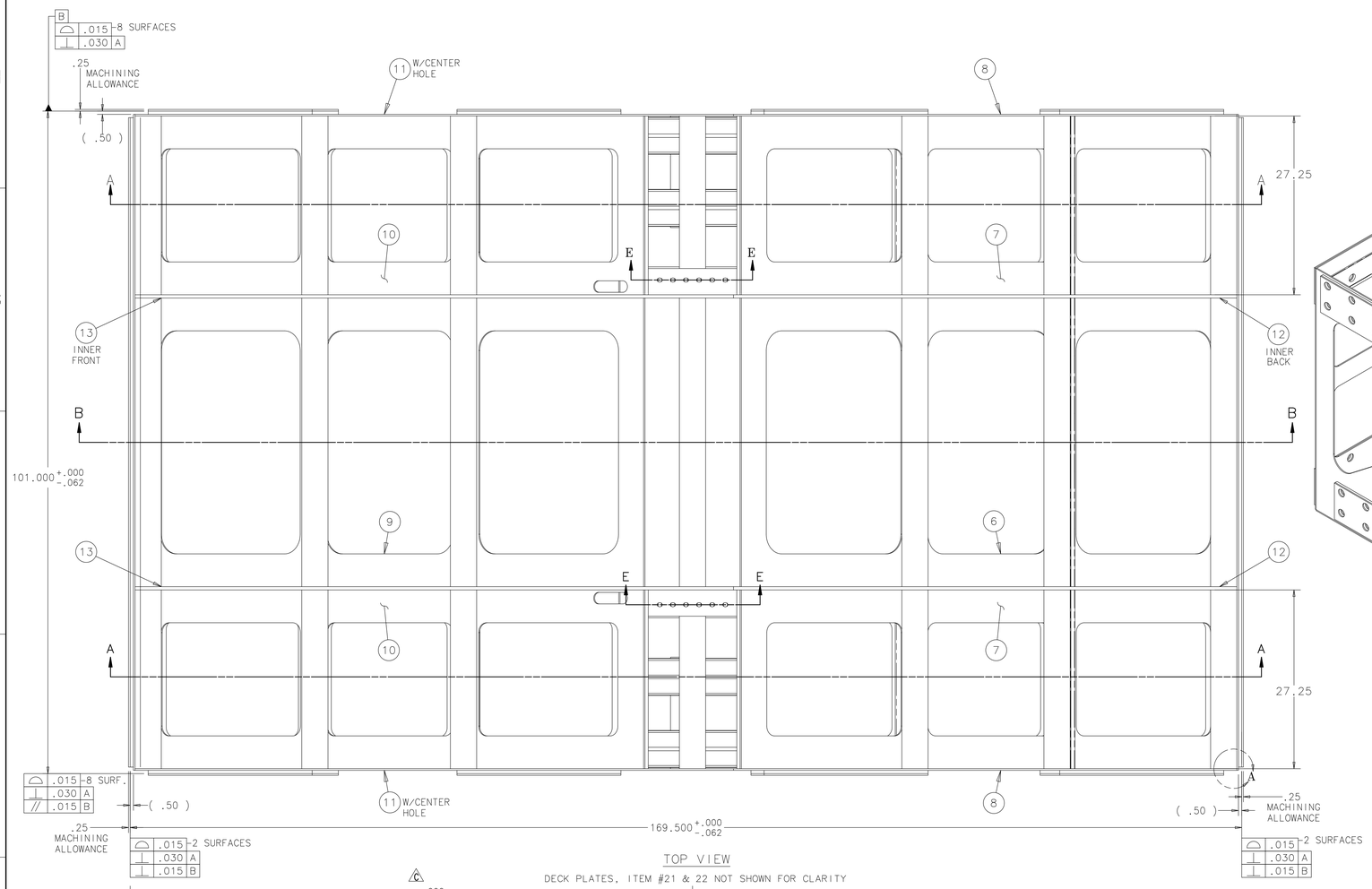
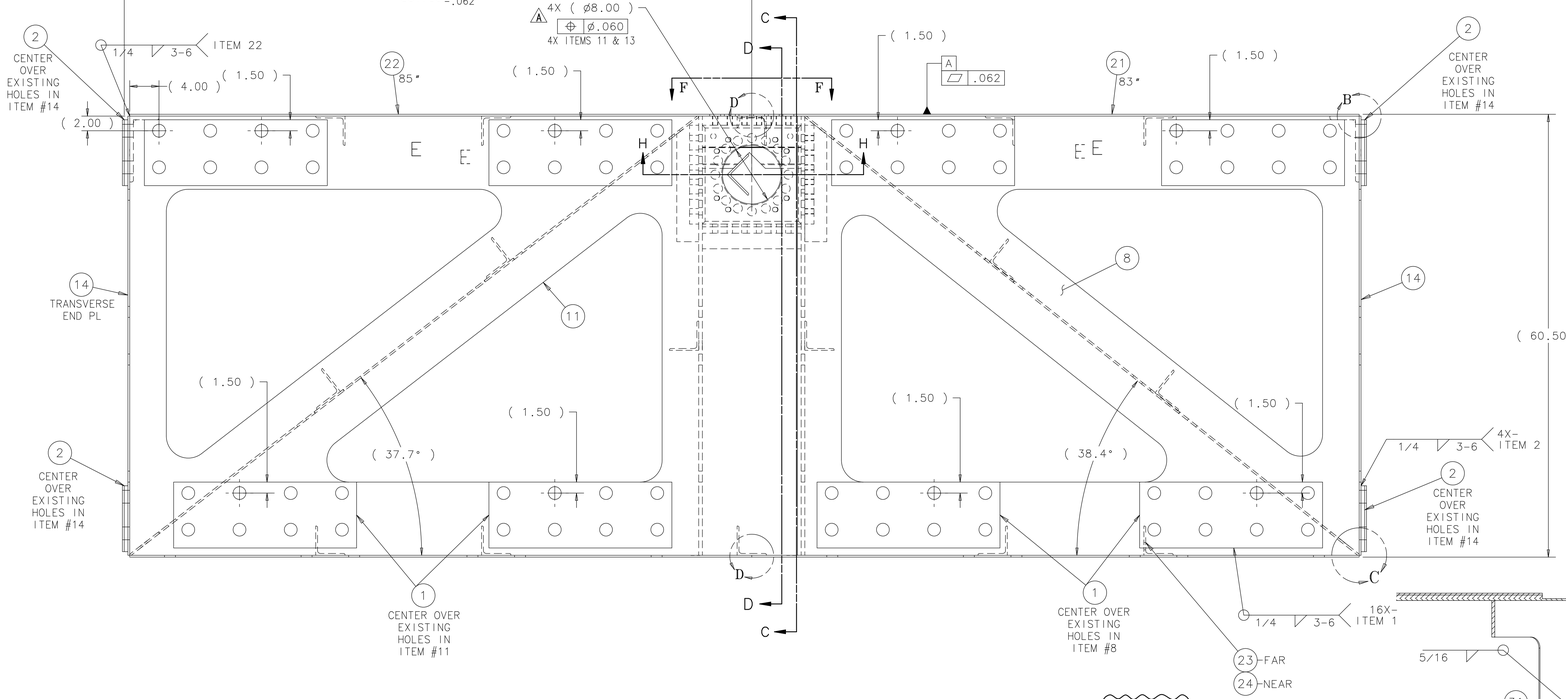
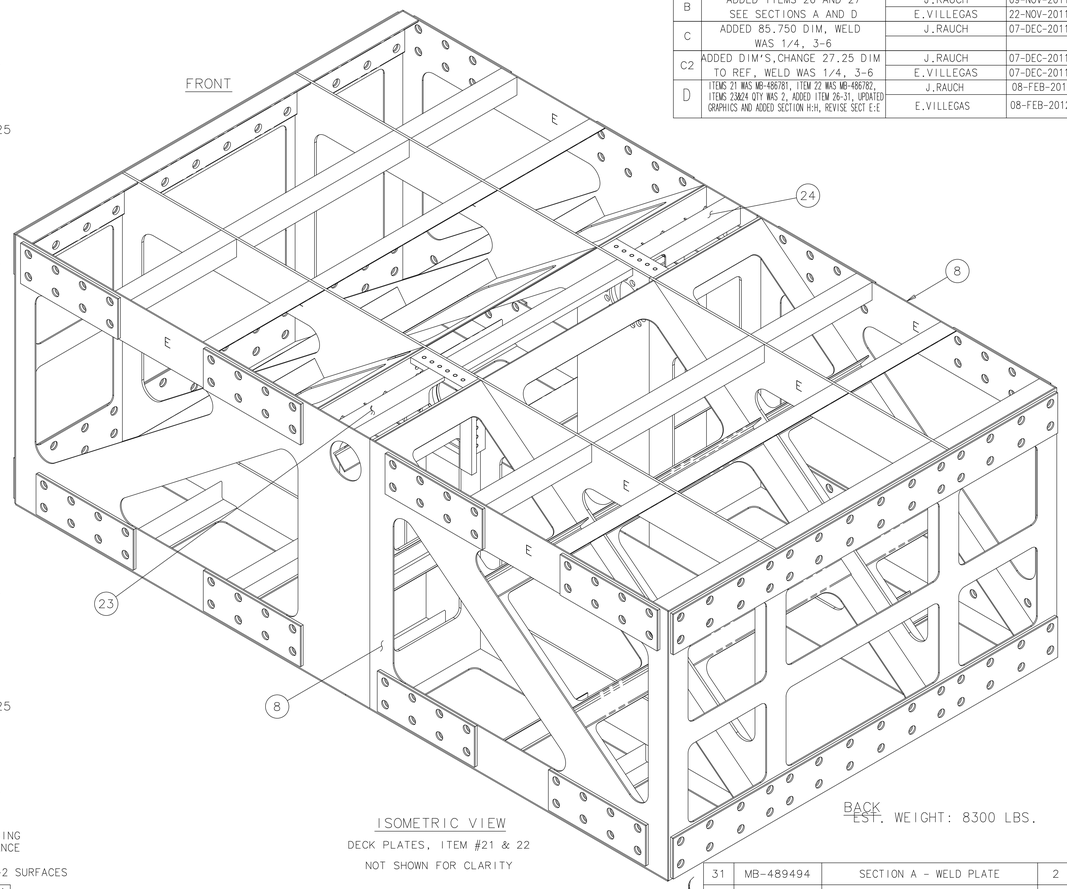
REV	DESCRIPTION	DRAWN / APPROVED	DATE
A	REV. QTY. OF ITEMS 19, 20, 23 & 24. SECTION D-D DIM. 5.17 WAS 5.00. ADDED ITEMS 25 AND 26 ANGLE TO CHANNEL. ADDED SECTION E-E. ADDED ø8.00 DIM. AND MODIFIED NOTE #6.	B.CYKO / E.VILLEGAS	05-31-2011 / 24-JUN-2011
B	ADDED ITEMS 26 AND 27 SEE SECTIONS A AND D	J.RAUCH / E.VILLEGAS	09-NOV-2011 / 22-NOV-2011
C	ADDED 85.750 DIM, WELD WAS 1/4, 3-6	J.RAUCH	07-DEC-2011
C2	ADDED DIM'S,CHANGE 27.25 DIM TO REF, WELD WAS 1/4, 3-6	J.RAUCH / E.VILLEGAS	07-DEC-2011 / 07-DEC-2011
D	ITEMS 21 WAS MB-486781, ITEM 22 WAS MB-486782, ITEMS 23&24 QTY WAS 2, ADDED ITEM 26-31, UPDATED GRAPHICS AND ADDED SECTION H:H, REVISE SECT E:E	J.RAUCH / E.VILLEGAS	08-FEB-2011 / 08-FEB-2012



TOP VIEW

DECK PLATES, ITEM #21 & 22 NOT SHOWN FOR CLARITY





ISOMETRIC VIEW

DECK PLATES, ITEM #21 & 22

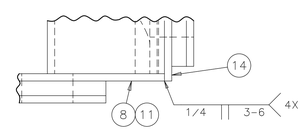
NOT SHOWN FOR CLARITY

BACK

EST. WEIGHT: 8300 LBS.

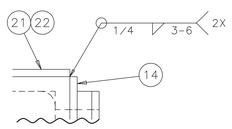
NOTES

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 WELDING SHALL BE IN ACCORDANCE WITH ANSI/AWS D1.1, "STRUCTURAL WELDING CODE - STEELL"
3. ALL WELDS SHALL BE MADE IN A SEQUENCE THAT WILL BALANCE APPLIED WELDING HEAT WHILE THE WELDING PROGRESSES. THE PROCEDURE AND SEQUENCE SHALL BE DESIGNED TO MINIMIZE DISTORTION AND SHRIKNAGE 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.
5. ALL WELD THAT FAIL AN INSPECTION SHALL BE REPAIRED IN ACCORDANCE WITH ANSI/AWS D1.1.
6. PAINT WITH PRIMER, DAMP-PROOF "RUST-O-LEUM" OR SHOP PRIMER.
7. STAMPED LETTER "E" PROVIDED ON SOME ITEMS TO AID IN POSITIONING.



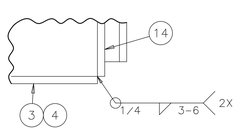
DETAIL A - SIDE CORNER WELD

SCALE= 1:2



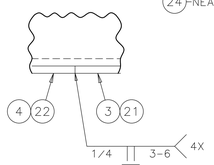
DETAIL B - TOP CORNER WELD

SCALE= 1:2



DETAIL C - BOTTOM CORNER WELD

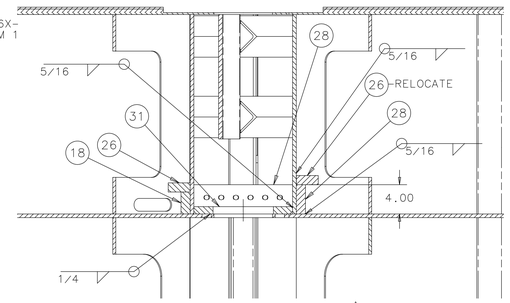
SCALE= 1:2



DETAIL D - SEAM WELD

TYP FOR DECK PLATES & BOTTOM PLATES

SCALE= 1:2



SECTION VIEW H:H

ITEM	PART NO.	DESCRIPTION OR SIZE	QTY.
31	MB-489494	SECTION A - WELD PLATE	2
30	MB-489496	ANGLE,4X4X23.25,COPED-RIGHT	1
D 29	MB-489497	ANGLE,4X4X23.25,COPED-LEFT	1
28	MB-489499	BEARING HOUSING VERT SUPT BLOCK	4
B 27	MB-489403	BEARING HOUSING H SUPT BLOCK	2
B 26	MB-489402	BEARING HOUSING V SUPT BLOCK	4
A 25	COML.	CHANNEL, C4 X 5.4# X 44.00 LG.	1
A 24	MB-486816	STIFFENER ANGLE,4 x 4,COPED-RIGHT	1
A 23	MB-486814	STIFFENER ANGLE, 4 x 4,COPED-LEFT	1
22	MB-489492	DECK PLATE, 85 x 100	1
21	MB-489491	DECK PLATE, 83 x 100	1
A 20	MB-486778	STIFFENER ANGLE, 4 x 4 x 44.00	8
A 19	MB-486777	STIFFENER ANGLE, 4 x 4 x 27.25 LG	28
18	MB-486556	BEARING HOUSING SUPPORT BLOCK	4
17	MC-486796	TABLE PIVOT, SHAFT GUIDE WELDMENT	2
16	MC-486555	STIFFENER ANGLE B, 4 x 9 x 44.00	2
15	MC-486554	STIFFENER ANGLE A, 4 x 9 x 27.25	4
14	MC-486549	TRANSVERSE END PLATE	2
13	MD-486547	INNER FRONT PLATE	2
12	MC-486546	INNER BACK PLATE	2
11	MC-486544	FRONT SIDE PLATE	2
10	MC-486543	FRONT DIAGONAL PLATE	2
9	MC-486542	FRONT CENTER DIAGONAL PLATE	1
8	MC-486541	BACK SIDE PLATE	2
7	MC-486540	BACK DIAGONAL PLATE	2
6	MC-486539	BACK CENTER DIAGONAL PLATE	1
5	MC-486538	TRANSVERSE SIDE PLATE	4
4	MC-486532	BOTTOM PLATE, 1/4 x 28 x 85	2
3	MC-486531	BOTTOM PLATE, 1/4 x 28 x 83	2
2	MC-486507	REINFORCING PLATE, 3/4 x 9 x 99	4
1	MC-486506	REINFORCING PLATE, 3/4 x 9 x 25	16

PARTS LIST

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	E.VILLEGAS	29-APR-2010
.XX	.XXX	ANGLES	DRAWN	P.POLL	11-JAN-2011
± .03	± ---	± 1°	CHECKED	J.RAUCH	29-APR-2011
			APPROVED	E.VILLEGAS	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 250
5. DRAWING UNITS: U.S. INCH

USED ON: ME-489035

MATERIAL: SEE PARTS LIST ABOVE

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

NOVA-EQUIPMENT HANDLING ASH RIVER ASSEMBLY TABLE SECTION A PIVOT WELDMENT

SCALE	DRAWING NUMBER	SHEET	REV
1:8 & NOTED	3929.220-ME-486642	1 OF 1	D

CREATED WITH : Ideas12NXSeries | GROUP: PPD/MECHANICAL DEPARTMENT

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REV	DESCRIPTION	DRAWN / APPROVED	DATE
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B	ADDED ITEMS 26 AND 27 SEE SECTIONS A AND D	J.RAUCH / E.VILLEGAS	09-NOV-2011 / 22-NOV-2011
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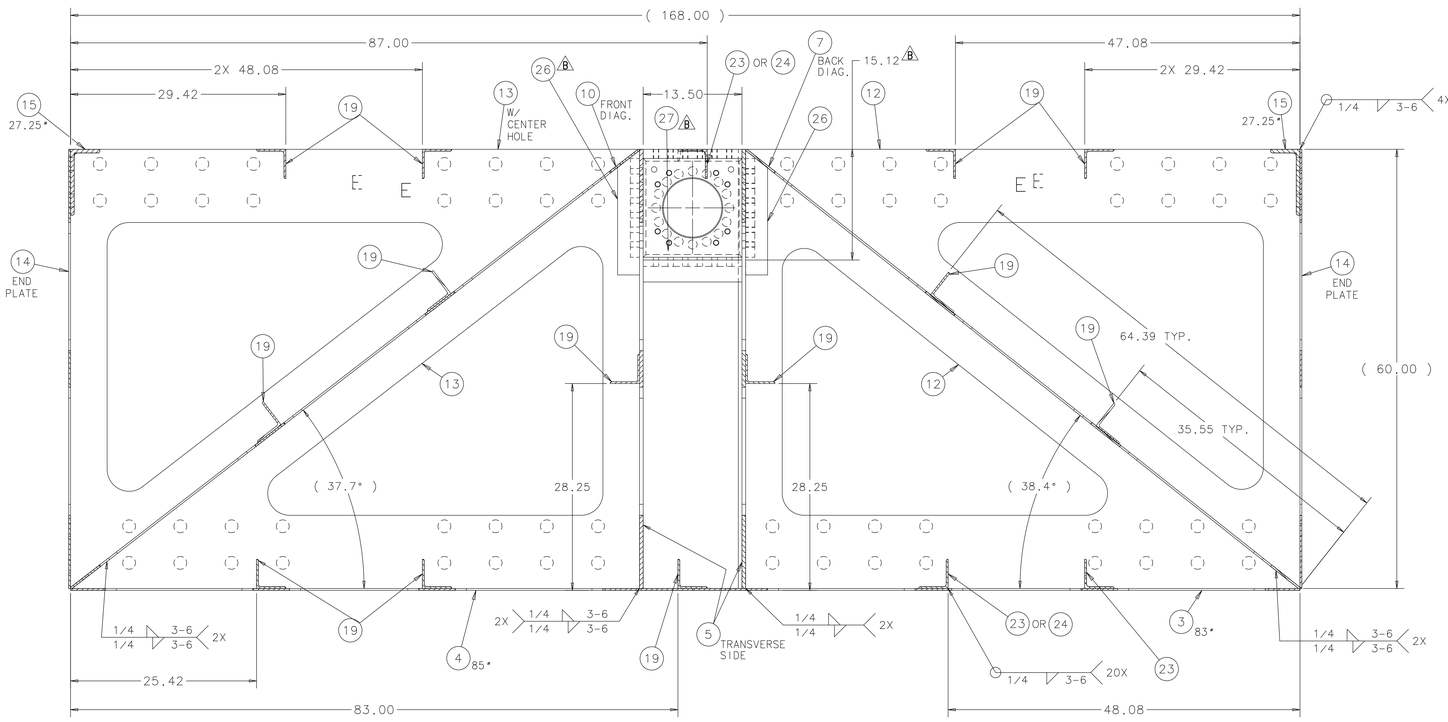
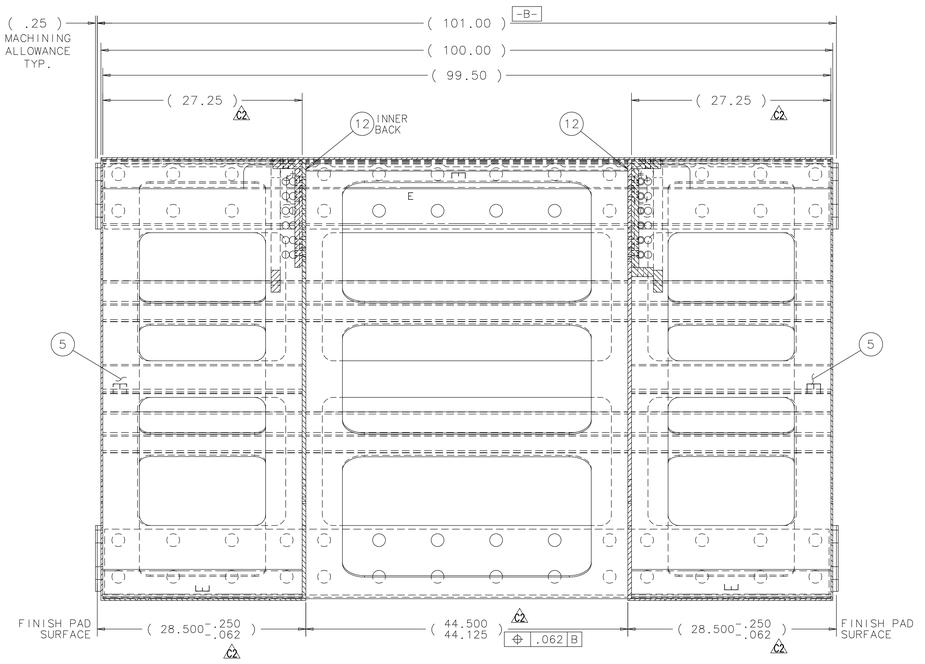


SECTION A-A

REINFORCING PLATES

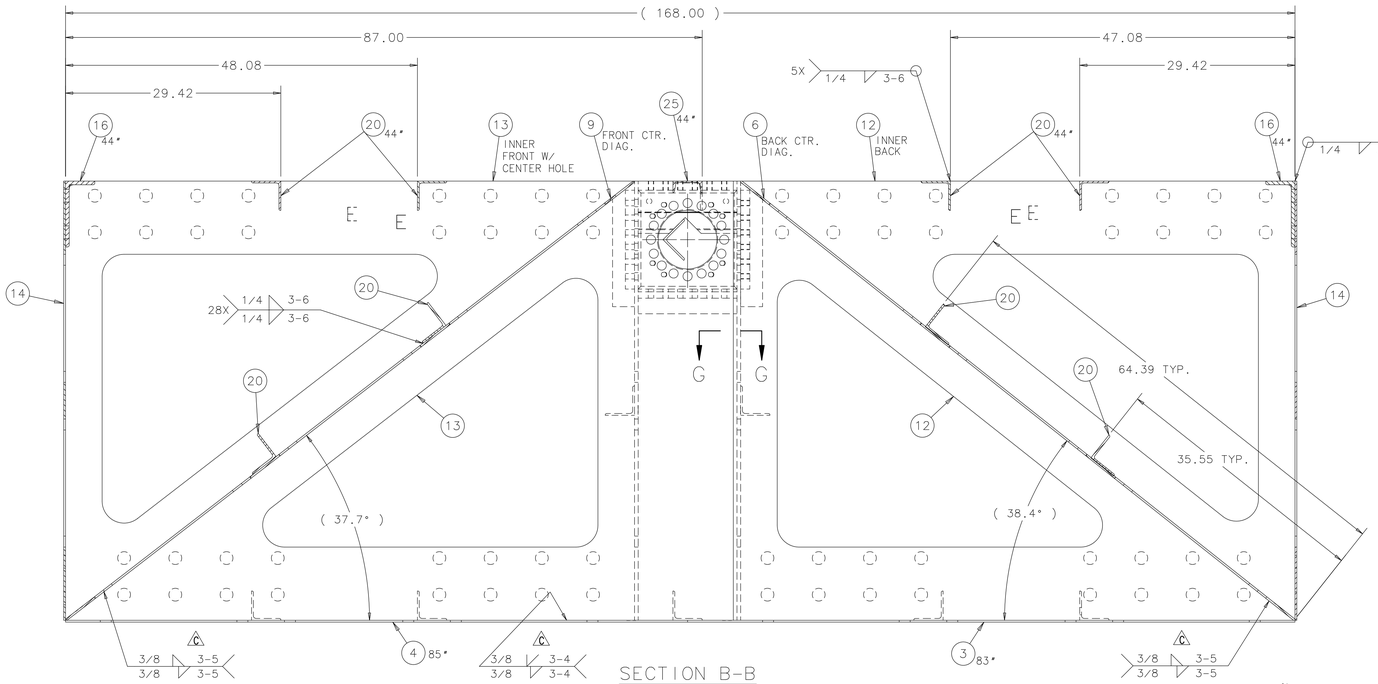
NOT SHOWN FOR CLARITY



SECTION C-C

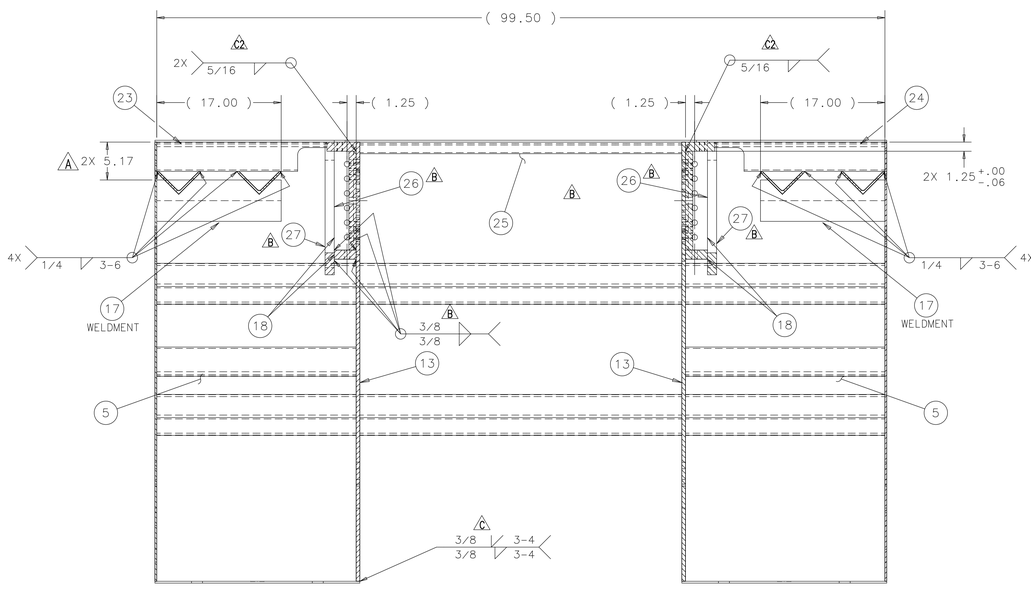
REINFORCING PLATES

NOT SHOWN FOR CLARITY



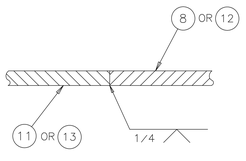
SECTION B-B

REINFORCING PLATES NOT SHOWN FOR CLARITY



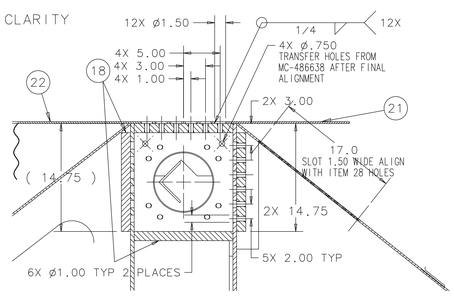
SECTION D-D

SOME STRUCTURAL PLATES NOT SHOWN FOR CLARITY

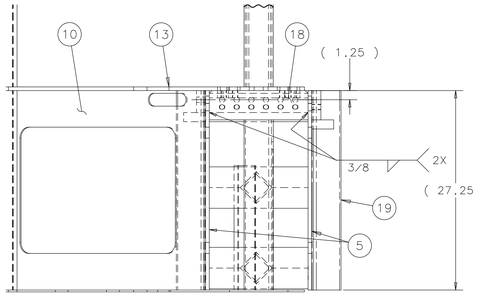


A SECTION G-G

SCALE: 1:1



SECTION E-E D



VIEW F-F

DECK PLATES NOT SHOWN FOR CLARITY

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	E.VILLEGAS	29-APR-2010
.XX	.XXX	ANGLES	DRAWN	P.POLL	11-JAN-2011
± .03	± ---	± 1°	CHECKED	J.RAUCH	29-APR-2011
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			USED ON	ME-489035	
			MATERIAL	SEE PARTS LIST ABOVE	

FERMI NATIONAL ACCELERATOR LABORATORY
UNITED STATES DEPARTMENT OF ENERGY

NOVA-EQUIPMENT HANDLING ASH RIVER ASSEMBLY TABLE SECTION A PIVOT WELDMENT

SCALE	DRAWING NUMBER	SHEET	REV
1:8 & NOTED	3929.220-ME-486642	2 OF 1	D

CREATED WITH : Ideas12NXSeries | GROUP: PPD/MECHANICAL DEPARTMENT

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