



1. Part Number: EPIC-200	2. Part Name: EPIC 8M TOWER ASSEMBLY TOWER BODY ASSEMBLY	3. Serial Number: N/A	4. FAIR Identifier: 5213
5. Part Revision Level: 0	6. Drawing Number: EPIC-200	7. Drawing Revision Level: 0	8. Additional Changes: N/A
9. Manufacturing Process Reference: N/A	10. Organization Name: OAK RIDGE NATIONAL LABORATORY	11. Supplier Code: N/A	12. Purchase Order Number:
13. Detail: <input checked="" type="checkbox"/> Assembly: <input checked="" type="checkbox"/> PARTIAL ASSEMBLY	14. Full FAI: <input type="checkbox"/> Partial FAI: <input checked="" type="checkbox"/> Baseline Part Number (including revision level): Reason for Full / Partial FAI: "ONLY CERTAIN PARTS WERE DONE; ENTIRE PROCESS IS NOT COMPLETE"		
a) If the part number above is a detail part only, go to field 19. b) If the part number above is an assembly, go to the "INDEX" section below.			
INDEX of part numbers or sub-assembly numbers required to make the assembly noted above.			
15. Part Number:	16. Part Name:	17. Part Type:	18. FAIR Identifier:
N/A	N/A	N/A	N/A
19. Does FAIR Contain a Documented Nonconformance(s)? Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>			
20. FAIR Verified By: Mauro Contreras			21. Date: 5/07/2024
22. FAIR Reviewed/Approved By:			23. Date:
24. Customer Approval:			25. Date:
26. Comments:			

AS9102 REV C - FORM 2 - PRODUCT ACCOUNTABILITY - MATERIALS, SPECIAL PROCESSES, AND FUNCTIONAL TESTING



1. Part Number: EPIC-200	2. Part Name: EPIC 8M TOWER ASSEMBLY TOWER BODY ASSEMBLY		3. Serial Number: N/A		4. FAIR Identifier 5213
5. Material or Process Name:	6. Specification Number:	7. Code:	8. Supplier:	9: Customer Approval Verification:	10. Certificate of Conformance Number:
MATERIAL	AISI 1020 PLATE-375, ASIS 10 HR PLATE-625, ALUM 6061-T625"THKX4"X8"	N/A	LEADING EDGE METALS & ALLOYS INC. 22916 LOCKNESS AVE, TORRANCE, CA 90501	N/A	600
MATERIAL	CRS 1020 ANNELED AK .078"X8"X55"	N/A	LEADING EDGE METALS & ALLOYS INC. 22916 LOCKNESS AVE, TORRANCE, CA 90501	N/A	651
MATERIAL	A36 1.500"X6"X58"	N/A	LEADING EDGE METALS & ALLOYS INC. 22916 LOCKNESS AVE, TORRANCE, CA 90501	N/A	639
MATERIAL	6061-T6511, 50"X5"X60" - 50"X10"X60"	N/A	LEADING EDGE METALS & ALLOYS INC. 22916 LOCKNESS AVE, TORRANCE, CA 90501	N/A	32323/32325
MATERIAL	1018 1.50"X6"-1"X6"X5FT,-HR FLATS 1"X6"X2FT-HR CHAIN 4"X1.64"X.247"X5FT	N/A	LEADING EDGE METALS & ALLOYS INC. 22916 LOCKNESS AVE, TORRANCE, CA 90501	N/A	625
		N/A		N/A	
11. Functional Test Procedure Number:			12. Acceptance Report Number:		
N/A			N/A		
13. Comments:					
14. Signature: Mauro Contreras			15. Date: 5/07/2024		



1. Part Number:					2. Part Name:			3. Serial Number:	4. FAIR Identifier:
EPIC-200					EPIC 8M TOWER ASSEMBLY TOWER BODY ASSEMBLY			N/A	5213
Characteristic Accountability					Inspection/Test Results				
5. Char. No.:	6. Reference Location:	7. Characteristic Designator:	8. Requirement:	GD&T	9. Results:	10: Designed/Qualified Tooling:	11. Nonconformance Number:	12. Additional Data/Comments:	
1	S1 A-1	Minor	Note: EPIC-200 EPIC 8M TOWER ASSEMBLY TOWER BODY ASSEMBLY	N/A	COMPLY	N/A	N/A	N/A	N/A
2	S1 A-1	Minor	Note: EPIC-201 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
3	S1 A-1	Minor	Note: EPIC-202 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
4	S1 B-1	Minor	Note: EPIC-203 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
5	S1 B-1	Minor	Note: EPIC-204 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
6	S1 B-1	Minor	Note: EPIC-205 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
7	S1 B-1	Minor	Note: EPIC-206 MATERIAL	N/A	STAINLESS STEEL	N/A	N/A	N/A	N/A
8	S1 B-1	Minor	Note: EPIC-207 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
9	S1 B-1	Minor	Note: EPIC-208 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
10	S1 B-1	Minor	Note: EPIC-209 MATERIAL	N/A	1020 CARBON STEEL	N/A	N/A	N/A	N/A
11	S1 A-3	Minor	Note: UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M BREAK SHARP CORNERS AND REMOVE ALL BURRS DEFAULT TOLERANCES: LINEAR / ANGULAR X.X = ±.100 ±1/2° X.XX = ±.010 X.XXX = ±.005	N/A	COMPLY	N/A	N/A	N/A	N/A
12	S1 D-8	Minor	Note: 1. P/N 11 & 12 WILL BE ORIENTED WITH THE TAPPED HOLES FACING UP.	N/A	COMPLY	N/A	N/A	N/A	N/A
13	S1 D-8	Minor	Note: 2. FOR REFERENCE, P/N 11 TO BE PLACED IN POSITION # 17, 34, & 51 FOR ALL ABSORBER PLATES. MATCH UP HOLE PATTERN ON P/N 6 & 9 TO VERIFY PRIOR TO WELDING.	N/A	COMPLY	N/A	N/A	N/A	N/A

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14	S1 D-8	Minor	Note: 3. E-BEAM WELD ALONG CENTERLINE OF CONTACTING FACES ALL PARTS P/N 4, 5, 6, 7, 8, 10, 11, & 12. ALLOW 1/8" CLEARANCE FROM WELDS TO ALL HOLES. DO NOT WELD P/N 9. USE A JIG AND SPACING PLATES OF PROPER WIDTH TO ENSURE PROPER SPACING. WELDING PROCEDURE TO BE DETAILED AND APPROVED BY ORNL PRIOR TO EXECUTION.	N/A	COMPLY	N/A	N/A	N/A	N/A
15	S1 D-8	Minor	Note: 4. POST MACHINE AND/OR STRAIGHTEN AS NECESSARY POST WELDING TO ACHIEVE FINAL DIMENSIONING AND TOLERANCING. VERIFY THE INTEGRITY OF ALL WELDS AFTER ALL POST MACHINING PROCESSES.	N/A	COMPLY	N/A	N/A	N/A	N/A
16	S1 D-8	Minor	Note: 5. ALL WELDING AND WELD INSPECTIONS PER AWS D1.1/D1.1M - 2010.	N/A	COMPLY	N/A	N/A	N/A	N/A
17	S1 D-8	Minor	Note: 6. ALL WELDS SHALL RECEIVE A VISUAL INSPECTION. SELLER SHALL PROVIDE VISUAL EXAMINATION CERTIFICATION OF COMPLIANCE CERTIFYING THE PERFORMANCE OF THE INSPECTION AND THE ACCEPTABILITY OF THE WELDS.	N/A	COMPLY	N/A	N/A	N/A	N/A
18	S1 C-8	Minor	Note: 7. PERSONNEL PERFORMING VISUAL INSPECTIONS SHALL BE CERTIFIED WELD INSPECTORS UNDER AWS QC-1 OR AS VISUAL TESTING LEVEL II OR LEVEL III IN ACCORDANCE WITH SNTTC-IA.	N/A	COMPLY	N/A	N/A	N/A	N/A
19	S1 C-8	Minor	Note: 8. ELECTROLESS NICKEL PLATE FINAL WELDMENT (EXCLUDING P/N 1, 2, 3, & 9) TO 0.001" THICKNESS MINIMUM / 0.002" THICKNESS MAXIMUM PER ASTM B766.	N/A	COMPLY	N/A	N/A	TO BE DONE..	
20	S1 C-7	Minor	Linear Dimension: 52.760 +/--.005 in	N/A		MITUTOYO CMM B251	N/A	N/A	N/A
21	S1 B-6	Minor	Note: 3. 67X	N/A	COMPLY	N/A	N/A	N/A	N/A
22	S1 B-6	Minor	Note: 3. 67X	N/A	COMPLY	N/A	N/A	N/A	N/A
23	S1 B-5	Minor	Note: 3. 67X	N/A	COMPLY	N/A	N/A	N/A	N/A
24	S1 B-5	Minor	Flatness: <= .010 in	□ .010	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A

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25	S1 C-4	Minor	Linear Dimension: .209 +/- .002 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
26	S1 B-3	Minor	Thickness: 3.927 +.000 -.010 in	N/A	IN PROCESS	3"-4" Micrometer	N/A	N/A	N/A
27	S1 B-4	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
28	S1 B-6	Minor	Thickness: 7.864 +.000 -.010 in	N/A	IN PROCESS	0-12" CALIPER	N/A	N/A	N/A
29	S1 B-5	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
30	S1 D-5	Minor	Note: ITEM# 1	N/A	COMPLY	N/A	N/A	N/A	N/A
31	S1 D-4	Minor	Note: ITEM# 9	N/A	COMPLY	N/A	N/A	N/A	N/A
32	S1 D-4	Minor	Note: ITEM# 5	N/A	COMPLY	N/A	N/A	N/A	N/A
33	S1 D-4	Minor	Note: ITEM# 3	N/A	COMPLY	N/A	N/A	N/A	N/A
34	S1 D-3	Minor	Note: ITEM# 6	N/A	COMPLY	N/A	N/A	N/A	N/A
35	S1 D-2	Minor	Note: ITEM# 8	N/A	COMPLY	N/A	N/A	N/A	N/A
36	S1 D-1	Minor	Note: ITEM# 2	N/A	COMPLY	N/A	N/A	N/A	N/A
37	S1 C-1	Minor	Note: ITEM# 4	N/A	COMPLY	N/A	N/A	N/A	N/A
38	S1 B-1	Minor	Note: ITEM# 7	N/A	COMPLY	N/A	N/A	N/A	N/A
39	S1 B-2	Minor	Note: ITEM# 10	N/A	COMPLY	N/A	N/A	N/A	N/A
40	S1 C-4	Minor	Note: ITEM# 11	N/A	COMPLY	N/A	N/A	N/A	N/A
41	S1 C-4	Minor	Note: ITEM# 12	N/A	COMPLY	N/A	N/A	N/A	N/A
42	S2 A-1	Minor	Note: EPIC-201 FRONT PLATE	N/A	COMPLY	N/A	N/A	N/A	N/A
43	S2 B-7	Minor	Linear Dimension - Basic: .236 in	N/A	0.2358	XM-1600-CMM	N/A	N/A	N/A
44	S2 B-8	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I .005@0 A B C	0.0039	MITUTOYO CMM B251	N/A	N/A	N/A
45	S2 B-8	Minor	Linear Dimension - Basic: 3.778 in	N/A	3.7782	3"-4" Micrometer	N/A	N/A	N/A
46	S2 B-7	Minor	Linear Dimension - Basic: 3.346 in	N/A	3.3447	XM-1600-CMM	N/A	N/A	N/A
47	S2 C-8	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I .005@0 A B C	0.0041	MITUTOYO CMM B251	N/A	N/A	N/A
48	S2 C-7	Minor	Thread Type: M3X0.5-6H	N/A	COMPLY6	M3 THREAD GAUGE	N/A	N/A	N/A
49	S2 C-7	Minor	Diameter: .10 +/- .010 in	N/A	0.098	PIN GAUGE	N/A	N/A	N/A
50	S2 C-7	Minor	Depth: .30 +/- .010 in	N/A	0.02987	DROP GAUGE	N/A	N/A	N/A
51	S2 C-7	Minor	Thread Depth: .24 +/- .010 in	N/A	0.2398	PIN WITH DROP INDICATOR	N/A	N/A	N/A
52	S2 C-7	Minor	True Position: <= .007 in Diameter, Reference Datum A B C	.007 A B C	0.0042	MITUTOYO CMM B251	N/A	N/A	N/A
53	S2 C-7	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I .005@0 A B C	0.0044	MITUTOYO CMM B251	N/A	N/A	N/A
54	S2 D-5	Minor	Linear Dimension - Basic: 7.715 in	N/A	7.716	0-12" CALIPER	N/A	N/A	N/A
55	S2 D-5	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.9367	XM-1600-CMM	N/A	N/A	N/A
56	S2 C-4	Minor	Thickness: .598 +/- .005 in	N/A	0.5972	0-1" Micrometer	N/A	N/A	N/A
57	S2 C-3	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I .005@0 A B C	0.0038	MITUTOYO CMM B251	N/A	N/A	N/A
58	S2 C-4	Minor	Thickness: .079 +.000 -.005 in	N/A	0.0775	0-1" Micrometer	N/A	N/A	N/A

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59	S2 C-5	Minor	Thread Type: M6X1.0-6H	N/A	COMPLY	M6 THREAD GAUGE	N/A	N/A	N/A
60	S2 C-5	Minor	Diameter: .20 +/- .010 in	N/A	0.1997	PIN GAUGE	N/A	N/A	N/A
61	S2 C-4	Minor	Depth: .59 +/- .010 in	N/A	0.588	DIGITAL DROP INDICATOR	N/A	N/A	N/A
62	S2 C-4	Minor	Thread Depth: .47 +/- .010 in	N/A	0.4693	PIN WITH DROP INDICATOR	N/A	N/A	N/A
63	S2 C-4	Minor	True Position: <= .009 in Diameter, Reference Datum A B C	.009 A B C	0.0038	MITUTOYO CMM B251	N/A	N/A	N/A
64	S2 C-6	Minor	Flatness: <= .010 in	□ .010	0.0008	MITUTOYO CMM B251	N/A	N/A	N/A
65	S2 C-6	Minor	Linear Dimension - Basic: .339 in	N/A	0.3378	XM-1600-CMM	N/A	N/A	N/A
66	S2 B-7	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.0044	MITUTOYO CMM B251	N/A	N/A	N/A
67	S2 B-6	Minor	Thickness: 3.927 +.000 -.005 in	N/A	3.9254	3"-4" Micrometer	N/A	N/A	N/A
68	S2 C-5	Minor	Diameter: .41 +/- .010 in	N/A	0.4098	PINGAUGE	N/A	N/A	N/A
69	S2 C-4	Minor	Thread Type: M12X1.5-6H	N/A	COMPLY	M12 THREAD GAUGE	N/A	N/A	N/A
70	S2 C-4	Minor	True Position: <= 0.025 in Diameter, Reference Datum A B C	0.025 A B C	0.0085	MITUTOYO CMM B251	N/A	N/A	N/A
71	S2 B-5	Minor	Linear Dimension: 7.864 +.000 -.005 in	N/A	7.862	0-12" CALIPER	N/A	N/A	N/A
72	S2 B-5	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.003	MITUTOYO CMM B251	N/A	N/A	N/A
73	S3 A-1	Minor	Note: EPIC-202 BACK PLATE	N/A	COMPLY	N/A	N/A	N/A	N/A
74	S3 B-7	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I [0.005⊙0 A B C	0.0035	MITUTOYO CMM B251	N/A	N/A	N/A
75	S3 B-8	Minor	Linear Dimension - Basic: .157 in	N/A	0.1567	HB400-Comparator	N/A	N/A	N/A
76	S3 B-8	Minor	Linear Dimension - Basic: 3.346 in	N/A	3.3455	HB400-Comparator	N/A	N/A	N/A
77	S3 C-8	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I [0.005⊙0 A B C	0.0045	MITUTOYO CMM B251	N/A	N/A	N/A
78	S3 C-8	Minor	Thread Type: M3X0.5-6H	N/A	COMPLY	M3 THREAD GAUGE	N/A	N/A	N/A
79	S3 C-7	Minor	Diameter: .10 +/- .010 in	N/A	0.0998	PIN GAUGE	N/A	N/A	N/A
80	S3 C-7	Minor	Depth: .30 +/- .010 in	N/A	0.0302	PIN WITH DROP INDICATOR	N/A	N/A	N/A
81	S3 C-7	Minor	Thread Depth: .24 +/- .010 in	N/A	0.2398	PIN WITH DROP INDICATOR	N/A	N/A	N/A
82	S3 B-7	Minor	True Position: <= .007 in Diameter, Reference Datum A B C	.007 A B C	0.0045	MITUTOYO CMM B251	N/A	N/A	N/A
83	S3 B-7	Minor	Thickness - Basic: 3.778 in	N/A	3.3791	3"-4" Micrometer	N/A	N/A	N/A
84	S3 C-7	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	I [0.005⊙0 A B C	0.0042	MITUTOYO CMM B251	N/A	N/A	N/A
85	S3 C-7	Minor	Flatness: <= .010 in	□ .010	0.0015	MITUTOYO CMM B251	N/A	N/A	N/A

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86	S3 C-5	Minor	Thickness: .315 +/- .005 in	N/A	0.3145	0-1" Micrometer	N/A	N/A	N/A
87	S3 C-4	Minor	Thickness: .079 +.000 -.005 in	N/A	0.0774	0-1" Micrometer	N/A	N/A	N/A
88	S3 C-4	Minor	Profile of a Surface: <= .005 in Reference Datum A B C	$\text{I } \left[\begin{array}{c} \text{0.005} \\ \text{0} \end{array} \right] \text{A} \left[\begin{array}{c} \text{B} \\ \text{C} \end{array} \right]$	0.0033	MITUTOYO CMM B251	N/A	N/A	N/A
89	S3 C-5	Minor	Thickness - Basic: 7.715 in	N/A	7.7152	0-12" CALIPER	N/A	N/A	N/A
90	S3 B-7	Minor	True Position: <= 0.25 in Reference Datum A B C	$\left \begin{array}{c} 0.25 \\ \text{A} \end{array} \right \text{B} \left \begin{array}{c} \text{C} \\ \end{array} \right $	0.0077	MITUTOYO CMM B251	N/A	N/A	N/A
91	S3 B-7	Minor	Linear Dimension: 2.76 +/- .010 in	N/A	2.7646	XM-1600-CMM	N/A	N/A	N/A
92	S3 C-6	Minor	Perpendicularity: <= .010 in Reference Datum A	$\left \begin{array}{c} 0.010 \\ \text{A} \end{array} \right $	0.0046	MITUTOYO CMM B251	N/A	N/A	N/A
93	S3 C-6	Minor	Thickness: 7.864 +.000 -.005 in	N/A	7.8632	0-12" CALIPER	N/A	N/A	N/A
94	S3 B-5	Minor	Radius: .20 +/- .010 in	N/A	0.2	HB400-Comparator	N/A	N/A	N/A
95	S3 B-4	Minor	Thickness: 3.927 +.000 -.005 in	N/A	3.9263	3"-4" Micrometer	N/A	N/A	N/A
96	S3 B-4	Minor	Perpendicularity: <= .010 in Reference Datum A B	$\left \begin{array}{c} 0.010 \\ \text{A} \end{array} \right \text{B} \left \begin{array}{c} \text{B} \\ \end{array} \right $	0.004	MITUTOYO CMM B251	N/A	N/A	N/A
97	S3 B-5	Minor	Linear Dimension: 6.69 +/- .010 in	N/A	6.6812	XM-1600-CMM	N/A	N/A	N/A
98	S3 A-5	Minor	True Position: <= .025 in Reference Datum A B C	$\left \begin{array}{c} 0.025 \\ \text{A} \end{array} \right \text{B} \left \begin{array}{c} \text{C} \\ \end{array} \right $	0.0068	MITUTOYO CMM B251	N/A	N/A	N/A
99	S3 B-4	Minor	Radius: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
100	S3 B-3	Minor	Radius: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
101	S4 A-1	Minor	Note: EPIC-203 TOP PLATE	N/A	COMPLY	N/A	N/A	N/A	N/A
102	S4 B-7	Minor	Perpendicularity: <= .010 in Reference Datum A	$\left \begin{array}{c} 0.010 \\ \text{A} \end{array} \right $	0.0056	MITUTOYO CMM B251	N/A	N/A	N/A
103	S4 B-7	Minor	Thickness: 7.864 +.000 -.005 in	N/A	7.8605	0-12" CALIPER	N/A	N/A	N/A
104	S4 C-6	Minor	Perpendicularity: <= .010 in Reference Datum A B	$\left \begin{array}{c} 0.010 \\ \text{A} \end{array} \right \text{B} \left \begin{array}{c} \text{B} \\ \end{array} \right $	0.006	MITUTOYO CMM B251	N/A	N/A	N/A
105	S4 C-5	Minor	Linear Dimension: 54.961 +/- .010 in	N/A	54.9538	MITUTOYO CMM B251	N/A	N/A	N/A
106	S4 C-3	Minor	Diameter: .332 +/- .005 in	N/A	0.335	PIN GAUGE	N/A	N/A	N/A
107	S4 C-3	Minor	True Position: <= .006 in Diameter, At maximum material condition , Reference Datum A B C	$\left \left \begin{array}{c} 0.006 \\ \text{M} \end{array} \right \text{A} \right \text{B} \left \begin{array}{c} \text{C} \\ \end{array} \right $	0.004	MITUTOYO CMM B251	N/A	N/A	N/A
108	S4 B-3	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.9368	MITUTOYO CMM B251	N/A	N/A	N/A
109	S4 B-4	Minor	Diameter: .260 +/- .005 in	N/A	0.2598	PIN GAUGE	N/A	N/A	N/A
110	S4 B-3	Minor	True Position: <= .005 in Diameter, At maximum material condition , Reference Datum A B C	$\left \left \begin{array}{c} 0.005 \\ \text{M} \end{array} \right \text{A} \right \text{B} \left \begin{array}{c} \text{C} \\ \end{array} \right $	0.0042	MITUTOYO CMM B251	N/A	N/A	N/A
111	S4 B-4	Minor	Linear Dimension - Basic: 52.681 in	N/A	52.678	MITUTOYO CMM B251	N/A	N/A	N/A
112	S4 B-4	Minor	Linear Dimension - Basic: 41.382 in	N/A	41.377	MITUTOYO CMM B251	N/A	N/A	N/A
113	S4 B-5	Minor	Linear Dimension - Basic: 27.661 in	N/A	27.657	MITUTOYO CMM B251	N/A	N/A	N/A
114	S4 B-6	Minor	Linear Dimension - Basic: 13.940 in	N/A	13.936	MITUTOYO CMM B251	N/A	N/A	N/A

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115	S4 B-7	Minor	Linear Dimension - Basic: .260 in	N/A	0.256	MITUTOYO CMM B251	N/A	N/A	N/A
116	S5 A-1	Minor	Note: EPIC-204 BOTTOM PLATE	N/A	COMPLY	N/A	N/A	N/A	N/A
117	S5 B-7	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.0022	MITUTOYO CMM B251	N/A	N/A	N/A
118	S5 B-7	Minor	Thickness: 7.864 +.000 -.005 in	N/A	7.8641	0-12" CALIPER	N/A	N/A	N/A
119	S5 C-6	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.0027	MITUTOYO CMM B251	N/A	N/A	N/A
120	S5 C-5	Minor	Linear Dimension: 54.961 +/- .010 in	N/A	54.958	MITUTOYO CMM B251	N/A	N/A	N/A
121	S5 C-3	Minor	Diameter: .335 +/- .005 in	N/A	0.3348	PIN GAUGE	N/A	N/A	N/A
122	S5 B-3	Minor	True Position: <= .006 in Diameter, At maximum material condition , Reference Datum A B C	.006(M) A B C	0.0035	MITUTOYO CMM B251	N/A	N/A	N/A
123	S5 B-3	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.9365	MITUTOYO CMM B251	N/A	N/A	N/A
124	S5 B-5	Minor	Linear Dimension - Basic: 52.681 in	N/A	52.6741	MITUTOYO CMM B251	N/A	N/A	N/A
125	S6 A-1	Minor	Note: EPIC-205 SIDE COVER	N/A	COMPLY	N/A	N/A	N/A	N/A
126	S6 B-7	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.007	MITUTOYO CMM B251	N/A	N/A	N/A
127	S6 B-7	Minor	Thickness: 3.778 +.000 -.005 in	N/A	3.7792	0-12" CALIPER	N/A	N/A	N/A
128	S6 B-5	Minor	Linear Dimension: 54.961 +/- .010 in	N/A	54.948	MITUTOYO CMM B251	N/A	N/A	N/A
129	S6 B-4	Minor	Radius: .20 +/- .010 in	N/A	0.2	HB400-Comparator	N/A	N/A	N/A
130	S6 B-3	Minor	Linear Dimension - Basic: .39 in	N/A	0.3898	XM-1600-CMM	N/A	N/A	N/A
131	S6 B-3	Minor	Linear Dimension - Basic: 2.76 in	N/A	2.7603	XM-1600-CMM	N/A	N/A	N/A
132	S6 B-3	Minor	Linear Dimension - Basic: 1.57 in	N/A	1.5709	XM-1600-CMM	N/A	N/A	N/A
133	S6 B-4	Minor	Profile of a Surface: <= .025 in Reference Datum A B C	.025 A B C	0.008	MITUTOYO CMM B251	N/A	N/A	N/A
134	S6 B-6	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.007	MITUTOYO CMM B251	N/A	N/A	N/A
135	S7 A-1	Minor	Note: EPIC-206 PCB SIDE COVER	N/A	COMPLY	N/A	N/A	N/A	N/A
136	S7 B-7	Minor	Linear Dimension - Basic: 2.76 in	N/A	IN PROCESS	XM-1600-CMM	N/A	N/A	N/A
137	S7 B-7	Minor	Radius: .20 +/- .010 in	N/A	IN PROCESS	HB400-Comparator	N/A	N/A	N/A
138	S7 B-7	Minor	Linear Dimension - Basic: 1.57 in	N/A	IN PROCESS	XM-1600-CMM	N/A	N/A	N/A
139	S7 B-7	Minor	Linear Dimension - Basic: .39 in	N/A	IN PROCESS	XM-1600-CMM	N/A	N/A	N/A
140	S7 C-7	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
141	S7 B-5	Minor	Linear Dimension: 54.951 +/- .010 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
142	S7 B-6	Minor	Diameter: .134 +/- .005 in	N/A	IN PROCESS	PIN GAUGE	N/A	N/A	N/A
143	S7 B-6	Minor	Counterbore Diameter: .256 +/- .005 in	N/A	IN PROCESS	PIN GAUGE	N/A	N/A	N/A
144	S7 B-5	Minor	Counterbore Depth: .039 +/- .005 in	N/A	IN PROCESS	Digital Drop Indicator	N/A	N/A	N/A

AS9102 REV C - FORM 3 - CHARACTERISTIC ACCOUNTABILITY, VERIFICATION, AND COMPATIBILITY EVALUATION

145	S7 B-6	Minor	True Position: <= .006 in Diameter, At maximum material condition , Reference Datum A B C	.006M A B C	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
146	S7 B-3	Minor	Thickness: 3.768 +.000 -.010 in	N/A	IN PROCESS	3"-4" Micrometer	N/A	N/A	N/A
147	S7 B-3	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
148	S7 B-3	Minor	Linear Dimension - Basic: 3.346 in	N/A	IN PROCESS	XM-1600-CMM	N/A	N/A	N/A
149	S7 B-4	Minor	Linear Dimension - Basic: 54.798 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
150	S7 B-5	Minor	Linear Dimension - Basic: 41.015 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
151	S7 B-6	Minor	Linear Dimension - Basic: 27.294 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
152	S7 B-6	Minor	Linear Dimension - Basic: 13.574 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
153	S7 B-7	Minor	Profile of a Surface: <= .025 in Reference Datum A B C	.025 A B C	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
154	S7 B-7	Minor	Linear Dimension - Basic: .152 in	N/A	IN PROCESS	MITUTOYO CMM B251	N/A	N/A	N/A
155	S8 A-1	Minor	Note: EPIC-207 STEEL ABSORBER PLATE	N/A	COMPLY	N/A	N/A	N/A	N/A
156	S8 C-8	Minor	Thickness: .598 +.000 -.002 in	N/A	0.5961	0-1" Micrometer	N/A	N/A	N/A
157	S8 B-6	Minor	Linear Dimension: .197 +/- .005 in	N/A	0.1985	HB400-Comparator	N/A	N/A	N/A
158	S8 B-7	Minor	True Position: <= .010 in Reference Datum A B C	.010 A B C	0.007	MITUTOYO CMM B251	N/A	N/A	N/A
159	S8 B-6	Minor	Linear Dimension: 2.953 +/- .005 in	N/A	2.9494	HB400-Comparator	N/A	N/A	N/A
160	S8 C-6	Minor	Radius: = .05 in	N/A	0.042	HB400-Comparator	N/A	N/A	N/A
161	S8 C-5	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.007	MITUTOYO CMM B251	N/A	N/A	N/A
162	S8 C-5	Minor	Linear Dimension: 7.715 +.000 -.005 in	N/A	7.7112	0-12" CALIPER	N/A	N/A	N/A
163	S8 C-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
164	S8 C-3	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
165	S8 B-4	Minor	Thickness: 3.778 +.000 -.005 in	N/A	3.7761	3"-4" Micrometer	N/A	N/A	N/A
166	S8 B-4	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.0055	MITUTOYO CMM B251	N/A	N/A	N/A
167	S9 A-1	Minor	Note: EPIC-208 STEEL ABSORBER PLATE, TAPPED	N/A	COMPLY	N/A	N/A	N/A	N/A
168	S9 B-8	Minor	Linear Dimension - Basic: 3.346 in	N/A	3.3457	XM-1600-CMM	N/A	N/A	N/A
169	S8 B-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
170	S8 B-4	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
171	S9 C-8	Minor	Thickness: .598 +.000 -.002 in	N/A	0.5971	0-1" Micrometer	N/A	N/A	N/A
172	S9 C-7	Minor	Thread Type: M3X.05-6H	N/A	COMPLY	M3 THREAD GAUGE	N/A	N/A	N/A
173	S9 C-7	Minor	Diameter: .10 +/- .010 in	N/A	0.0988	PIN GAUGE	N/A	N/A	N/A

AS9102 REV C - FORM 3 - CHARACTERISTIC ACCOUNTABILITY, VERIFICATION, AND COMPATIBILITY EVALUATION

174	S9 C-7	Minor	Depth: .30 +/- .010 in	N/A	0.0298	PIN WITH DROP INDICATOR	N/A	N/A	N/A
175	S9 C-7	Minor	Thread Depth: .24 +/- .010 in	N/A	0.2398	PIN WITH DROP INDICATOR	N/A	N/A	N/A
176	S9 B-7	Minor	True Position: <= .007 in Diameter, Reference Datum A B C	.007 A B C	0.0045	MITUTOYO CMM B251	N/A	N/A	N/A
177	S9 B-7	Minor	Linear Dimension - Basic: .299 in	N/A	0.2987	XM-1600-CMM	N/A	N/A	N/A
178	S9 D-5	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.3775	XM-1600-CMM	N/A	N/A	N/A
179	S9 D-4	Minor	Thread Type: M6X1.0-6H	N/A	COMPLY	M6 THREAD GAUGE	N/A	N/A	N/A
180	S9 D-4	Minor	Diameter: .20 +/- .010 in	N/A	0.1998	PIN GAUGE	N/A	N/A	N/A
181	S9 D-4	Minor	Depth: .47 +/- .010 in	N/A	0.4688	PIN WITH DROP INDICATOR	N/A	N/A	N/A
182	S9 D-3	Minor	Thread Depth: .47 +/- .010 in	N/A	0.4692	PIN WITH DROP INDICATOR	N/A	N/A	N/A
183	S9 C-4	Minor	True Position: <= .009 in Diameter, Reference Datum A B C	.009 A B C	0.0042	MITUTOYO CMM B251	N/A	N/A	N/A
184	S9 C-4	Minor	Linear Dimension - Basic: .299 in	N/A	0.2988	XM-1600-CMM	N/A	N/A	N/A
185	S9 B-6	Minor	Linear Dimension: .197 +/- .005 in	N/A	0.1969	HB400-Comparator	N/A	N/A	N/A
186	S9 B-7	Minor	True Position: <= .010 in Reference Datum A B C	.010 A B C	0.0065	MITUTOYO CMM B251	N/A	N/A	N/A
187	S9 B-6	Minor	Linear Dimension: 2.953 +/- .005 in	N/A	2.9545	HB400-Comparator	N/A	N/A	N/A
188	S9 B-6	Minor	Radius: = .05 in	N/A	0.052	HB400-Comparator	N/A	N/A	N/A
189	S9 C-5	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.0055	MITUTOYO CMM B251	N/A	N/A	N/A
190	S9 C-5	Minor	Linear Dimension: 7.715 +.000 -.005 in	N/A	7.7123	0-12" CALIPER	N/A	N/A	N/A
191	S9 C-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
192	S9 C-3	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
193	S9 B-3	Minor	Thickness: 3.778 +.000 -.005 in	N/A	3.7758	0-12" CALIPER	N/A	N/A	N/A
194	S9 B-4	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.0042	MITUTOYO CMM B251	N/A	N/A	N/A
195	S9 B-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
196	S9 B-4	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
197	S10 A-1	Minor	Note: EPIC-209 STEEL ABSORBER PLATE, LAST	N/A	COMPLY	N/A	N/A	N/A	N/A
198	S10 D-7	Minor	Thickness: .598 +.000 -.002 in	N/A	0.5968	0-1" Micrometer	N/A	N/A	N/A
199	S10 D-5	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.9364	XM-1600-CMM	N/A	N/A	N/A
200	S10 D-4	Minor	Thread Type: M6X1.0-6H	N/A	COMPLY	M6 THREAD GAUGE	N/A	N/A	N/A
201	S10 D-4	Minor	Diameter: .20 +/- .010 in	N/A	0.1998	PINGAUGE	N/A	N/A	N/A
202	S10 D-4	Minor	Depth: .59 +/- .010 in	N/A	0.592	PIN WITH DROP INDICATOR	N/A	N/A	N/A
203	S10 D-4	Minor	Thread Depth: .47 +/- .010 in	N/A	0.472	PIN WITH DROP INDICATOR	N/A	N/A	N/A
204	S10 C-4	Minor	True Position: <= .009 in Diameter, Reference Datum A B C	.009 A B C	0.0056	MITUTOYO CMM B251	N/A	N/A	N/A
205	S10 C-4	Minor	Linear Dimension - Basic: .299 in	N/A	0.2986	XM-1600-CMM	N/A	N/A	N/A

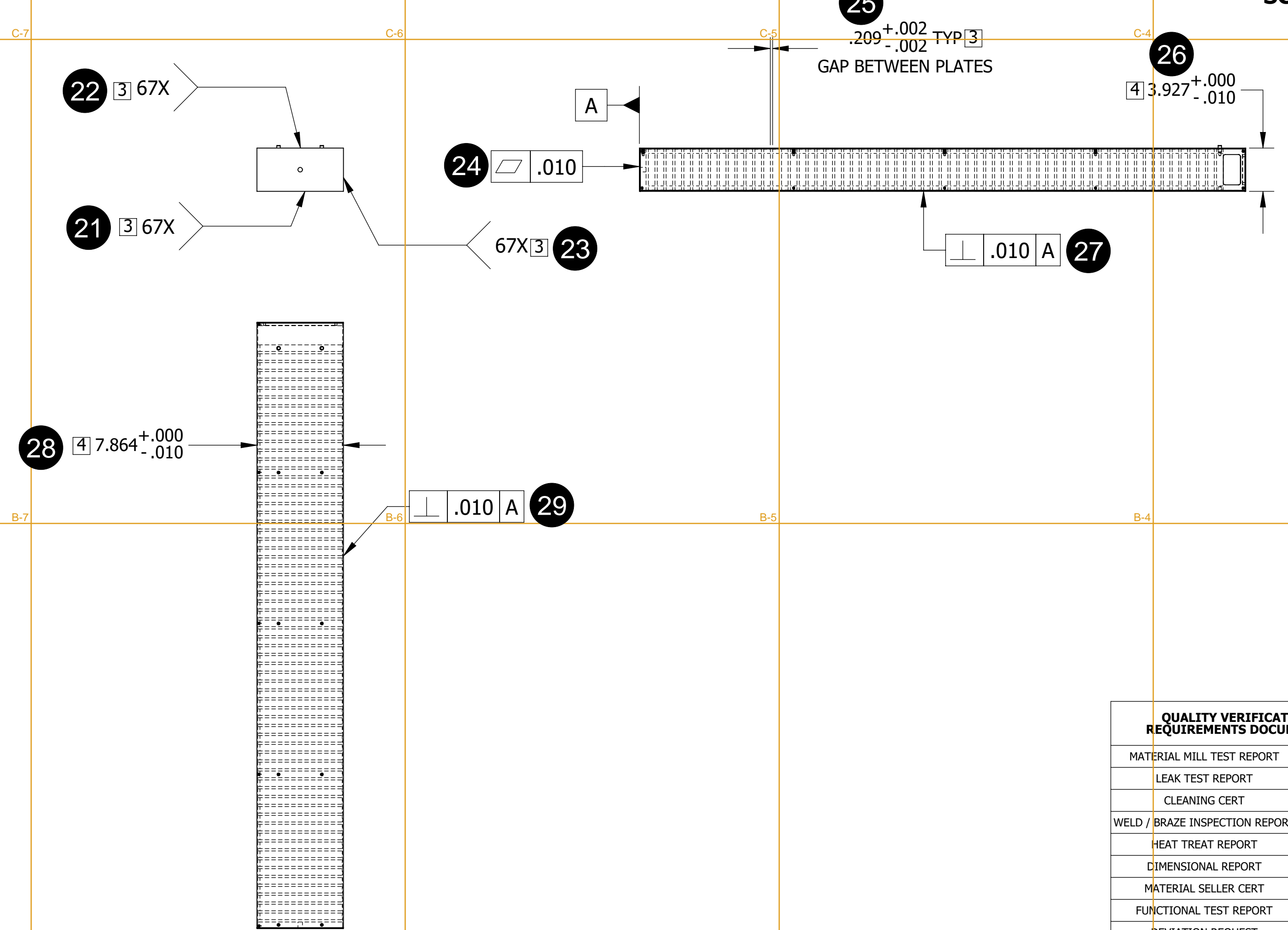
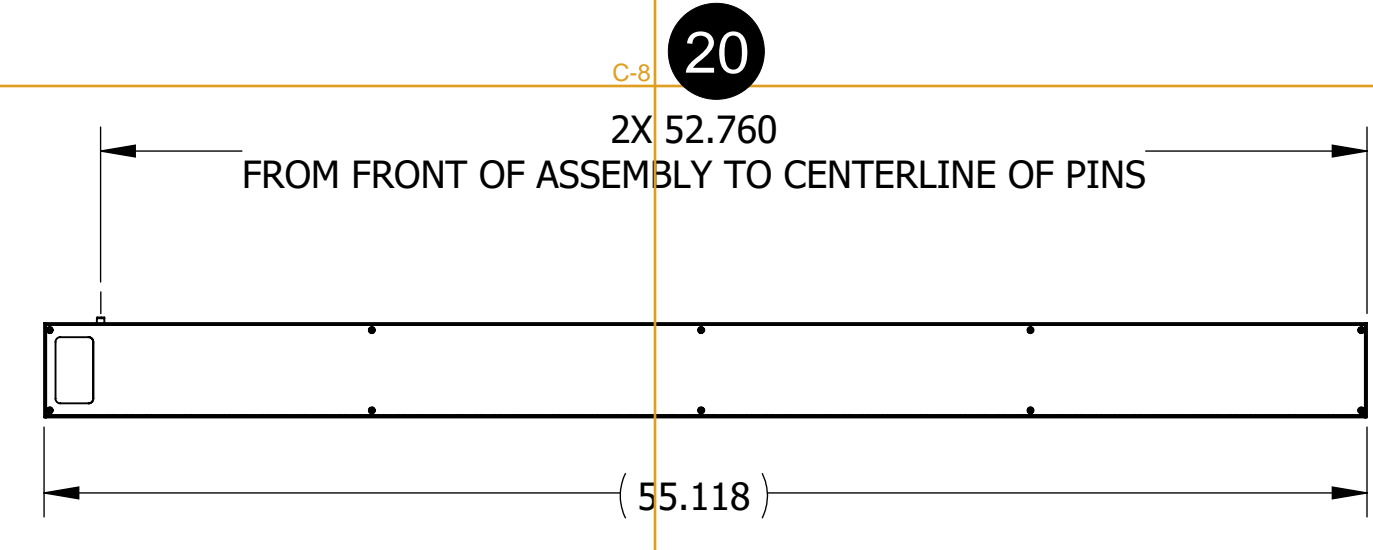
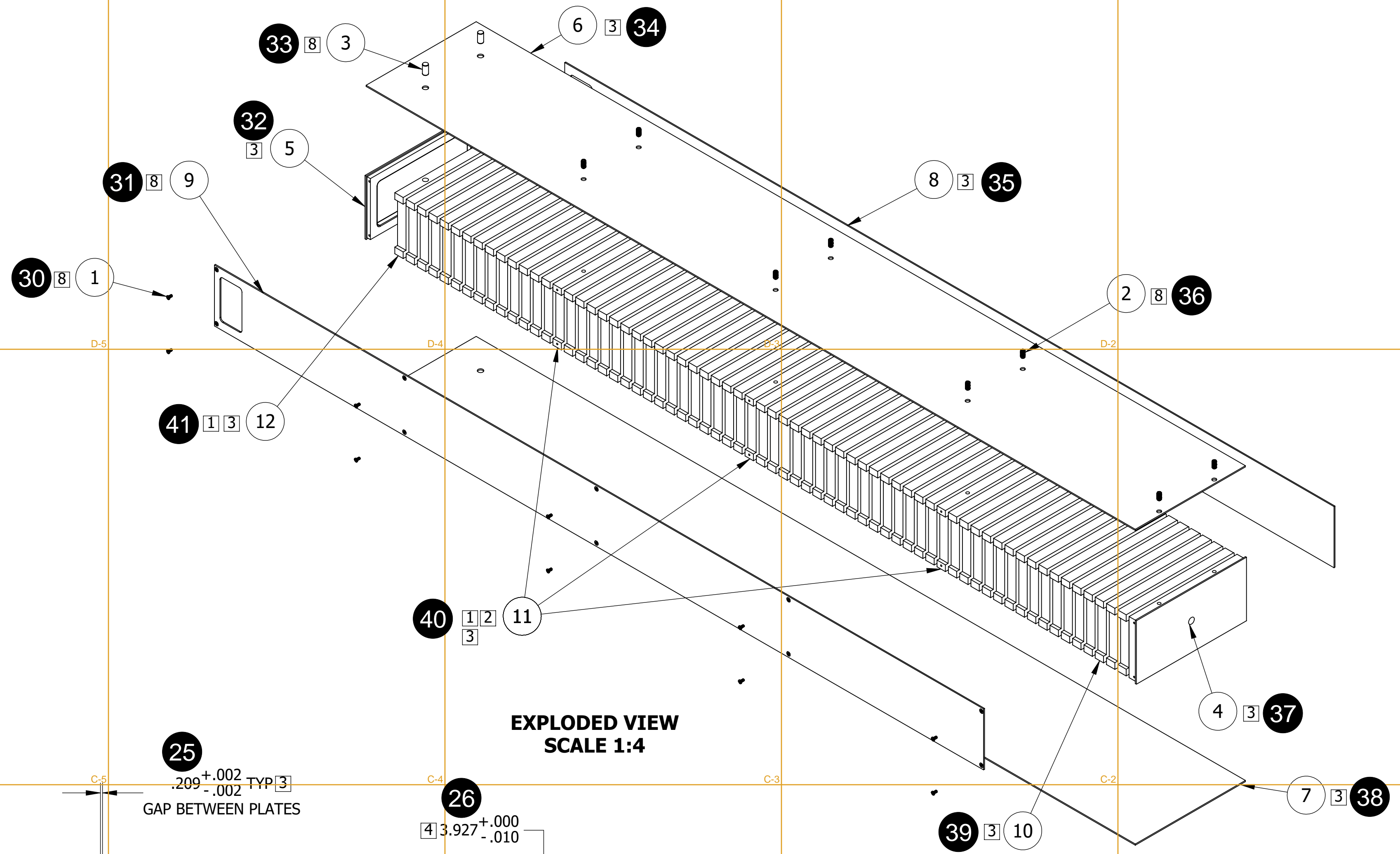
AS9102 REV C - FORM 3 - CHARACTERISTIC ACCOUNTABILITY, VERIFICATION, AND COMPATIBILITY EVALUATION

206	S10 B-6	Minor	Linear Dimension: .197 +/- .005 in	N/A	0.1975	HB400-Comparator	N/A	N/A	N/A
207	S10 B-7	Minor	True Position: <= .010 in Reference Datum A B C	.010 A B C	0.0052	MITUTOYO CMM B251	N/A	N/A	N/A
208	S10 B-7	Minor	Linear Dimension: 2.953 +/- .005 in	N/A	2.9544	HB400-Comparator	N/A	N/A	N/A
209	S10 C-7	Minor	Radius: = .05 in	N/A	0.05	HB400-Comparator	N/A	N/A	N/A
210	S10 C-5	Minor	Perpendicularity: <= .010 in Reference Datum A	.010 A	0.0036	MITUTOYO CMM B251	N/A	N/A	N/A
211	S10 C-5	Minor	Linear Dimension: 7.715 +.000 -.005 in	N/A	7.7125	0-12" CALIPER	N/A	N/A	N/A
212	S10 C-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	0.04	HB400-Comparator	N/A	N/A	N/A
213	S10 C-4	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
214	S10 B-4	Minor	Thickness: 3.778 +.000 -.005 in Reference Datum A B	.010 A B	0.0046	MITUTOYO CMM B251	N/A	N/A	N/A
215	S10 B-4	Minor	Perpendicularity: <= .010 in Reference Datum A B	.010 A B	0.0048	MITUTOYO CMM B251	N/A	N/A	N/A
216	S10 B-4	Minor	Chamfer Size: .04 +/- .010 in	N/A	4	HB400-Comparator	N/A	N/A	N/A
217	S10 B-4	Minor	Chamfer Angle: 45 +/- .5 deg	N/A	45°	HB400-Comparator	N/A	N/A	N/A
218	S10 A-6	Minor	True Position: <= .006 in Diameter, Reference Datum A B C	.006 A B C	0.0045	MITUTOYO CMM B251	N/A	N/A	N/A
219	S10 A-6	Minor	Diameter: .332 +/- .005 in	N/A	0.3318	PINGAUGE	N/A	N/A	N/A
220	S10 A-6	Minor	Depth: .39 +/- .010 in	N/A	0.392	PIN WITH DROP INDICATOR	N/A	N/A	N/A
221	S10 B-4	Minor	Linear Dimension - Basic: .299 in	N/A	0.2987	XM-1600-CMM	N/A	N/A	N/A
222	S10 A-5	Minor	Linear Dimension - Basic: 3.937 in	N/A	3.9368	XM-1600-CMM	N/A	N/A	N/A
<p>The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.</p>									
<p>12. Signature: <i>Mauro Contreras</i></p>								<p>13. Date: 5/07/2024</p>	

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NOTES

- 12 1. P/N 11 & 12 WILL BE ORIENTED WITH THE TAPPED HOLES FACING UP.
- 13 2. FOR REFERENCE, P/N 11 TO BE PLACED IN POSITION # 17, 34, & 51 FOR ALL ABSORBER PLATES. MATCH UP HOLE PATTERN ON P/N 6 & 9 TO VERIFY PRIOR TO WELDING.
- 14 3. E-BEAM WELD ALONG CENTERLINE OF CONTACTING FACES ALL PARTS P/N 4, 5, 6, 7, 8, 10, 11, & 12. ALLOW 1/8" CLEARANCE FROM WELDS TO ALL HOLES. DO NOT WELD P/N 9. USE A JIG AND SPACING PLATES OF PROPER WIDTH TO ENSURE PROPER SPACING. WELDING PROCEDURE TO BE DETAILED AND APPROVED BY ORNL PRIOR TO EXECUTION.
- 15 4. POST MACHINE AND/OR STRAIGHTEN AS NECESSARY POST WELDING TO ACHIEVE FINAL DIMENSIONING AND TOLERANCING. VERIFY THE INTEGRITY OF ALL WELDS AFTER ALL POST MACHINING PROCESSES.
- 16 5. ALL WELDING AND WELD INSPECTIONS PER AWS D1.1/D1.1M - 2010.
- 17 6. ALL WELDS SHALL RECEIVE A VISUAL INSPECTION. SELLER SHALL PROVIDE VISUAL EXAMINATION CERTIFICATION OF COMPLIANCE CERTIFYING THE PERFORMANCE OF THE INSPECTION AND THE ACCEPTABILITY OF THE WELDS.
- 18 7. PERSONNEL PERFORMING VISUAL INSPECTIONS SHALL BE CERTIFIED WELD INSPECTORS UNDER AWS QC-1 OR AS VISUAL TESTING LEVEL II OR LEVEL III IN ACCORDANCE WITH SNT-TC-1A.
- 19 8. ELECTROLESS NICKEL PLATE FINAL WELDMENT (EXCLUDING P/N 1, 2, 3, & 9) TO 0.001" THICKNESS MINIMUM / 0.002" THICKNESS MAXIMUM PER ASTM B766.



ITEM	QTY.	NAME/PART NO	MATERIAL	DESCRIPTION	DWG
12	1	STEEL ABSORBER PLATE, LAST	AISI 1020 CARBON STEEL	PLATE	10 EPIC-209
11	3	STEEL ABSORBER PLATE, TAPPED	AISI 1020 CARBON STEEL	PLATE	9 EPIC-208
10	61	STEEL ABSORBER PLATE	AISI 1020 CARBON STEEL	PLATE	8 EPIC-207
9	1	PCB COVER	AISI 304 STAINLESS STEEL	SHEET METAL 1/4 GA	7 EPIC-206
8	1	SIDE COVER	AISI 1020 CARBON STEEL	SHEET METAL 1/4 GA	6 EPIC-205
7	1	BOTTOM PLATE	AISI 1020 CARBON STEEL	SHEET METAL 1/4 GA	5 EPIC-204
6	1	TOP PLATE	AISI 1020 CARBON STEEL	SHEET METAL 1/4 GA	4 EPIC-203
5	1	BACK PLATE	AISI 1020 CARBON STEEL	PLATE	3 EPIC-202
4	1	FRONT PLATE	AISI 1020 CARBON STEEL	PLATE	2 EPIC-201
3	2	MCMMASTER_98381A579	4037 STEEL ALLOY	5/16" X 5/8" LG DOWEL PIN	COTS
2	8	MCMMASTER_91390A129	ALLOY STEEL	M6-1.0 X 12MM LG SET SCREW	COTS
1	10	MCMMASTER_90358A001	ALLOY STEEL	M3-0.5 X 6MM LG LOW SHCS	COTS

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS	
MATERIAL MILL TEST REPORT	
LEAK TEST REPORT	
CLEANING CERT	
WELD / BRAZE INSPECTION REPORT	X
HEAT TREAT REPORT	
DIMENSIONAL REPORT	X
MATERIAL SELLER CERT	X
FUNCTIONAL TEST REPORT	
DEVIATION REQUEST	X
NONCONFORMANCE REPORT	X

APPROVALS		DATE
DES	EJ FOUNTAIN	03/09/2023
DRW	EJ FOUNTAIN	03/09/2023
CHK	CD OTTINGER	03/09/2023
ENG	EJ FOUNTAIN	03/09/2023
QA		

THIS DRAWING IS THE PROPERTY OF
OAK RIDGE NATIONAL LABORATORY
 OPERATED FOR THE U.S. DEPARTMENT OF ENERGY UNDER
 CONTRACT DE-AC05-00OR22725 OAK RIDGE, TN

REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
TOWER BODY ASSEMBLY

TOTAL WEIGHT: **350.16 LBS**

THIS DRAWING PRODUCED USING **SolidWorks**

SIZE: **D** NEXT ASSY: **EPIC-100** DWG NO.: **EPIC-200** REV: **0**

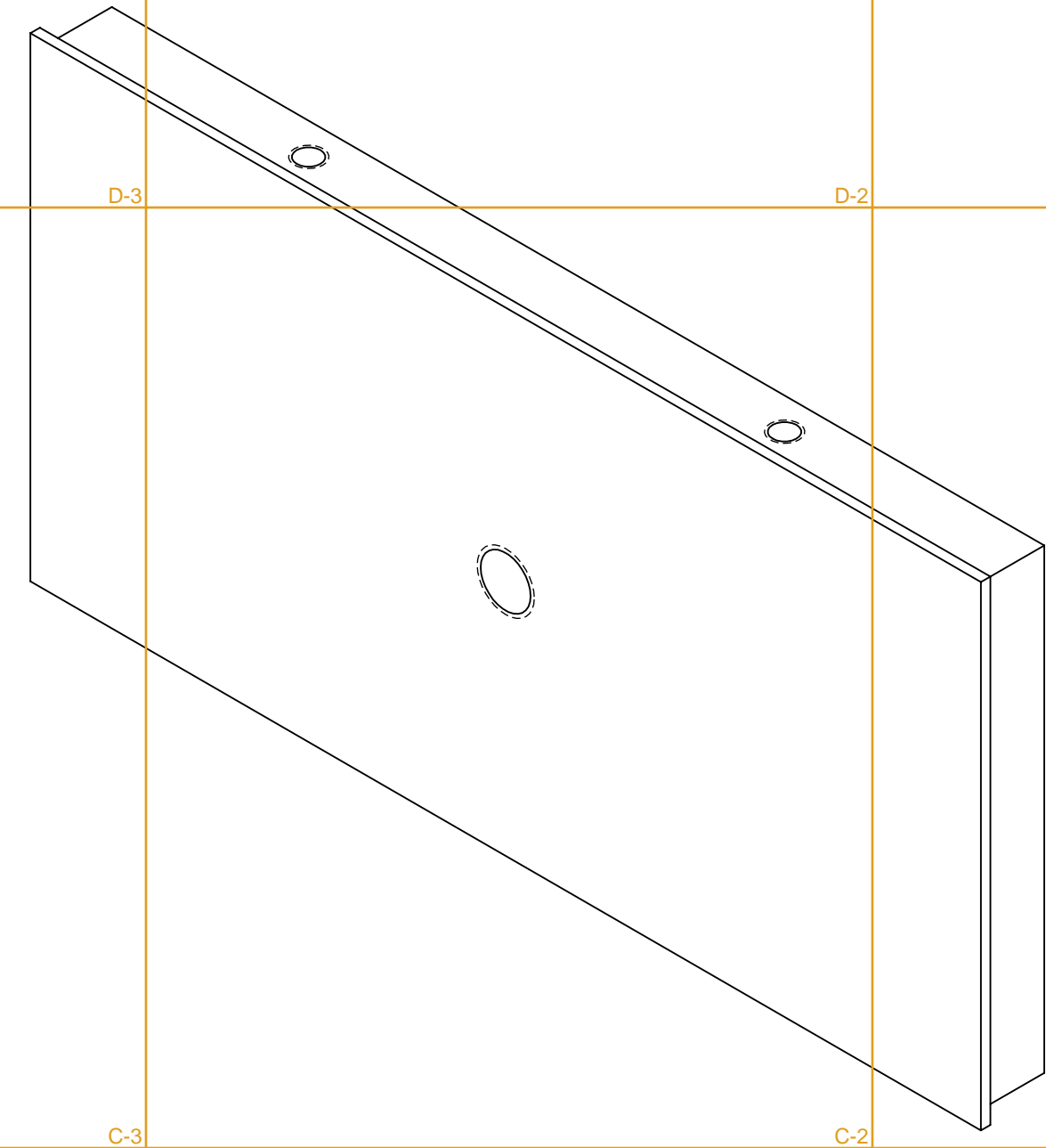
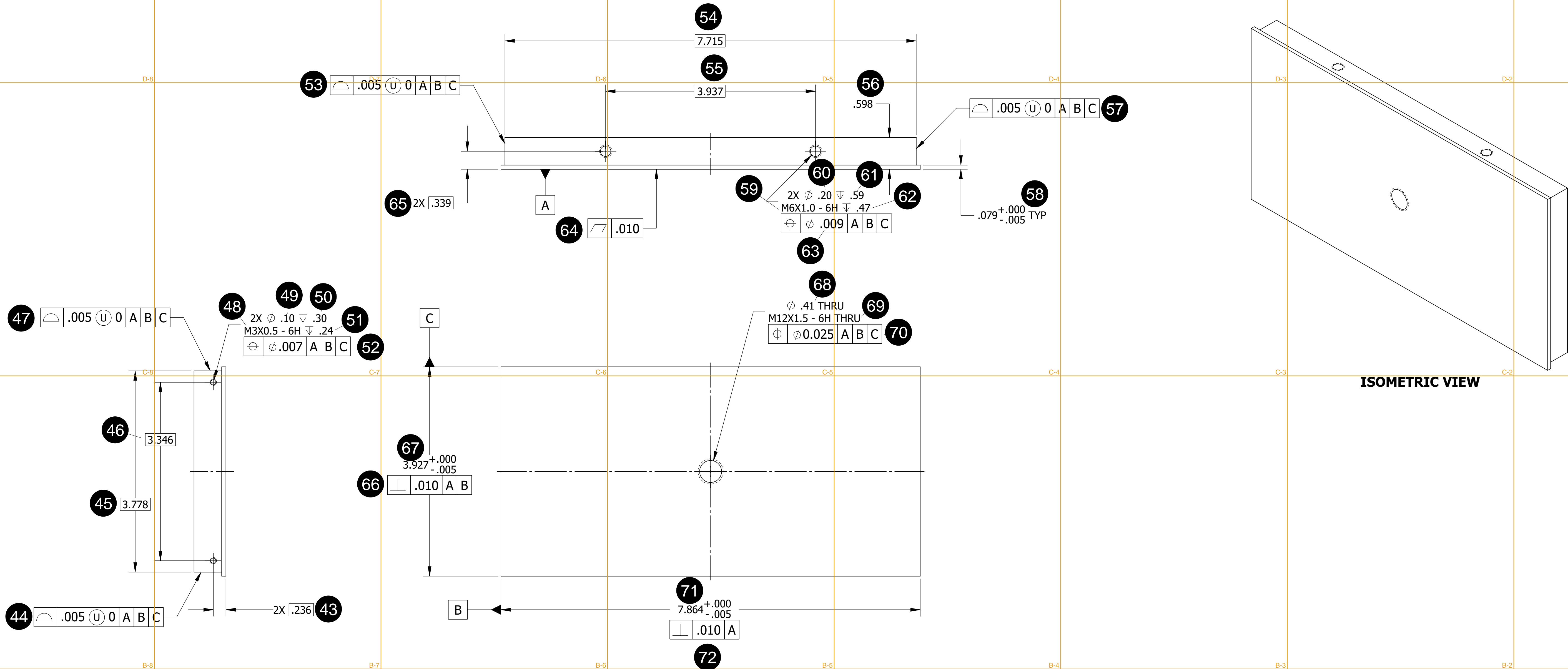
SCALE: 1:8 NAME: 8M TOWER WELDMENT SHEET: 1 of 1

DWG NO. EPIC-200
 CAD FILE: 8M Module Body_Assembly_B

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NOTES

1. MATERIAL CERTIFICATIONS REQUIRED.



MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M BREAK SHARP CORNERS AND REMOVE ALL BURRS DEFAULT TOLERANCES LINEAR .XX = ±.100 ANGULAR .X/XX = ±.1/2 .XXX = ±.010 .XXX = ±.005 DO NOT SCALE DRAWING
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

APPROVALS	DATE
DES EJ FOUNTAIN	03/09/2023
DRW EJ FOUNTAIN	03/09/2023
CHK CD OTTINGER	03/09/2023
ENG EJ FOUNTAIN	03/09/2023
QA	

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 CONTRACT DE-AC05-00OR22725 OAK RIDGE, TN

REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
FRONT PLATE

TOTAL WEIGHT: **4.98 LBS**

THIS DRAWING PRODUCED USING **SolidWorks**

SCALE: 1:1

NAME: FRONT PLATE

SHEET: 1 of 1

REV: 0

DWG NO.: **EPIC-201**

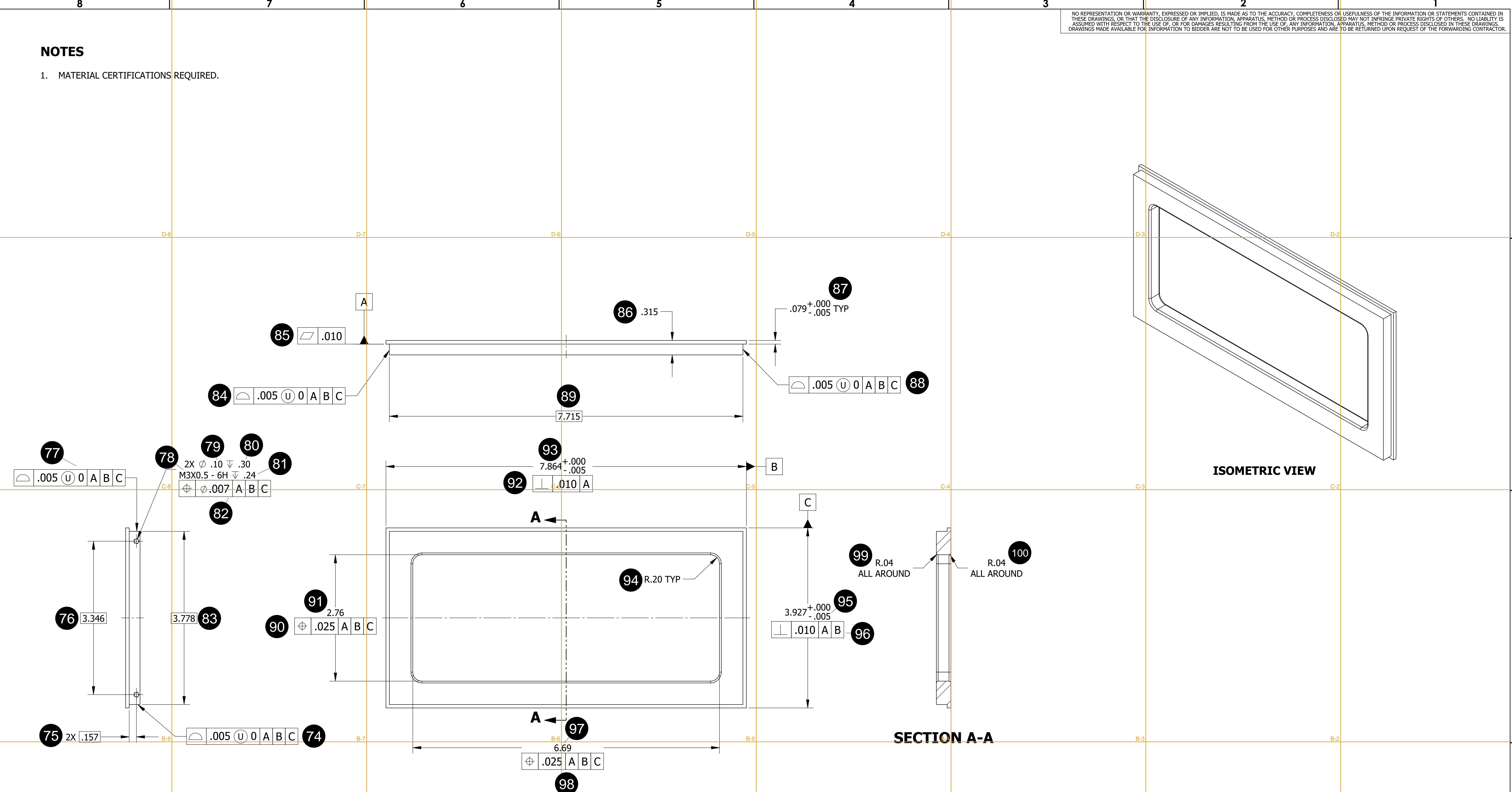
SIZE: NEXT ASSY EPIC-200

DWG NO. EPIC-201
 CAD FILE: Tower Front Plate_B

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NOTES

1. MATERIAL CERTIFICATIONS REQUIRED.



MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M BREAK SHARP CORNERS AND REMOVE ALL BURRS DEFAULT TOLERANCES: LINEAR .XX = ±.100 ANGLAR .X/XX = ±.1/2 XXX = ±.010 XXXX = ±.005 DO NOT SCALE DRAWING
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

APPROVALS	DATE
DES EJ FOUNTAIN	03/16/2023
DRW EJ FOUNTAIN	03/16/2023
CHK CD OTTINGER	03/24/2023
ENG EJ FOUNTAIN	03/16/2023
QA	

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 CONTRACT DE-AC05-00OR22725 OAK RIDGE, TN

REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
BACK PLATE

TOTAL WEIGHT: **1.00 LBS**

THIS DRAWING PRODUCED USING **SolidWorks**

SCALE: 1:1

NAME: BACK PLATE

SHEET 1 of 1

REV **0**

DWG NO. **EPIC-202**

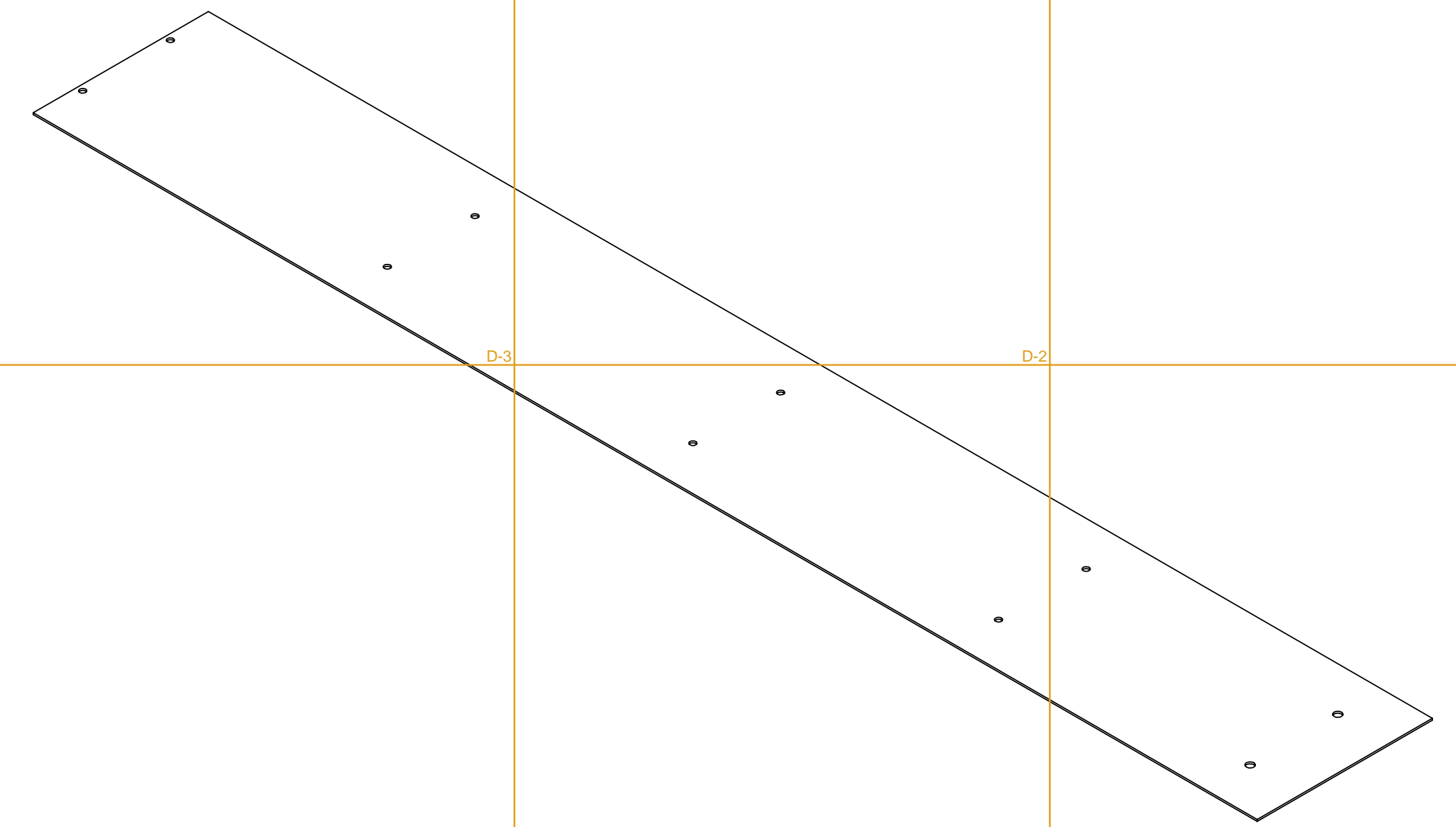
SIZE **D** NEXT ASSY **EPIC-200**

DWG NO. EPIC-202
CAD FILE: Tower Back Plate_B

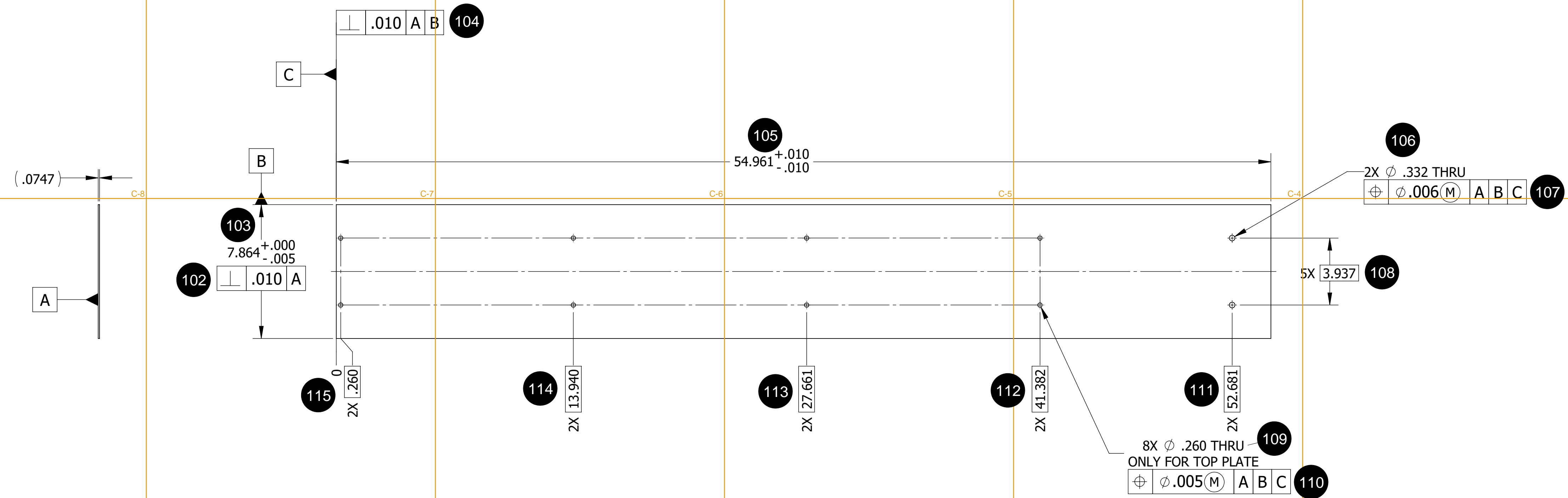
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NOTES

1. MATERIAL CERTIFICATIONS REQUIRED.
2. THE 8X BOLT HOLE PATTERN IS ONLY FOR THE TOP PLATE.



ISOMETRIC VIEW



MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M. BREAK SHARP CORNERS AND REMOVE ALL BURRS. DEFAULT TOLERANCES: LINEAR .XX = ±.100, ANGULAR .XX = ±1/2. XXX = ±.010, XXXX = ±.005. **DO NOT SCALE DRAWING**

APPROVALS		DATE
DES	EJ FOUNTAIN	03/16/2023
DRW	EJ FOUNTAIN	03/16/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/16/2023
QA		

TOTAL WEIGHT: **9.20 LBS**
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REMOTE SYSTEMS GROUP

EPIC 8M TOWER ASSEMBLY TOP PLATE

SIZE: **D** NEXT ASSY: EPIC-200 DWG NO.: **EPIC-203** REV: **0**

SCALE: 1:4 NAME: TOP PLATE SHEET: 1 of 1

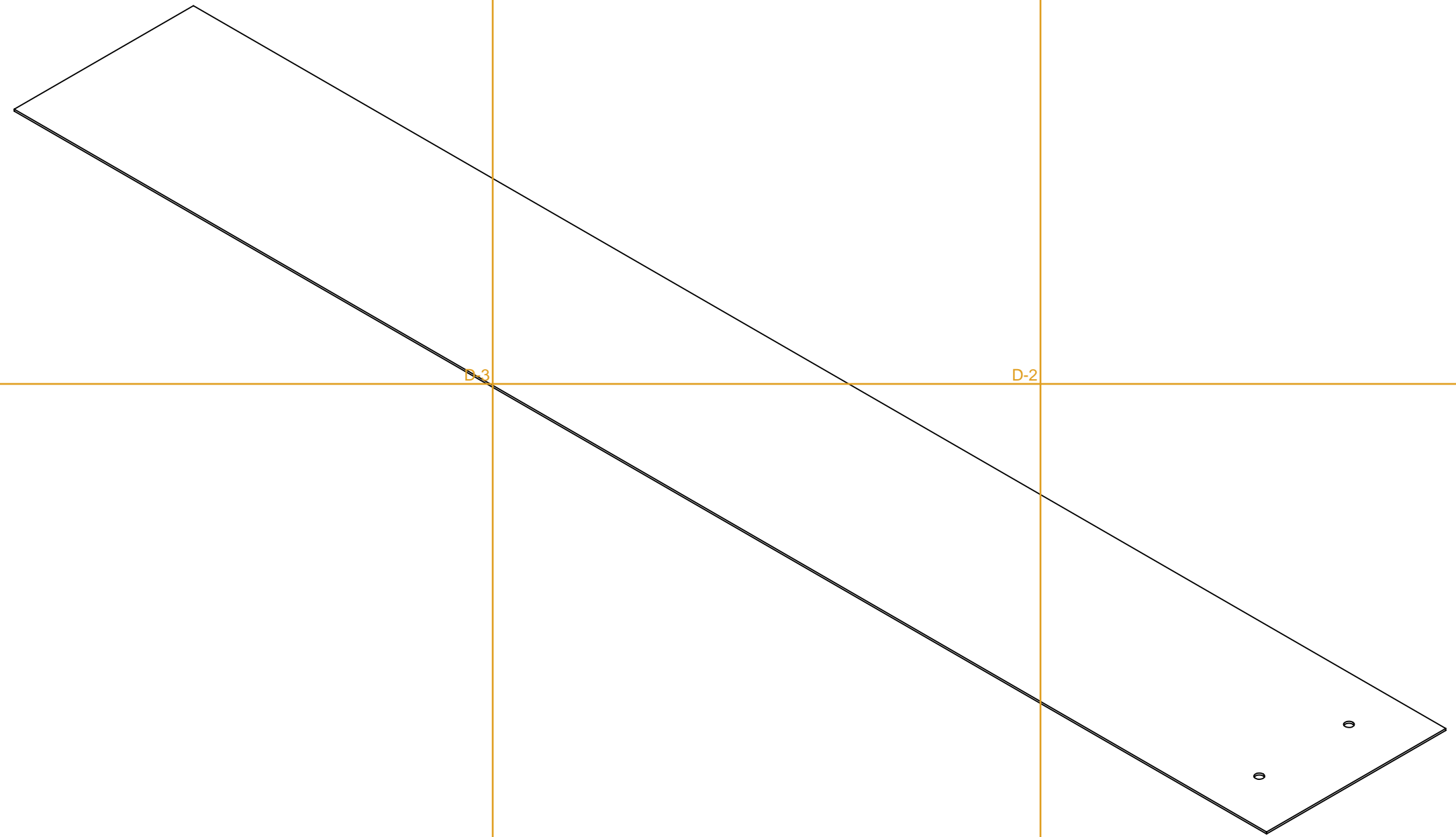
DWG NO. EPIC-203
CAD FILE: 8M Module Top Plate_B

101

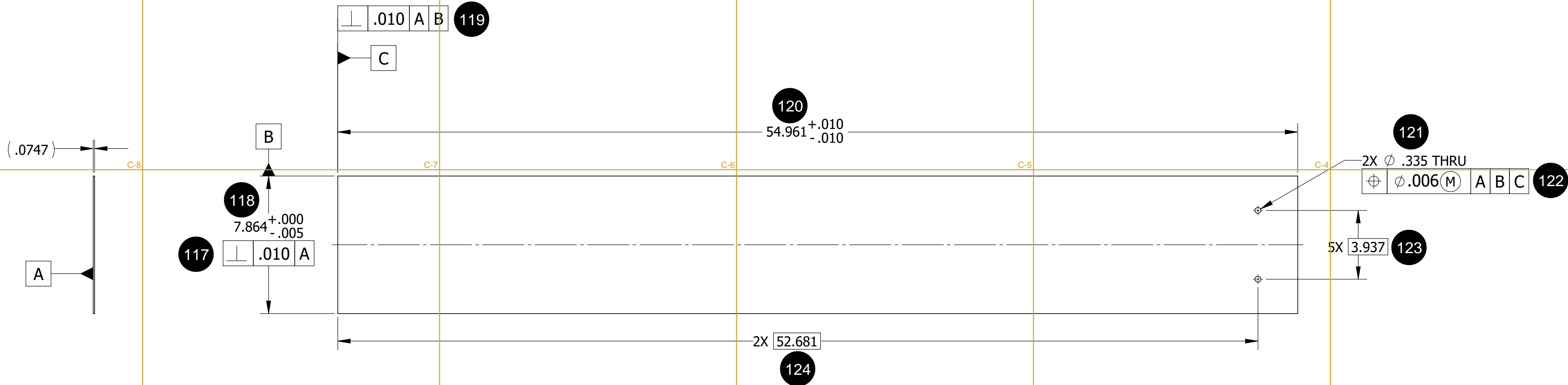
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NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED.



ISOMETRIC VIEW



MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

APPROVALS		DATE
DES	EJ FOUNTAIN	03/16/2023
DRW	EJ FOUNTAIN	03/16/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/16/2023
QA		

9.21 LBS
THIS DRAWING PRODUCED USING SolidWorks

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REMOTE SYSTEMS GROUP			
EPIC 8M TOWER ASSEMBLY BOTTOM PLATE			
SIZE	NEXT ASSY	DWG NO.	REV
D	EPIC-200	EPIC-204	0
SCALE	NAME	SHEET	1 of 1
1:4	BOTTOM PLATE	1	

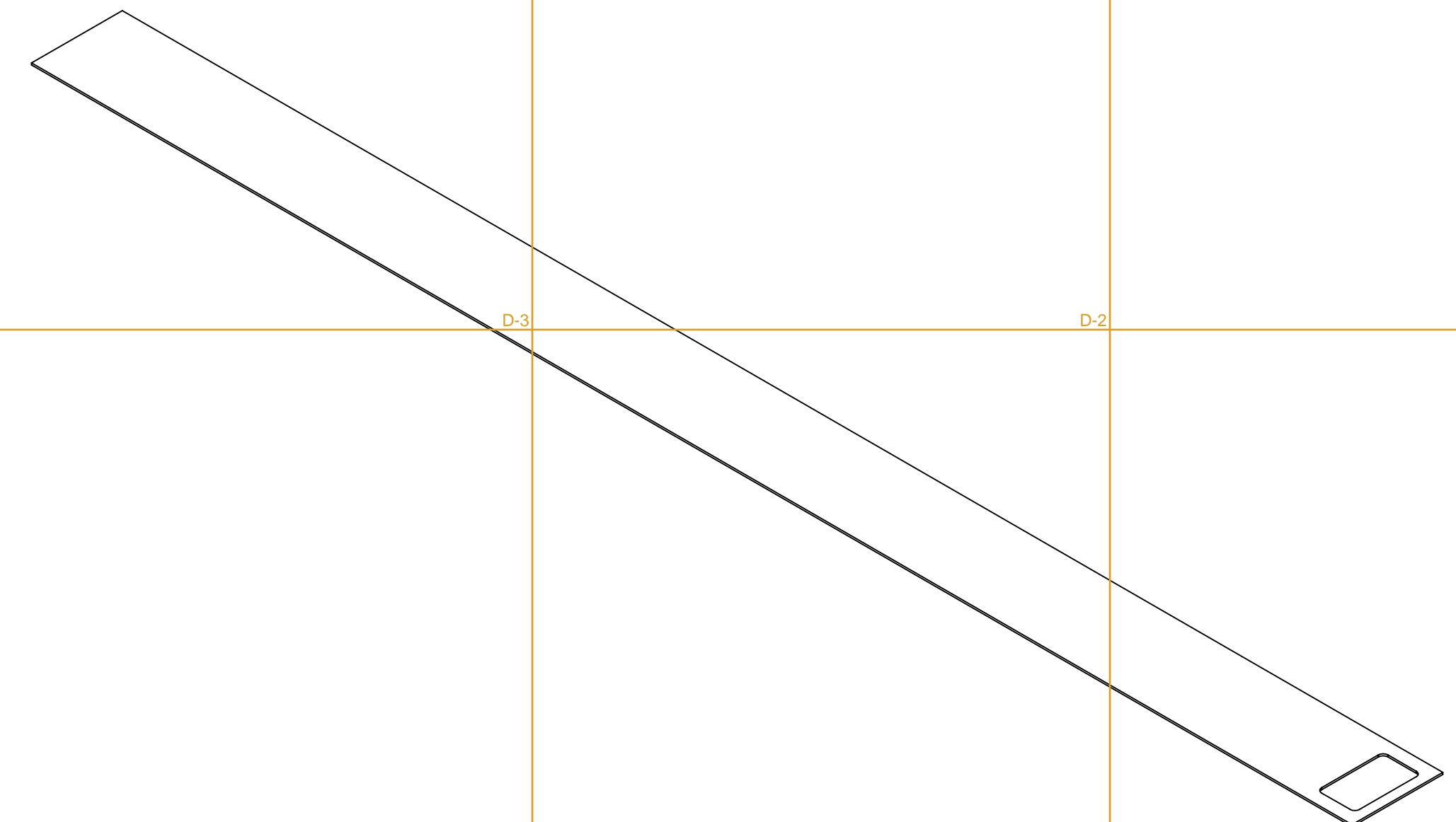
DWG NO. EPIC-204
CAD FILE: 8M Module Bottom Plate

116

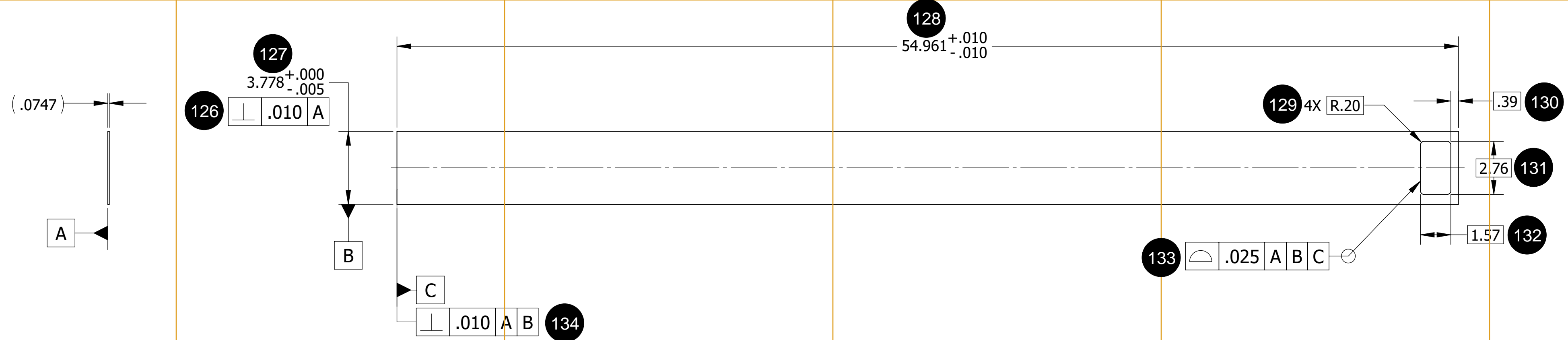
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NOTES

1. MATERIAL CERTIFICATIONS REQUIRED.



ISOMETRIC VIEW



MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

UNLESS OTHERWISE NOTED
DIMENSIONS ARE IN INCHES
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
BREAK SHARP CORNERS AND REMOVE ALL BURRS
DEFAULT TOLERANCES
LINEAR .XX = ±.100 ANGULAR .X/12 = ±1/2
X.XX = ±.010
X.XXX = ±.005

DO NOT SCALE DRAWING

APPROVALS		DATE
DES	EJ FOUNTAIN	03/23/2023
DRW	EJ FOUNTAIN	03/23/2023
CHK	CD OTTINGER	03/23/2023
ENG	EJ FOUNTAIN	03/23/2023
QA		
TOTAL WEIGHT	4.33 LBS	
THIS DRAWING PRODUCED USING SolidWorks		

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REMOTE SYSTEMS GROUP

**EPIC
8M TOWER ASSEMBLY
SIDE COVER**

125

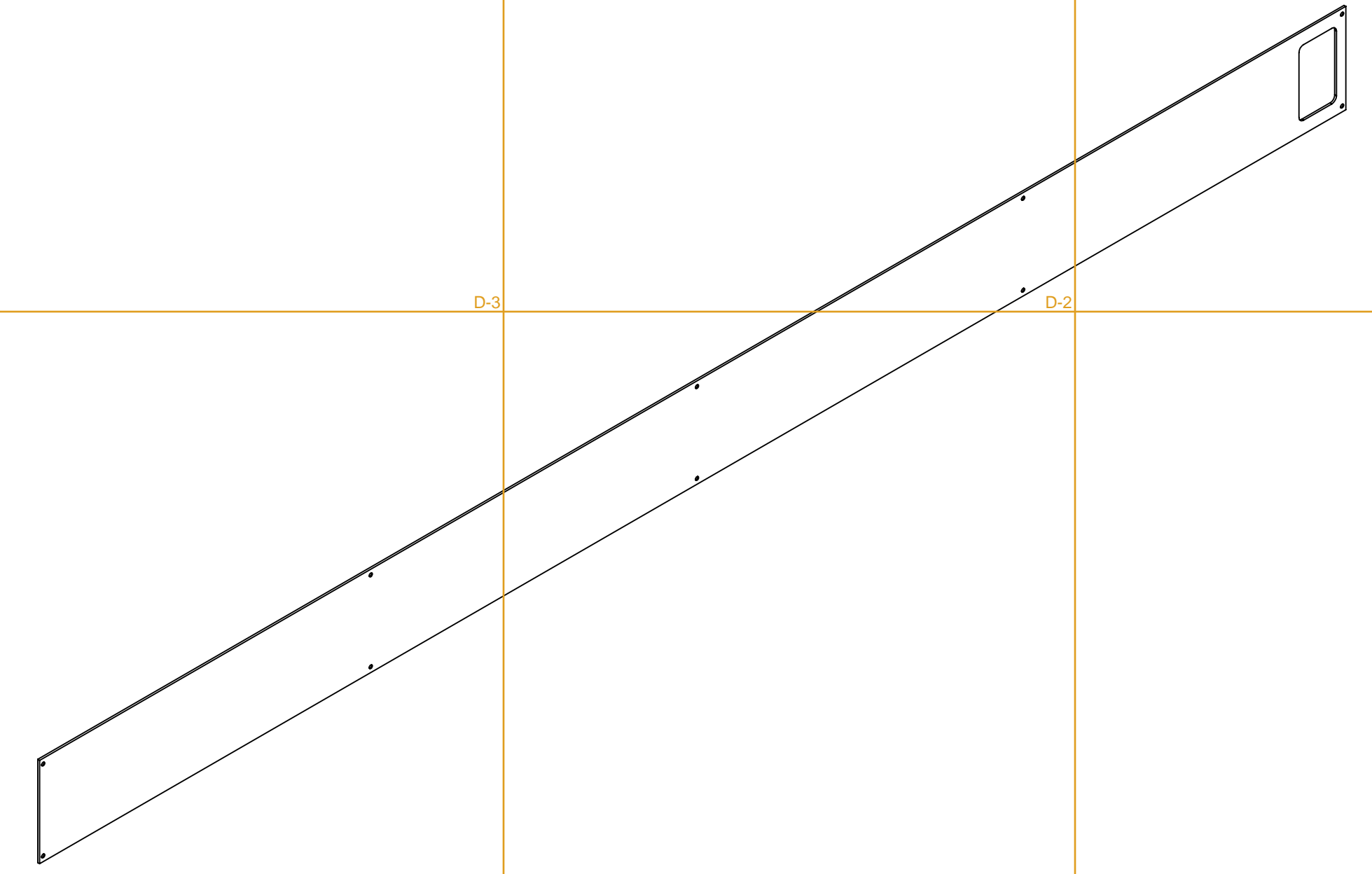
SIZE D	NEXT ASSY EPIC-200	DWG NO. EPIC-205	REV 0
SCALE 1:4	NAME SIDE COVER	SHEET 1 of 1	

DWG NO. EPIC-205
CAD FILE: 8M Module Side Cover_B

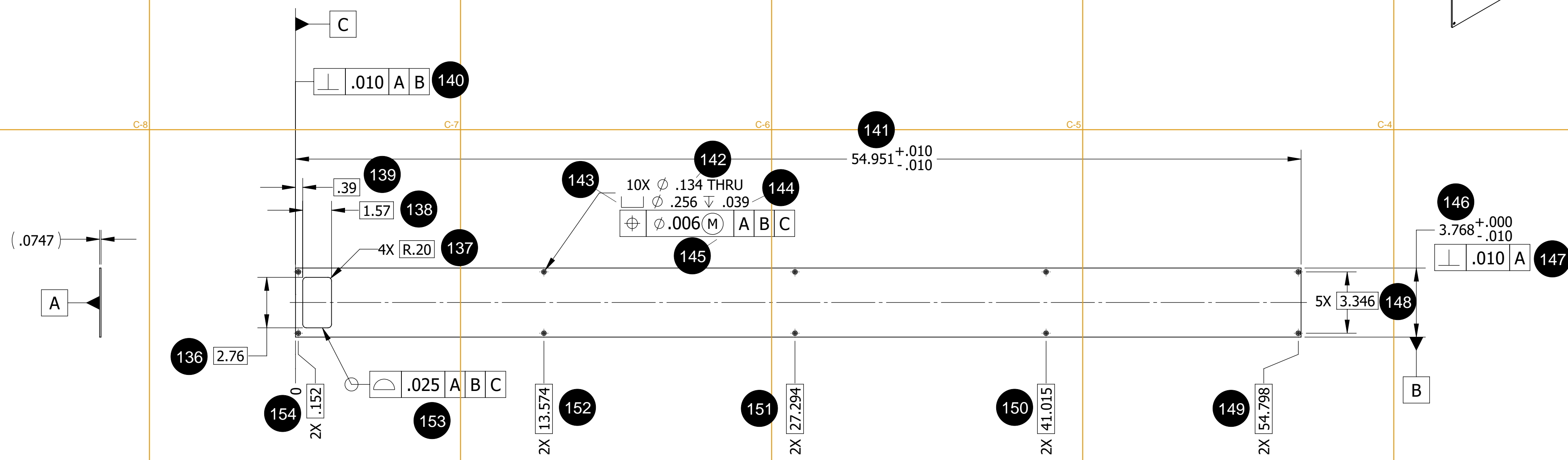
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NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED.

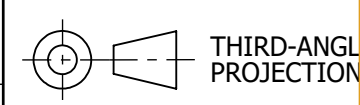


ISOMETRIC VIEW



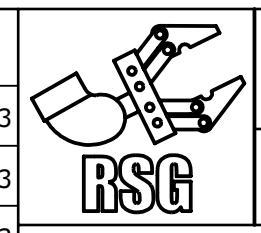
MATERIAL: AISI 304 STAINLESS STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS	
MATERIAL MILL TEST REPORT	x
LEAK TEST REPORT	
CLEANING CERT	
WELD / BRAZE INSPECTION REPORT	
HEAT TREAT REPORT	
DIMENSIONAL REPORT	
MATERIAL SELLER CERT	
FUNCTIONAL TEST REPORT	
DEVIATION REQUEST	x
NONCONFORMANCE REPORT	x



THIRD-ANGLE PROJECTION
UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M. BREAK SHARP CORNERS AND REMOVE ALL BURRS.
DEFAULT TOLERANCES:
LINEAR .XX = ±.100 ANGULAR .XX = ±1/2
X.XX = ±.010
X.XXX = ±.005
DO NOT SCALE DRAWING

APPROVALS		DATE
DES	EJ FOUNTAIN	03/17/2023
DRW	EJ FOUNTAIN	03/17/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/17/2023
QA		



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REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
PCB SIDE COVER

135

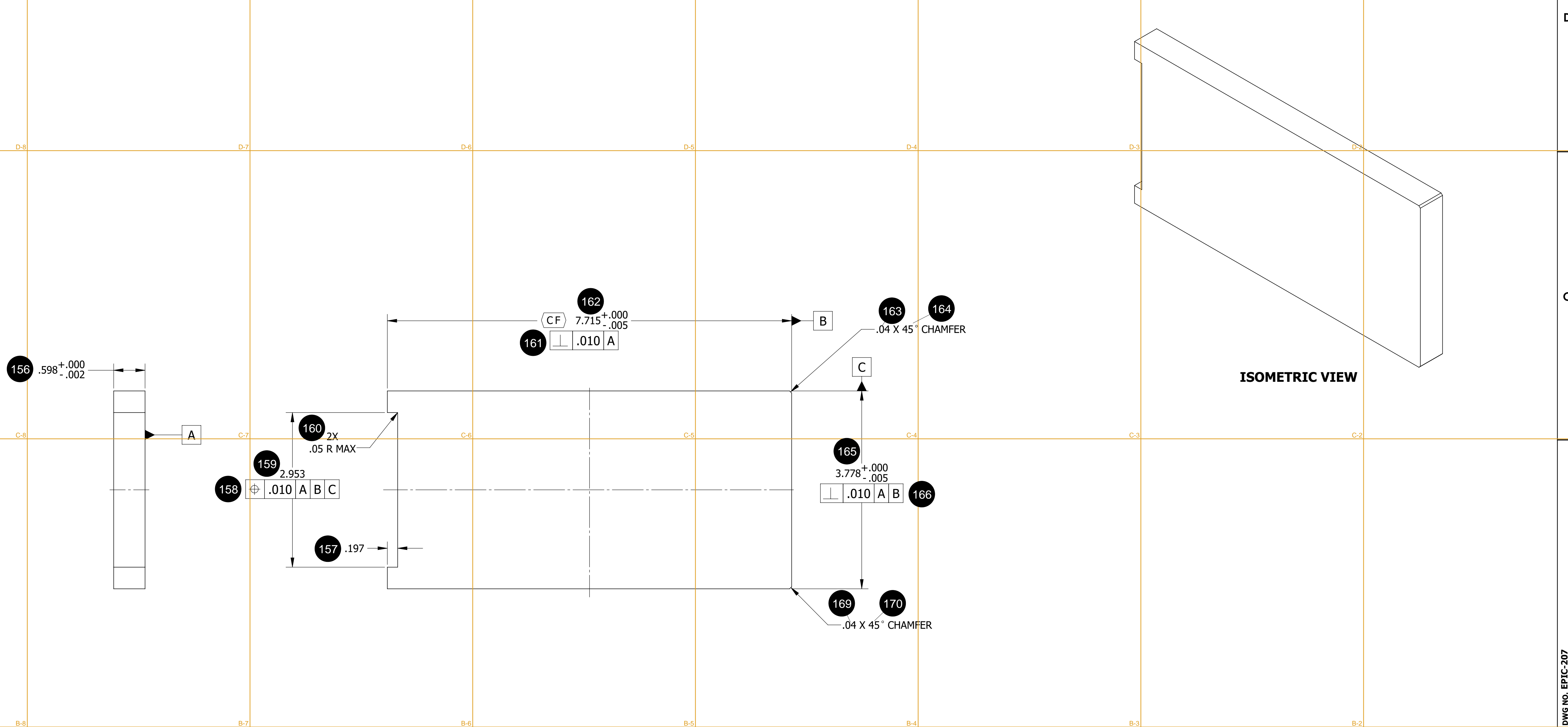
TOTAL WEIGHT	4.37 LBS	SIZE	NEXT ASSY	DWG NO.	REV
THIS DRAWING PRODUCED USING		D	EPIC-200	EPIC-206	0
SCALE	1:4	NAME	PCB COVER		SHEET 1 of 1

DWG NO. EPIC-206
CAD FILE: 8M Module Side Cover PCB_B

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NOTES

1. MATERIAL CERTIFICATIONS REQUIRED.



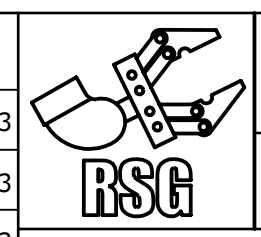
ISOMETRIC VIEW

MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M. BREAK SHARP CORNERS AND REMOVE ALL BURRS. DEFAULT TOLERANCES:
 LINEAR .XX = ±.100 ANGULAR .X.XX = ±.1/2
 .XXX = ±.010
 .XXX = ±.005
DO NOT SCALE DRAWING

APPROVALS		DATE
DES	EJ FOUNTAIN	03/08/2023
DRW	EJ FOUNTAIN	03/08/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/08/2023
QA		



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 CONTRACT DE-AC05-00OR22725 OAK RIDGE, TN

REMOTE SYSTEMS GROUP

**EPIC
 8M TOWER ASSEMBLY
 STEEL ABSORBER PLATE**

155

TOTAL WEIGHT	4.88 LBS
THIS DRAWING PRODUCED USING SolidWorks	

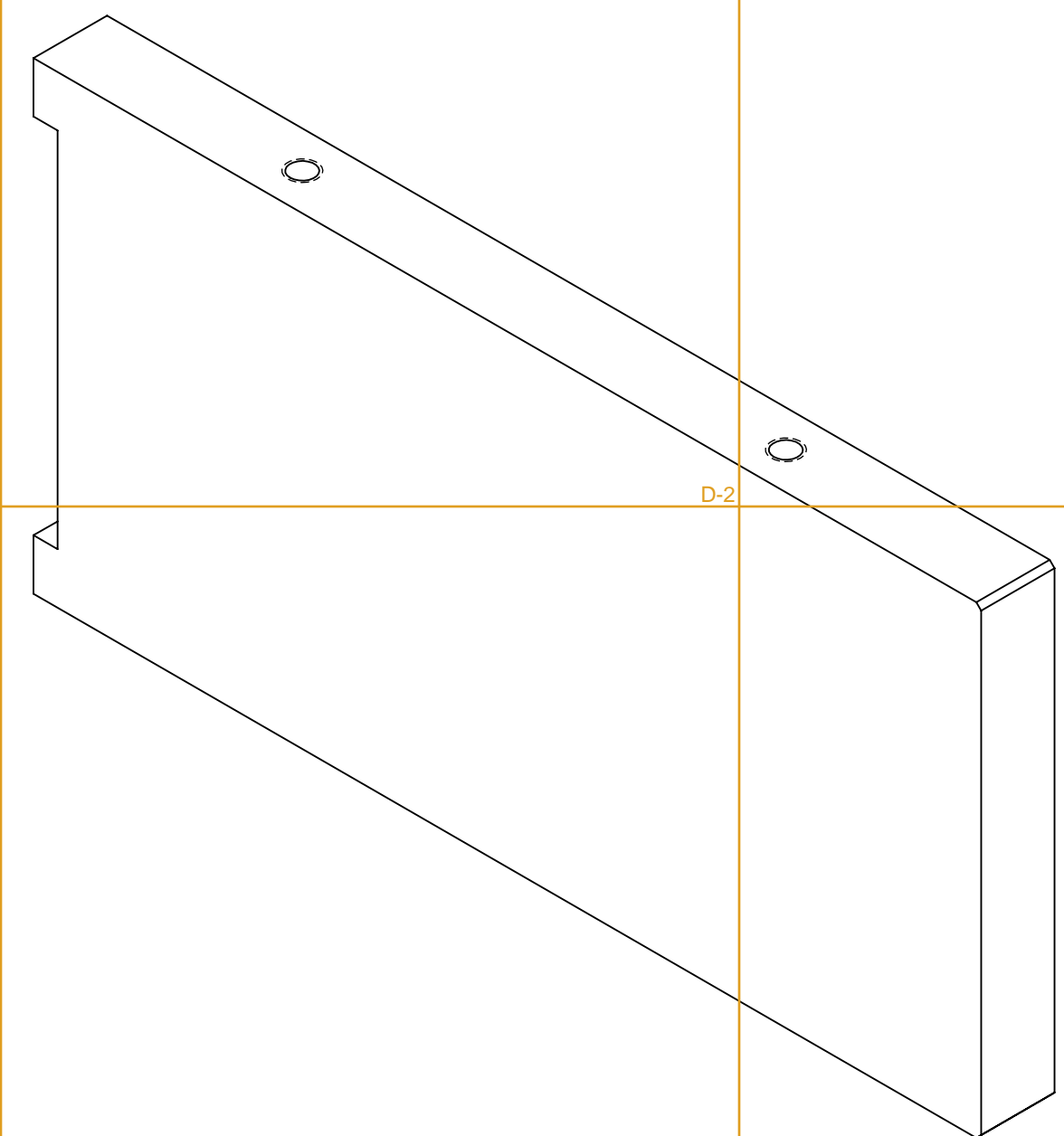
SIZE	NEXT ASSY	DWG NO.	REV
D	EPIC-200	EPIC-207	0
SCALE	1:1	NAME	STEEL ABSORBER PLATE
SHEET	1 of 1		

DWG NO. EPIC-207
 CAD FILE: 8M Absorber_Plate_B

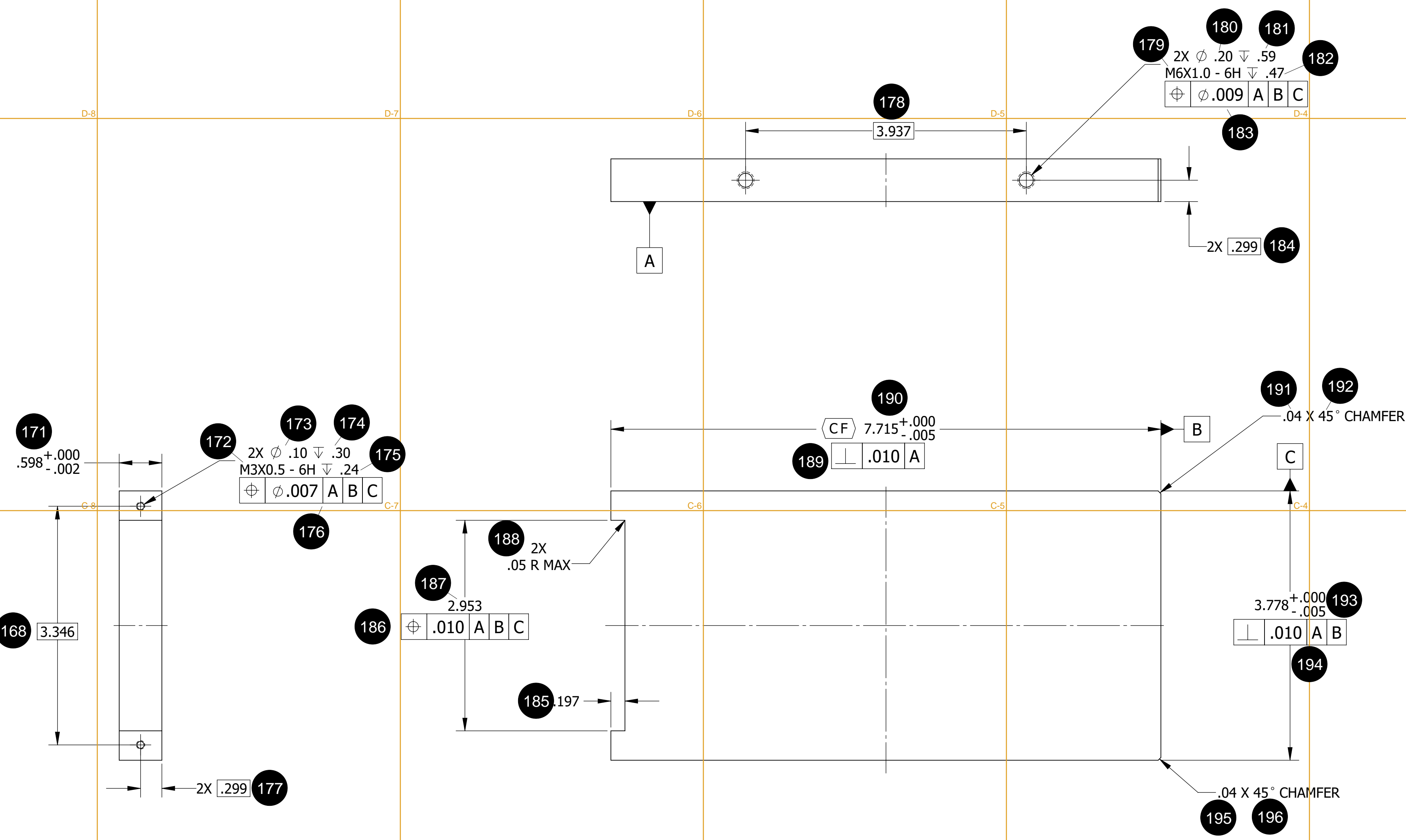
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NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED.



ISOMETRIC VIEW

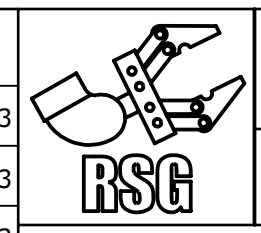


MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES
 INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M
 BREAK SHARP CORNERS AND REMOVE ALL BURRS
 DEFAULT TOLERANCES
 LINEAR .XX = ±.100 ANGULAR .X/XX = ±.1/2
 .XXX = ±.010
 .XXX = ±.005
DO NOT SCALE DRAWING

APPROVALS		DATE
DES	EJ FOUNTAIN	03/08/2023
DRW	EJ FOUNTAIN	03/08/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/08/2023
QA		



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 CONTRACT DE-AC05-00OR22725 OAK RIDGE, TN

REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
STEEL ABSORBER PLATE, TAPPED

TOTAL WEIGHT	4.87 LBS	SIZE	NEXT ASSY	DWG NO.	REV
THIS DRAWING PRODUCED USING		D	EPIC-200	EPIC-208	0
SCALE	1:1	NAME	STEEL ABSORBER PLATE, TAPPED		

DWG NO. EPIC-208
 CAD FILE: 8M Absorber_Plate_Tapped_B

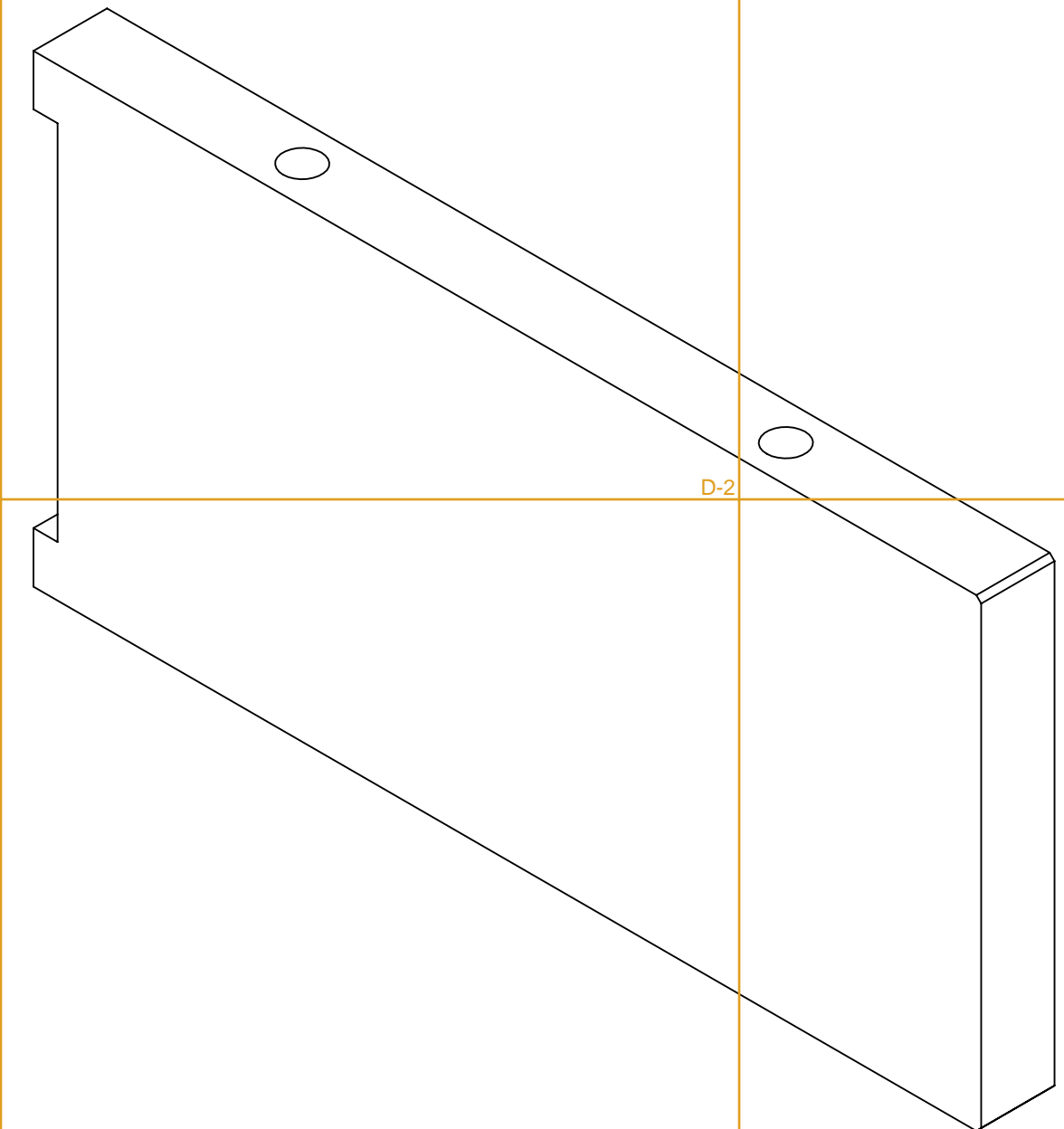
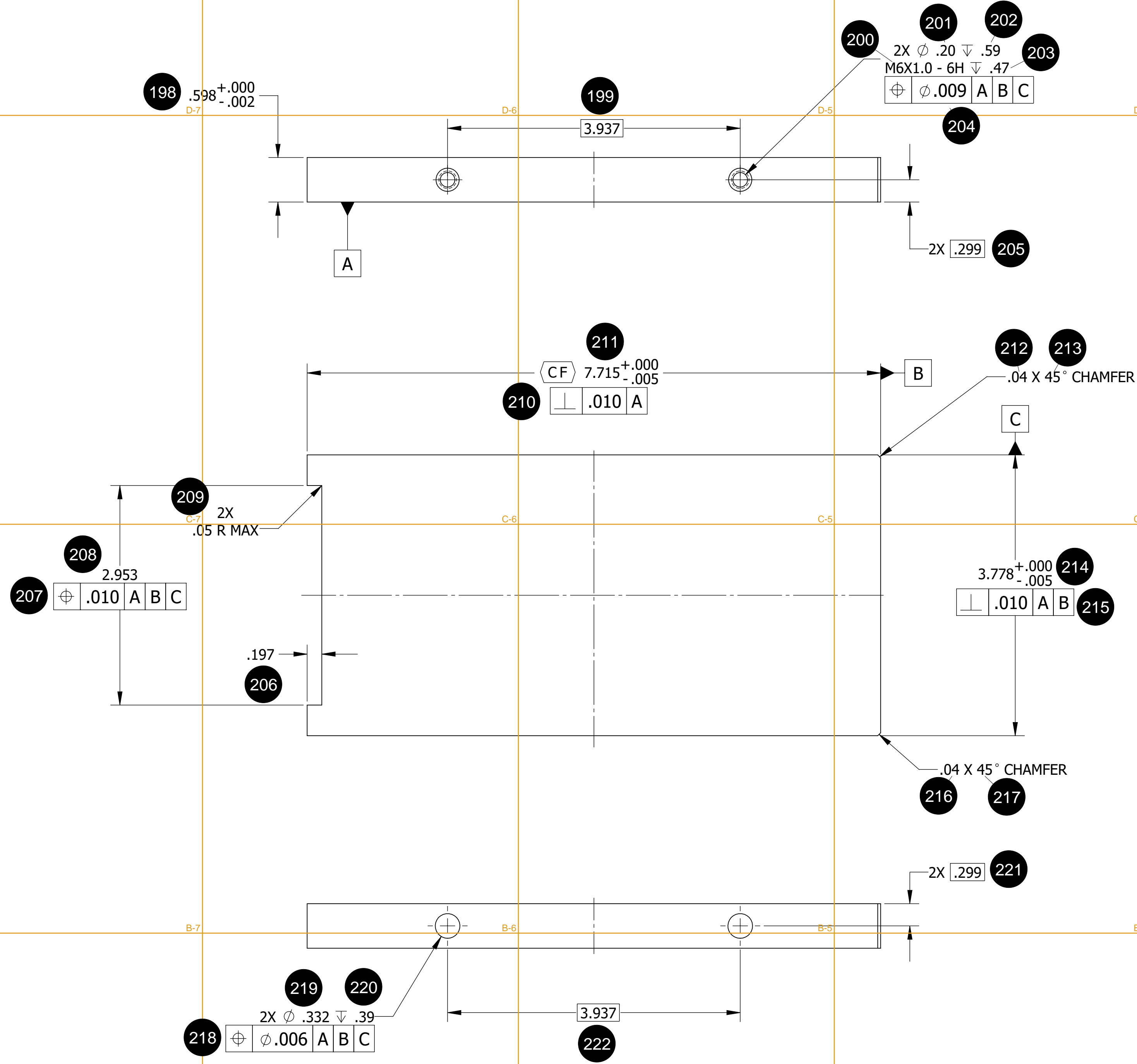
167

1 of 1

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NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED.



ISOMETRIC VIEW

MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		THIRD-ANGLE PROJECTION
MATERIAL MILL TEST REPORT	x	
LEAK TEST REPORT		
CLEANING CERT		
WELD / BRAZE INSPECTION REPORT		
HEAT TREAT REPORT		
DIMENSIONAL REPORT		
MATERIAL SELLER CERT		
FUNCTIONAL TEST REPORT		
DEVIATION REQUEST	x	
NONCONFORMANCE REPORT	x	

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APPROVALS		DATE
DES	EJ FOUNTAIN	03/08/2023
DRW	EJ FOUNTAIN	03/08/2023
CHK	CD OTTINGER	03/24/2023
ENG	EJ FOUNTAIN	03/08/2023
QA		
TOTAL WEIGHT	4.84 LBS	
THIS DRAWING PRODUCED USING SolidWorks		

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REMOTE SYSTEMS GROUP

EPIC
8M TOWER ASSEMBLY
STEEL ABSORBER PLATE, LAST

THIS DRAWING PRODUCED USING **SolidWorks**

SIZE	NEXT ASSY	DWG NO.	REV
D	EPIC-200	EPIC-209	0
SCALE	1:1	NAME	STEEL ABSORBER PLATE, LAST SHEET
		SHEET	1 of 1

DWG NO. EPIC-209
CAD FILE: 8M Absorber_Plate_Last