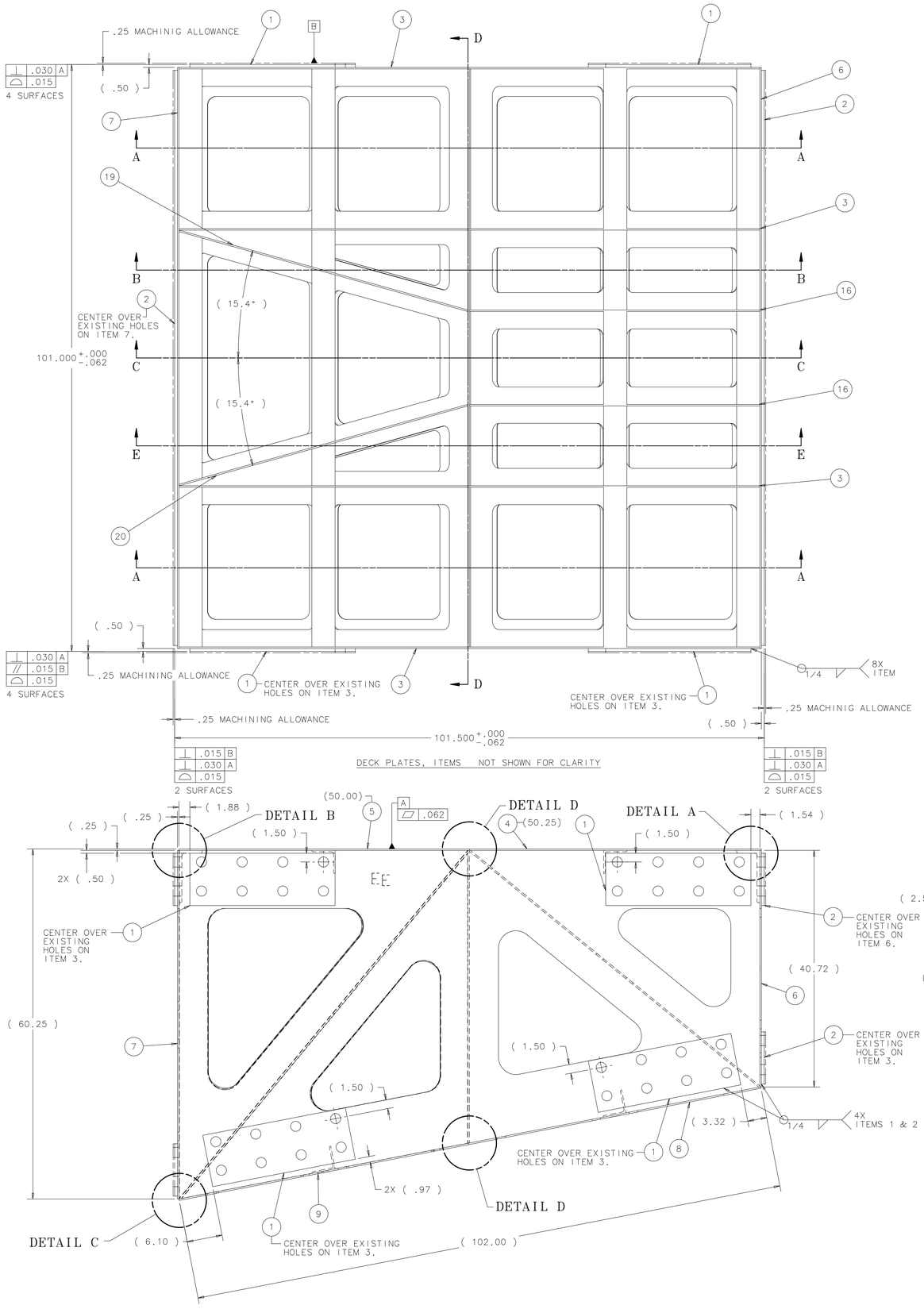
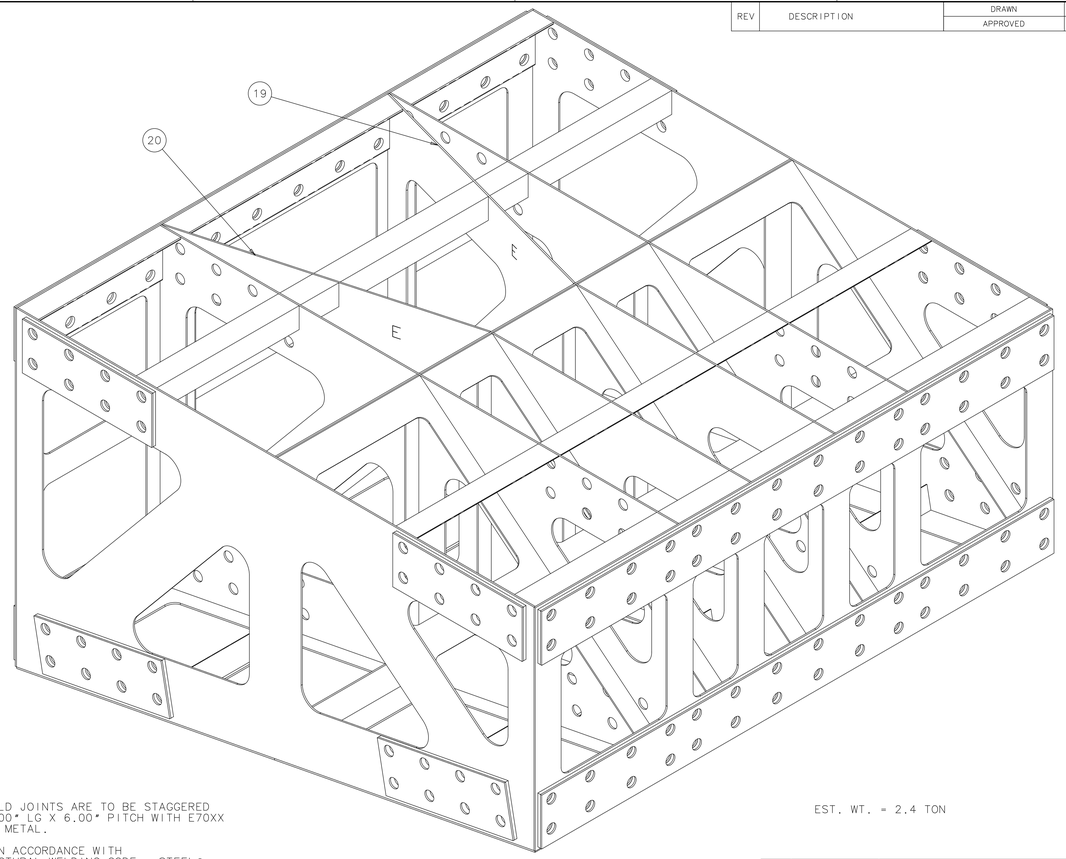
REV	DESCRIPTION	DRAWN	DATE
		APPROVED	DATE



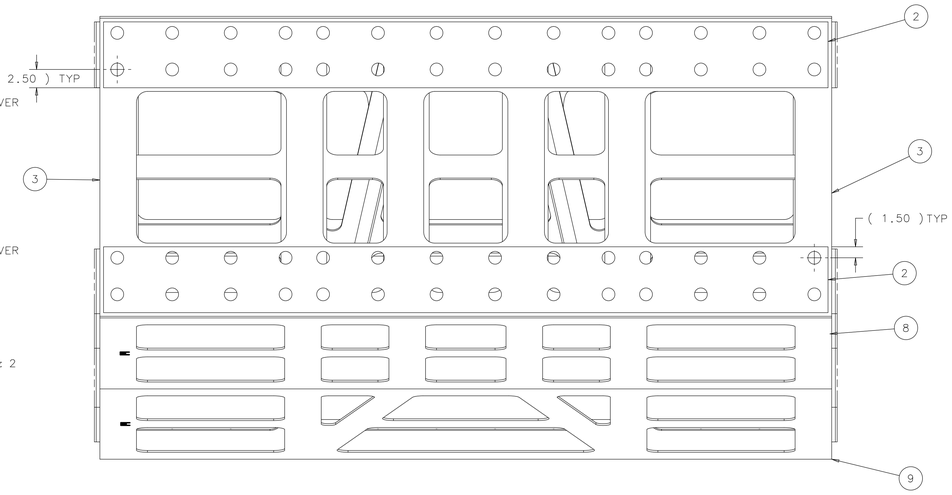


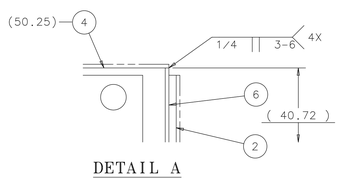
ISOMETRIC VIEW
SCALE=1:8
DECK PLATES, ITEMS NOT SHOWN FOR CLARITY

EST. WT. = 2.4 TON

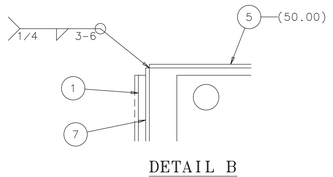
NOTES:

1. UNLESS NOTED, ALL WELD JOINTS ARE TO BE STAGGERED 1/4" FILLET WELDS 3.00" LG X 6.00" PITCH WITH E70XX OR EQUIVALENT FILLER METAL.
2. ALL WELDS SHALL BE IN ACCORDANCE WITH ANSI/AWS D1.1, "STRUCTURAL WELDING CODE - STEEL".
3. ALL WELDS SHALL BE MADE IN A SEQUENCE THAT WILL BALANCE THE APPLIED WELDING HEAT WHILE THE WELDING PROGRESSES. THE PROCEDURE AND SEQUENCE SHALL BE DESIGNED TO MINIMIZE DISTORTION AND SHRINKAGE STRESSES.
4. ALL WELDS SHALL BE VISUALLY INSPECTED AND DYE PENETRANT INSPECTED TO DETECT SURFACE AND SUBSURFACE CRACKS AND DISCONTINUITIES IN ACCORDANCE WITH ANSI/AWS D1.1, "STRUCTURAL WELDING CODE - STEEL".
5. ALL WELDS THAT FAIL INSPECTION SHALL BE REPAIRED IN ACCORDANCE WITH ANSI/AWS D1.1, "STRUCTURAL WELDING CODE - STEEL".
6. PAINT WITH PRIMER, DAMP PROOF RUST-OLEUM NO 769 OR EQUIVALENT.
7. ITEMS WITH "E" STAMP, NOTE THE POSITION TO AID CORRECT POSITION.

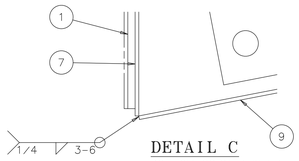




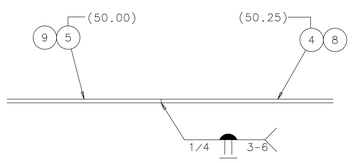
DETAIL A
SIDE CORNER WELD
SCALE=1:4



DETAIL B
TOP CORNER WELD
SCALE=1:4



DETAIL C
BOTTOM CORNER WELD
SCALE=1:4



DETAIL D
2X- DECK PLATES AND BOTTOM PLATES
SCALE=1:4

ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.
33	MC-486685	ANGLE 9X4X500X43-500 DIAG CUT	1
32	MB-486703	ANGLE 9X4X500X13-750 L	1
31	MB-486710	ANGLE 4X4X250X7-428 L	2
30	MC-486711	ANGLE 4X4X250X30-837 C	2
29	MC-486518	ANGLE 4X4X250X16	2
28	MB-486700	ANGLE 9X4X500X16	1
27	MB-486701	ANGLE 9X4X500X13-750 R	1
26	MC-486688	ANGLE 9X4X500X27-500 R	2
25	MC-486517	ANGLE 4X4X250X13-75	4
24	MB-486708	ANGLE 4X4X250X7-428 R	2
23	MB-486792	ANGLE 4X4X250X27-50	8
22	MC-486682	ANGLE 9X4X500X27-500 L	2
21	MC-486631	AR SECT B BCK WLDNT BOTT LFT PLT	1
20	MC-486579	AR SECT B BCK WLDNT TOP LFT PLT	1
19	MC-486593	AR SECT B BCK WLDNT TOP RT PLT	1
18	MC-486678	AR SECT B BCK WLDNT BOTT RT PLT	1
17	MC-486771	AR SECT B BCK WLDNT DIAG C PLT	1
16	MC-486552	AR SECT B BCK WLDNT TOP PLT	2
15	MD-486728	AR SECT B BCK WLDNT TRANSV C PLT	1
14	MC-486734	AR SECT B BCK WLDNT DIAG E PLT	1
13	MC-486784	AR SECT B BCK WLDNT DIAG B PLT	2
12	MD-486725	AR SECT B BCK WLDNT TRANSV B PLT	2
11	MC-486768	AR SECT B BCK WLDNT DIAG D PLT	2
10	MC-486786	AR SECT B BCK WLDNT DIAG A PLT	2
9	MD-486791	PLATE BOTT 250X50-75X102	1
8	MD-486789	PLATE BOTT 250X51-250X102	1
7	MC-486549	AR SECTION A TRANSV END PLATE	1
6	MC-486489	AR SECTION D TRANSV A PLATE	1
5	MC-486799	PLATE TOP 250X50X100	1
4	MC-486795	PLATE TOP 250X50-250X100	1
3	MD-486548	AR SECT B BCK WLDNT LONGL PLT	4
2	MC-486507	FLAT PLATE 3/4X9X99	4
1	MC-486506	FLAT PLATE 3/4X9X25	8

PARTS LIST

PARTS LIST

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	E.VILLEGAS	31-JAN-2011
.XX	.XXX	ANGLES	DRAWN	B.ELLISON	31-JAN-2011
± .06	± •••	± 1°	CHECKED	J.RAUCH	29-APR-2011
1. BREAK ALL SHARP EDGES .015 MAX			APPROVED	E.VILLEGAS	29-APR-2011
2. DO NOT SCALE DRAWING.			USED ON	ME-486926 & ME-486927	
3. DIMENSIONS BASED UPON ASME Y14.5M-1994					
4. MAX. ALL MACH. SURFACES 500			MATERIAL	SEE PARTS LIST ABOVE	
5. DRAWING UNITS: U.S. INCH					

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

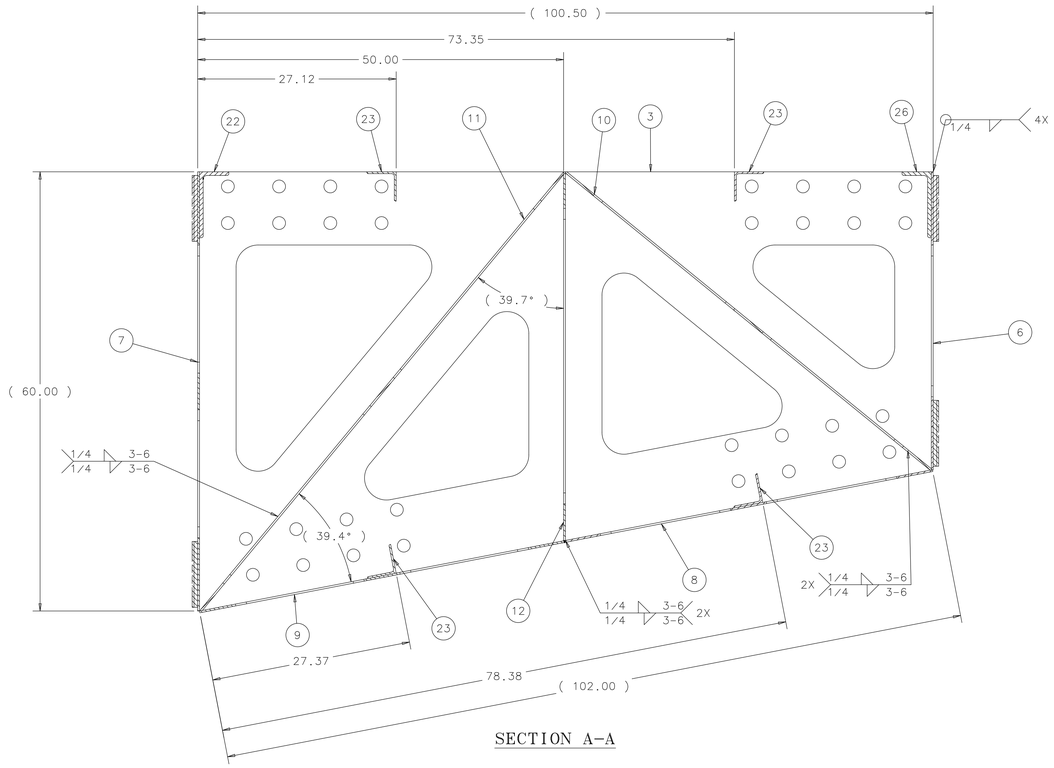
NOVA-EQUIPMENT HANDLING ASH RIVER ASSY TABLE AR SECTION B WLDNT

SCALE	DRAWING NUMBER	SHEET	REV
1:8 & AS NOTED	3929.220-ME-486827	1 OF 2	

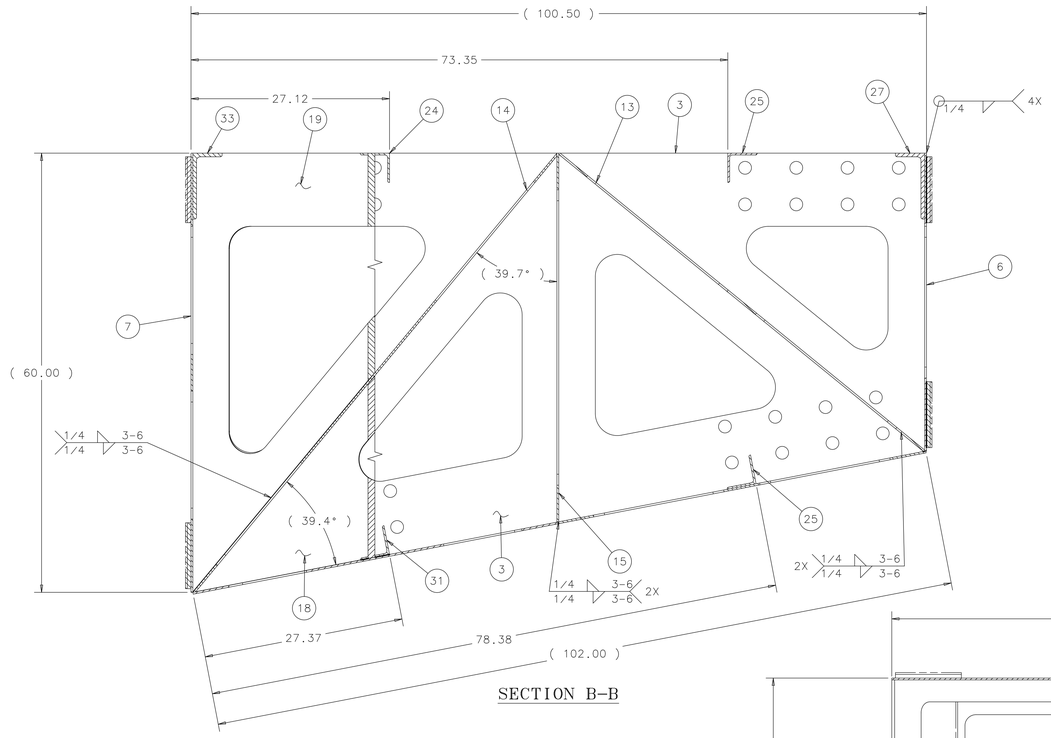
CREATED WITH : Ideas12NXSeries | GROUP: PPD/MECHANICAL DEPARTMENT

Created: 14:34:00 on 09-05-11 (D-M-Y) By: jerauch State: 1-INITIAL

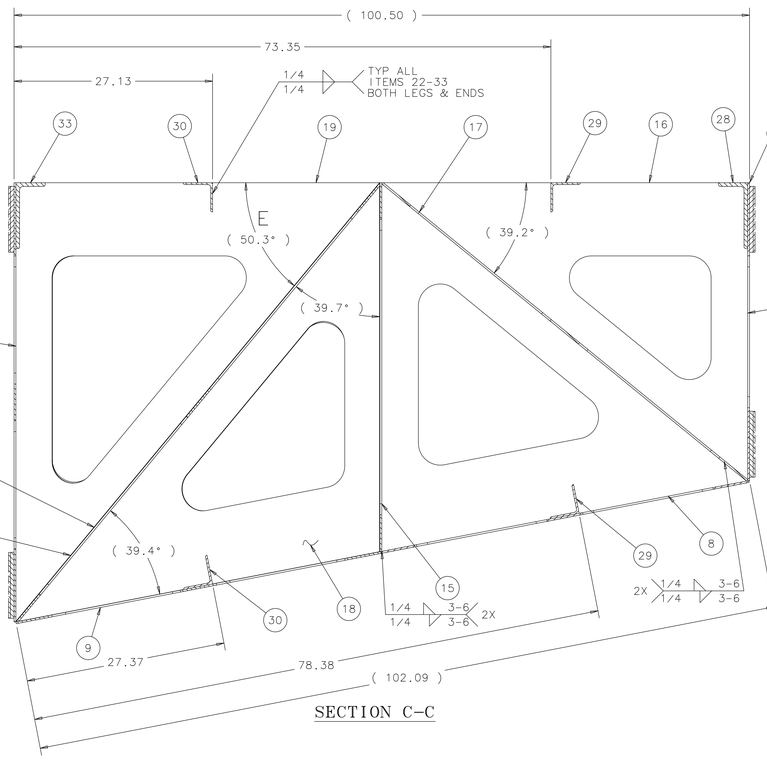
REV	DESCRIPTION	DRAWN	DATE
		APPROVED	DATE



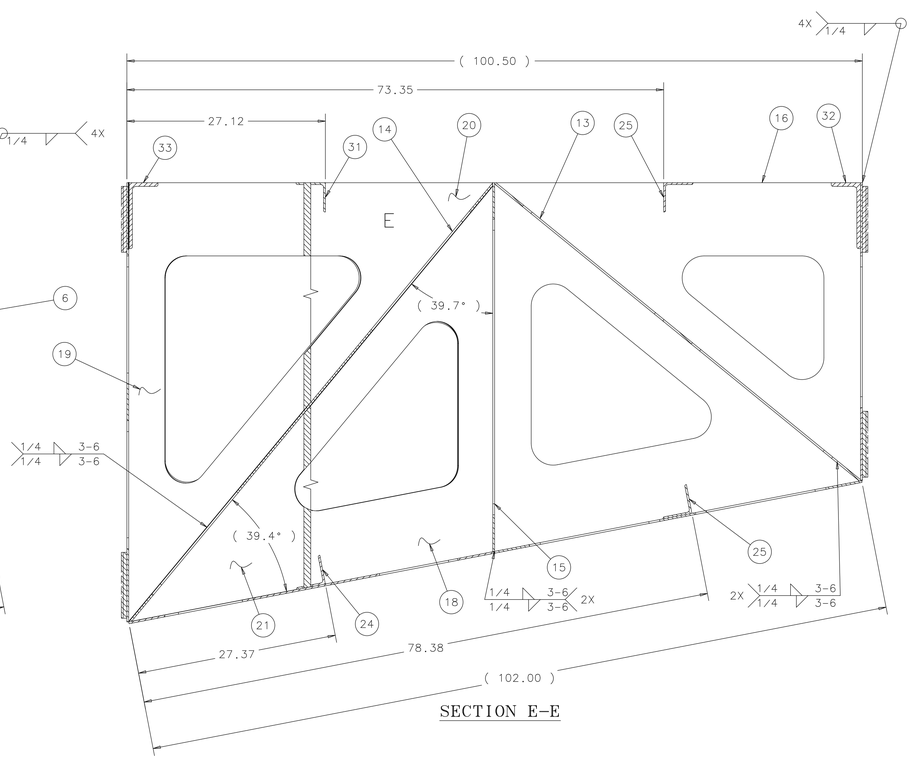
SECTION A-A



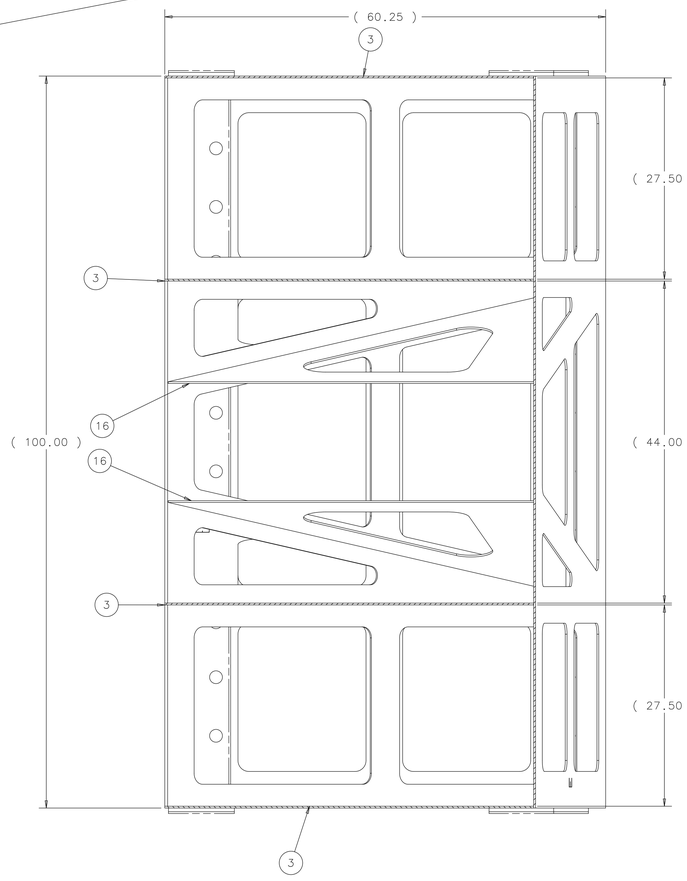
SECTION B-B



SECTION C-C



SECTION E-E



SECTION D-D

UNLESS OTHERWISE SPECIFIED		ORIGINATOR	E.VILLEGAS	31-JAN-2011
.XX	.XXX	ANGLES	DRAWN	B.ELLISON	31-JAN-2011
± .06	± •••	± 1°	CHECKED	J.RAUCH	29-APR-2011
1. BREAK ALL SHARP EDGES .015 MAX. 2. DO NOT SCALE DRAWING. 3. DIMENSIONS BASED UPON ASME Y14.5M-1994 4. MAX. ALL MACH. SURFACES 500 5. DRAWING UNITS: U.S.INCH			APPROVED	E.VILLEGAS	29-APR-2011
			USED ON	ME-486926 & ME-486927	
			MATERIAL	SEE PARTS LIST ABOVE	

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

NOVA-EQUIPMENT HANDLING ASH RIVER ASSY TABLE AR SECTION B WLDNT

SCALE	DRAWING NUMBER	SHEET	REV
1:8 & AS NOTED	3929.220-ME-486827	2 OF 2	
CREATED WITH : Ideas12NXSeries		GROUP: PPD/MECHANICAL DEPARTMENT	