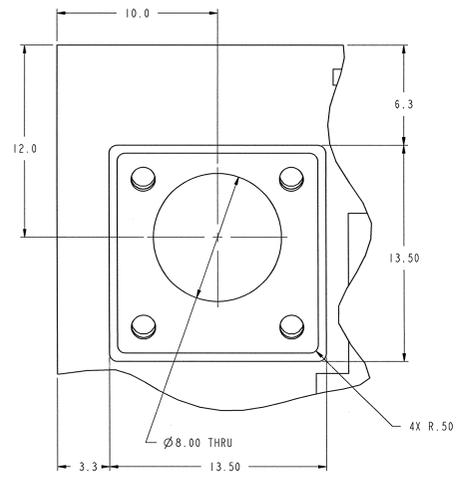
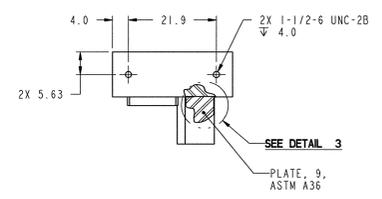
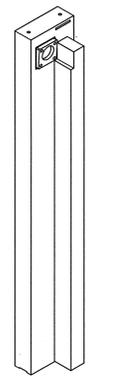
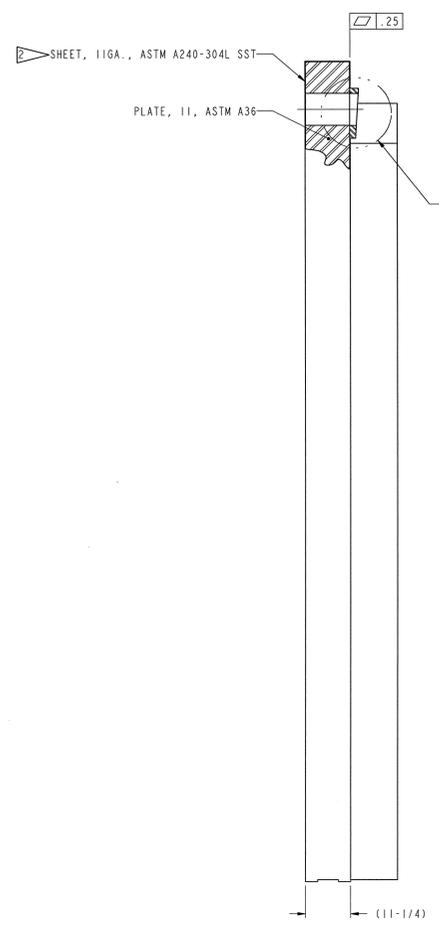


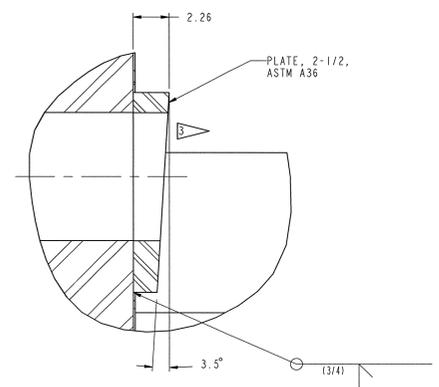
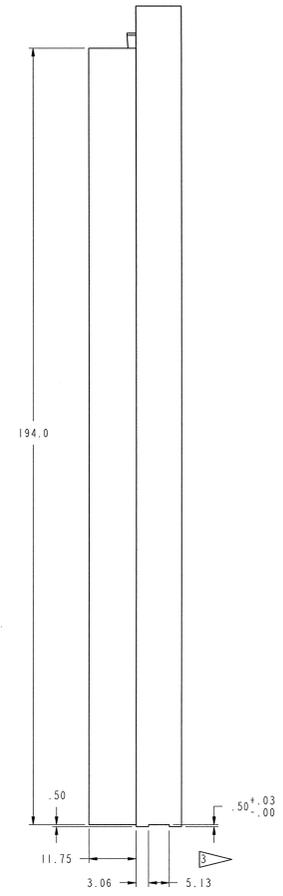
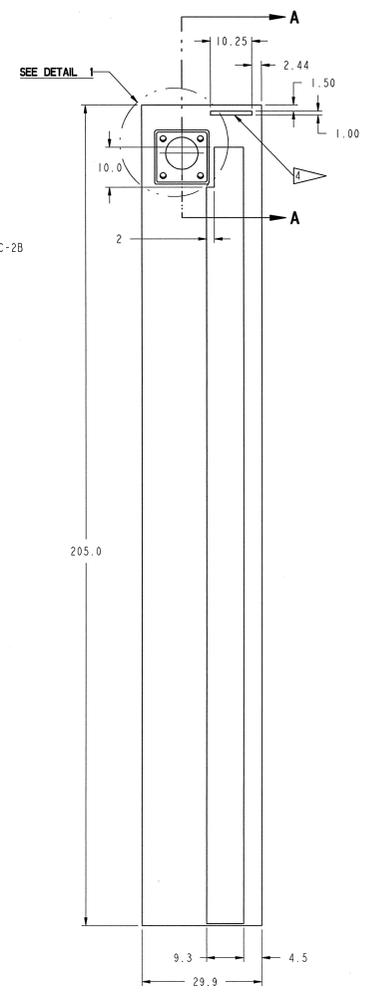
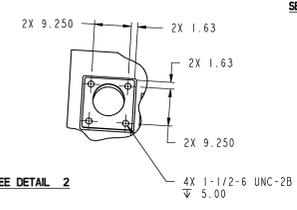
GENERAL NOTES:  
 1) DIMENSIONS AND SYMBOLS ARE AMERICAN NATIONAL STANDARD UNLESS OTHERWISE SPECIFIED.  
 2) ROUGHNESS AVERAGE EQUALS 125 MICRONS UNLESS OTHERWISE SPECIFIED.  
 3) DIMENSIONS AND TOLERANCES ARE IN INCHES.  
 4) BREAK ALL SHARP EDGES.  
 5) TOLERANCES:  
 DECIMALS: .X = ±.060  
 .XX = ±.030  
 .XXX = ±.010  
 FRACTIONS: ±1/16  
 ANGULAR: ±1°



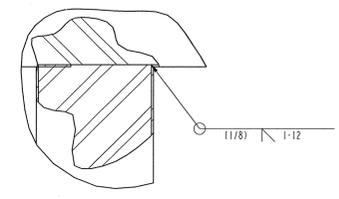
DETAIL 1  
SCALE 1/4



SECTION A-A  
SCALE 1/4



DETAIL 2  
SCALE 1/4



DETAIL 3  
SCALE 1/4

NOTES:

1. THIS COMPONENT IS SUBJECT TO THE REQUIREMENTS SET FORTH IN SECTION 15065.
2. CLAD ALL EXPOSED CARBON STEEL SURFACES USING 11GA. 304L SST. ALL SEAMS SHALL BE CONTINUOUSLY WELDED WITH ALL WELDS GROUND AND POLISHED TO A #4 FINISH. IN ADDITION PLUG WELD ALL LARGE FLAT 11GA. PANELS TO CS PLATE USING 1/4" PLUG WELDS ON 24" CENTERS.
3. BOTTOM OF DOOR, MOUNTING FLANGE, AND 8" BORE DO NOT NEED TO BE CLADDED. INSTEAD PAINT UNCLADDED CARBON STEEL IN ACCORDANCE WITH SECTION 09960. MASK FACE OF MOUNTING FLANGE AND TAPPED HOLES.
4. CUT OUT IN CLADDING, WELD DOOR PANEL CROSS BRACE HERE. SEE J7 SERIES DRAWINGS FOR BRACE INSTALLATION DETAILS.
5. COMPONENT WEIGHT: 25351 LBS.

SCALE: 1/16

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

**P** THIS DRAWING PRODUCED ON PRO-ENGINEER  
 THIS DOCUMENT CONTROLLED BY CHANGE CONTROL SYSTEM...  
 ENGINEERING PROCEDURE SMS-ENG-6001

REV	DATE	DESCRIPTION	DSN	CHK	DEPT	DATE	PE	DATE	PJ	DATE	REQ	DATE	UTB	DATE	RPE	RPE NO	DATE	ST	CV	EC	EE	EM	IE	M	PD	SE	AR
0		CERTIFIED FOR CONSTRUCTION - 10/26/01	PCD	TBO																							
1	10/26/01																										

RPE  
 DSN: [Signature]  
 CHK: [Signature]  
 DEPT: [Signature]  
 PE: [Signature]  
 P.J: [Signature]  
 REQ: [Signature]

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 Engineers & Architects  
**UT-BATTELLE**  
 Oak Ridge National Laboratory, managed by UT-Battelle, LLC, for the U.S. Dept. of Energy under contract DE-AC05-00OR22725  
 PROJECT NAME:  
 SPALLATION NEUTRON SOURCE  
 TARGET BUILDING  
 SOUTH FIXED SHIELD PANEL  
 WELDMENT  
 1 48 49 50 PLANT BLDG FL SH. OF TYPE CLASS  
 3 J X X 8 8700 I I G U  
 51 52 53 WBS  
 NC NA IN 1.8.3.7 J3.51.36  
 REV 0