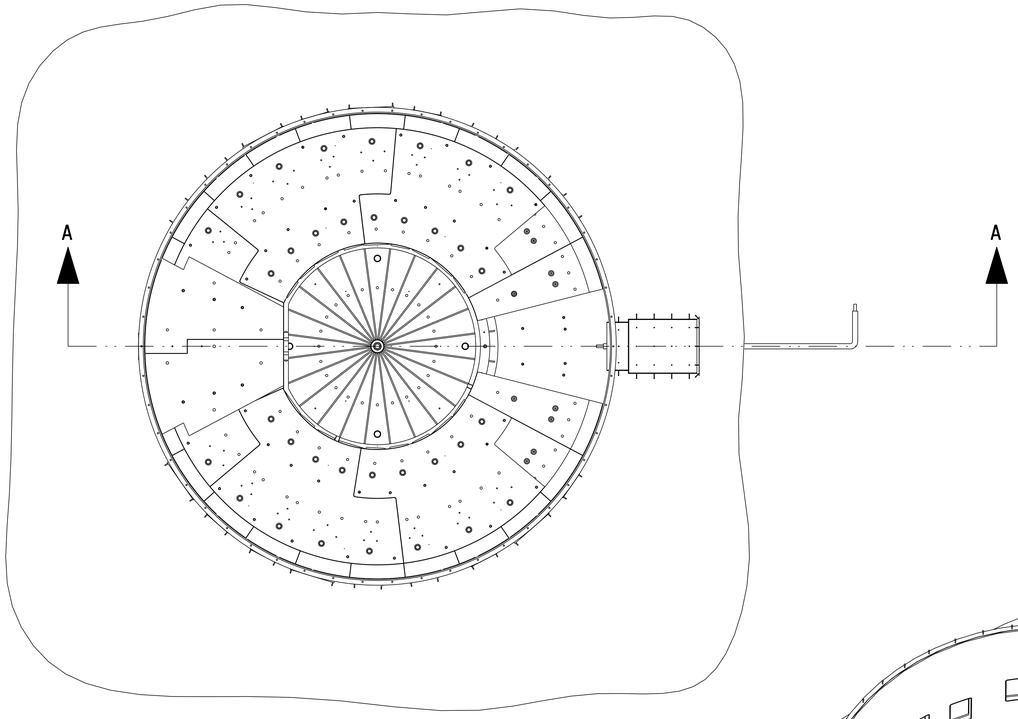
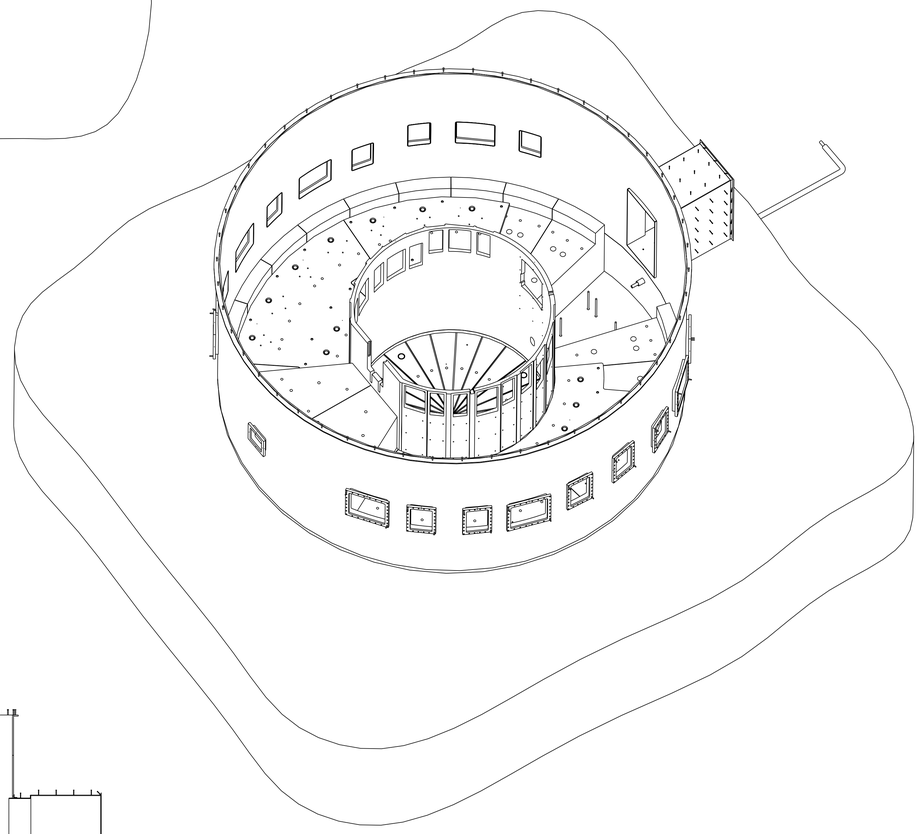
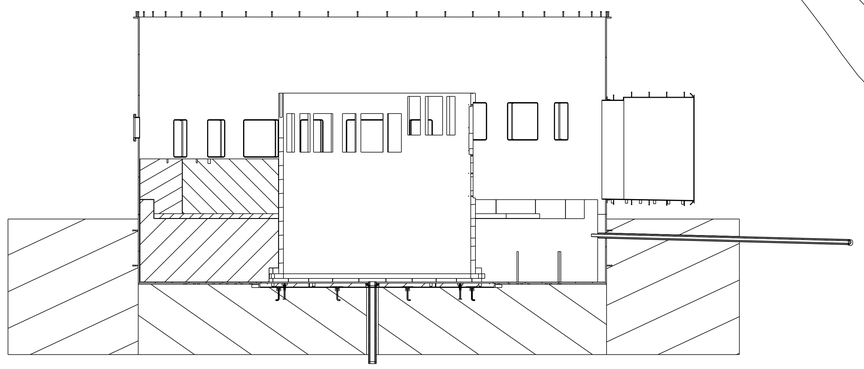
NOTES

1. INTERPRET DRAWING PER GLOBAL ENGINEERING DOCUMENTS DRAWING REQUIREMENTS MANUAL, LATEST REVISION.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M, LATEST REVISION.
3. DIMENSIONS ARE IN INCHES.
4. REMAINDER OF BUILDING STRUCTURES EXTERNAL TO THE BULK SHIELD LINER ARE NOT DEPICTED IN THIS DRAWING.
5. ALL GROUT SHALL BE HIGH DENSITY GROUT (300 PCF) IN ACCORDANCE WITH SNS SPECIFICATION 108000000TS0115, SECTION 03300, PARAGRAPH 3.3.E.







SECTION A-A

(1) BOTTOM BLOCK, RING PLATE INSTALLATION

	AR			GROUT			
	12	99862	CL-30000-SHR-1	SWIVEL HOIST RING			
	42		2.00 NOM	FLAT WASHER, TYPE B, SERIES W	SAE GR 8, STL	ANSI B18.22.2	36
	42		2-4.5 UNC X 5.5	HEX HEAD CAP SCREW	ASTM A193	GRADE B7	35
	72		1.25 NOM	FLAT WASHER, TYPE B, SERIES W	UNS G41400	ANSI B18.22.2	34
	1		106050101M8E8700A102-1	BULK SHIELD PBW BLOCK 2	--	--	33
	1		106050101M8E8700A101-1	BULK SHIELD PBW BLOCK 1	--	--	32
	72		106050101M8E8700A047-1	BOTTOM BLOCK NUT	--	--	31
	1		106050101M8E8700A045-1	BULK SHIELD SUPPORT RING 5	--	--	30
	1		106050101M8E8700A044-1	BULK SHIELD SUPPORT RING 4	--	--	29
	1		106050101M8E8700A043-1	BULK SHIELD SUPPORT RING 3	--	--	28
	1		106050101M8E8700A042-1	BULK SHIELD SUPPORT RING 2	--	--	27
	1		106050101M8E8700A041-1	BULK SHIELD SUPPORT RING 1	--	--	26
	1		106050101M8E8700A024-1	BULK SHIELD BOTTOM BLOCK 24	--	--	25
	1		106050101M8E8700A023-1	BULK SHIELD BOTTOM BLOCK 23	--	--	24
	1		106050101M8E8700A022-1	BULK SHIELD BOTTOM BLOCK 22	--	--	23
	1		106050101M8E8700A021-1	BULK SHIELD BOTTOM BLOCK 21	--	--	22
	1		106050101M8E8700A020-1	BULK SHIELD BOTTOM BLOCK 20	--	--	21
	1		106050101M8E8700A019-1	BULK SHIELD BOTTOM BLOCK 19	--	--	20
	1		106050101M8E8700A018-1	BULK SHIELD BOTTOM BLOCK 18	--	--	19
	1		106050101M8E8700A017-1	BULK SHIELD BOTTOM BLOCK 17	--	--	18
	1		106050101M8E8700A016-1	BULK SHIELD BOTTOM BLOCK 16	--	--	17
	1		106050101M8E8700A015-1	BULK SHIELD BOTTOM BLOCK 15	--	--	16
	1		106050101M8E8700A014-1	BULK SHIELD BOTTOM BLOCK 14	--	--	15
	1		106050101M8E8700A013-1	BULK SHIELD BOTTOM BLOCK 13	--	--	14
	1		106050101M8E8700A012-1	BULK SHIELD BOTTOM BLOCK 12	--	--	13
	1		106050101M8E8700A011-1	BULK SHIELD BOTTOM BLOCK 11	--	--	12
	1		106050101M8E8700A010-1	BULK SHIELD BOTTOM BLOCK 10	--	--	11
	1		106050101M8E8700A009-1	BULK SHIELD BOTTOM BLOCK 9	--	--	10
	1		106050101M8E8700A008-1	BULK SHIELD BOTTOM BLOCK 8	--	--	9
	1		106050101M8E8700A007-1	BULK SHIELD BOTTOM BLOCK 7	--	--	8
	1		106050101M8E8700A006-1	BULK SHIELD BOTTOM BLOCK 6	--	--	7
	1		106050101M8E8700A005-1	BULK SHIELD BOTTOM BLOCK 5	--	--	6
	1		106050101M8E8700A004-1	BULK SHIELD BOTTOM BLOCK 4	--	--	5
	1		106050101M8E8700A003-1	BULK SHIELD BOTTOM BLOCK 3	--	--	4
	1		106050101M8E8700A002-1	BULK SHIELD BOTTOM BLOCK 2	--	--	3
	1		106050101M8E8700A001-1	BULK SHIELD BOTTOM BLOCK 1	--	--	2
AR	X		106050101M8E8700A029-1	BOTTOM BLOCK INSTALLATION			1
106050101M8E8700A181	-1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

NEXT ASSEMBLY

PARTS LIST

QUALITY VERIFICATION
MECHANICAL AND STRUCTURAL
REFERENCE SNS-TS-G002

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO #
303	MATERIAL MILL TEST REPORT	-
325	MATERIAL SELLER CERT	-
326	SPECIAL MATERIAL INSPECTION REPORT	-
205	MANUFACTURING, INSPECTION, AND TEST PLAN	-
312	FIELD INSPECTION AND TEST PLAN	-
321	WELD AND BRAZE INSPECTION REPORT	-
322	HEAT TREAT REPORT (WCHART)	-
310	LEAK TEST REPORT	-
315	CLEANING CERT	-
318	DEVIATION REQUEST	-
319	NONCONFORMANCE PROCESS	-
323	DIMENSIONAL REPORT	X
330	FUNCTIONAL TEST REPORT	-
100	DOCUMENTATION	-

SYMBOL X INDICATES APPLICABLE TO ALL PARTS OR ITEMS

ORIGINAL SIGNED BY:

QA REP DATE

RPE

REV. XX DATE XX/XX/XX

106050101M8E8700A029 B

REV	CHANGE TYPE	CHANGE CONTROL SYSTEM	CHANGE CONTROL NUMBER	DESCRIPTION	BY	CHK	SECT	DEPT	DATE	PE	REQ	DOE
0	-	3	-	CERTIFIED FOR CONSTRUCTION	RLM				1/02			

REVISION OR ISSUE PURPOSE — REVISION APPROVALS

SCALE 0.020

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS :
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED

		DRAWING APPROVALS	DATE
DES	K CHIPLEY		8/27/01
DRW	R MOON		8/27/01
CHK	R H NELSON		1/02
L3	K K CHIPLEY		1/02
L2	T J McMANAMY		1/18/02

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Oak Ridge, Tennessee

SNS Spallation Neutron Source

TARGET SYSTEMS
BOTTOM BLOCK, RING PLATE
INSTALLATION, PHASE I

BLDG	FL	SHT	OF	CLASS
8700		1	5	U

106050101M8E8700A029 REV 0

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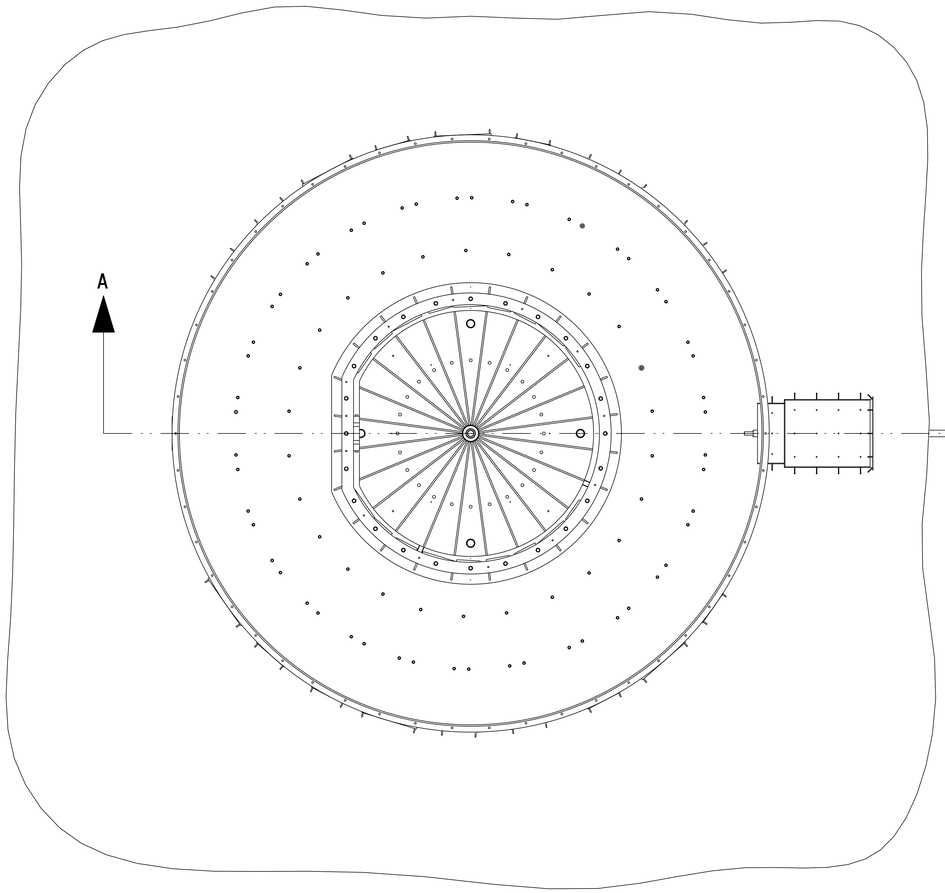
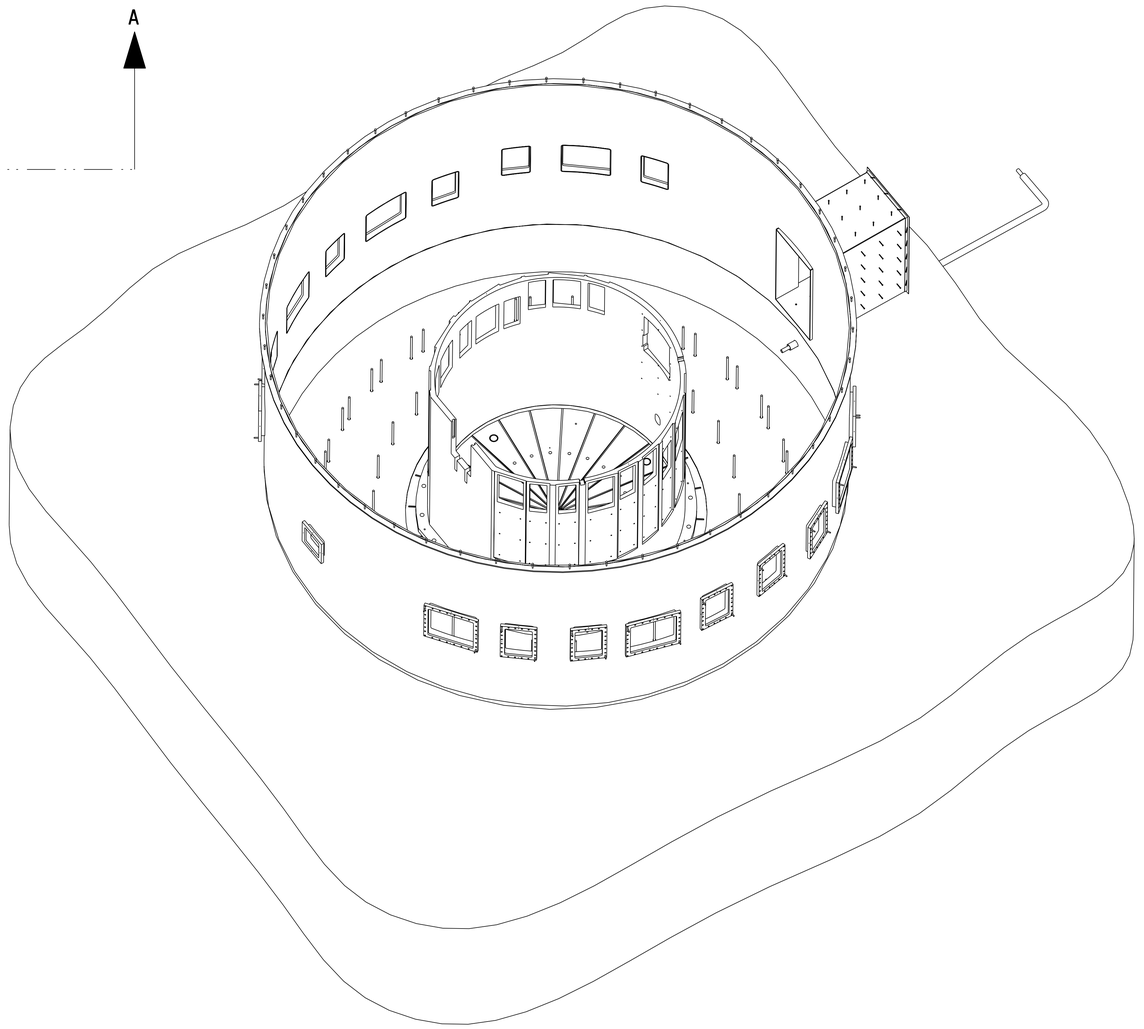
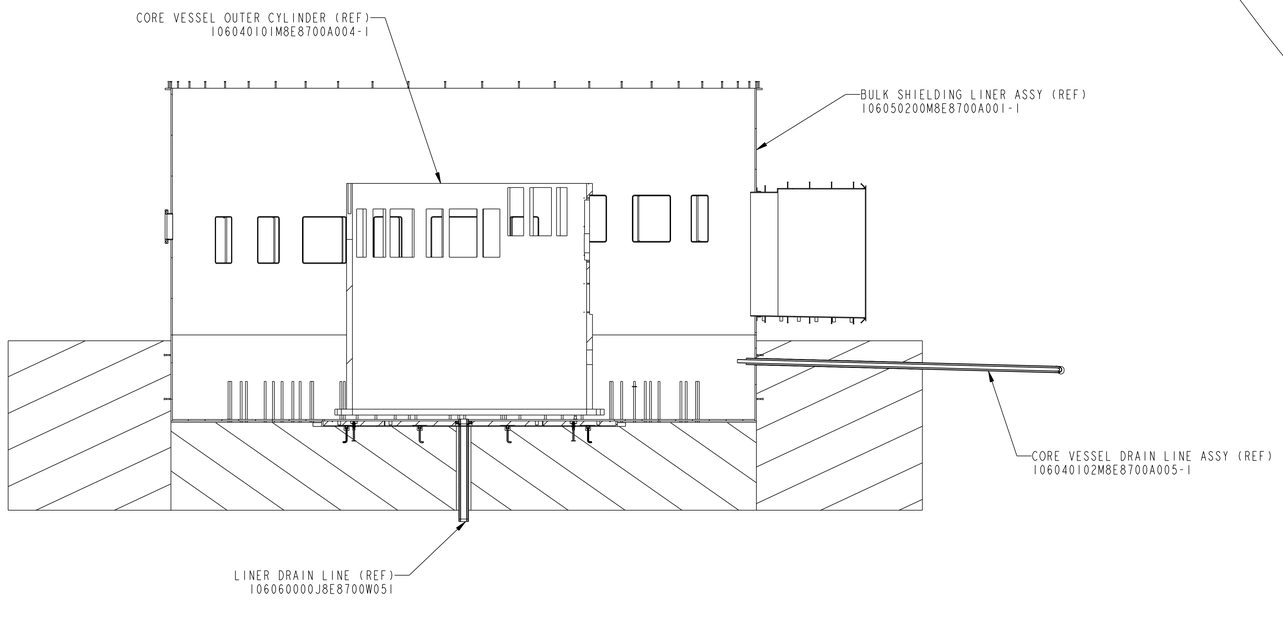
P THIS DRAWING PRODUCED ON PRO-ENGINEER

THIS DOCUMENT CONTROLLED BY
CHANGE CONTROL SYSTEM 3
SNS PROCEDURE SNS-IS-G001







SECTION A-A

INSTALLATION REFERENCES

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE 0.025

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	:
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0°15'
BREAK SHARP EDGES	.06 MAX
FINISH	125 RMS UNLESS OTHERWISE SPECIFIED

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Oak Ridge, Tennessee
SNS Spallation Neutron Source

TARGET SYSTEMS
BOTTOM BLOCK, RING PLATE
INSTALLATION, PHASE I

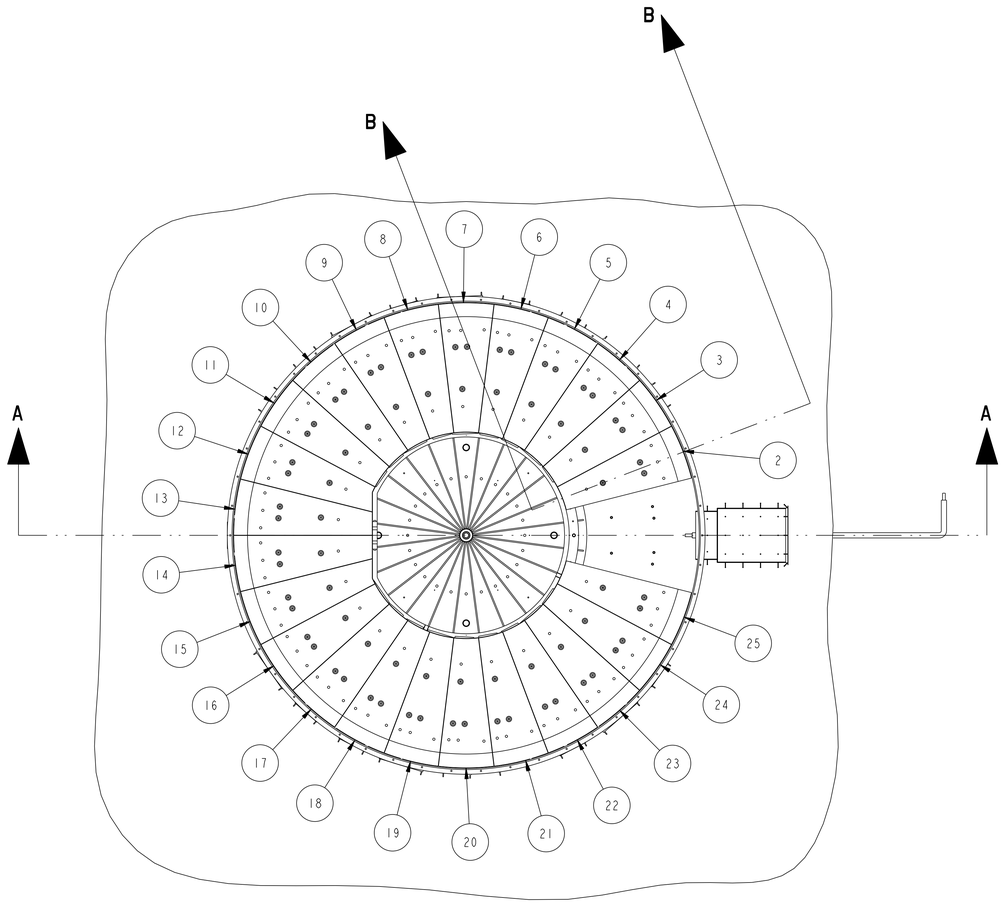
BLDG	FL	SHT	OF	CLASS
8700		2	5	U

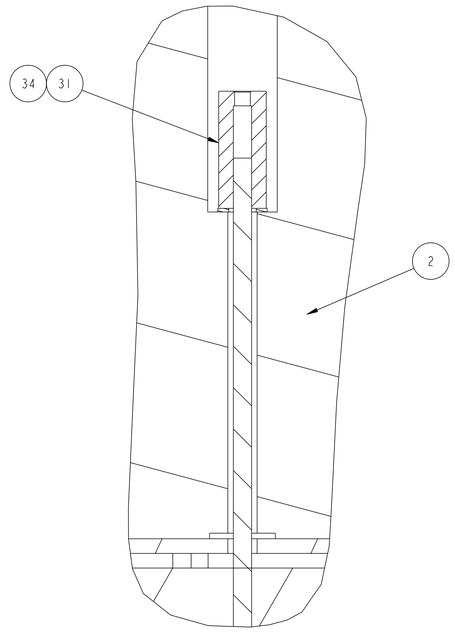
I06050101M8E8700A029 REV 0

I06050101M8E8700A029

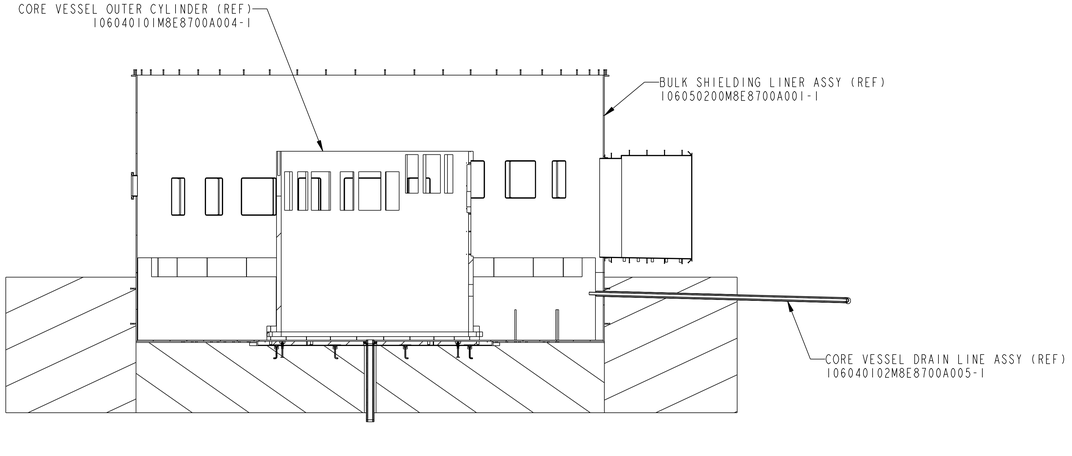
NOTES

1. INSTALL (LOWER VERTICALLY) SHIELD BLOCKS -2 THRU -25 IN POSITION AS SHOWN.
2. INSTALL -31 BOTTOM BLOCK NUTS AND -34 FLAT WASHERS (72 PLCS) AS SHOWN AND TIGHTEN TO 1300 FT/LBS TORQUE.
3. FILL ALL VOIDS AND CRACKS BETWEEN SHIELD BLOCKS WITH GROUT.

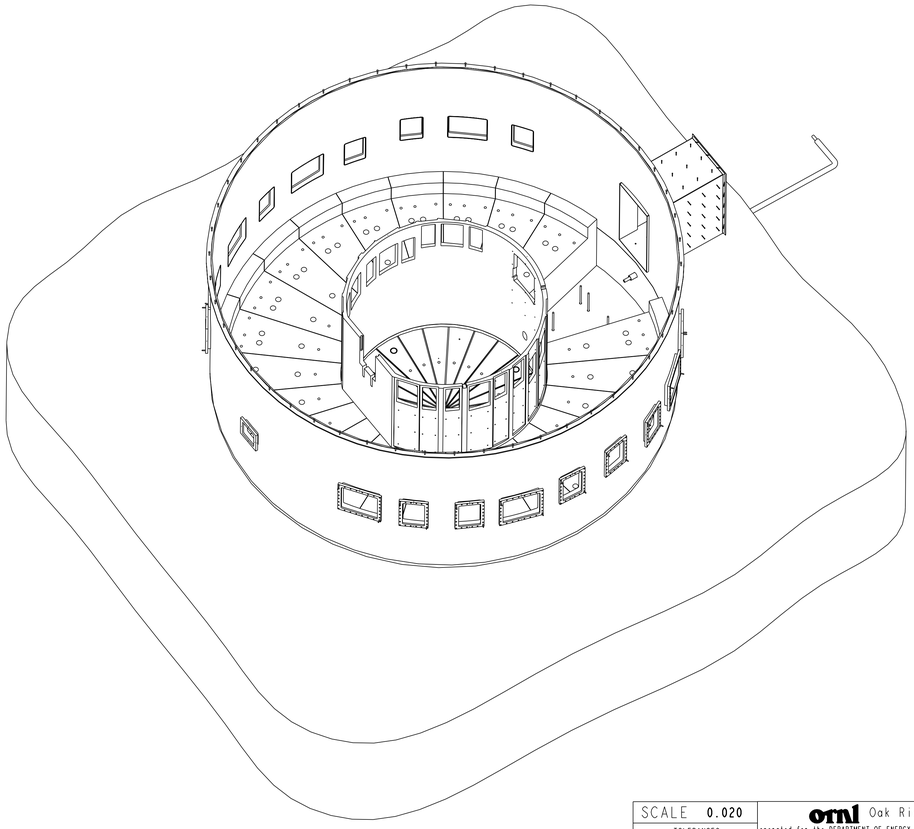




SECTION B-B
SCALE 0.250



SECTION A-A



BOTTOM BLOCK INSTALLATION SEQUENCE

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE	0.020
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	:
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0°15'
BREAK SHARP EDGES	.06 MAX
FINISH	125 RMS UNLESS OTHERWISE SPECIFIED

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Oak Ridge, Tennessee

SNS Spallation Neutron Source

TARGET SYSTEMS BOTTOM BLOCK, RING PLATE INSTALLATION, PHASE 1

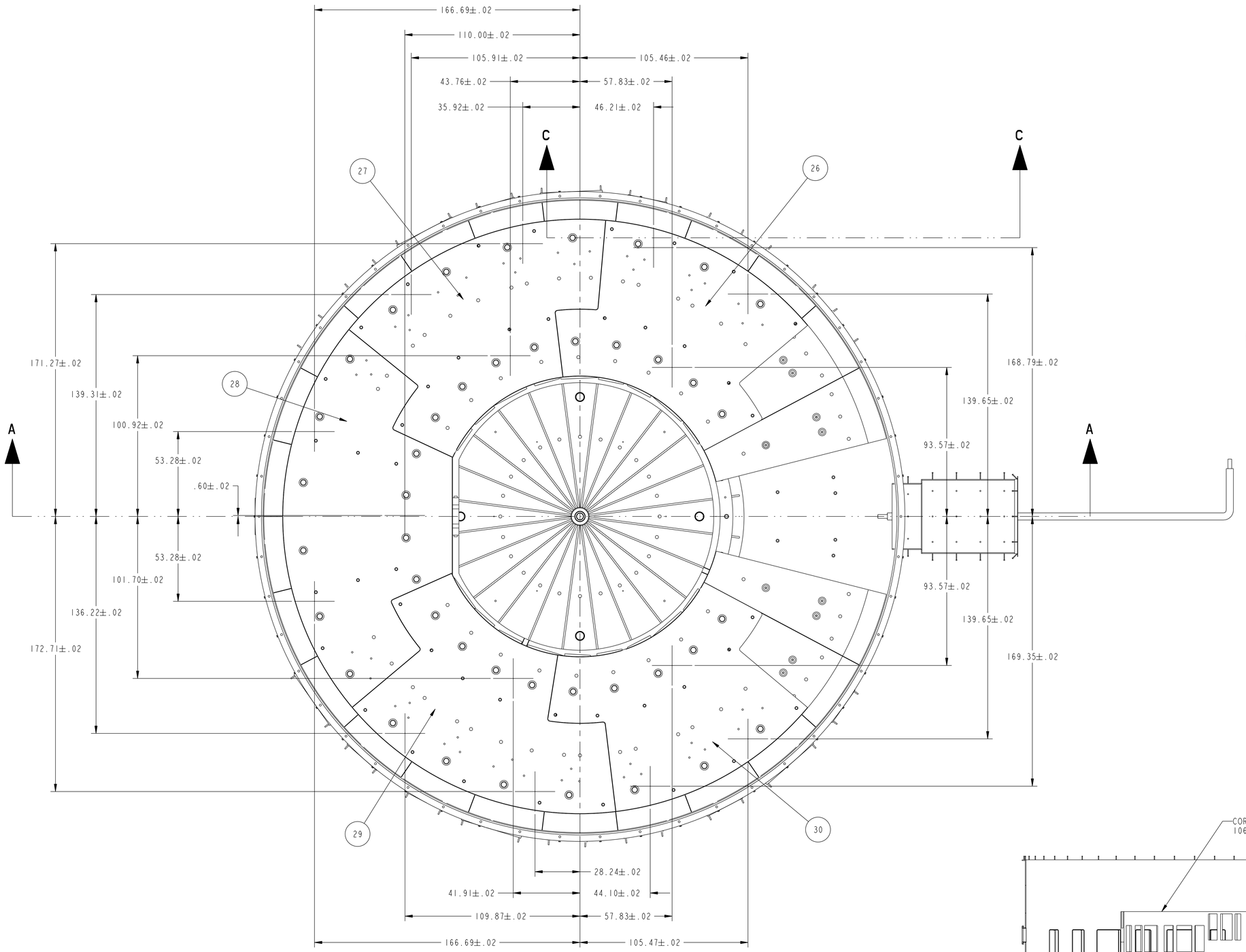
BLDG	FL	SHT	OF	CLASS
8700		3	5	U

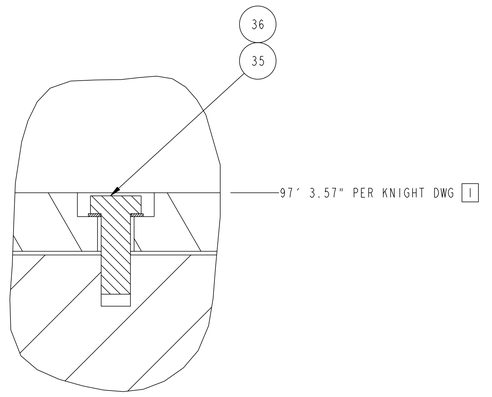
106050101M8E8700A029 REV 0

106050101M8E8700A029

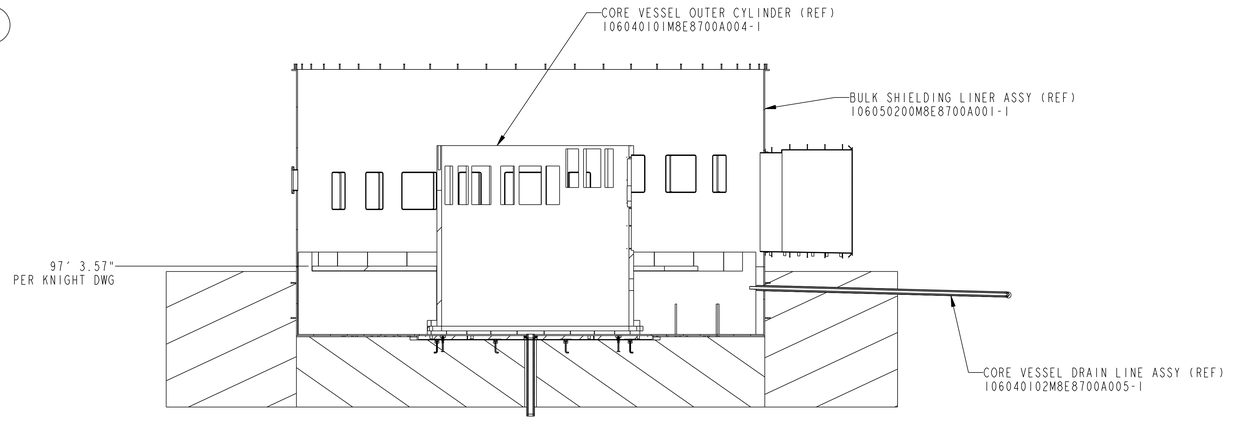
NOTES

1. LOWER -26 THRU -30 RING PLATES INTO POSITION AS SHOWN. USE BOLTS (NOT SUPPLIED) IN THREADED HOLES AS REQUIRED TO LEVEL AND ACHIEVE CORRECT HEIGHT.
2. SECURE RING PLATES WITH -35 HEX HEAD CAP SCREWS AND -36 WASHERS (42 PLCS) AS SHOWN. TIGHTEN TO 2700 FT/LBS TORQUE.
3. FILL ALL VOIDS AND CRACKS BETWEEN PLATES WITH GROUT.





SECTION C-C
SCALE 0.250



SECTION A-A
SCALE 0.020

BOTTOM BLOCK INSTALLATION SEQUENCE

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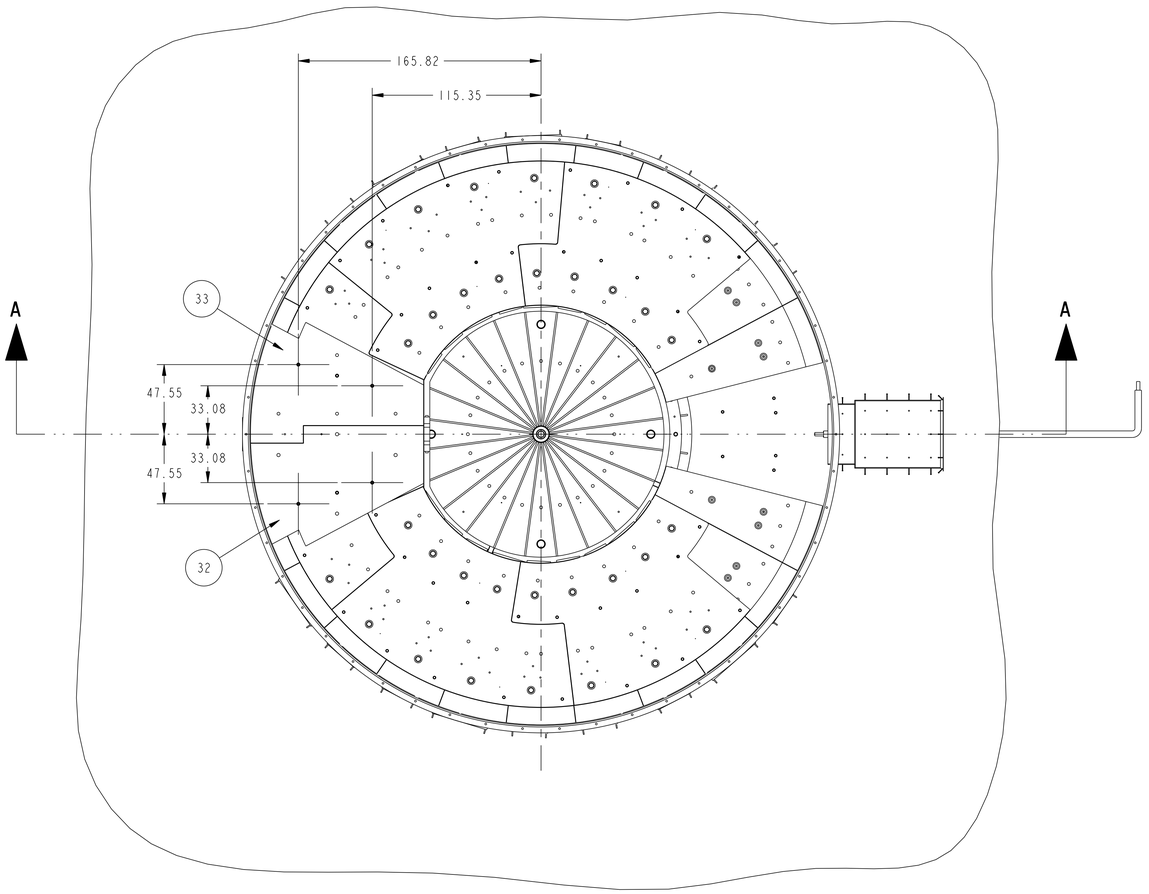
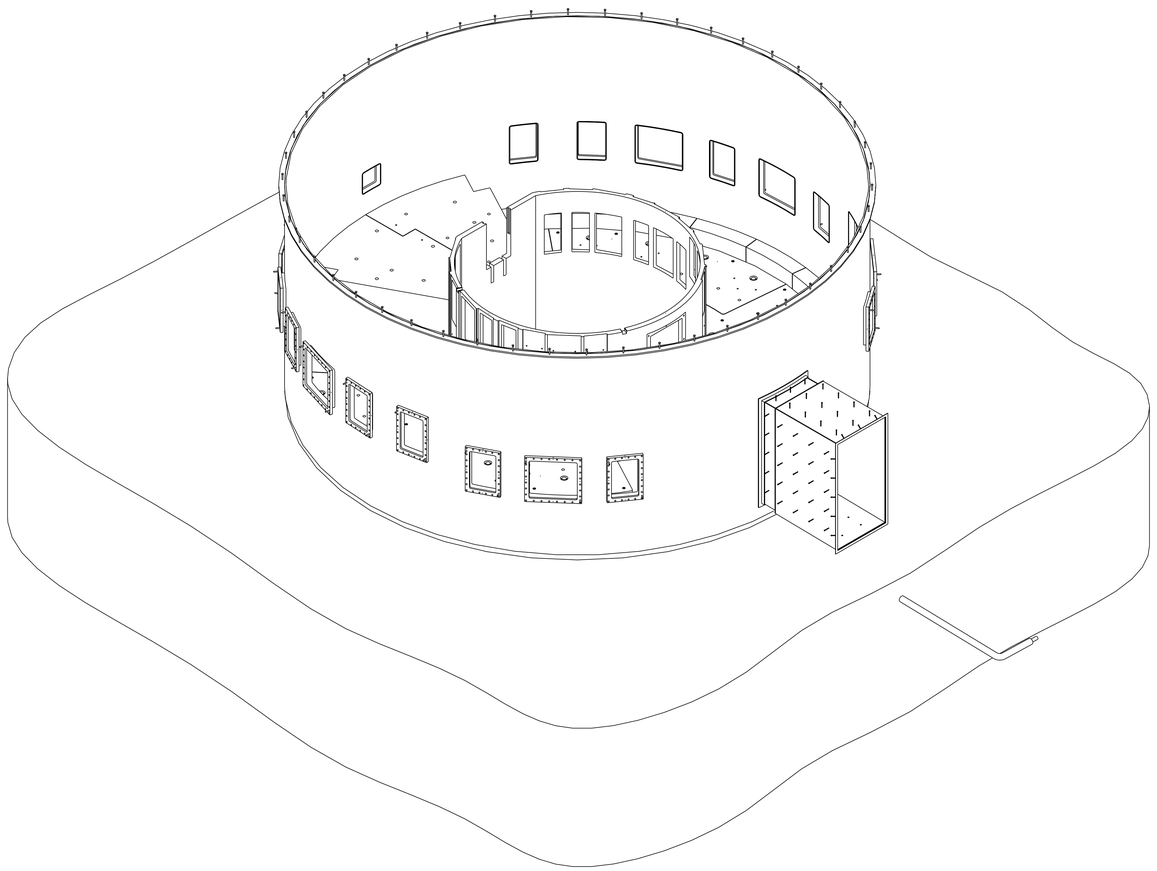
SCALE 0.040	ornl Oak Ridge National Laboratory
TOLERANCES UNLESS OTHERWISE SPECIFIED	operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee
FRACTIONS :	SNS Spallation Neutron Source
XX DECIMALS ±.01	TARGET SYSTEMS
XXX DECIMALS ±.005	BOTTOM BLOCK, RING PLATE
ANGLES ±0°15'	INSTALLATION, PHASE I
BREAK SHARP EDGES .06 MAX	BLDG 8700 | FL | SHT OF 4 5 | CLASS U
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	I06050101M8E8700A029 | REV 0

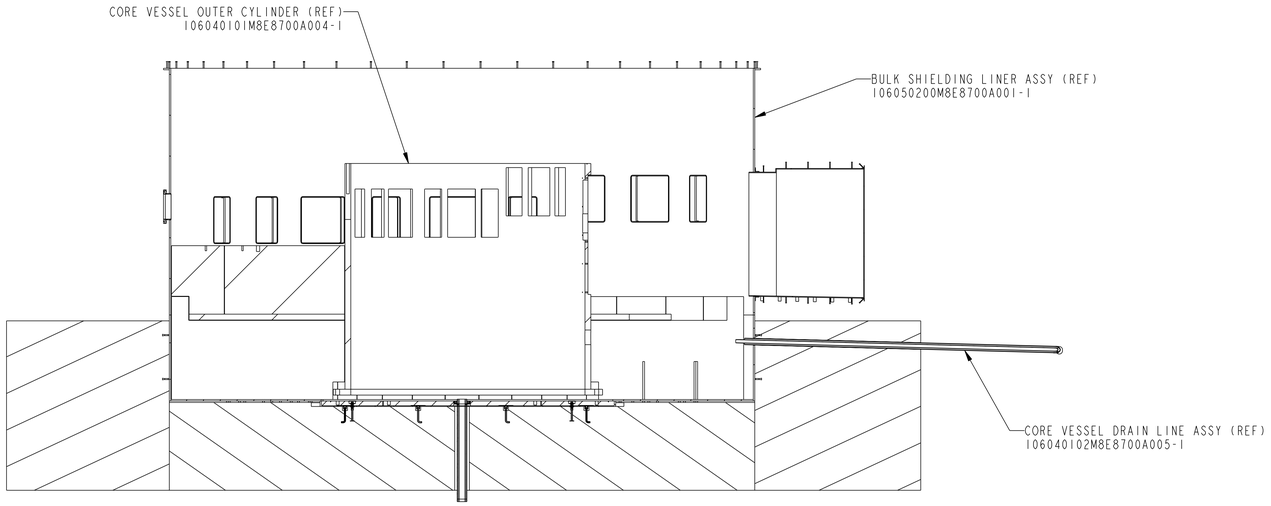
I06050101M8E8700A029

NOTES

1. LOWER -32 AND -33 BULK SHIELD PBW BLOCKS INTO POSITION AS SHOWN.
3. FILL ALL VOIDS AND CRACKS BETWEEN SHIELD BLOCKS WITH GROUT.







SECTION A-A

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SCALE 0.025	ornl Oak Ridge National Laboratory
TOLERANCES UNLESS OTHERWISE SPECIFIED	operated for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 Oak Ridge, Tennessee
FRACTIONS :	SNS Spallation Neutron Source
XX DECIMALS ±.01	TARGET SYSTEMS BOTTOM BLOCK, RING PLATE INSTALLATION, PHASE 1
XXX DECIMALS ±.005	
ANGLES ±0°15'	
BREAK SHARP EDGES .06 MAX	
FINISH 125 RMS UNLESS OTHERWISE SPECIFIED	BLDG 8700 · FL · SHT 5 OF 5 · CLASS U · REV 0
	I06050101M8E8700A029

I06050101M8E8700A029