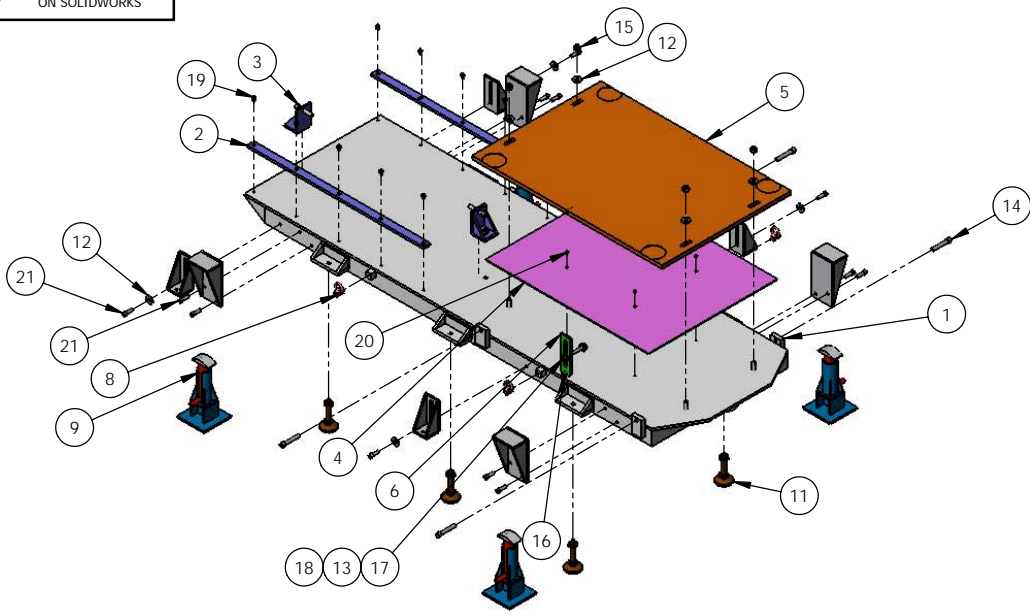
<p>THIRD-ANGLE PROJECTION</p>	<p>UNLESS OTHERWISE NOTED</p> <p>1. ALL DIMENSIONS ARE IN INCHES</p> <p>2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M</p> <p>3. MACHINED FINISH 125 MICRO-INCHES RMS</p> <p>4. CONCENTRICITY .010 TIR</p> <p>5. MACHINED ANGLES ±1/2°</p> <p>6. BREAK SHARP CORNERS AND 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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
	<p>DES V GRAVES 06/04/2005</p> <p>DRW T OQUIN 06/04/2005</p> <p>CHK</p> <p>ENG V GRAVES 06/04/2005</p>		<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERCURY INTENSE TARGET (MERIT)</b> <b>TOP-LEVEL ASSEMBLY</b></p>	
DRAWING APPROVALS		DATE	CAD FILE COMMON BASE LOADED HJT	PREV ASSY ---	SCALE 1:16	SHEET 1 of 2
			SIZE C	DWG NO. 203-HJT-0001	REV 9b	

1. MATERIAL CERTIFICATIONS REQUIRED



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DES V GRAVES 06/04/2005 DRW T OQUIN 06/04/2005 CHK ENG V GRAVES 06/04/2005 QA	CAD FILE COMMON BASE LOADED HJT SIZE DWG NO.			PREV ASSY ---	SCALE 1:15	SHEET 2 of 2
DRAWING APPROVALS DATE			C 203-HJT-0001		REV 9b	

S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

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

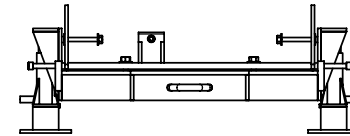
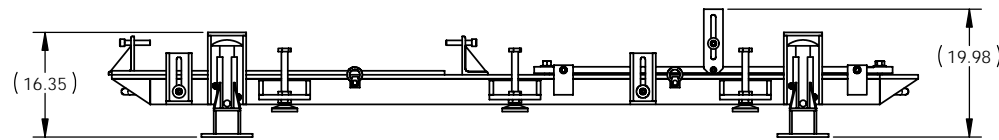
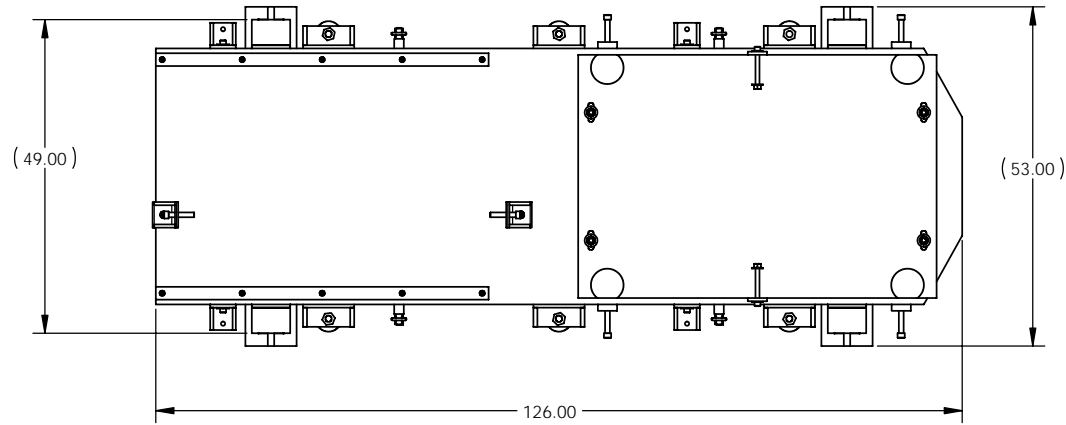
ITEM	EXPLODED/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
21	12	Socket Head Cap Screw_AI	SS - 18-8	SHCS - 5/8-11 x 2.00	N/A
20	4	CSBOLT 0.3125-18x0.625x0.625-S-N	SS - 18-8	FHMS - 5/16-18 UNC x 5/8	N/A
19	10	HX-SHCS 0.5-13x0.625x0.625-N	SS - 18-8	SHCS - 1/2-13 x .63	N/A
18	2	HHNUT 0.6250-11-D-N	SS - 18-8	HEX NUT - 5/8-11 UNC	N/A
17	2	HX-SHCS 0.625-11x6x2.25-N	SS - 18-8	SHCS - 5/8-11 x 6.00	N/A
16	2	HX-SHCS 0.625-11x1x1-N	SS - 18-8	SHCS - 5/8-11 x 1.00	N/A
15	4	HHNUT 0.7500-10-D-N	SS - 18-8	HEX NUT - 3/4-10 UNC	N/A
14	4	HX-SHCS 0.75-16x4.5x4.5-N	SS - 18-8	SHCS - 3/4-16 x 4.50	N/A
13	4	FW 0.625	SS - 18-8	FLAT WASHER - 5/8"	N/A
12	8	FW 0.75	SS - 18-8	FLAT WASHER - 3/4"	N/A
11	6	leveling foot hjt	SS - 303	S & W MFG. CO., Bensenville, IL. Phone 888-538-3548, #SSW-5G	N/A
10	4	hyd jack weldment hjt	CRS - 1018	ANCHOR PLATE WELDMENT	203-HJT-0134
9	4	hyd jack assy hjt	---	---	203-HJT-0130
8	4	sidemount swivel hoist ring	ALLOY STEEL	MCMMASTER CARR 29525183	N/A
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	slick sheet hjt	UHMW	MCMMASTER CARR #8752K813	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 52 X 1	203-HJT-0111
1	1	base weldment hjt	AL - 6061 T6	BASE WELDMENT	203-HJT-0110

<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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>																		
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<table border="1"> <tr> <td>DES</td> <td>V GRAVES</td> <td>12/10/2005</td> </tr> <tr> <td>DRW</td> <td>T OQUIN</td> <td>06/02/2005</td> </tr> <tr> <td>CHK</td> <td></td> <td></td> </tr> <tr> <td>ENG</td> <td>V GRAVES</td> <td>12/10/2005</td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> </table>	DES	V GRAVES	12/10/2005	DRW	T OQUIN	06/02/2005	CHK			ENG	V GRAVES	12/10/2005	QA			<p><b>MERIT EXPERIMENT</b> <b>COMMON BASE ASSY</b></p>		<p>CAD FILE COMMON BASE ASSY HJT</p>	<p>PREV ASSY 203-HJT-0001</p>	<p>SCALE 1:20</p>	<p>SHEET 1 of 2</p>
DES	V GRAVES	12/10/2005																			
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QA																					
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>SIZE C</p>	<p>DWG NO. 203-HJT-0100</p>	<p>REV 0</p>																

DWG NO. 203-HJT-0100

NOTES

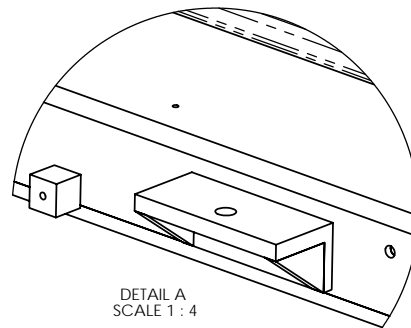
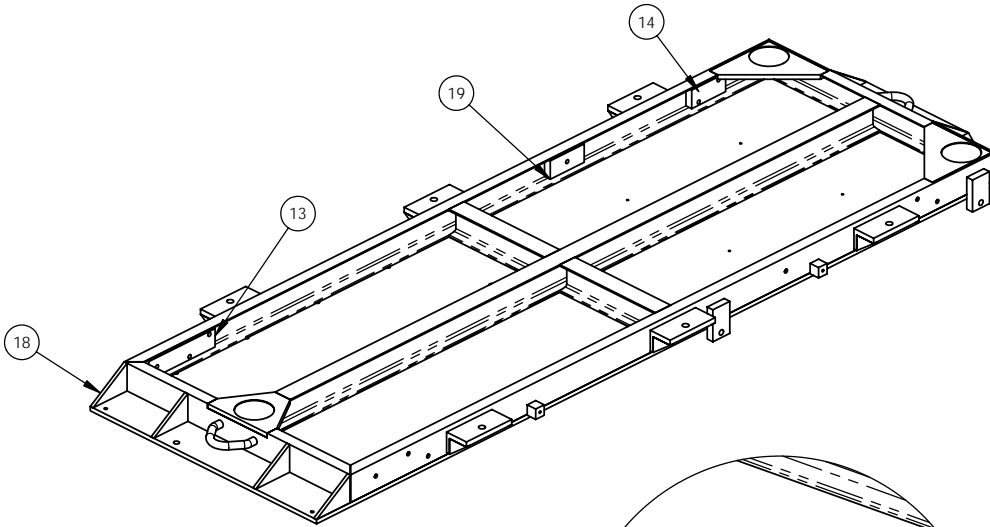
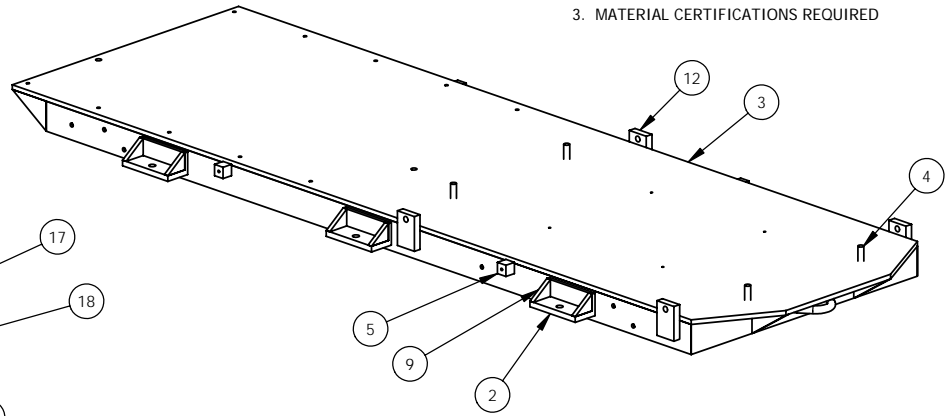
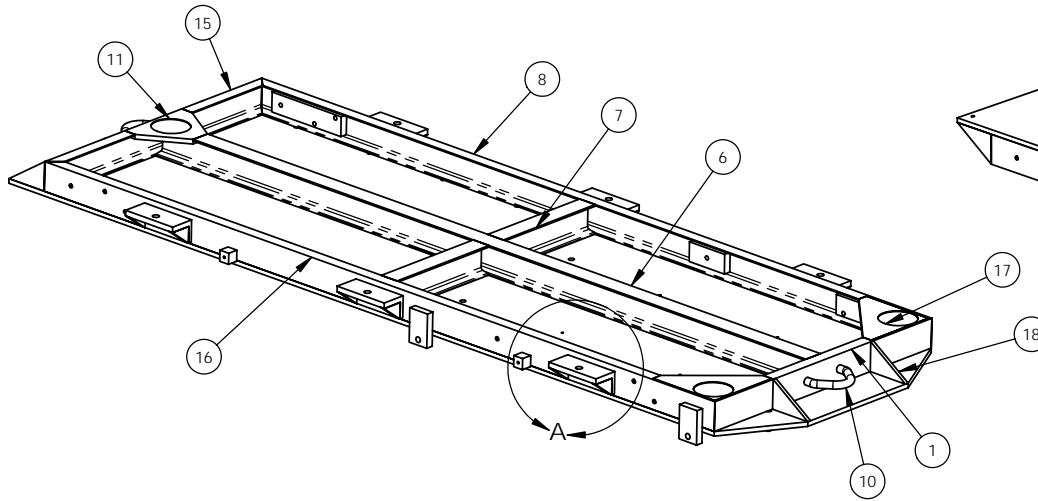
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2. TACK WELD NUTS ON ENDS OF JACK SCREWS AFTER ASSY



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CAD FILE COMMON BASE ASSY HJT SIZE DWG NO.			PREV ASSY 203-HJT-0001	SCALE 1:15	SHEET 2 of 2
DRAWING APPROVALS DATE			C	203-HJT-0100	REV 0

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

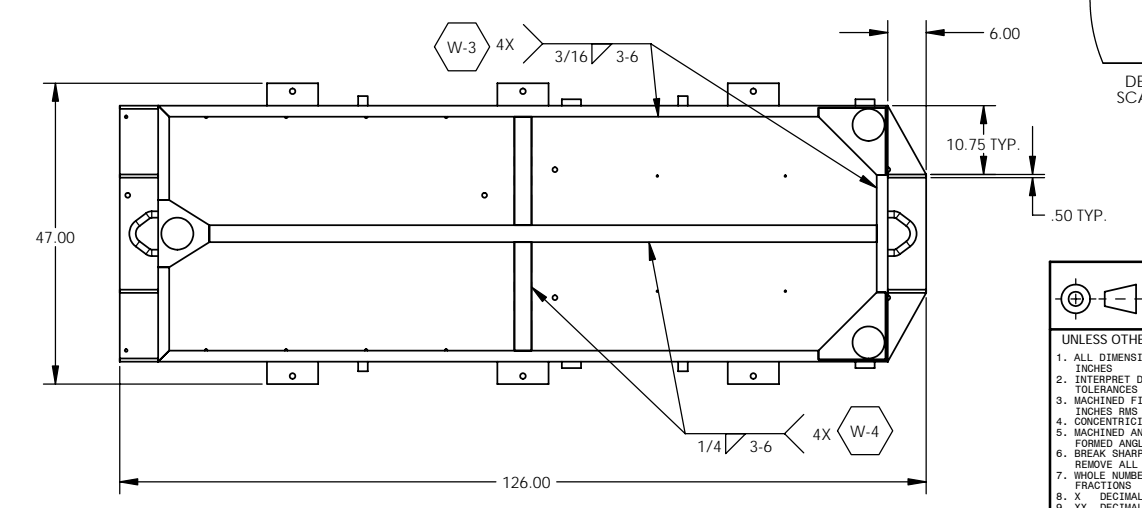
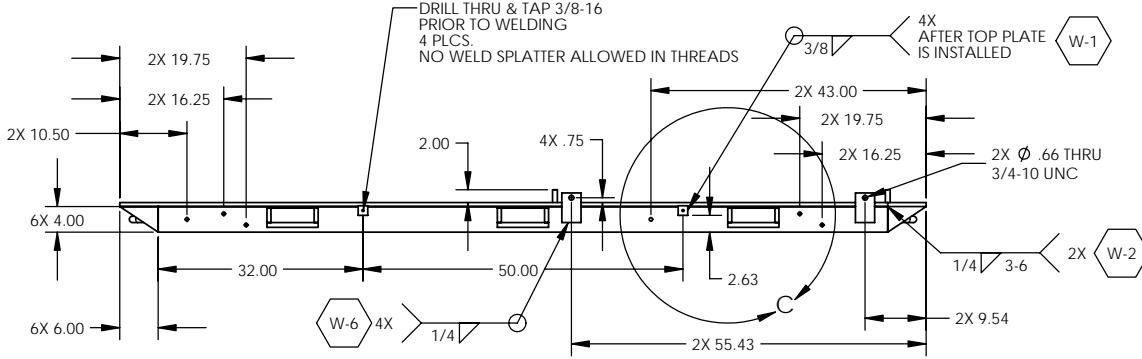
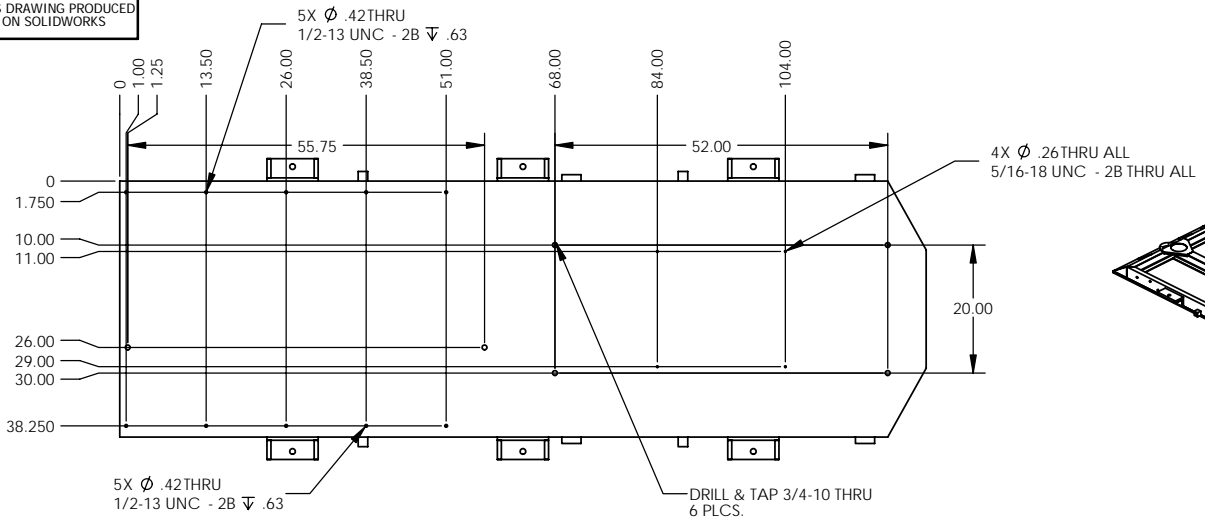


DETAIL A  
SCALE 1 : 4

ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
19	2	PLATE, 2.66 x 6.00 x 1.00	AL - 6061 T6511, ASTM B-221	6.00
18	6	PLATE, 4.00 x 6.00 x .50	AL - 6061 T6511, ASTM B-221	---
17	2	PLATE, 10.50 x 10.50 x .63	AL - 6061 T6511, ASTM B-221	10.50
16	1	C CHANNEL, 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	114
15	1	C CHANNEL, 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	40
14	2	PLATE, 2.66 x 6.00 x 1.00	AL - 6061 T6511, ASTM B-221	6.00
13	2	PLATE, 2.66 x 11.75 x 1.00	AL - 6061 T6511, ASTM B-221	11.75
12	4	PLATE, 3.00 x 4.63 x 1.00	AL - 6061 T6511, ASTM B-221	4.63
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	114
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	110.56
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 126.00 x .63	AL - 6061 T651, ASTM B-209	126.00
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

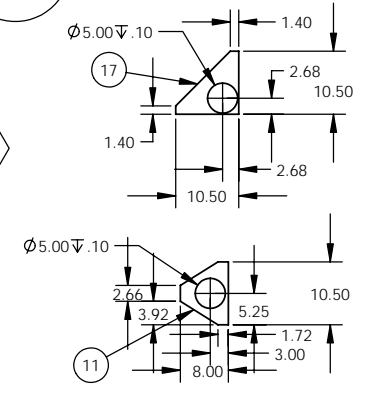
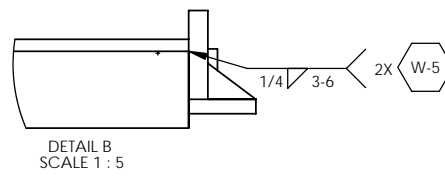
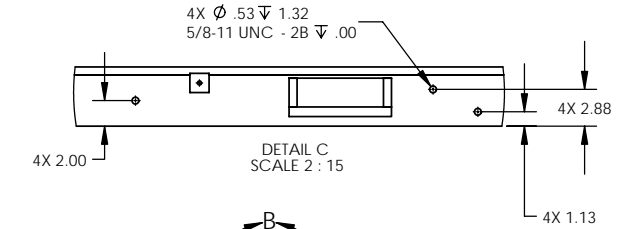
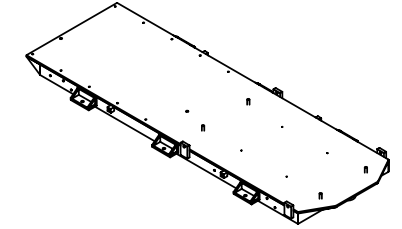
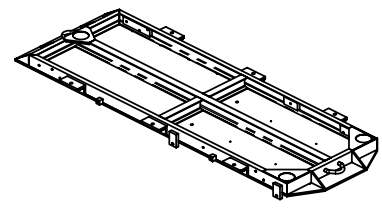
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S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

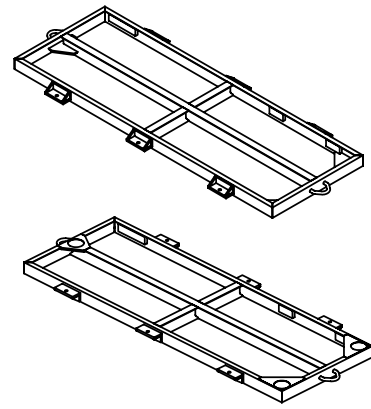
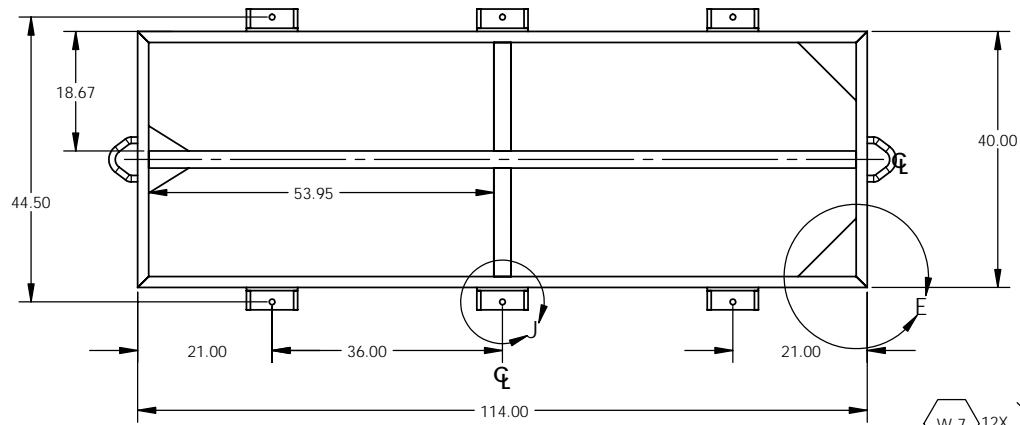
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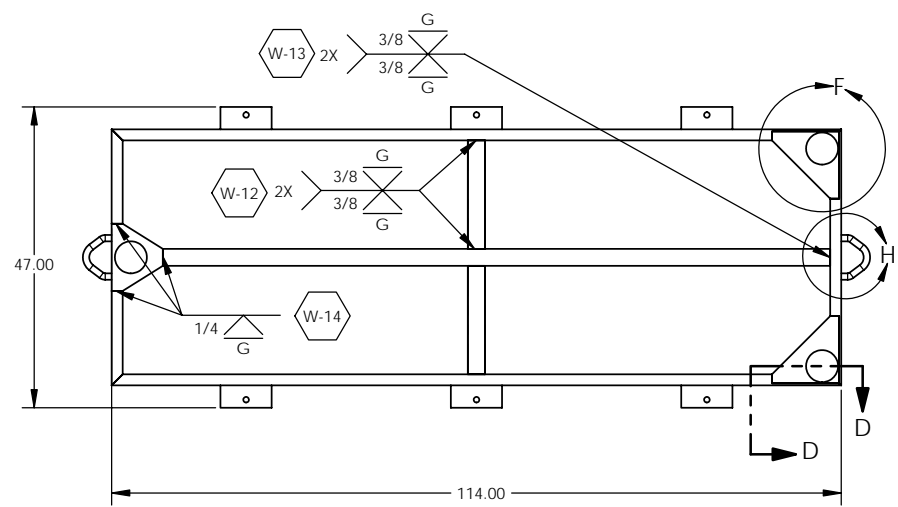
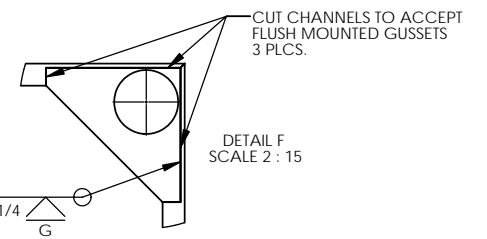
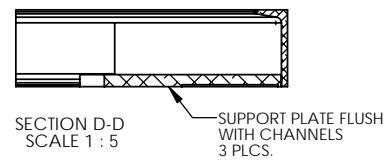
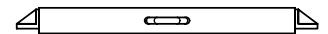
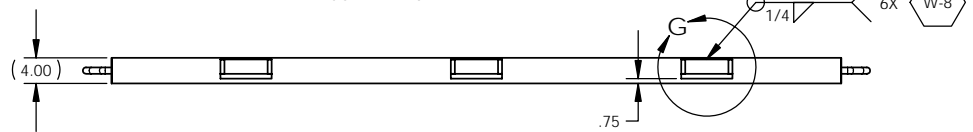
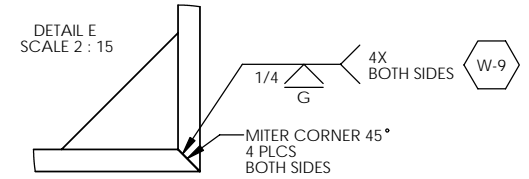
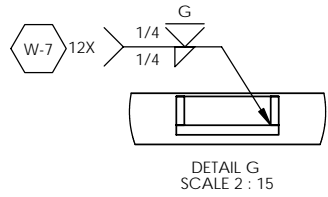
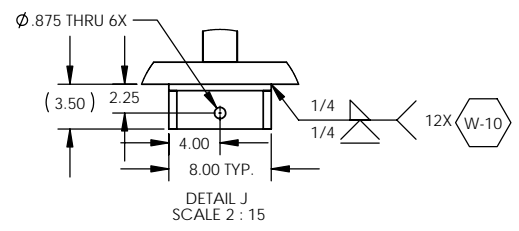
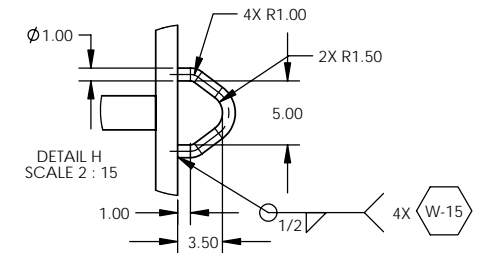
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<p>DES V GRAVES 12/10/2005</p> <p>DRW T OQUIN 12/10/2005</p> <p>CHK</p> <p>ENG V GRAVES 12/10/2005</p> <p>QA</p>		<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>BASE WELDMENT</b></p>		<p>CAD FILE BASE WELDMENT HJT</p> <p>PREV ASSY 203-HJT-0100</p> <p>SCALE 1:15</p> <p>SHEET 2 of 4</p>	
<p>DRAWING APPROVALS</p> <p>DATE</p>		<p>SIZE DWG NO. C 203-HJT-0110</p>		<p>REV 0</p>	

DWG NO. 203-HJT-0110

S THIS DRAWING PRODUCED ON SOLIDWORKS

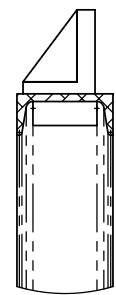
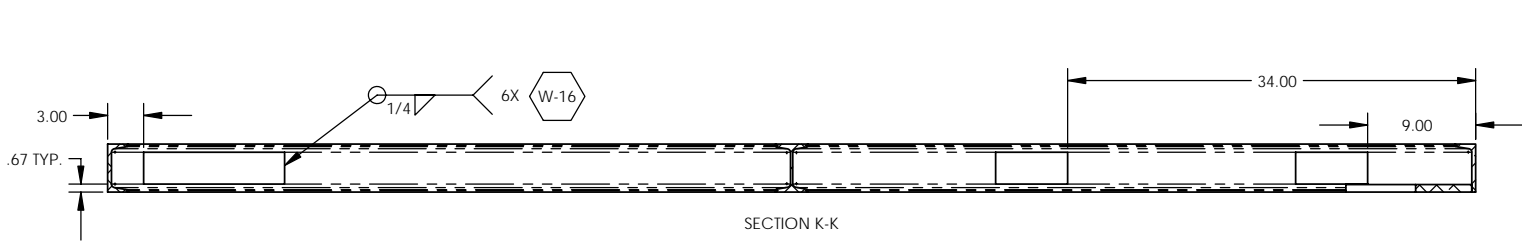


- NOTES
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
  2. ALL WELDS SHALL BE DYE PENETRANT INSPECTED
  3. MATERIAL CERTIFICATIONS REQUIRED

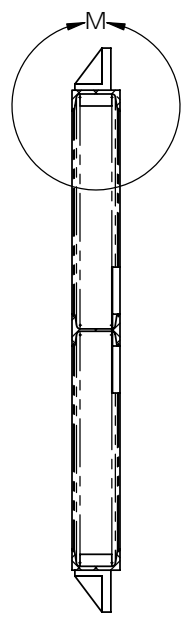
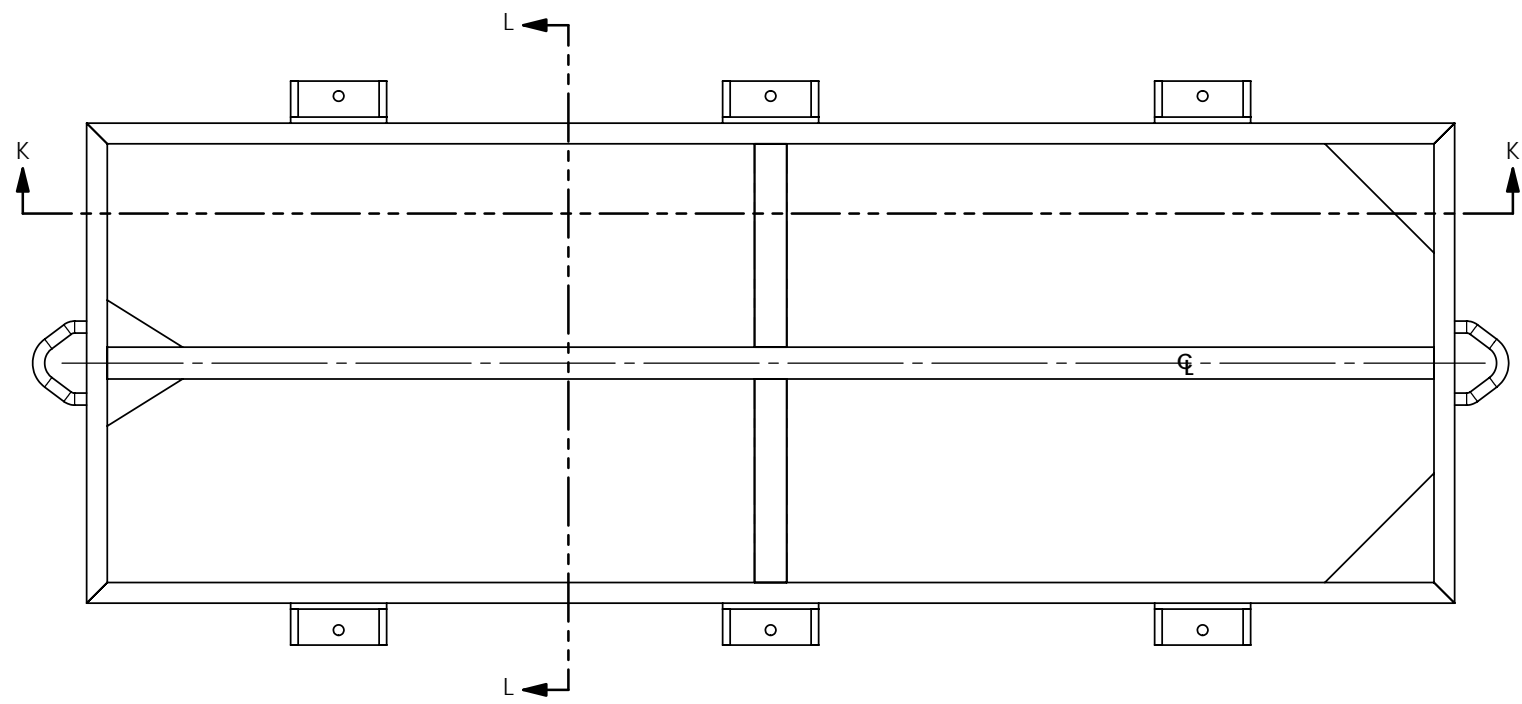


<p>THIRD-ANGLE PROJECTION</p>	<p>This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.</p>			<p><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
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<p>DES V GRAVES 12/10/2005</p> <p>DRW T OQUIN 12/10/2005</p> <p>CHK</p> <p>ENG V GRAVES 12/10/2005</p> <p>QA</p>			<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>BASE WELDMENT</b></p>		
<p>DRAWING APPROVALS</p>			<p>DATE</p>	<p>CAD FILE BASE WELDMENT HJT</p>	<p>PREV ASSY 203-HJT-0100</p>
<p>SIZE DWG NO.</p>			<p>SCALE 1:10</p>	<p>SHEET 3 of 4</p>	<p>REV 0</p>
<p>DATE</p>			<p>203-HJT-0110</p>		<p>REV 0</p>

DWG NO. 203-HJT-0110



DETAIL M  
SCALE 1 : 4



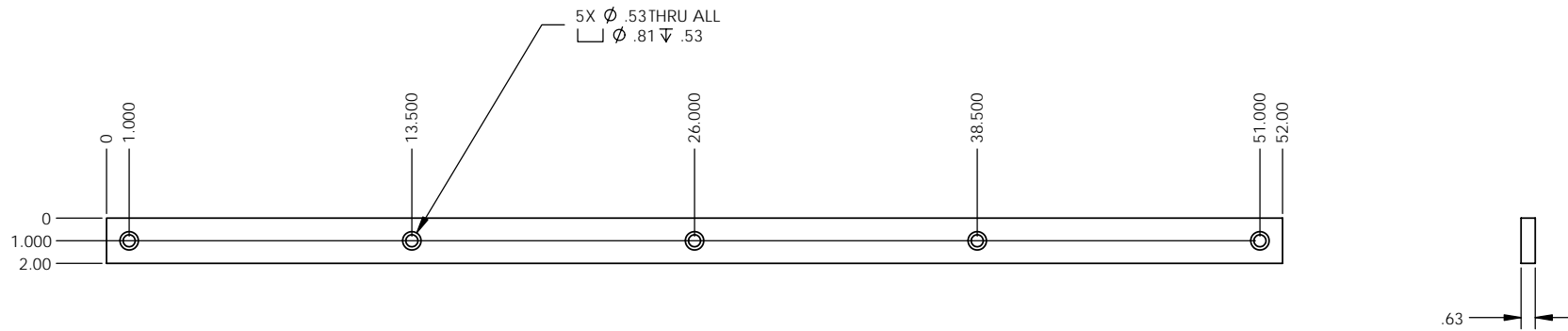
SECTION L-L

<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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>				
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DES V GRAVES 12/10/2005 DRW T OQUIN 12/10/2005 CHK ENG V GRAVES 12/10/2005 QA		<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>BASE WELDMENT</b></p>		CAD FILE BASE WELDMENT HJT	PREV ASSY 203-HJT-0100	SCALE 1:8	SHEET 4 of 4
DRAWING APPROVALS DATE		SIZE DWG NO. C 203-HJT-0110		REV 0			



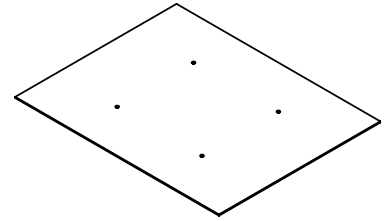
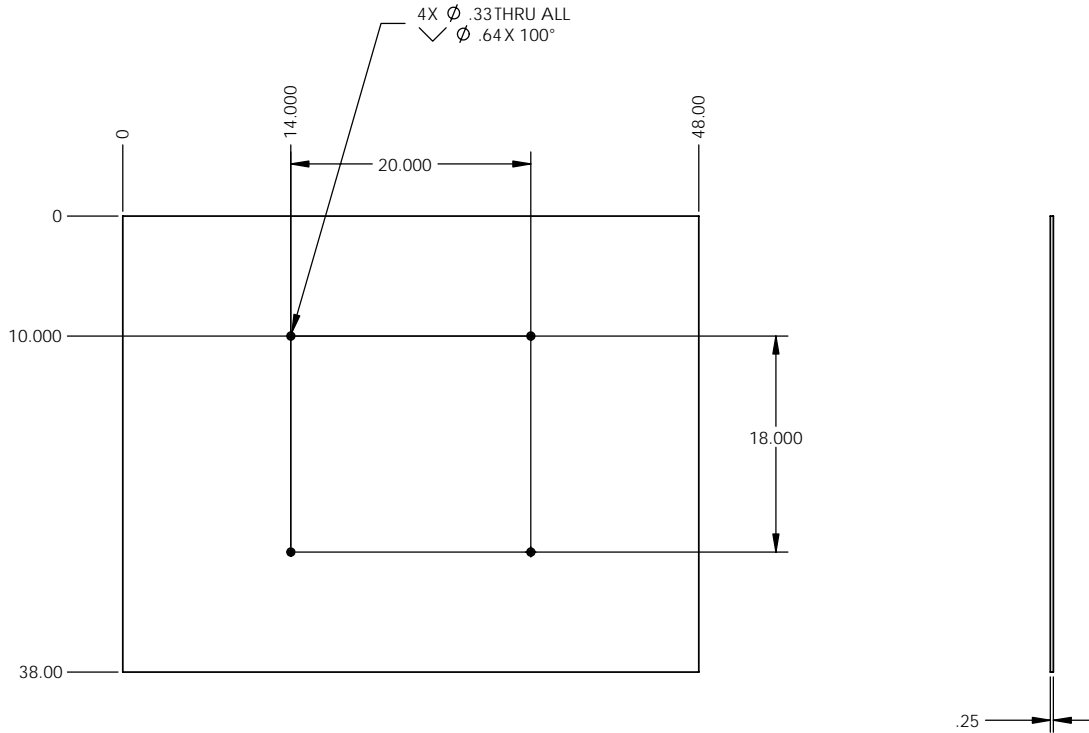
NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



MATERIAL: SS - 304L

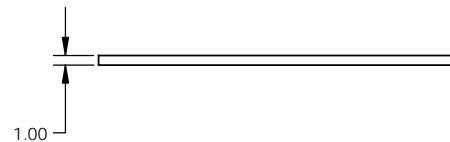
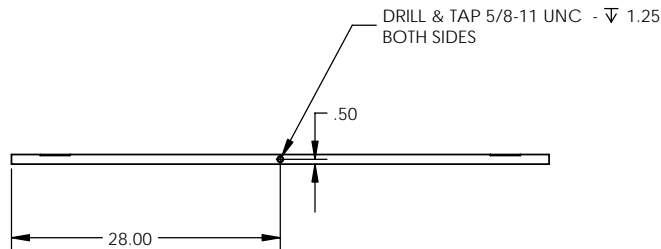
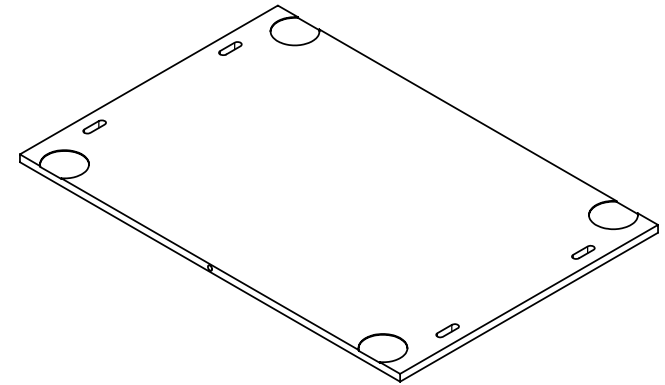
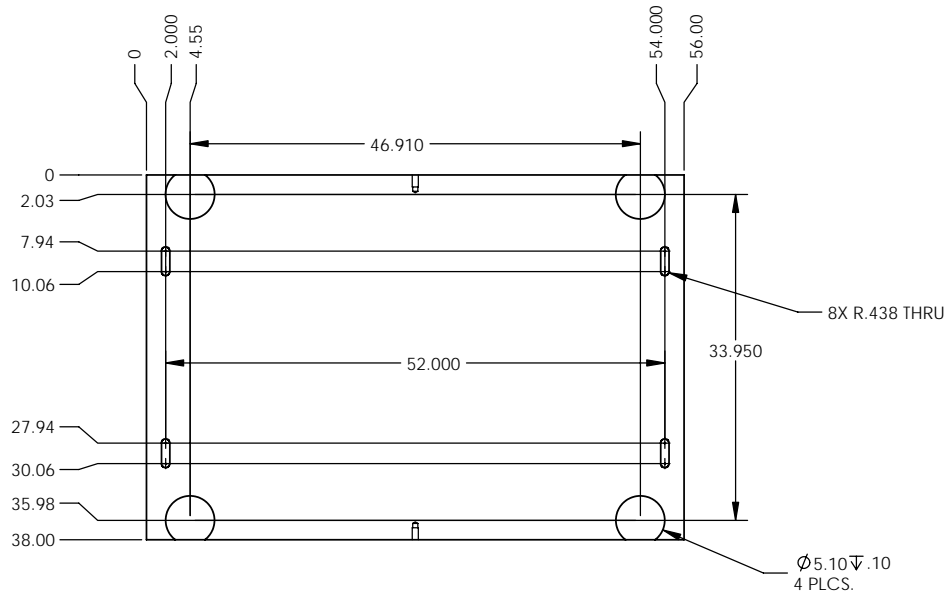
<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned upon request.			<p><b>OAK RIDGE NATIONAL LABORATORY</b>                  operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>	
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DES V GRAVES 12/10/2005 DRW T OQUIN 12/10/2005 CHK ENG V GRAVES 12/10/2005 QA			<p><b>MERIT EXPERIMENT</b>  <b>COMMON BASEPLATE ASSY</b>  <b>FLAT RAIL - COMMON BASEPLATE</b></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 0



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><b>OAK RIDGE NATIONAL LABORATORY</b>                  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		<p><b>MERIT EXPERIMENT</b>  <b>COMMON BASEPLATE ASSY</b>  <b>MAGNET UHMW SHEET</b></p>		
DRAWING APPROVALS DATE		CAD FILE UHMW SHEET HJT SIZE DWG NO. C	PREV ASSY 203-HJT-0100 SCALE 1:8	SHEET 1 of 1 REV 0
		203-HJT-0112		

NOTES  
1. MATERIAL CERTIFICATIONS REQUIRED



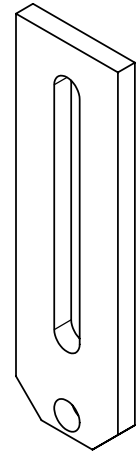
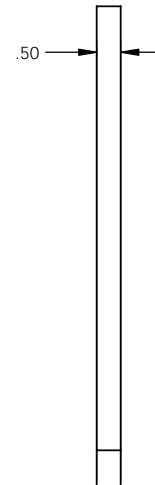
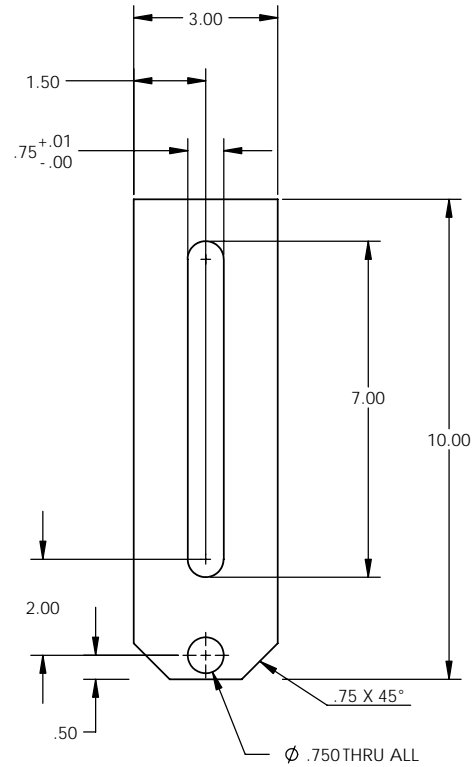
MATERIAL: AL - 6061 T651, ASTM B-209

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>MAGNET SUPPORT PLATE</b></p>		
DRAWING APPROVALS DATE			CAD FILE MAGNET SUPPORT PLATE HJT	PREV ASSY 203-HJT-0100	SCALE 1:10
SIZE DWG NO.			C	203-HJT-0113	SHEET 1 of 1 REV 0

DWG NO. 203-HJT-0113

NOTES

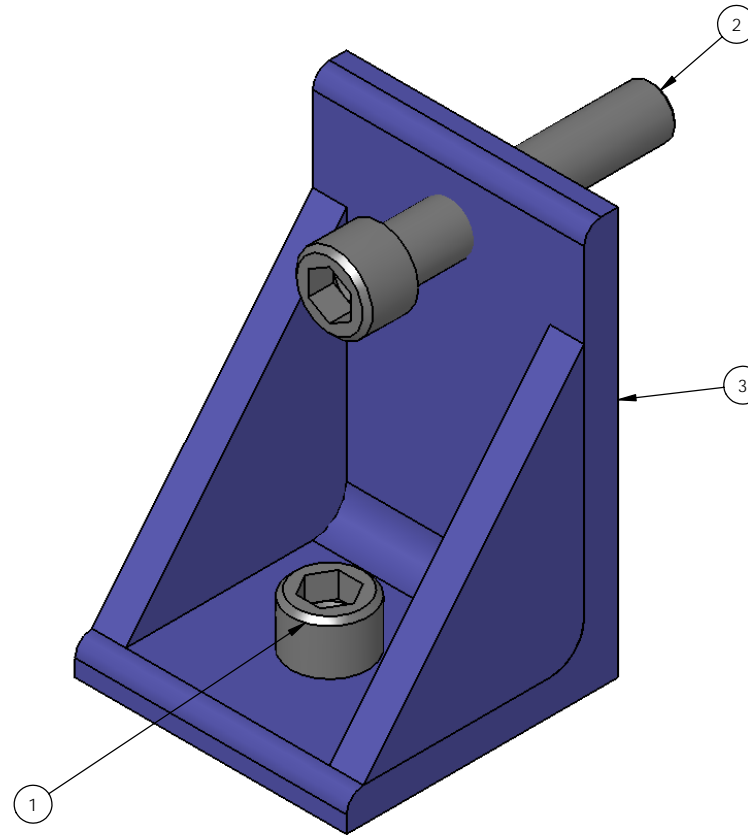
1. MATERIAL CERTIFICATIONS REQUIRED



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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>MAGNET RESTRAINT PLATE</b></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 0

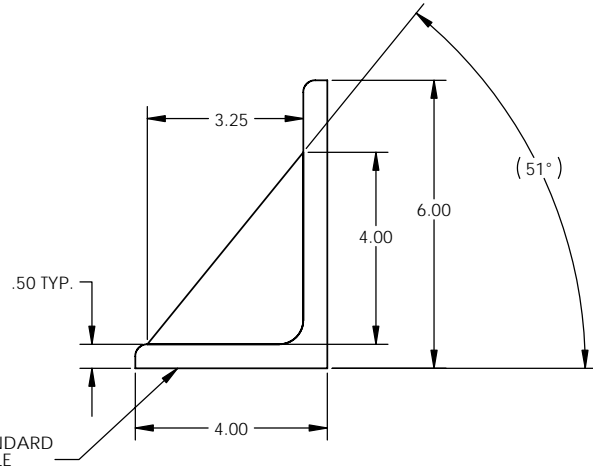
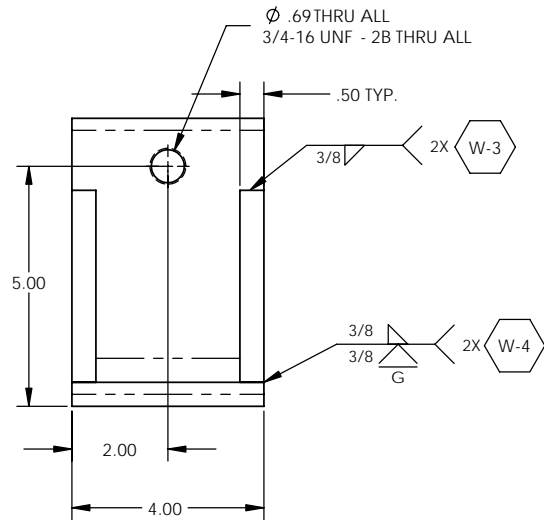
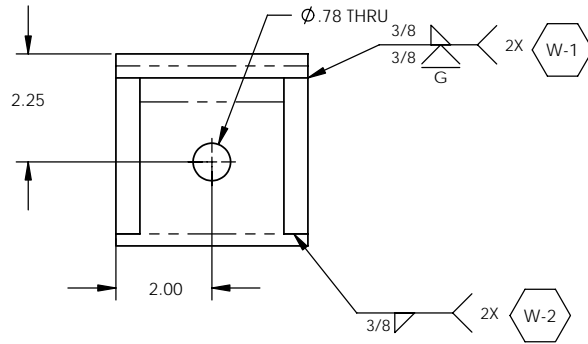
NOTES  
1. MATERIAL CERTIFICATIONS REQUIRED



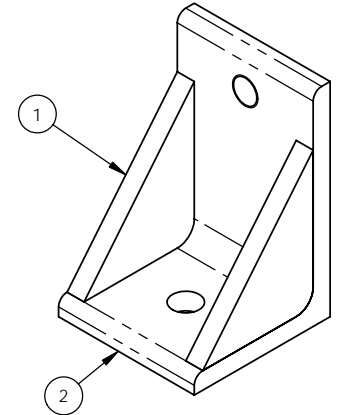
ITEM	QTY.	NAME	MATERIAL	DESCRIPTION	DWG
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2	1	HX-SHCS 0.75-16x4x4-N	SS - 18-8	SHCS - 3/4-16 x 4.00	N/A
1	1	HX-SHCS 0.75-16x1.5x1.5-N	SS - 18-8	SHCS - 3/4-16 x 1.50	N/A

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DES	V GRAVES	05/19/2005	<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>CART ANCHOR ASSY</b></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
DRAWING APPROVALS			DATE	SIZE	DWG NO.	REV
				C	203-HJT-0120	0

DWG NO. 203-HJT-0120



- NOTES
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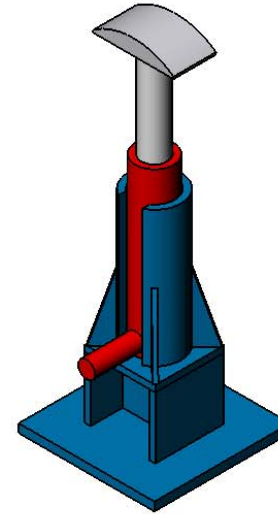
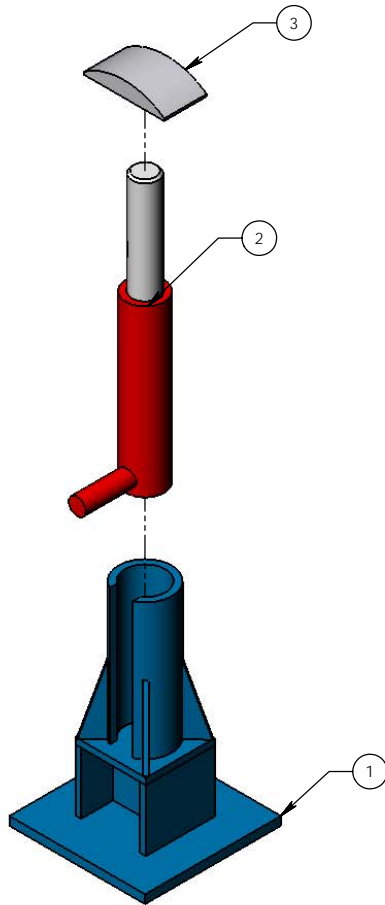
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
2	1	AM STD ANGLE - 6.00 x 4.00	AL - 6061 T6, ASTM B-308	4.00
1	2	PLATE, 3.25 x 4.00 x .50	AL - 6061 T6511, ASTM B-221	4.00

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DES	V GRAVES	05/19/2005	<p align="center"><b>MERIT EXPERIMENT CART ANCHOR ASSY CART JACKING WELDMENT</b></p>			
DRW	T OQUIN	05/19/2005				
CHK						
ENG	V GRAVES	05/19/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CART JACKING PLATE HJT	203 HJT 0120	1:2	1 of 1
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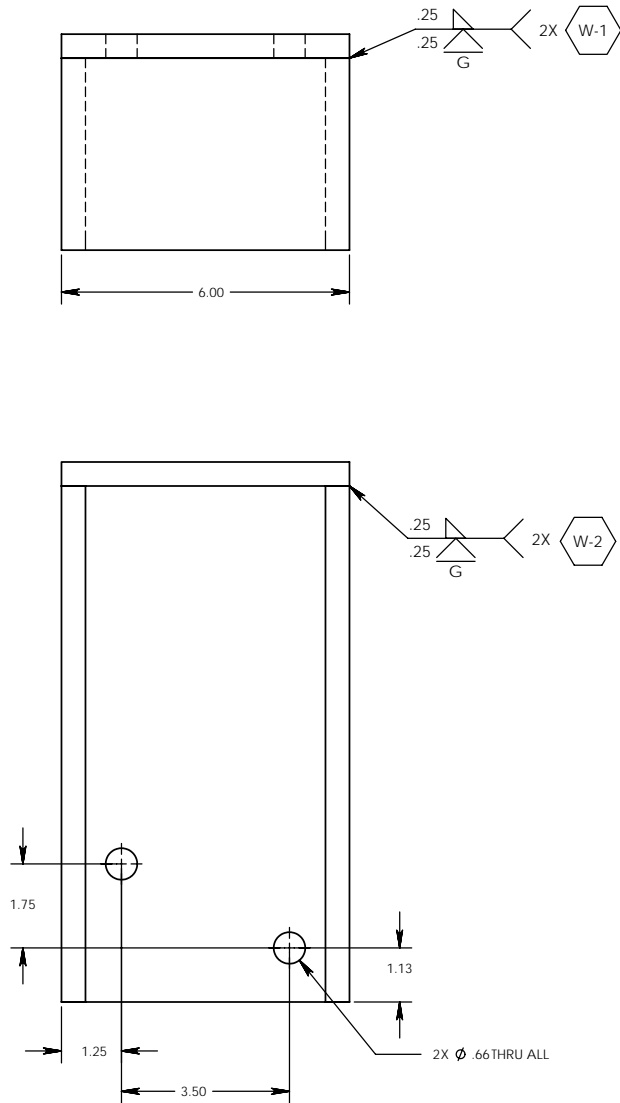
NOTES

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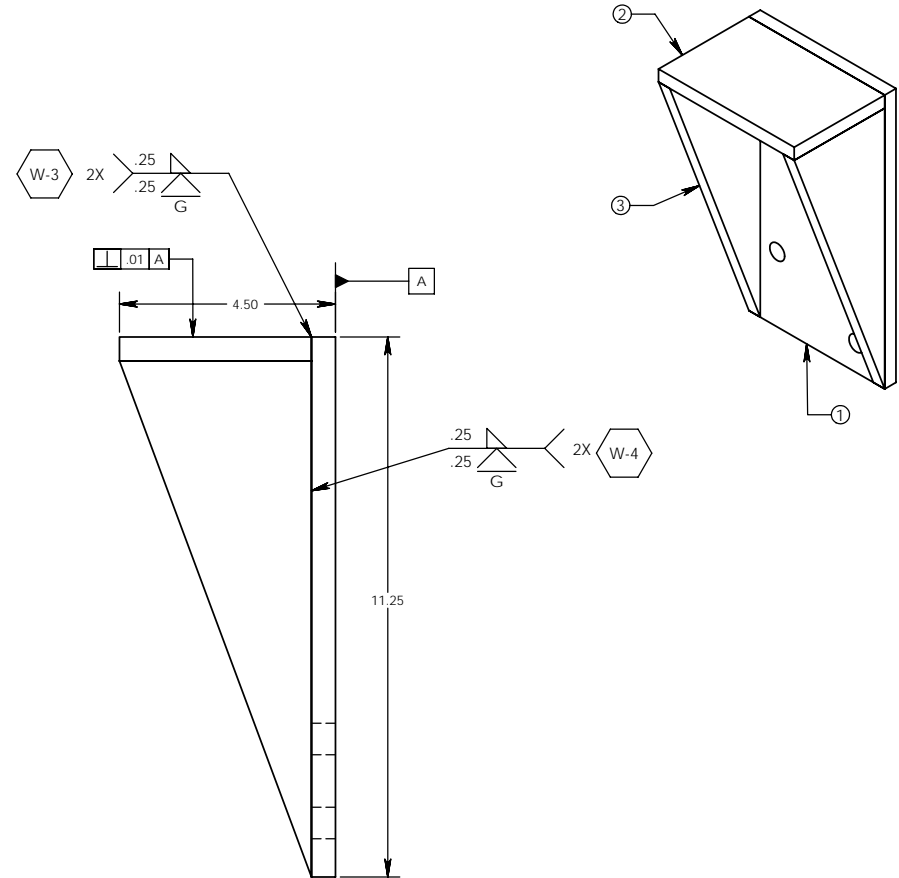
3	1	hyd jack rocker hjt	CRS - 1018	ROUND - 4.000" OD X 2.500	203-HJT-0133
2	1	hyd jack #2990T18 hjt		MCMMASTER-CARR #2990T18	N/A
1	1	hyd jack baseplate hjt	---	HYD JACK BASEPLATE WELDMENT	203-HJT-0132
ITEM	Default/QTY.	NAME	MATERIAL	DESCRIPTION	DWG

<p>THIRD-ANGLE PROJECTION</p>	<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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>FORMED ANGLES ±1°</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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>																				
<table border="1"> <tr> <td>DES</td> <td>T. OQUIN</td> <td>07/21/2005</td> </tr> <tr> <td>DRW</td> <td>T. OQUIN</td> <td>07/21/2005</td> </tr> <tr> <td>CHK</td> <td></td> <td></td> </tr> <tr> <td>ENG</td> <td>T. OQUIN</td> <td>07/21/2005</td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </table>	DES	T. OQUIN	07/21/2005	DRW	T. OQUIN	07/21/2005	CHK			ENG	T. OQUIN	07/21/2005	QA						<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>HYDRAULIC JACK ASSY</b></p>		<p>CAD FILE HYD JACK ASSY HJT</p>	<p>PREV ASSY 203-HJT-0100</p>	<p>SCALE 1:4</p>	<p>SHEET 1 of 1</p>
DES	T. OQUIN	07/21/2005																						
DRW	T. OQUIN	07/21/2005																						
CHK																								
ENG	T. OQUIN	07/21/2005																						
QA																								
<p>DRAWING APPROVALS      DATE</p>			<p>SIZE C</p>	<p>DWG NO. 203-HJT-0130</p>	<p>REV 0</p>																			

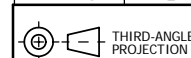


NOTES

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
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



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**NSTB** REMOTE SYSTEMS GROUP  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

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

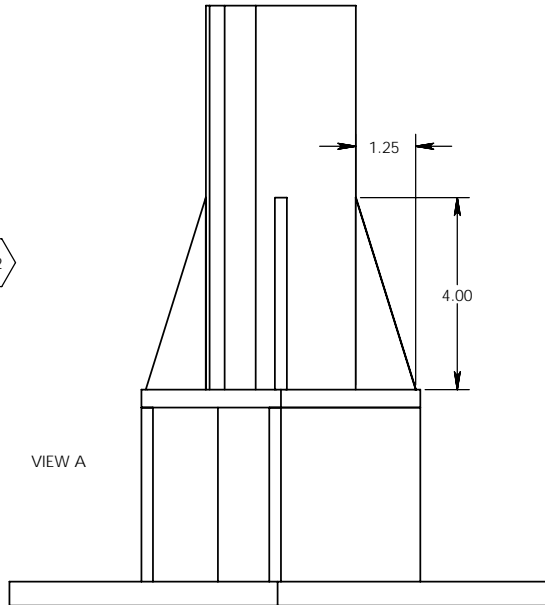
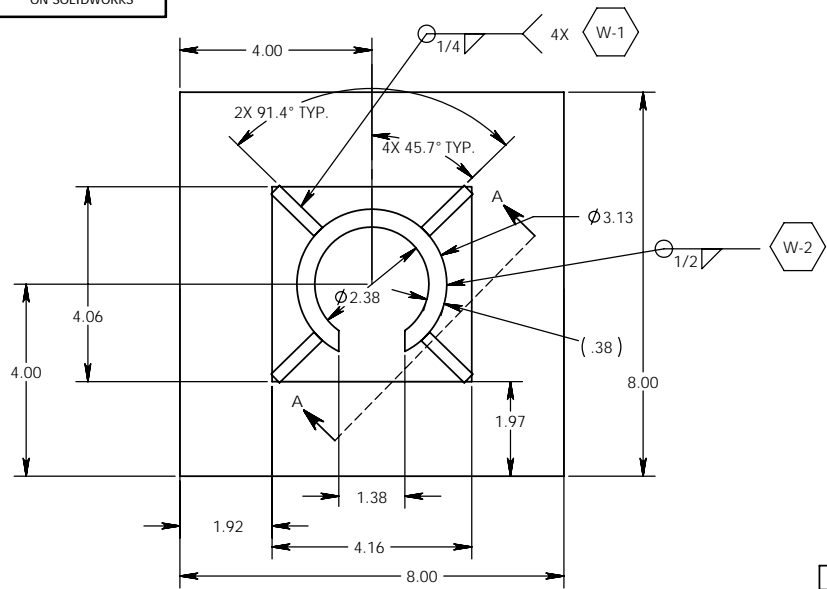
DES	T. OQUIN	07/20/2005
DRW	T. OQUIN	07/20/2005
CHK		
ENG	T. OQUIN	07/20/2005
QA		

**MERIT 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	0	

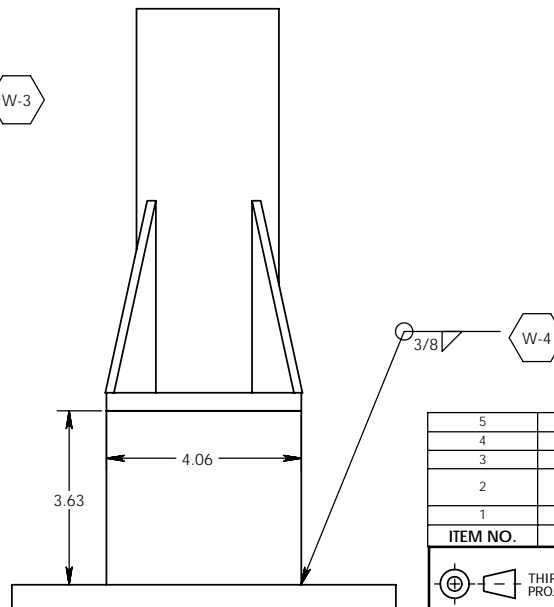
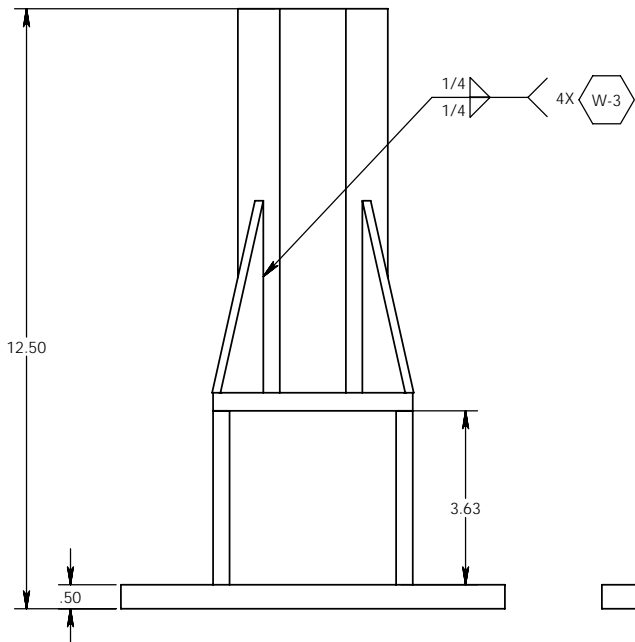
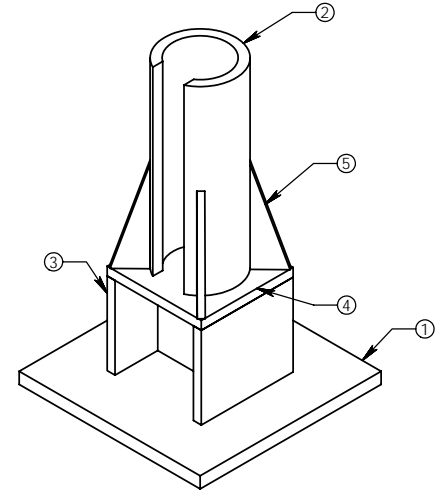


S THIS DRAWING PRODUCED ON SOLIDWORKS



NOTES

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

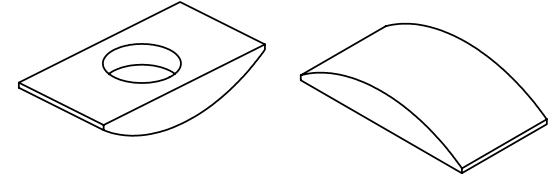
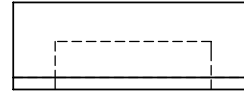
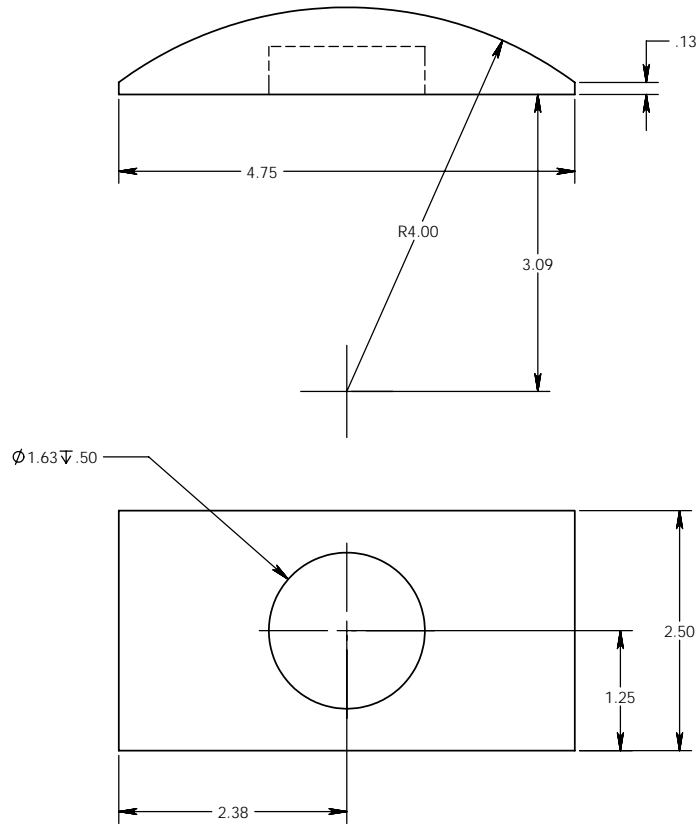


ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
5	4	PLATE, 1.25 x 4.00 x .25	CRS - 1018, ASTM A-108	4.00
4	1	PLATE, 4.06 x 4.16 x .38	CRS - 1018, ASTM A-108	4.16
3	1	W-4x13	STEEL"W" BEAM, ASTM A-992	3.63
2	1	TUBE, D.O.M. - 3.13 OD x .38 WALL	STEEL - 1020, D.O.M. WELDED TUBE, ASTM A-513 TYPE 5	8.00
1	1	PLATE, 8.00 x 8.00 x .50	CRS - 1018, ASTM A-108	8.00

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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>DES T. OQUIN 07/21/2005</p> <p>DRW T. OQUIN 07/21/2005</p> <p>CHK</p> <p>ENG T. OQUIN 07/21/2005</p> <p>QA</p>		<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
		<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>HYD JACK BASEPLATE WELDMENT</b></p>		<p>CAD FILE HYD JACK BASEPLATE HJT</p> <p>PREV ASSY 203-HJT-0100</p> <p>SCALE 1:2</p> <p>SHEET 1 of 1</p>	
DRAWING APPROVALS		DATE		<p>SIZE DWG NO. 203-HJT-0132</p> <p>REV 0</p>	

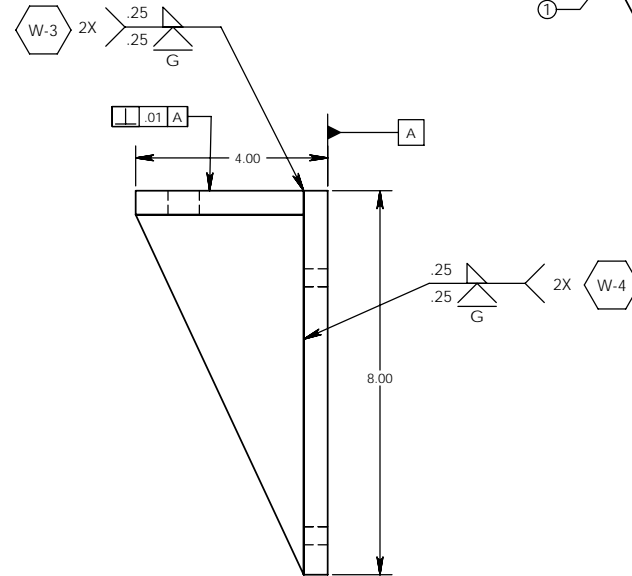
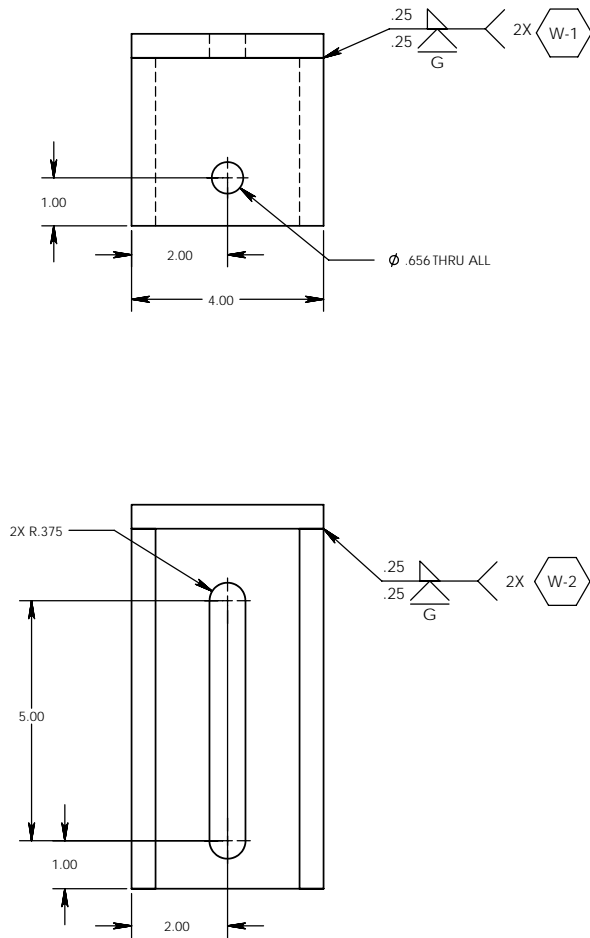
DWG NO. 203-HJT-0132

NOTES  
1. MATERIAL CERTIFICATIONS REQUIRED



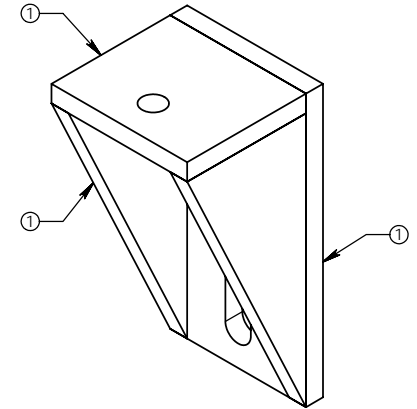
MATERIAL: CRS - 1018

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
DES V GRAVES 07/21/2005 DRW T OQUIN 07/21/2005 CHK ENG V GRAVES 07/21/2005 QA			<p><b>MERIT EXPERIMENT</b> <b>COMMON BASEPLATE ASSY</b> <b>HYD JACK ROCKER</b></p>		
DRAWING APPROVALS DATE			CAD FILE HYD JACK ROCKER HJT	PREV ASSY 203-HJT-0100	SCALE 1:1
SIZE DWG NO.			C	203-HJT-0133	SHEET 1 of 1 REV 0

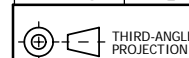


NOTES

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ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
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



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**OAK RIDGE NATIONAL LABORATORY**  
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**REMOTE SYSTEMS GROUP**  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

UNLESS OTHERWISE NOTED

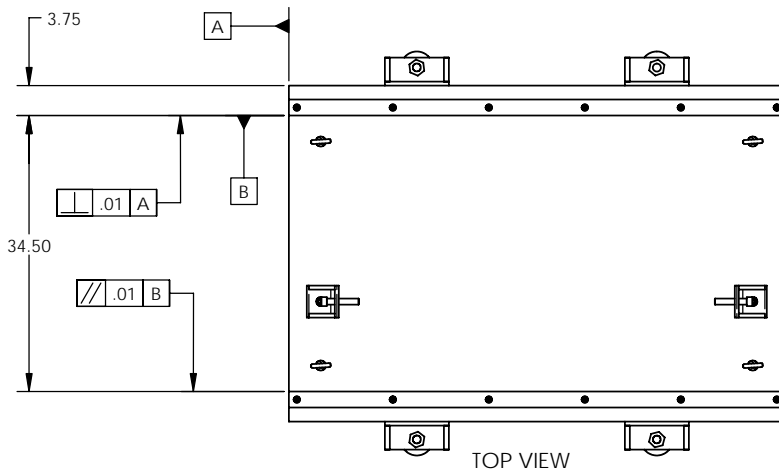
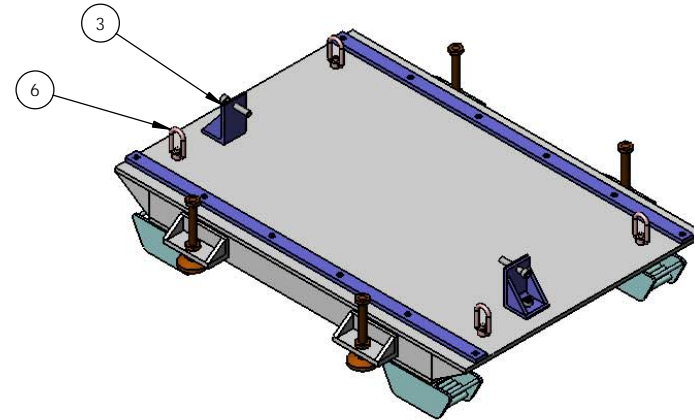
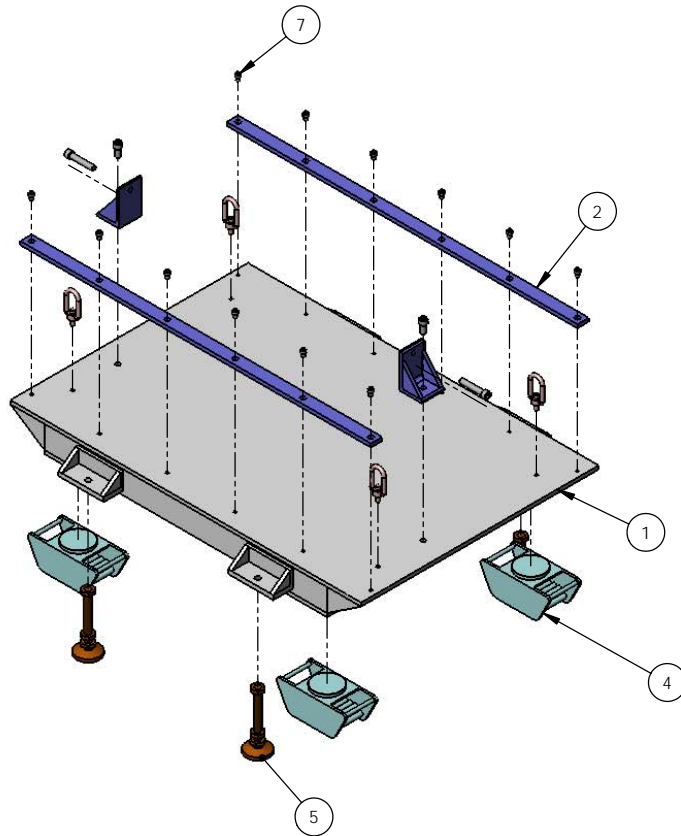
1. ALL DIMENSIONS ARE IN INCHES
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
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4. CONCENTRICITY .010 TIR
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DES	T. OQUIN	07/20/2005
DRW	T. OQUIN	07/20/2005
CHK		
ENG	T. OQUIN	07/20/2005
QA		

MERIT EXPERIMENT COMMON BASEPLATE ASSY ANCHOR PLATE 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-0134		0

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

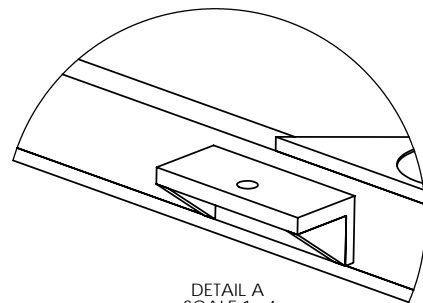
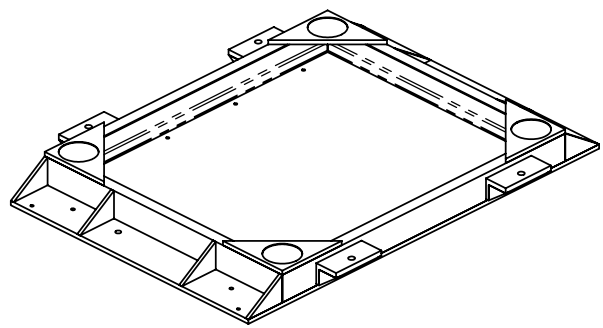
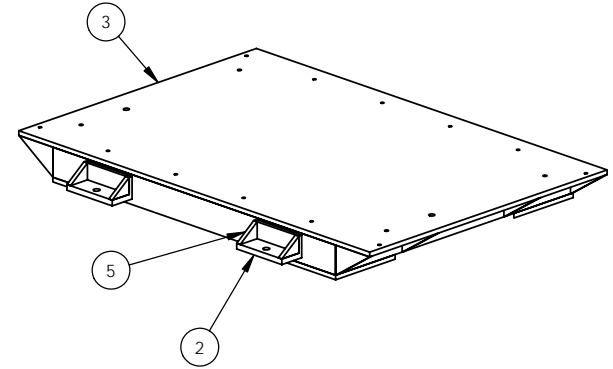
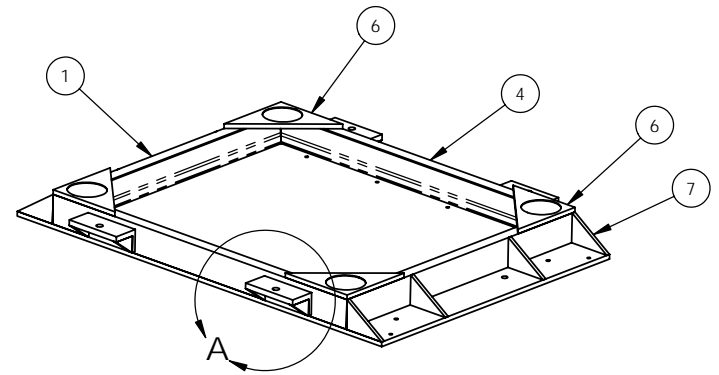


ITEM	with Hilmans/QTY.	NAME	MATERIAL	DESCRIPTION	DWG
7	12	HX-SHCS 0.5-13x0.625x0.625-N	SS - 18-8	SHCS - 1/2-13 x .63	N/A
6	4	swivel hoist ring hjt	ALLOY STEEL - MACHINED	McMASTER-CARR #3145123	N/A
5	4	leveling foot hjt	SS - 303	S & W MFG. CO., Bensenville, IL, Phone 888-538-3548, #SSW-5G	N/A
4	1 kit	hilman hjt	---	HILMAN ROLLER #KRS-15-SLP	N/A
3	2	cart anchor assy hjt	---	CART ANCHOR ASSY	203-HJT-0120
2	2	flat rail hjt	SS - 304L	BAR - 2.00 X 62.00 X .63	203-HJT-0202
1	1	base weldment hjt	AL - 6061 T6	BASE WELDMENT	203-HJT-0201

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	<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>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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>																								
<table border="1"> <tr> <td>DES</td> <td>V GRAVES</td> <td>05/30/2005</td> </tr> <tr> <td>DRW</td> <td>T OQUIN</td> <td>05/30/2005</td> </tr> <tr> <td>CHK</td> <td></td> <td></td> </tr> <tr> <td>ENG</td> <td>V GRAVES</td> <td>05/30/2005</td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> </table>	DES	V GRAVES	05/30/2005	DRW	T OQUIN	05/30/2005	CHK			ENG	V GRAVES	05/30/2005	QA			<p><b>MERIT EXPERIMENT</b> <b>TARGET TRANSPORTER ASSY</b></p>			<table border="1"> <tr> <td>CAD FILE</td> <td>PREV ASSY</td> <td>SCALE</td> <td>SHEET</td> </tr> <tr> <td>TARGET TRANSPORTER ASSY HJT</td> <td>203-HJT-0001</td> <td>1:12</td> <td>1 of 1</td> </tr> </table>		CAD FILE	PREV ASSY	SCALE	SHEET	TARGET TRANSPORTER ASSY HJT	203-HJT-0001	1:12	1 of 1
DES	V GRAVES	05/30/2005																										
DRW	T OQUIN	05/30/2005																										
CHK																												
ENG	V GRAVES	05/30/2005																										
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CAD FILE	PREV ASSY	SCALE	SHEET																									
TARGET TRANSPORTER ASSY HJT	203-HJT-0001	1:12	1 of 1																									
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV																							
			C	203-HJT-0200	0																							

NOTES

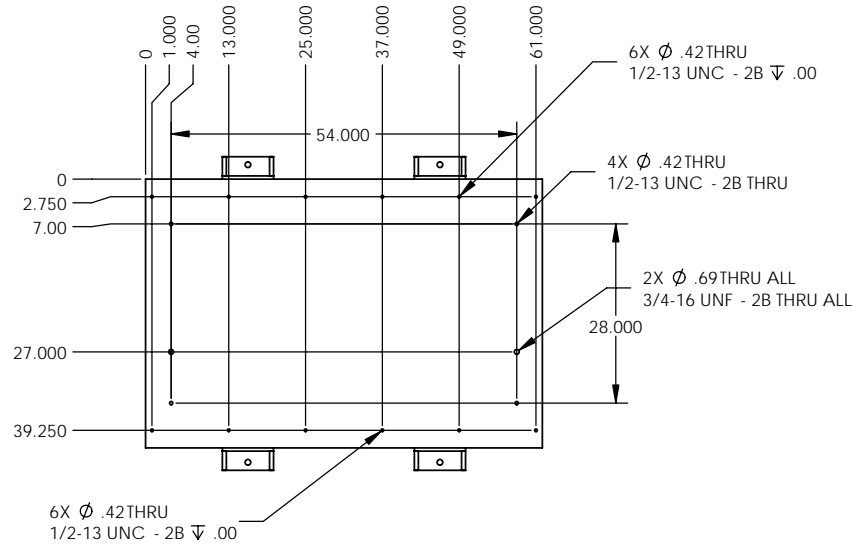
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
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DETAIL A  
SCALE 1 : 4

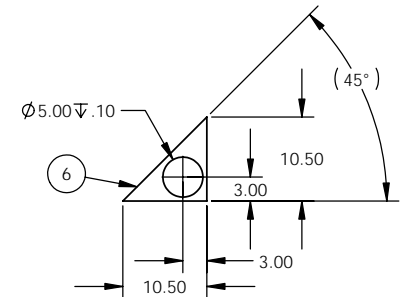
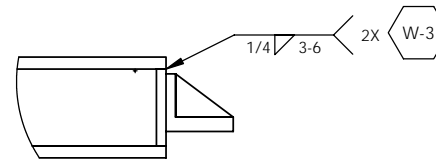
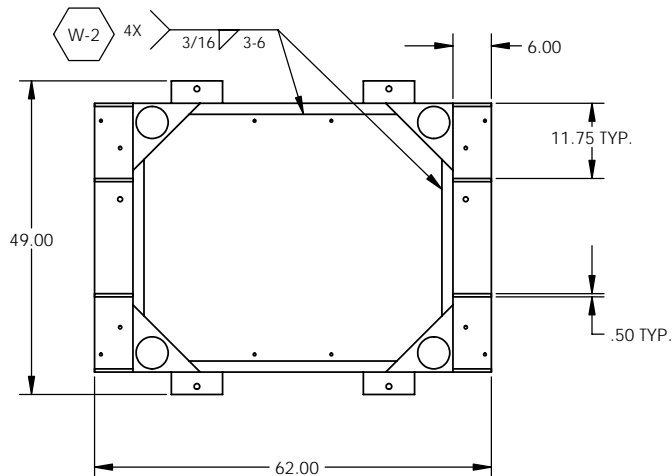
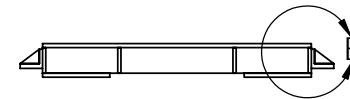
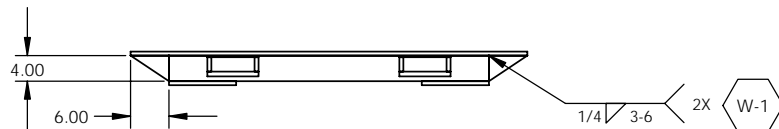
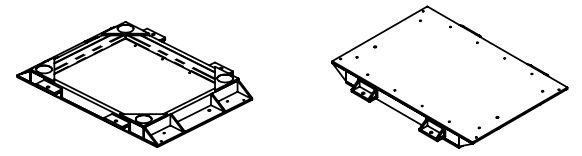
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
7	8	PLATE, 4.00 x 6.00 x .50	AL - 6061 T6511, ASTM B-221	---
6	4	PLATE, 10.50 x 10.50 x .63	AL - 6061 T651, ASTM B-209	---
5	8	PLATE - 2.50 X 3.00 X .63	AL - 6061 T6511, ASTM B-221	---
4	2	AMER STD "C", 4.00 X 1.72 X .32	AL - 6061 T6, ASTM B-308	50
3	1	PLATE, 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><b>OAK RIDGE NATIONAL LABORATORY</b> operated for the U.S. Department of Energy under contract DE-AC05-00OR22725 Oak Ridge, TN</p>				
	<p>DES V GRAVES 12/10/2005</p> <p>DRW T OQUIN 12/10/2005</p> <p>CHK</p> <p>ENG V GRAVES 12/10/2005</p> <p>QA</p>	<p><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>TARGET TRANSPORTER ASSY</b> <b>TRANSPORTER BASE WELDMENT</b></p>		<p>CAD FILE</p> <p>BASE WELDMENT HJT</p> <p>SIZE C</p>	<p>PREV ASSY</p> <p>203-HJT-0200</p> <p>DWG NO.</p> <p>203-HJT-0201</p>	<p>SCALE</p> <p>1:12</p>	<p>SHEET</p> <p>1 of 3</p>
<p>DRAWING APPROVALS</p>		<p>DATE</p>		<p>REV</p> <p>0</p>		<p>SCALE</p> <p>1:12</p>		<p>SHEET</p> <p>1 of 3</p>	



NOTES

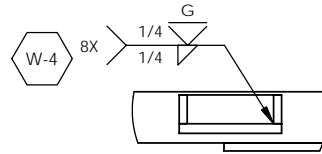
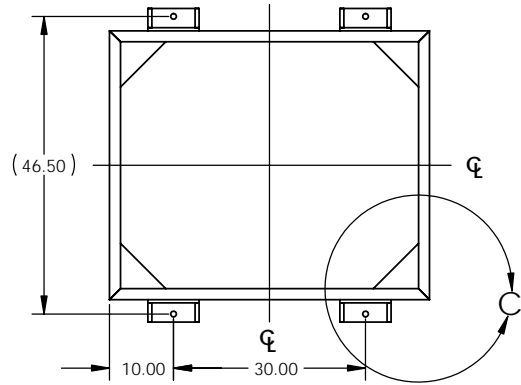
1. WELDING & INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH AWS D.1.2
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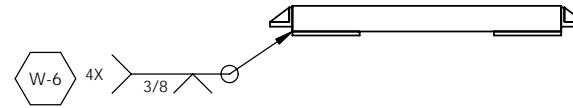
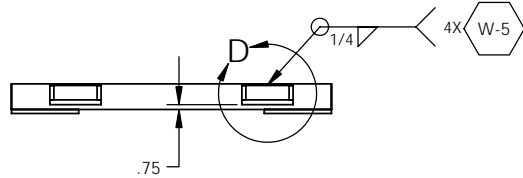
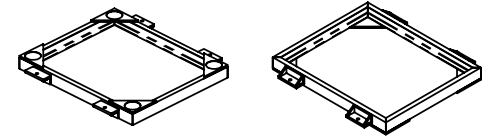
<p>THIRD-ANGLE PROJECTION</p>	This drawing was prepared by ORNL solely for use in work performed under Department of Energy contract number DE-AC05-00OR22725 and applicable Work for Others Agreements and Cooperative Research and Development Agreements. This drawing is property of ORNL and must be returned 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 12/10/2005 DRW T OQUIN 12/10/2005 CHK ENG V GRAVES 12/10/2005 QA	MERIT 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 0	

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

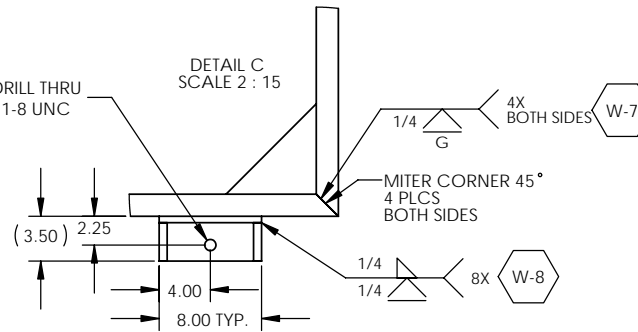


DETAIL D  
SCALE 2 : 15

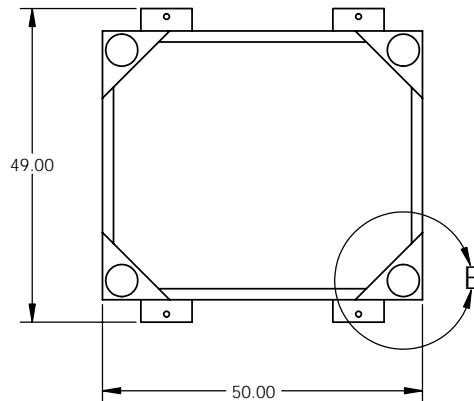


4X DRILL THRU  
TAP 1-8 UNC

DETAIL C  
SCALE 2 : 15



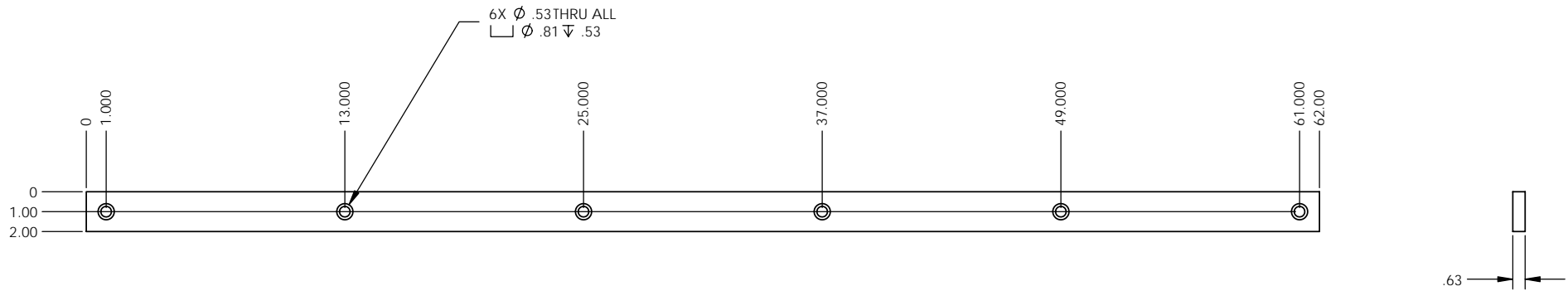
DETAIL E  
SCALE 2 : 15



<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		
DES	V GRAVES	12/10/2005	<p><b>MERIT EXPERIMENT</b> <b>TARGET TRANSPORTER ASSY</b> <b>REMOTE SYSTEMS BASEPLATE WELDMENT</b></p>			
DRW	T OQUIN	12/10/2005				
CHK						
ENG	V GRAVES	12/10/2005				
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	0

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED

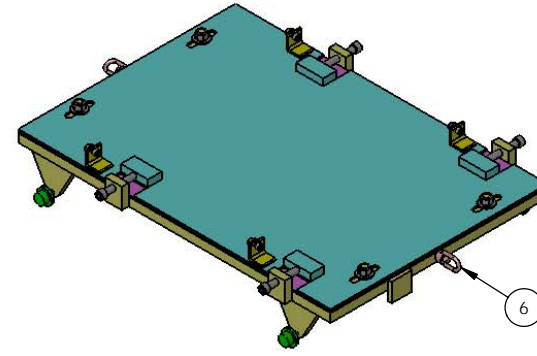
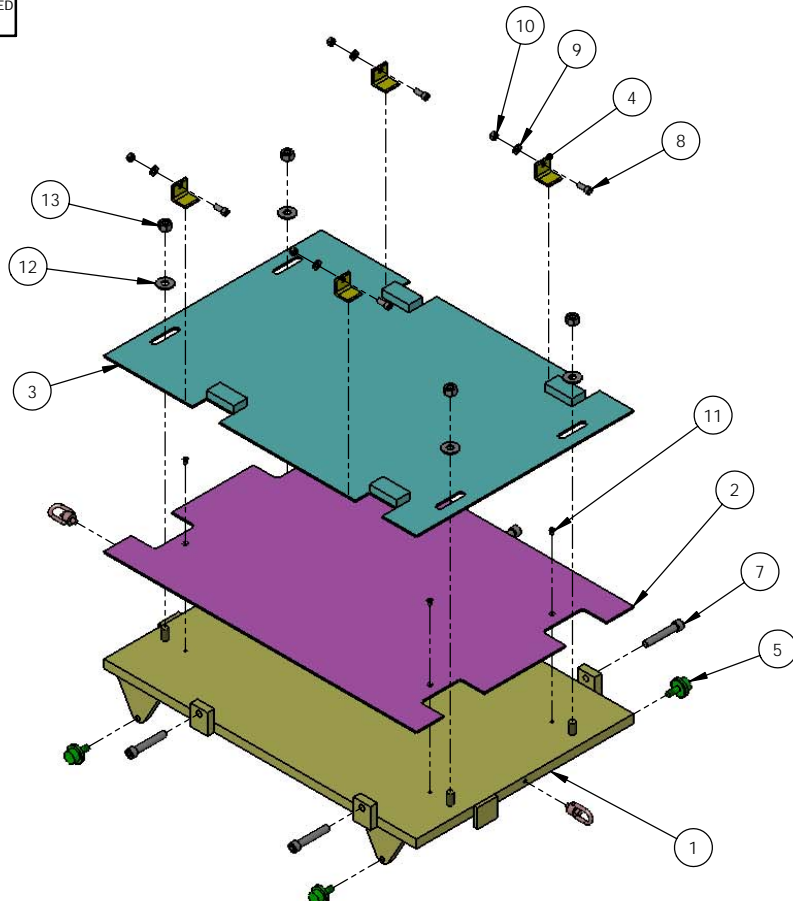


MATERIAL: SS - 304L

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DES DRW CHK ENG QA	V GRAVES T OQUIN V GRAVES V GRAVES	12/10/2005 12/10/2005 12/10/2005 12/10/2005	<p align="center"><b>MERIT EXPERIMENT                  TARGET TRANSPORTER ASSY                  FLAT RAIL - TRANSPORTER ASSY</b></p>	
DRAWING APPROVALS DATE		CAD FILE FLAT RAIL HJT SIZE C	PREV ASSY 203-HJT-0200 DWG NO. 203-HJT-0202	SCALE 1:4 SHEET 1 of 1 REV 0

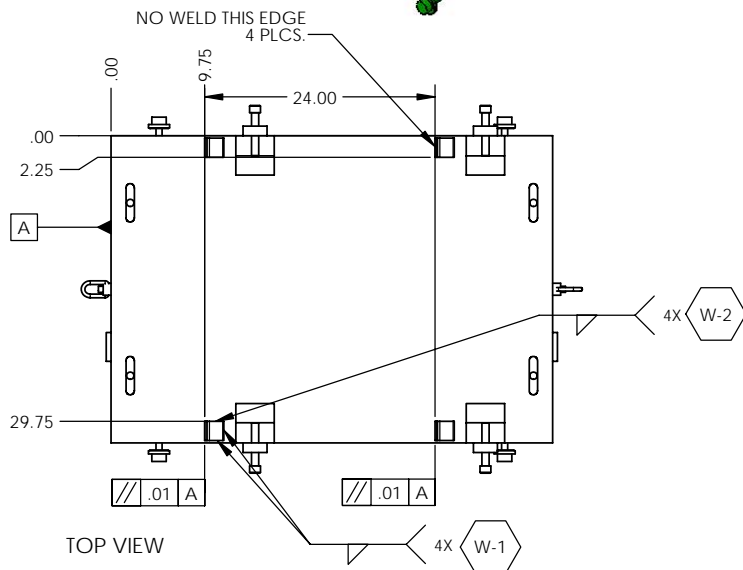
DWG NO. 203-HJT-0202





NOTES

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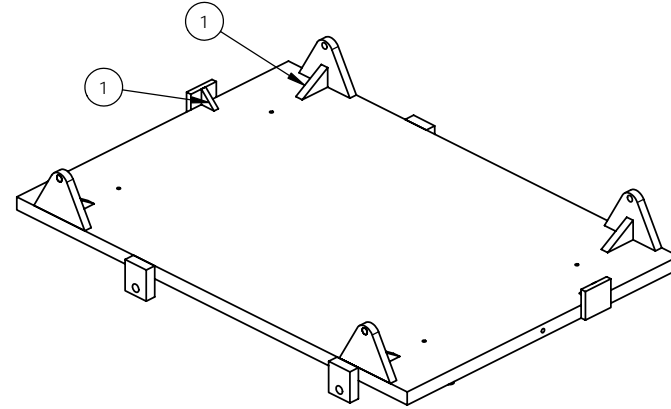
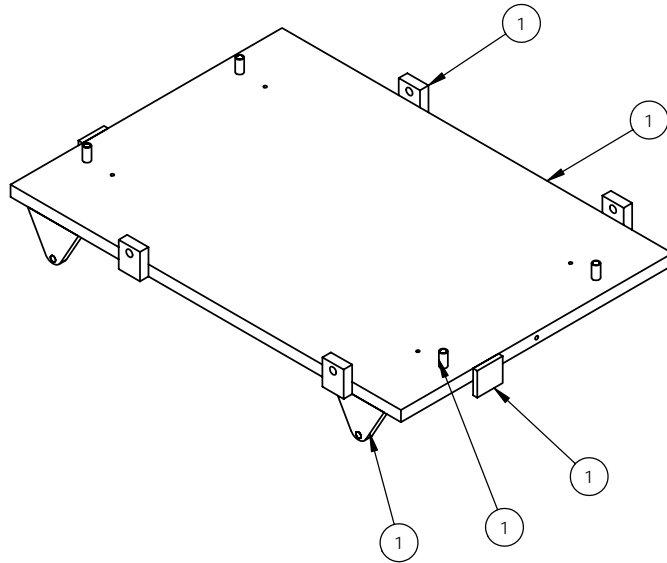


13	4	HHNUT 0.7500-10-D-N	SS - 18-8	HEX NUT - 3/4-10 UNC	N/A
12	4	FW 0.75	SS - 18-8	FLAT WASHER - 3/4"	N/A
11	4	CSBOLT 0.3125-18x0.625x0.625-S-N	SS - 18-8	FHMS - 5/16-18 UNC x 5/8	N/A
10	4	HNUT 0.5000-13-D-N	SS - 18-8	HEX NUT - 1/2-13 UNC	N/A
9	4	FW 0.5	SS - 18-8	FLAT WASHER - 1/2" NARROW	N/A
8	4	HX-SHCS 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	slick sheet hjt	UHMW	MCMMASTER CARR #8752K813	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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>																	
<table border="1"> <thead> <tr> <th>DES</th> <th>V GRAVES</th> <th>06/03/2005</th> </tr> </thead> <tbody> <tr> <td>DRW</td> <td>T OQUIN</td> <td>06/03/2005</td> </tr> <tr> <td>CHK</td> <td></td> <td></td> </tr> <tr> <td>ENG</td> <td>V GRAVES</td> <td>06/03/2005</td> </tr> <tr> <td>QA</td> <td></td> <td></td> </tr> </tbody> </table>	DES	V GRAVES	06/03/2005	DRW	T OQUIN	06/03/2005	CHK			ENG	V GRAVES	06/03/2005	QA			<p><b>MERIT EXPERIMENT TARGET CART ASSY</b></p>		<p>CAD FILE CART ASSY HJT</p>	<p>PREV ASSY 203-HJT-0001</p>	<p>SCALE 1:10</p>	<p>SHEET 1 of 1</p>
DES	V GRAVES	06/03/2005																			
DRW	T OQUIN	06/03/2005																			
CHK																					
ENG	V GRAVES	06/03/2005																			
QA																					
DRAWING APPROVALS		DATE	SIZE C	DWG NO. 203-HJT-0300	REV 0																

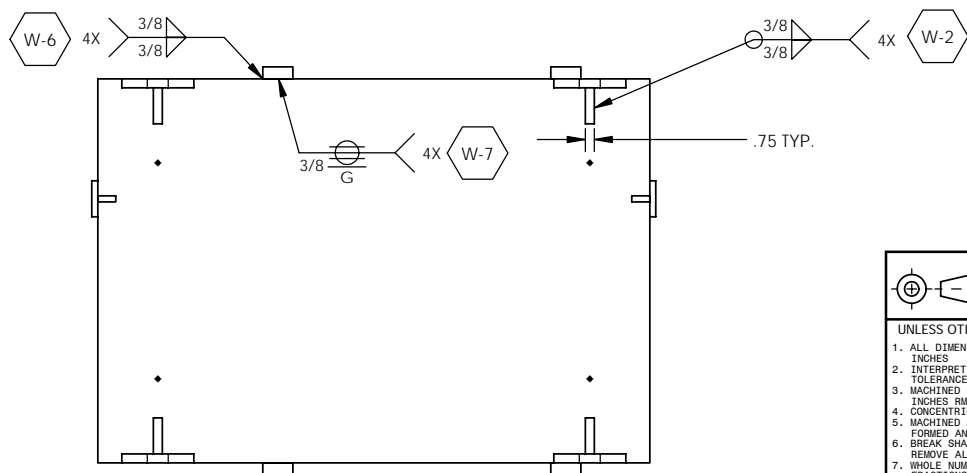
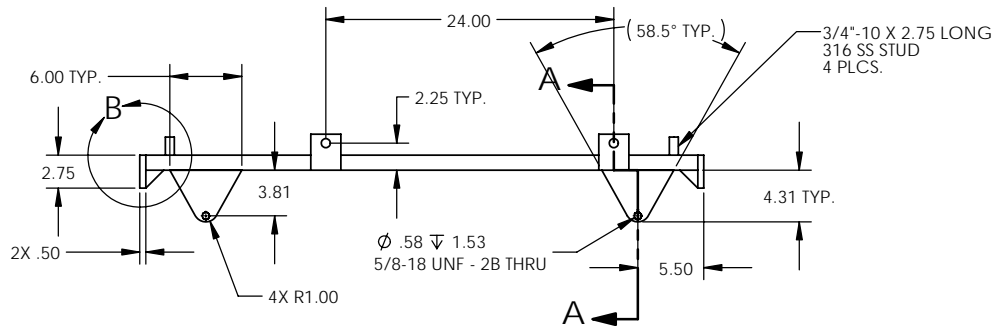
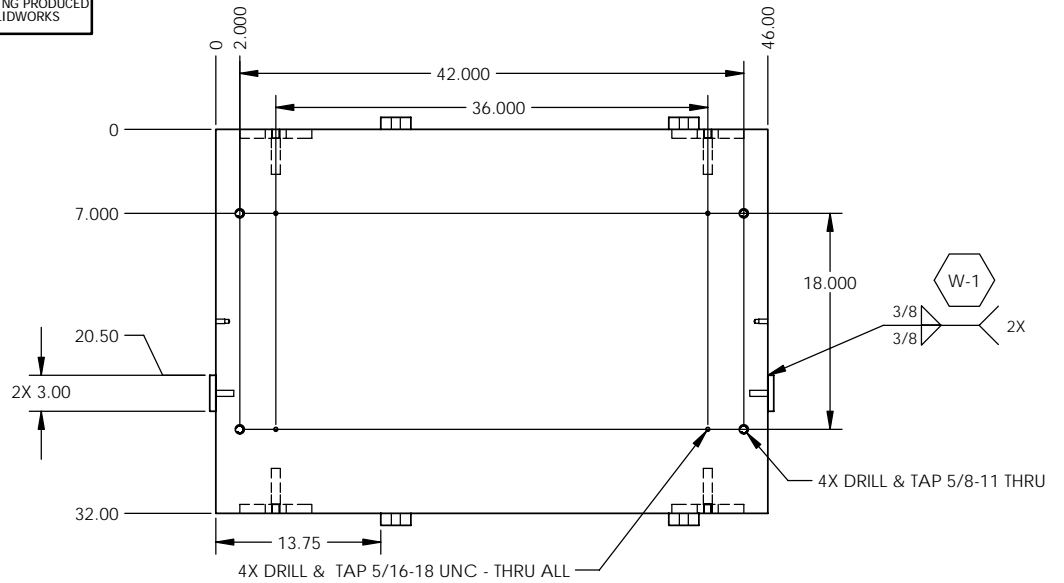
NOTES

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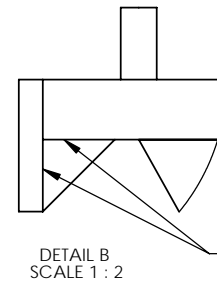
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH
7	4	PLATE, 2.50" x 3.00" x 1.00"	AL - 6061 T6511, ASTM B-221	3.00"
6	4	STUD, 3/4-10 UNC	SS - 8-18 ALL-THREAD	2.75"
5	1	PLATE, 32.00" x 46.00" x 1.25"	AL - 6061-T6511, ASTM B-209	46.00"
4	2	PLATE, 1.5" x 1.5" x .50"	AL - 6061 T6511, ASTM B-221	---
3	2	PLATE, 2.75" 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, 4.31" 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 ±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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>		<p><b>MERIT EXPERIMENT</b> <b>TARGET CART ASSY</b> <b>CART LOWER PLATE WELDMENT</b></p>	
<p>DRAWING APPROVALS</p> <p>DATE</p>		<p>CAD FILE CART LOWER PLATE HJT</p> <p>PREV ASSY 203-HJT-0300</p> <p>SCALE 1:8</p> <p>SHEET 1 of 2</p>		<p>SIZE C</p> <p>DWG NO. 203-HJT-0301</p> <p>REV 0</p>		

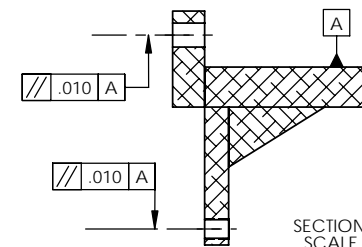
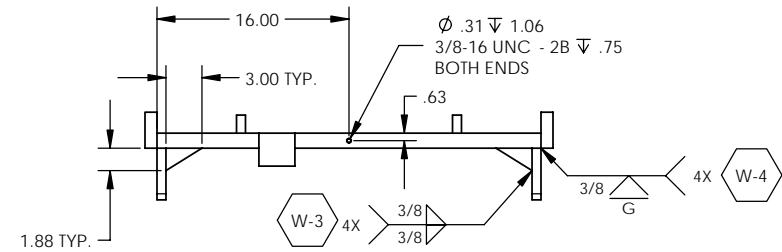
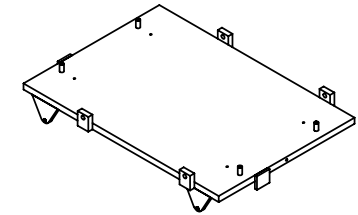


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DETAIL B  
SCALE 1 : 2

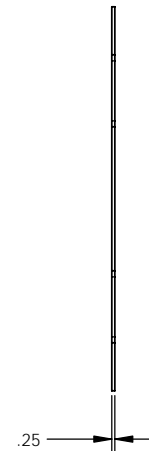
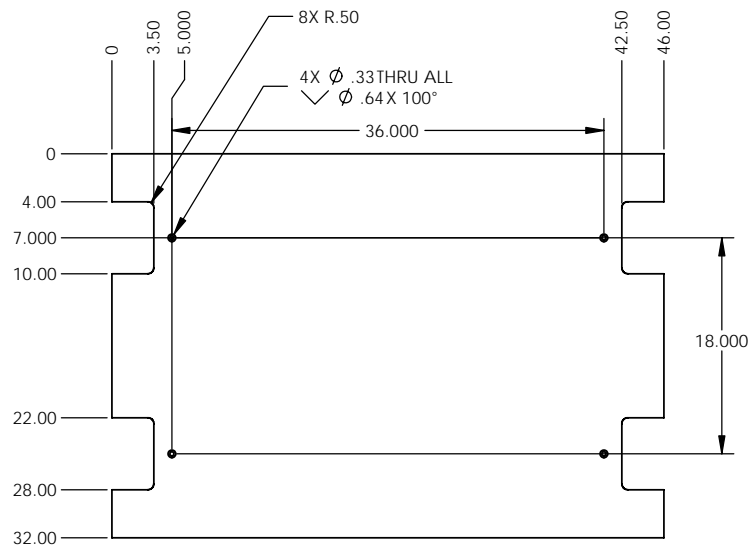
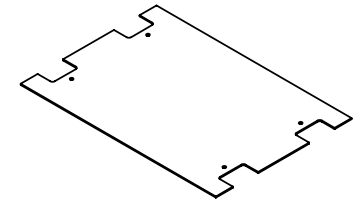


SECTION A-A  
SCALE 1 : 3

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DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005		<p><b>MERIT EXPERIMENT TARGET CART ASSY CART LOWER PLATE WELDMENT</b></p>		CAD FILE CART LOWER PLATE HJT	PREV ASSY 203-HJT-0300
DRAWING APPROVALS DATE		SIZE DWG NO. C	SCALE 1:8		SHEET 2 of 2
		203-HJT-0301		REV 0	

NOTES

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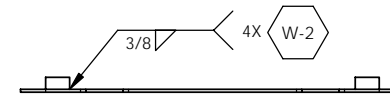
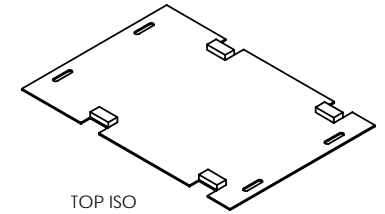
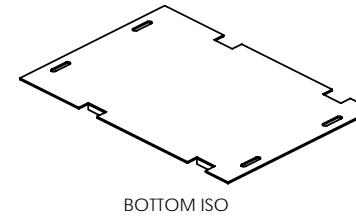
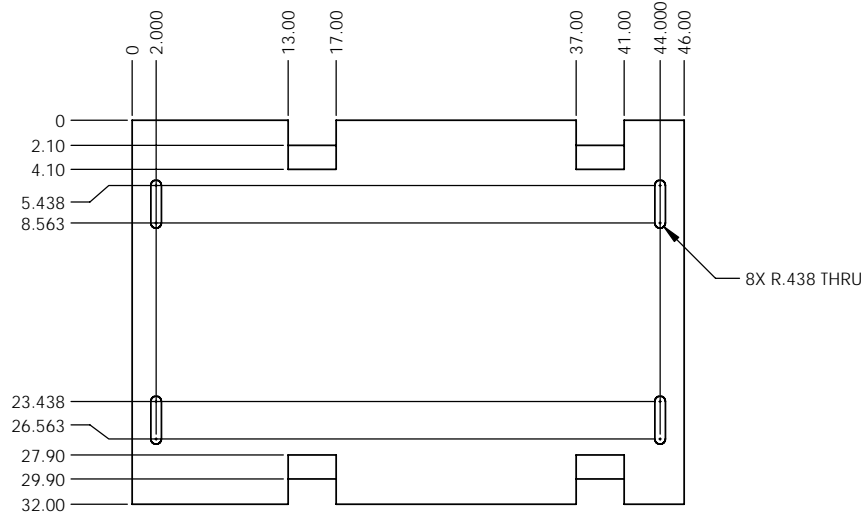


MATERIAL: UHMW

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<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><b>MERIT EXPERIMENT</b> <b>TARGET CART ASSY</b> <b>CART UHMW SHEET</b></p>		<p>CAD FILE UHMW SHEET HJT</p>
<p>DRAWING APPROVALS</p>		<p>DATE</p>	<p>SIZE DWG NO. C</p>	<p>PREV ASSY 203-HJT-0300</p> <p>SCALE 1:8</p> <p>SHEET 1 of 1</p>
<p>DRAWING APPROVALS</p>			<p>DATE</p>	<p>REV 0</p>

NOTES

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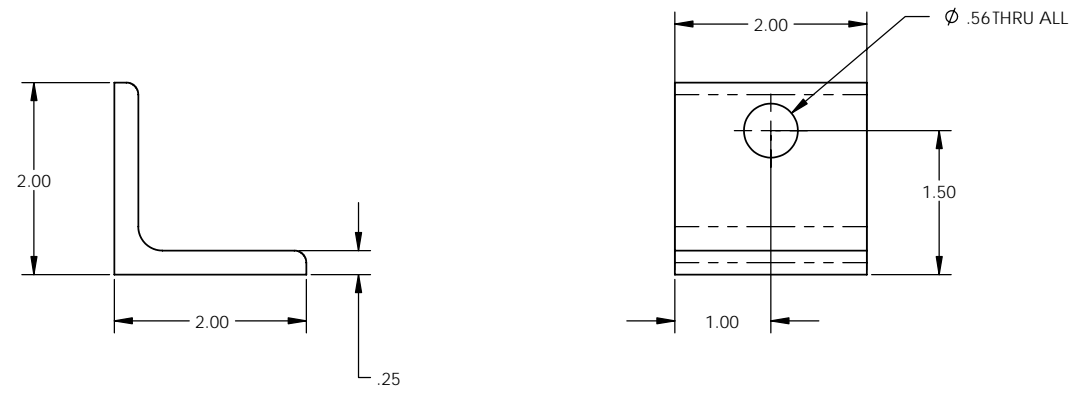
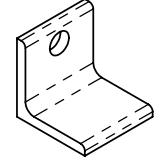


2	4	BLOCK	AL - 6061 T6	
1	1	PLATE, 32.00 x 46.00 x .25	AL - 6061-T651, ASTM B-209	46.00
ITEM NO.	QTY.	DESCRIPTION	MATERIAL	LENGTH

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DES	V GRAVES	06/03/2005	<p align="center"><b>MERIT EXPERIMENT TARGET CART ASSY UPPER PLATE WELDMENT</b></p>			
DRW	T OQUIN	06/03/2005				
CHK						
ENG	V GRAVES	06/03/2005				
QA			CAD FILE	PREV ASSY	SCALE	SHEET
			CART UPPER PLATE HJT	203-HJT-0300	1:8	1 of 1
DRAWING APPROVALS		DATE	SIZE	DWG NO.	REV	
			C	203-HJT-0303	0	

NOTES

1. MATERIAL CERTIFICATIONS REQUIRED



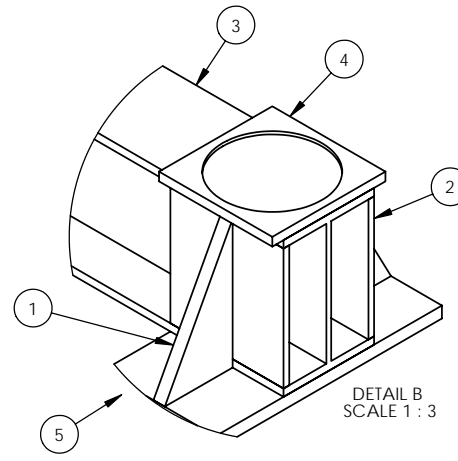
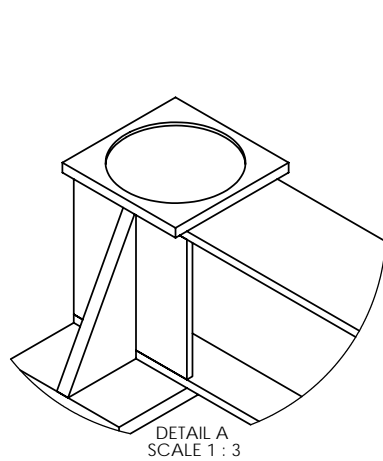
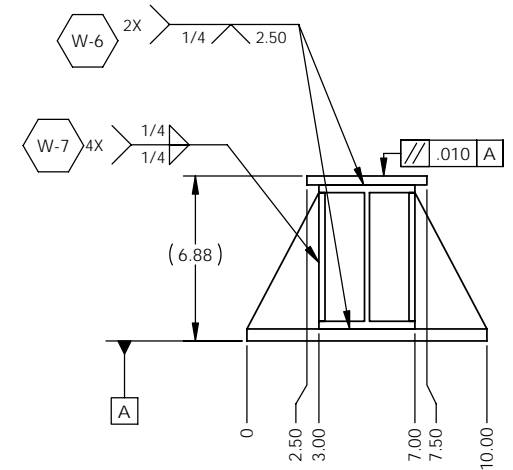
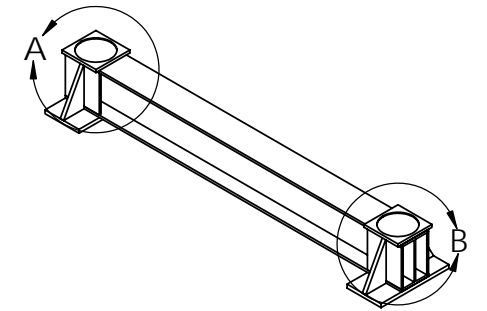
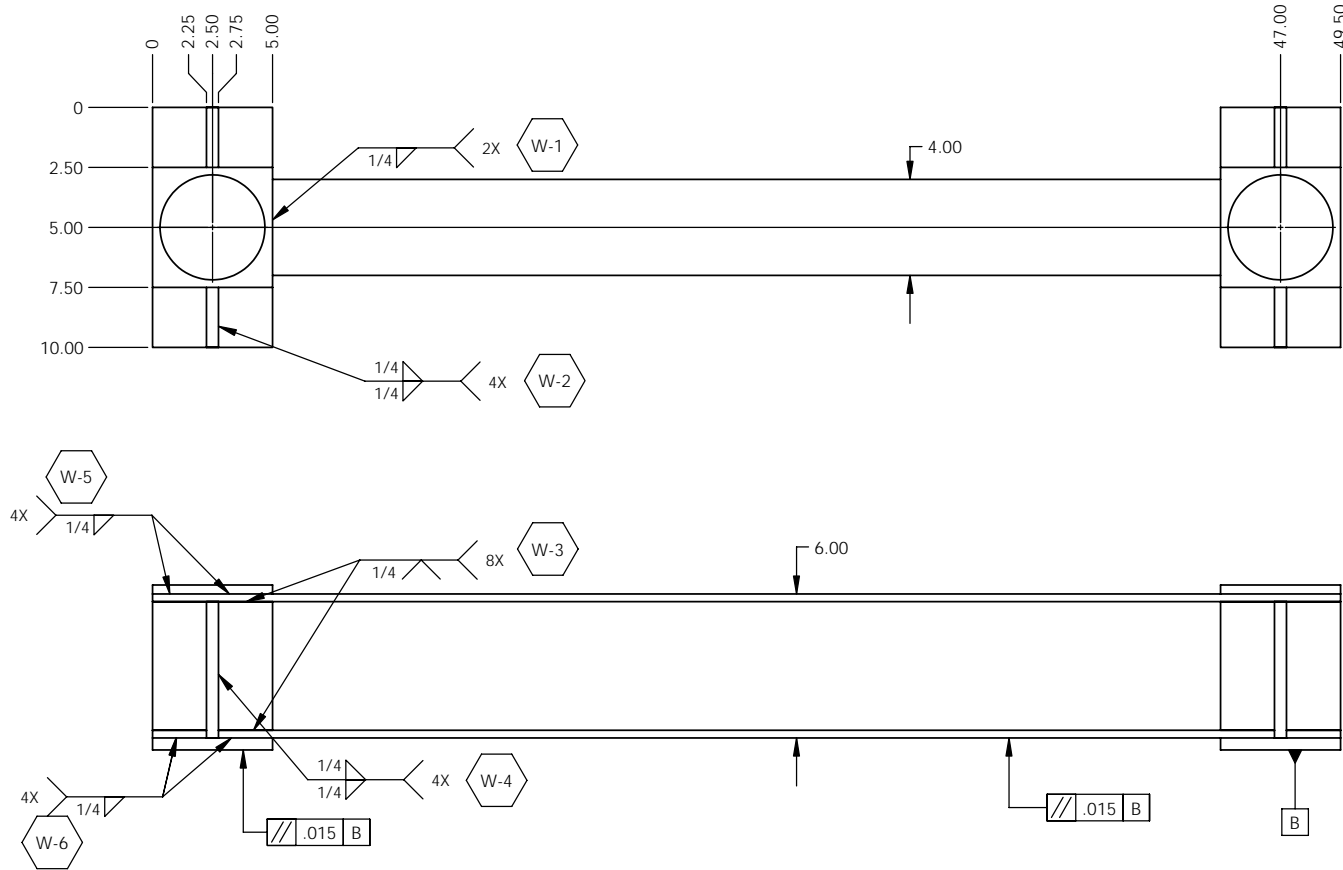
MATERIAL: AL - 6061 T6, ASTM B-308

<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><b>OAK RIDGE NATIONAL LABORATORY</b> 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><b>REMOTE SYSTEMS GROUP</b> NUCLEAR SCIENCE &amp; TECHNOLOGY DIVISION</p>	
DES V GRAVES 06/03/2005 DRW T OQUIN 06/03/2005 CHK ENG V GRAVES 06/03/2005			<p><b>MERIT EXPERIMENT</b> <b>TARGET CART ASSY</b> <b>HG SYS LOCATING BKT</b></p>		
CAD FILE HG SYS LOCATING BKT HJT SIZE DWG NO. C			PREV ASSY 203-HJT-0300	SCALE 1:1	SHEET 1 of 1
DRAWING APPROVALS DATE			203-HJT-0304		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 ±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

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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  
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**NSTB** REMOTE SYSTEMS GROUP  
NUCLEAR SCIENCE & TECHNOLOGY DIVISION

**MERIT 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		