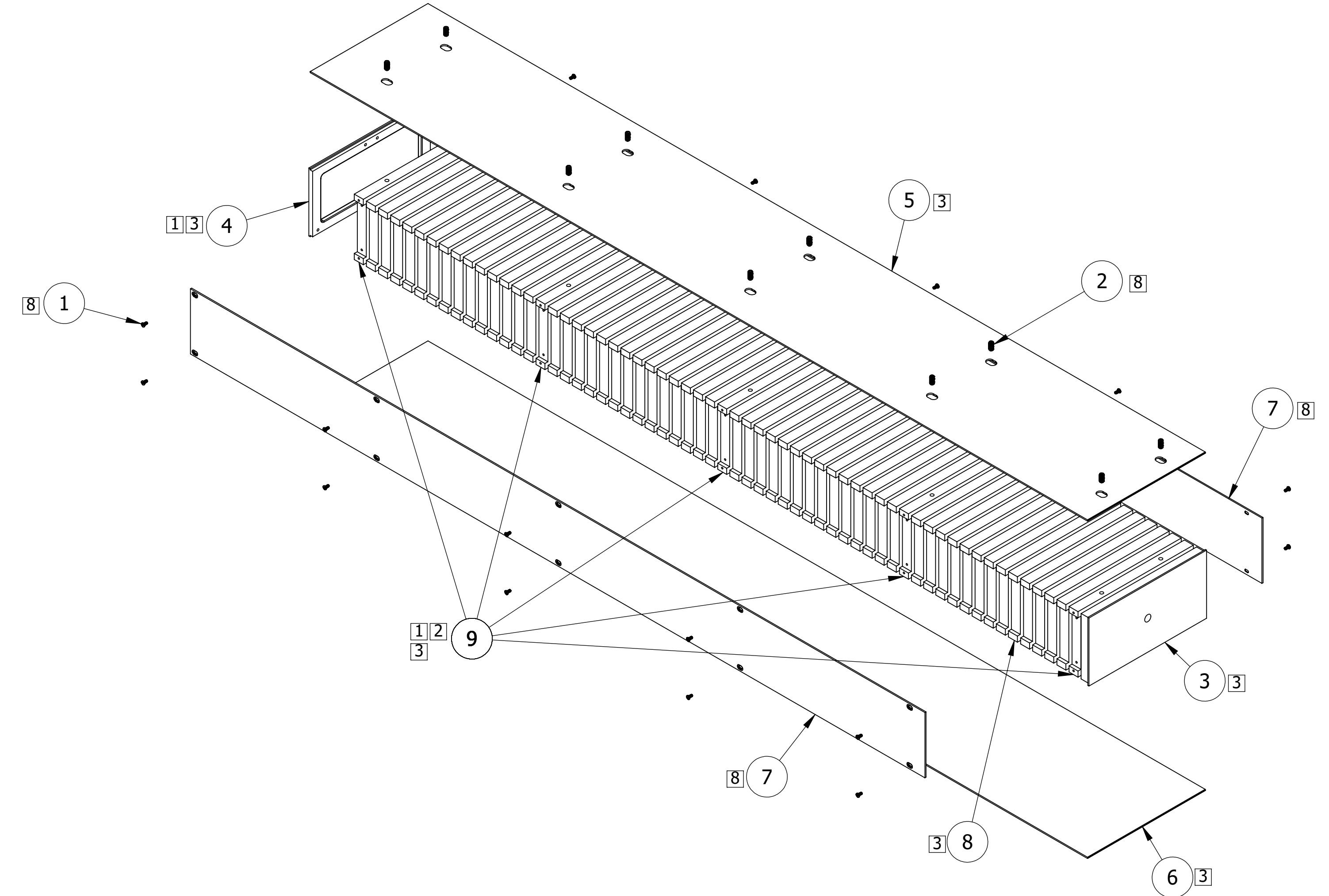


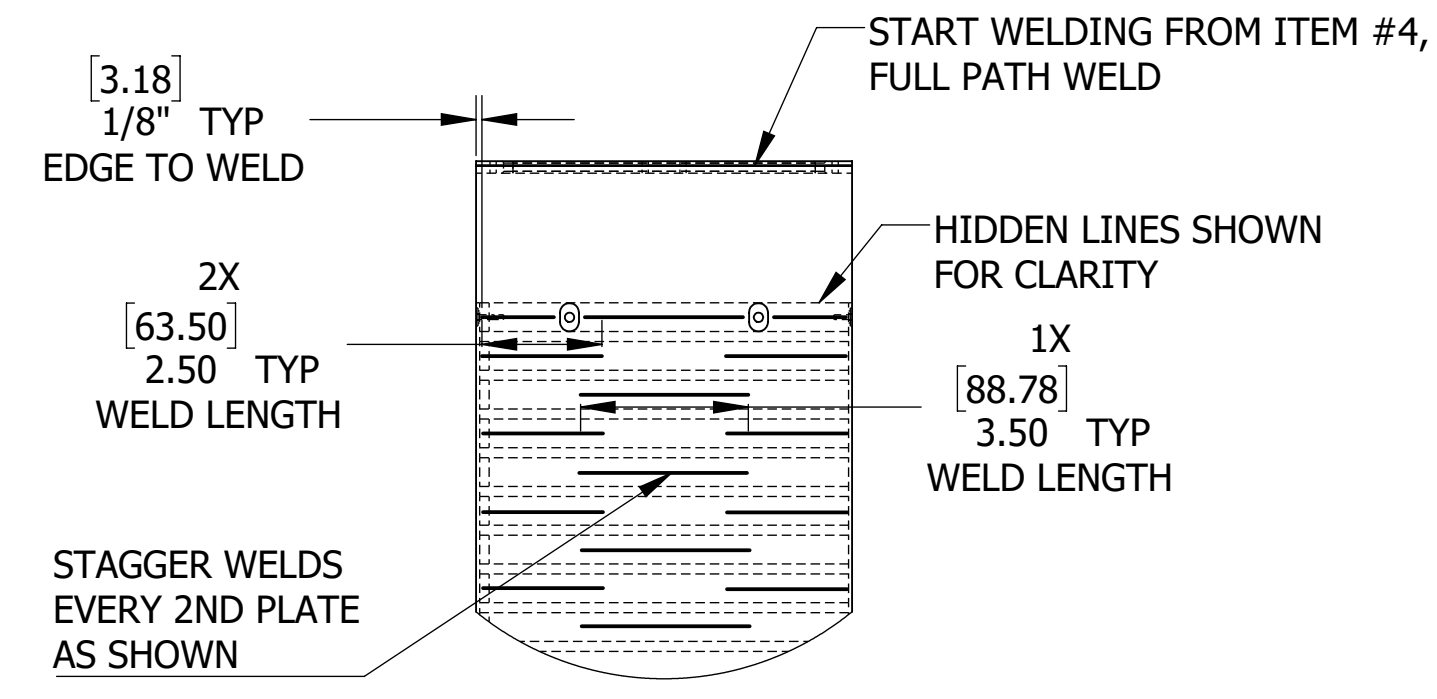
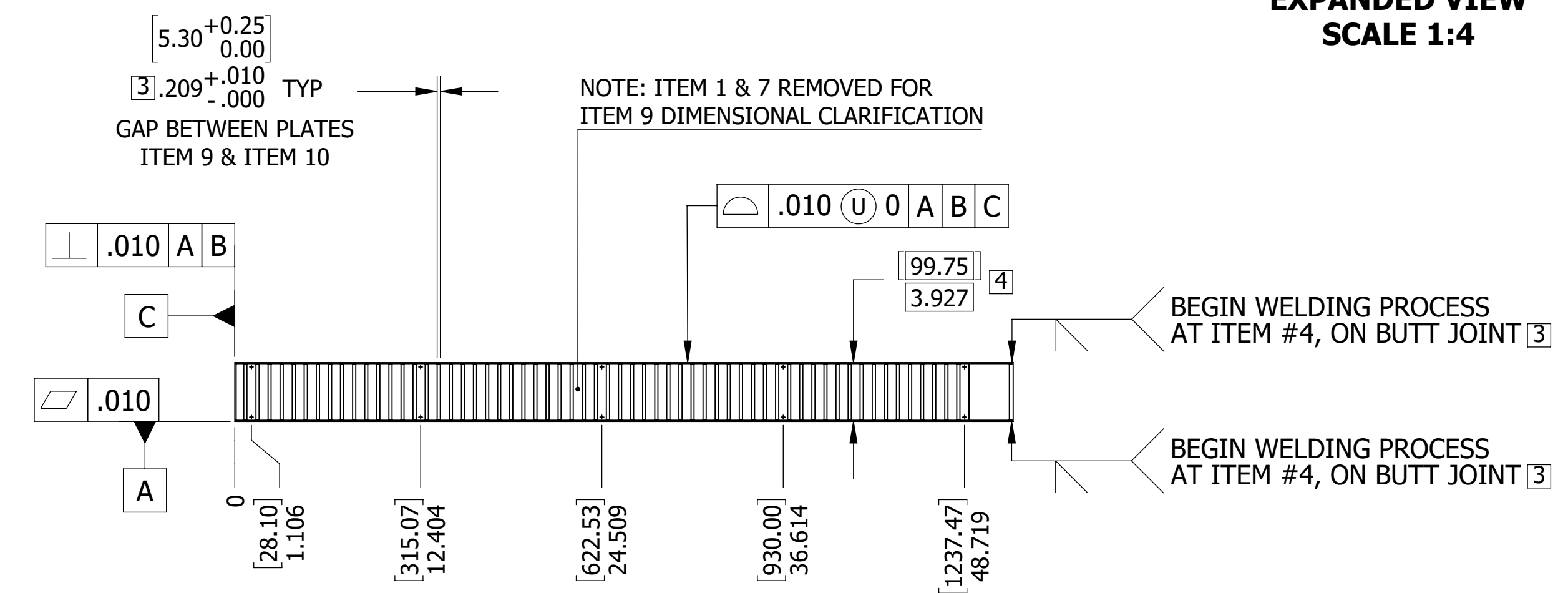
**NOTES**

1. ITEM 9 WILL BE ORIENTED WITH THE TAPPED HOLES FACING UP, ITEM 4 WILL BE ORIENTED WITH CLOSE HOLE PATTERN HOLES TOWARDS TOP.
2. ITEM 9 TO BE PLACED IN POSITION #1, 15, 30, 45, & 60 (IN REFERENCE FROM ITEM 3) FOR ALL ABSORBER PLATES. MATCH UP HOLE PATTERN ON ITEM 5 & 9 TO VERIFY PRIOR TO WELDING. THESE PLATES (ITEM 9) TO BE INSTALLED AND WELDED FOR PROPER ALIGNMENT PRIOR TO THE ADDITIONAL PLATES (ITEM 8).
3. E-BEAM WELD ALONG CENTERLINE OF CONTACTING FACES ALL ITEMS 3, 5, 6, & 9. START AT ITEM 4, AND WORK FORWARD, PERFORMING A STAGGERED STITCH WELD AS SHOWN IN DETAIL A. ALLOW 1/8" CLEARANCE FROM WELDS TO ALL HOLES AND EDGES. DO NOT WELD ITEM 7. USE A JIG AND SPACING PLATES TO ENSURE PROPER PLATE SPACING AND FINAL ASSEMBLY GEOMETRY. NOTE THAT ITEM 5 & 6 WILL SHRINK APPROXIMATELY 0.080" DURING THE WELDING PROCESS, THIS GAP IS ACCEPTABLE AND ITEM 3 IS TO BE WELDED ALONG CENTERLINE OF CONTACTING FACE TO ENSURE OVERALL ASSEMBLY LENGTH IS MAINTAINED. E-BEAM WELD SHALL PENETRATE WITH SUFFICIENT DEPTH TO ENSURE AT LEAST 0.020" WELD WIDTH AT ALL PART INTERFACES. WELDING PROCEDURE TO BE DETAILED, DEMONSTRATED, APPROVED BY ORNL PRIOR TO FULL SCALE PRODUCTION.
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.
5. ALL WELDING AND WELD INSPECTIONS PER AWS D1.1/D1.1M - 2010.
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.
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.
8. ELECTROLESS NICKEL PLATE FINAL WELDMENT (EXCLUDING ITEM 1, 2, & 7) TO 0.001" THICKNESS MINIMUM / 0.002" THICKNESS MAXIMUM PER ASTM B766.

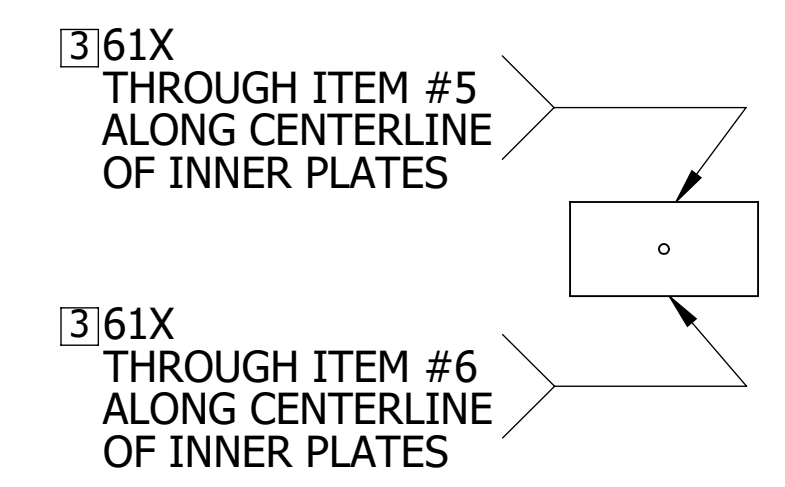
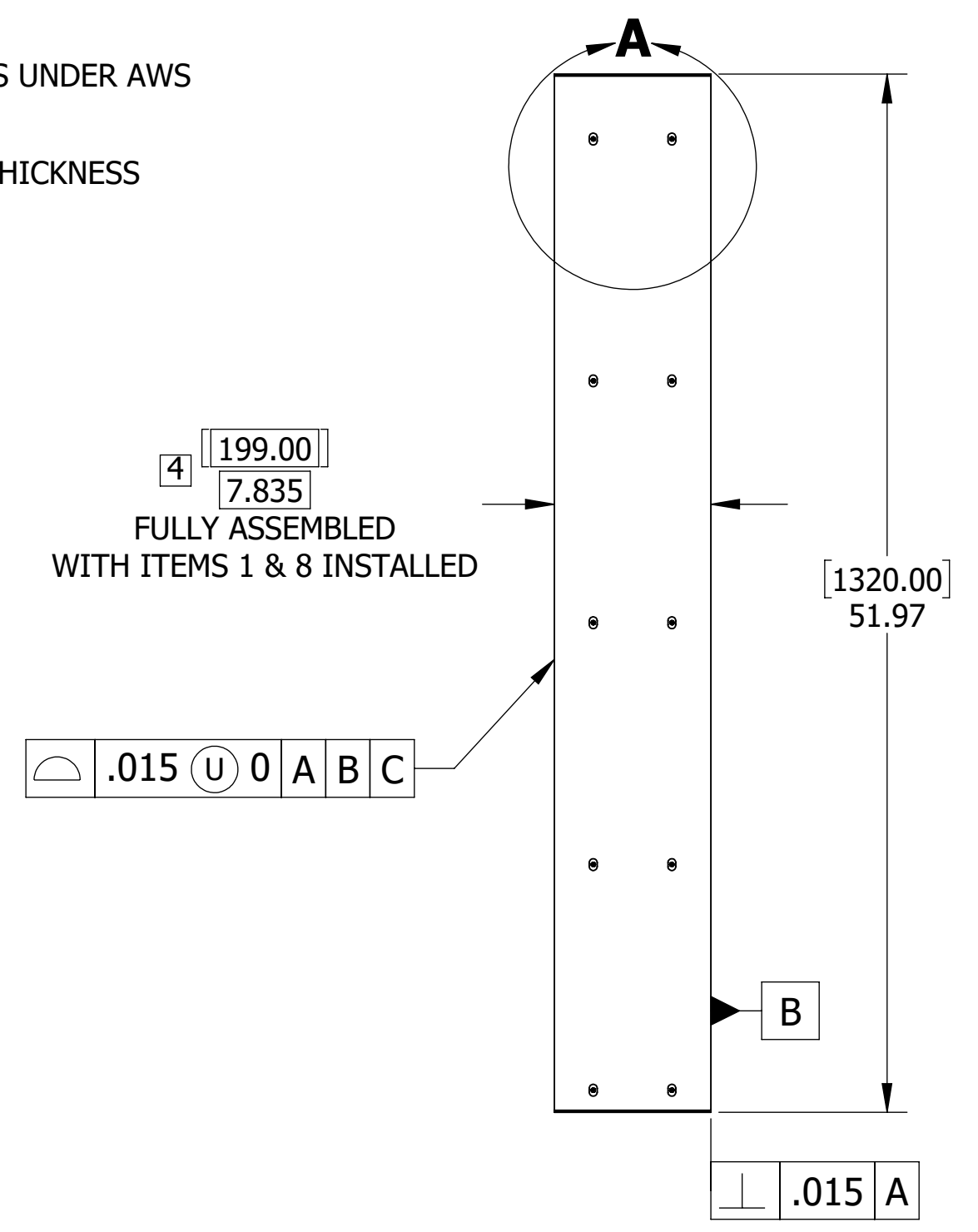
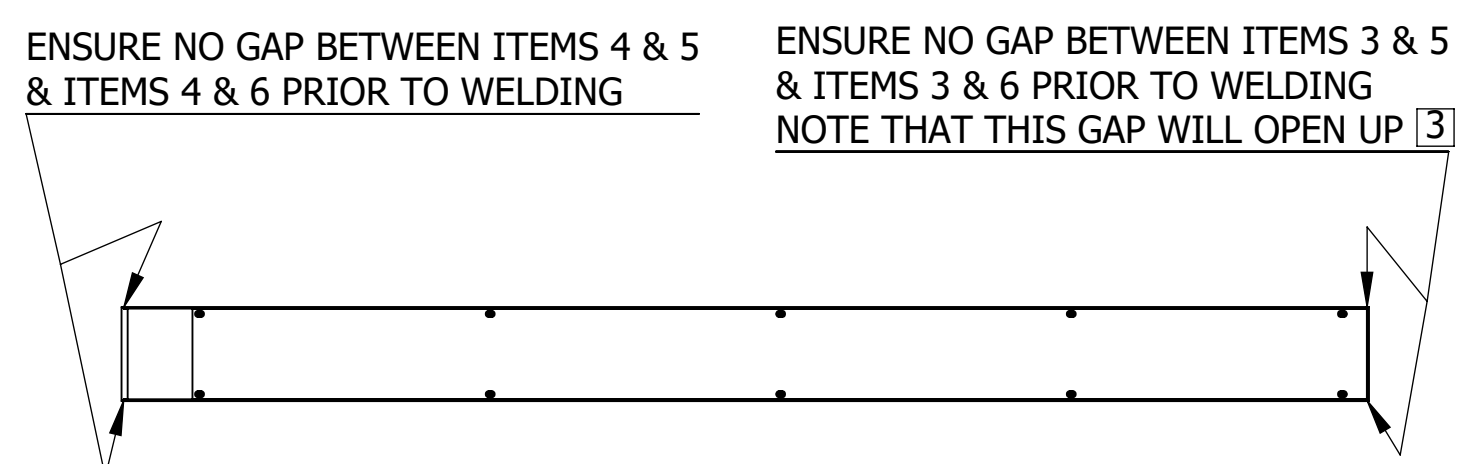
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**EXPANDED VIEW SCALE 1:4**



**DETAIL A WELDING DETIAL SCALE 1 : 4**



ITEM	QTY.	NAME/PART NO	MATERIAL	DESCRIPTION	DWG
9	5	ABSORBER PLATE, TAPPED	AISI 1020 CARBON STEEL	PLATE	EPC-FWD-HCL-DET-PRT-107
8	55	ABSORBER PLATE	AISI 1020 CARBON STEEL	PLATE	EPC-FWD-HCL-DET-PRT-106
7	2	PCB SIDE COVER	AISI 304 STAINLESS STEEL	SHEET METAL 14 GA	EPC-FWD-HCL-DET-PRT-105
6	1	BOTTOM PLATE	AISI 1020 CARBON STEEL	SHEET METAL 14 GA	EPC-FWD-HCL-DET-PRT-104
5	1	TOP PLATE	AISI 1020 CARBON STEEL	SHEET METAL 14 GA	EPC-FWD-HCL-DET-PRT-103
4	1	BACK PLATE	AISI 1020 CARBON STEEL	PLATE	EPC-FWD-HCL-DET-PRT-102
3	1	FRONT PLATE	AISI 1020 CARBON STEEL	PLATE	EPC-FWD-HCL-DET-PRT-101
2	10	MCMaster_91390A129	ALLOY STEEL	M6-1.0 X 12MM LG SET SCREW	COTS
1	20	MCMaster_90358A001	ALLOY STEEL	M3-0.5 X 6MM LG LOW SHCS	COTS

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
MATERIAL MILL TEST REPORT		FRACTION	± 1/64
LEAK TEST REPORT		XX DECIMALS	± 0.01
CLEANING CERT		XXX DECIMALS	± 0.005
WELD / BRAZE INSPECTION REPORT	x	ANGLES	± 0°-30'
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.
DIMENSIONAL REPORT	x	FINISH	= 125 RMS
MATERIAL SELLER CERT	x	ALL DIMENSIONS ARE IN INCHES	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
DEVIATION REQUEST	x	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	
NONCONFORMANCE REPORT	x		

DRAWN BY: ELIOTT J. FOUNTAIN DESIGN ENGINEER ELIOTT J. FOUNTAIN CHECKER DUSTIN C. OTTINGER DESIGN REVIEW DANIEL CACACE ENGINEERING LEAD RAHUL SHARMA LEAD SUBMITTER FRIEDERIKE BOCK SAFETY REVIEW MICHAEL GAFFNEY QA REVIEW JOE ZIPPER LEVEL 2 MANAGER ELKE ASCHENAUER LEVEL 3 MANAGER OLEG EYSER SPECIAL REVIEW	DRAWING APPROVALS: _____ DATE: _____
---	--------------------------------------

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**REMOTE SYSTEMS GROUP**

**ePIC - Electron-Proton/Ion Collider**

**EPIC**  
**8M TOWER BODY ASSEMBLY**

**EPC-FWD-HCL-DET-ASM-100**

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
322.29 LBS	1:8	D	1	1	EPC-FWD-HCL-DET-ASM-000	1

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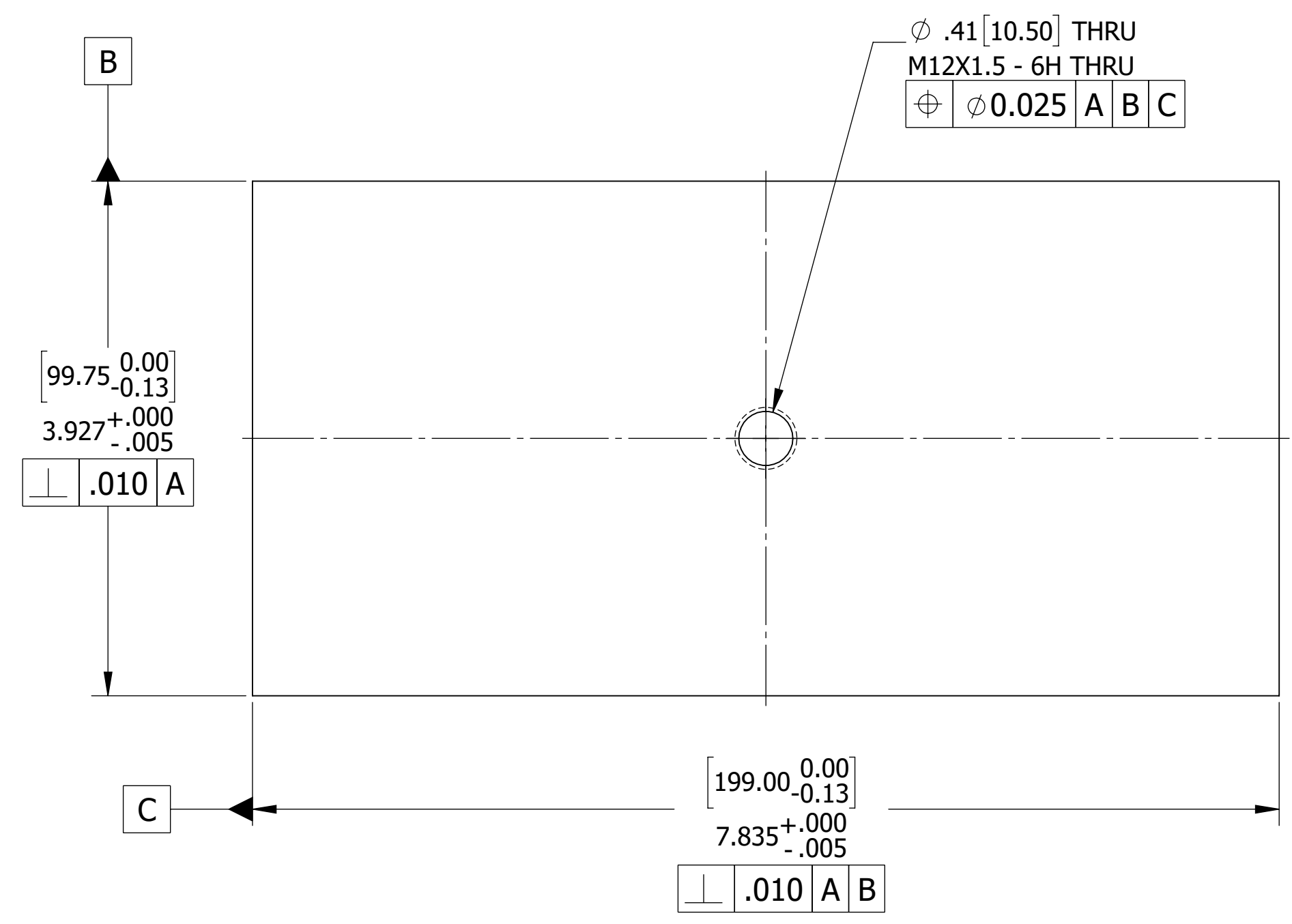
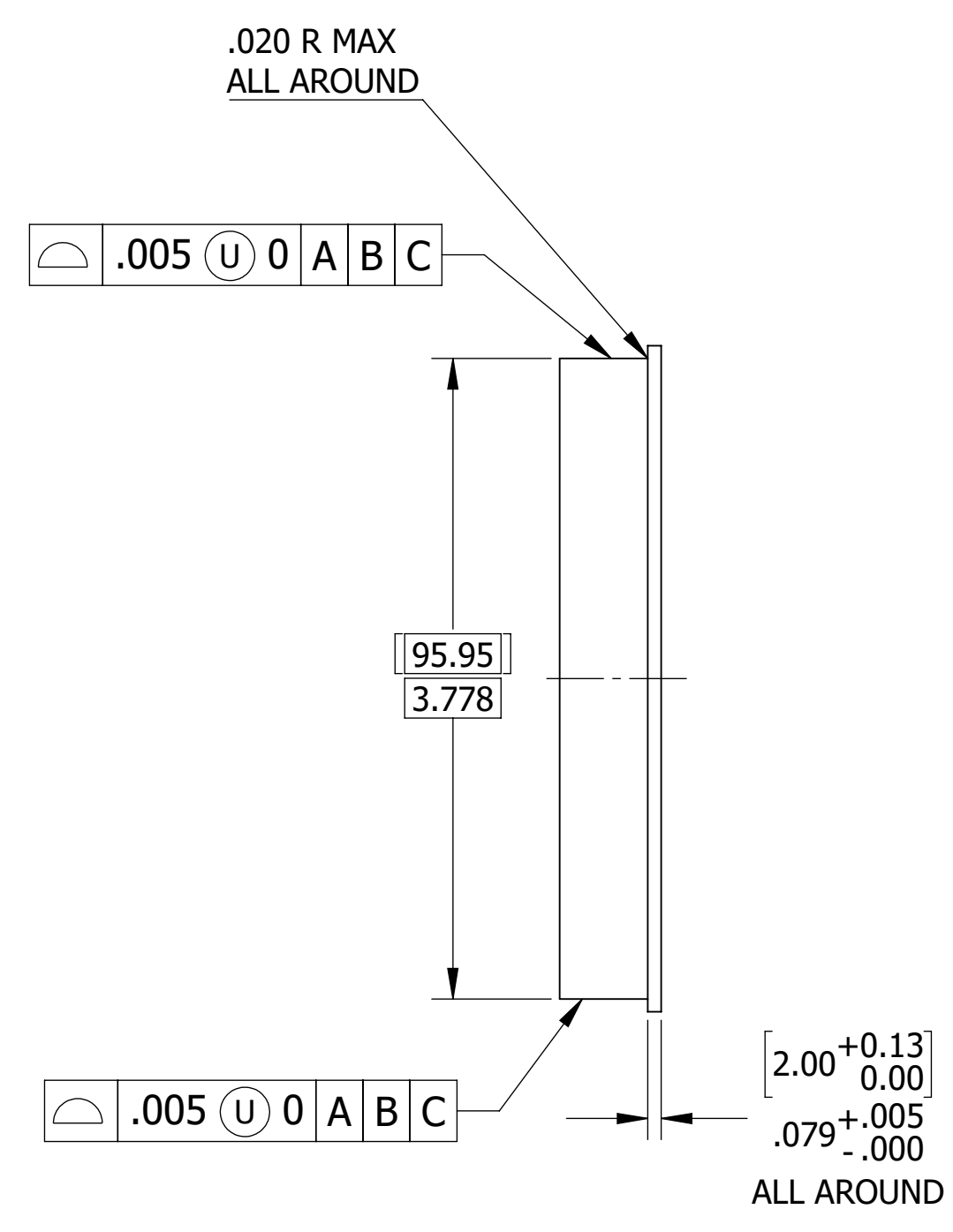
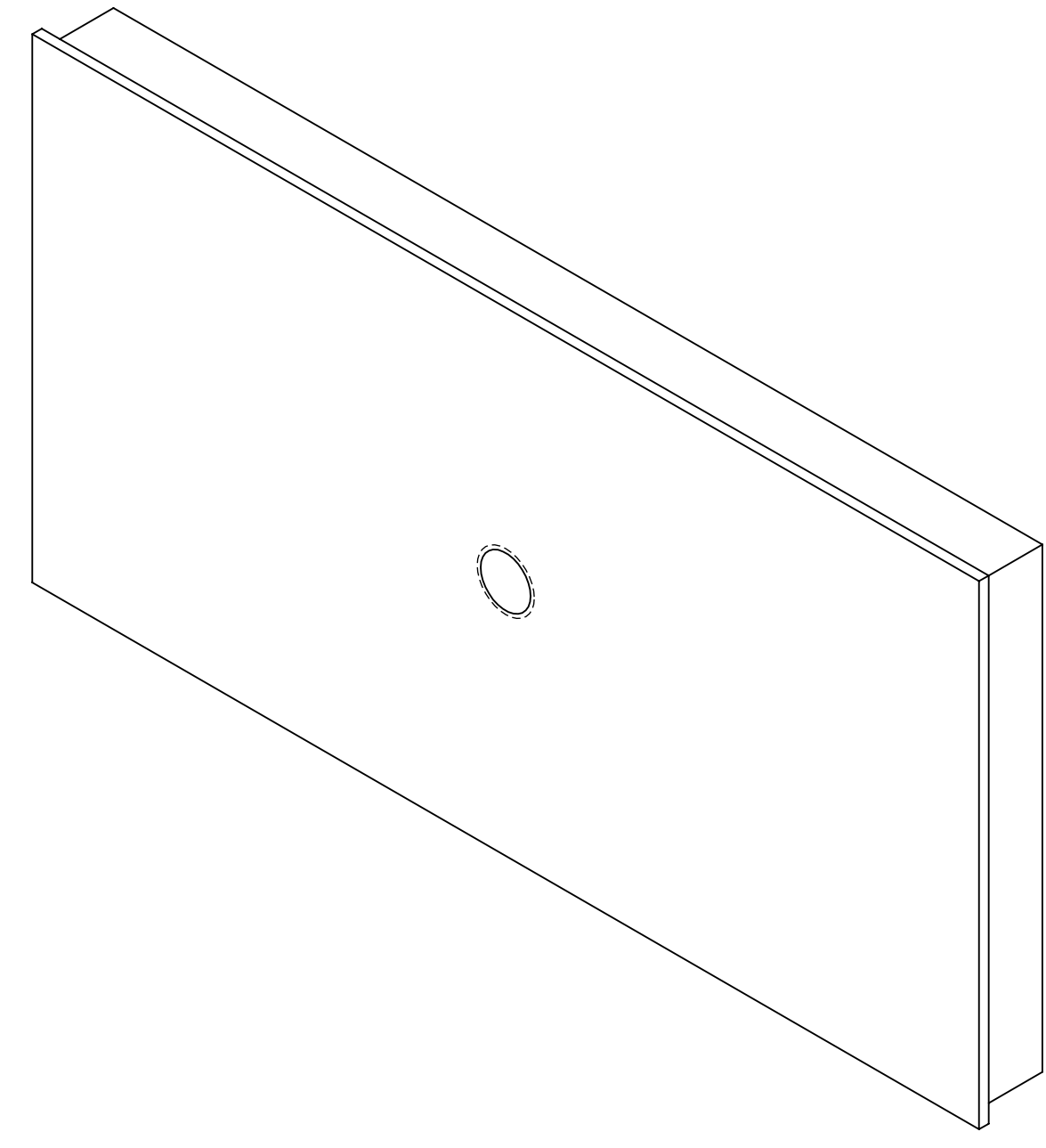
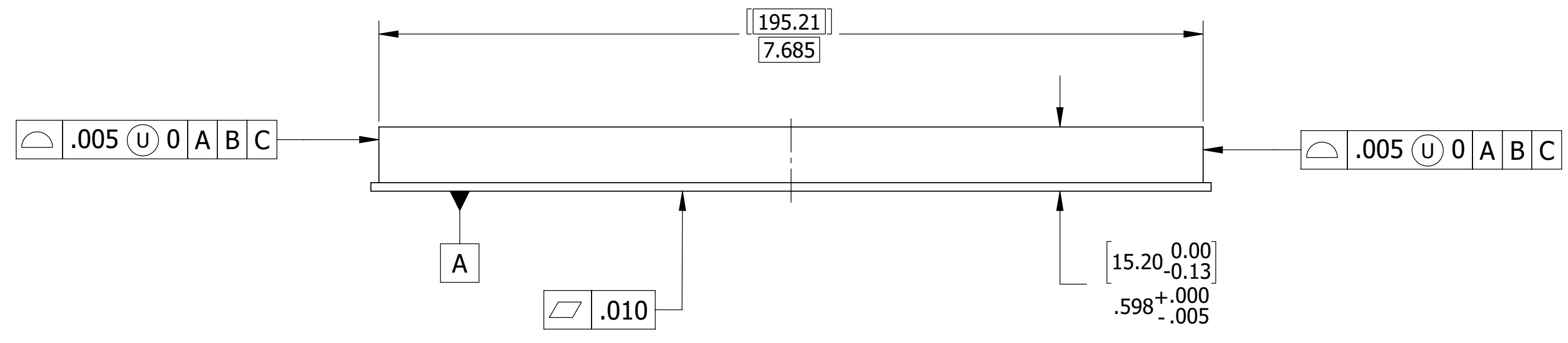
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**NOTES**

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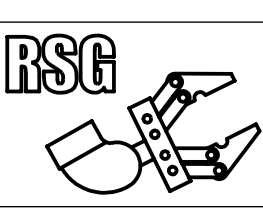


**MATERIAL: AISI 1020 CARBON STEEL**

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

DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
FRACTION	± 1/64
XX DECIMALS	± 0.01
XXX DECIMALS	± 0.005
ANGLES	± 0°-30'
BREAK SHARP EDGES	1/64 MAX.
FINISH	= 125 RMS
ALL DIMENSIONS ARE IN INCHES	
WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	

DRAWN BY	ELLIOTT J. FOUNTAIN
DESIGN ENGINEER	ELLIOTT J. FOUNTAIN
CHECKER	
DESIGN REVIEW	DUSTIN C. OTTINGER
DESIGN REVIEW	DANIEL CACACE
ENGINEERING LEAD	RAHUL SHARMA
LEAD SUBJECT	FRIEDERIKE BOCK
SAFETY REVIEW	MICHAEL GAFFNEY
QA REVIEW	JOE ZIPPER
LEVEL 2 MANAGER	ELKE ASCHENAUER
LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE



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**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

**EPIC**  
**8M TOWER BODY ASSEMBLY**  
**FRONT PLATE**

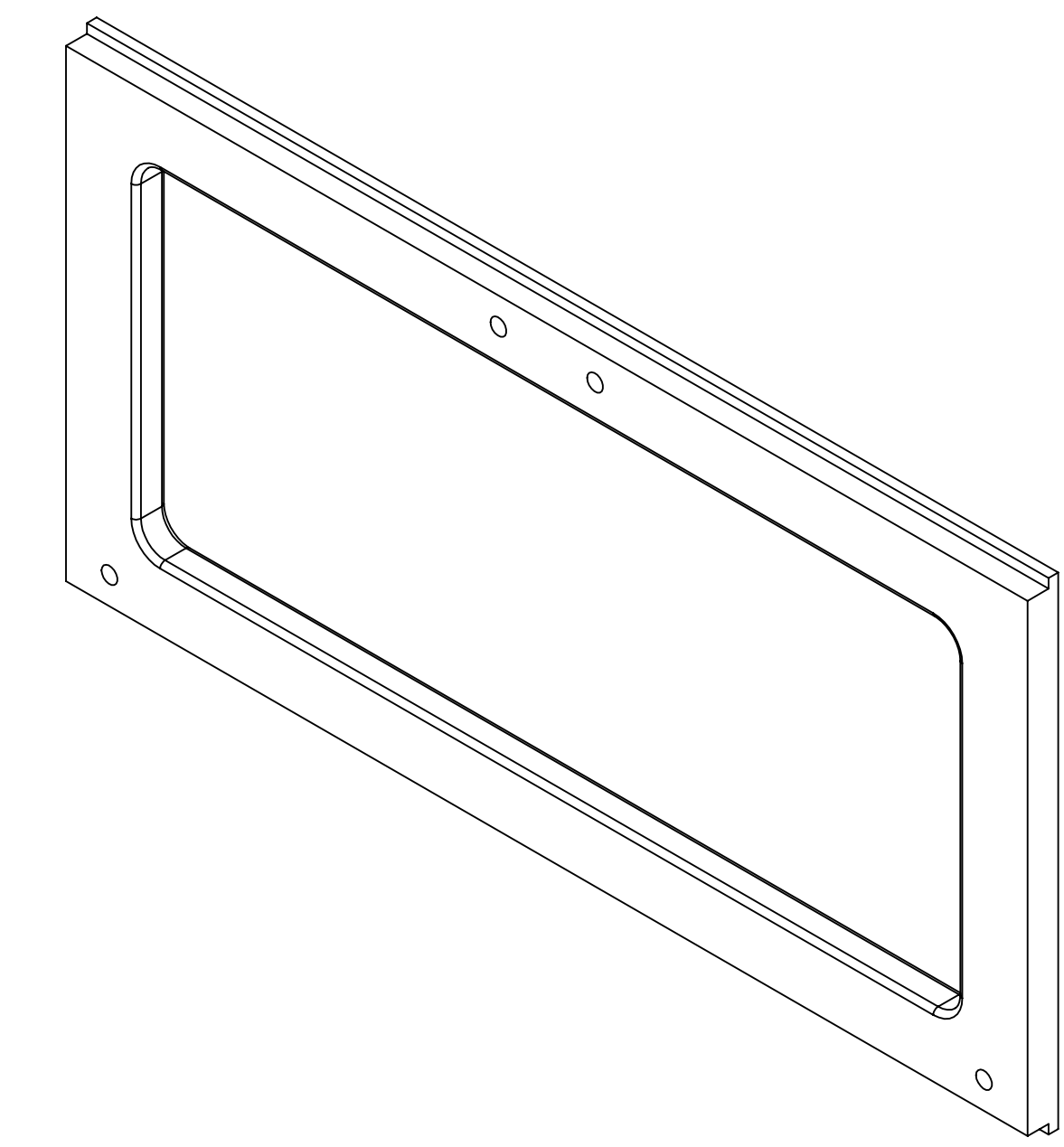
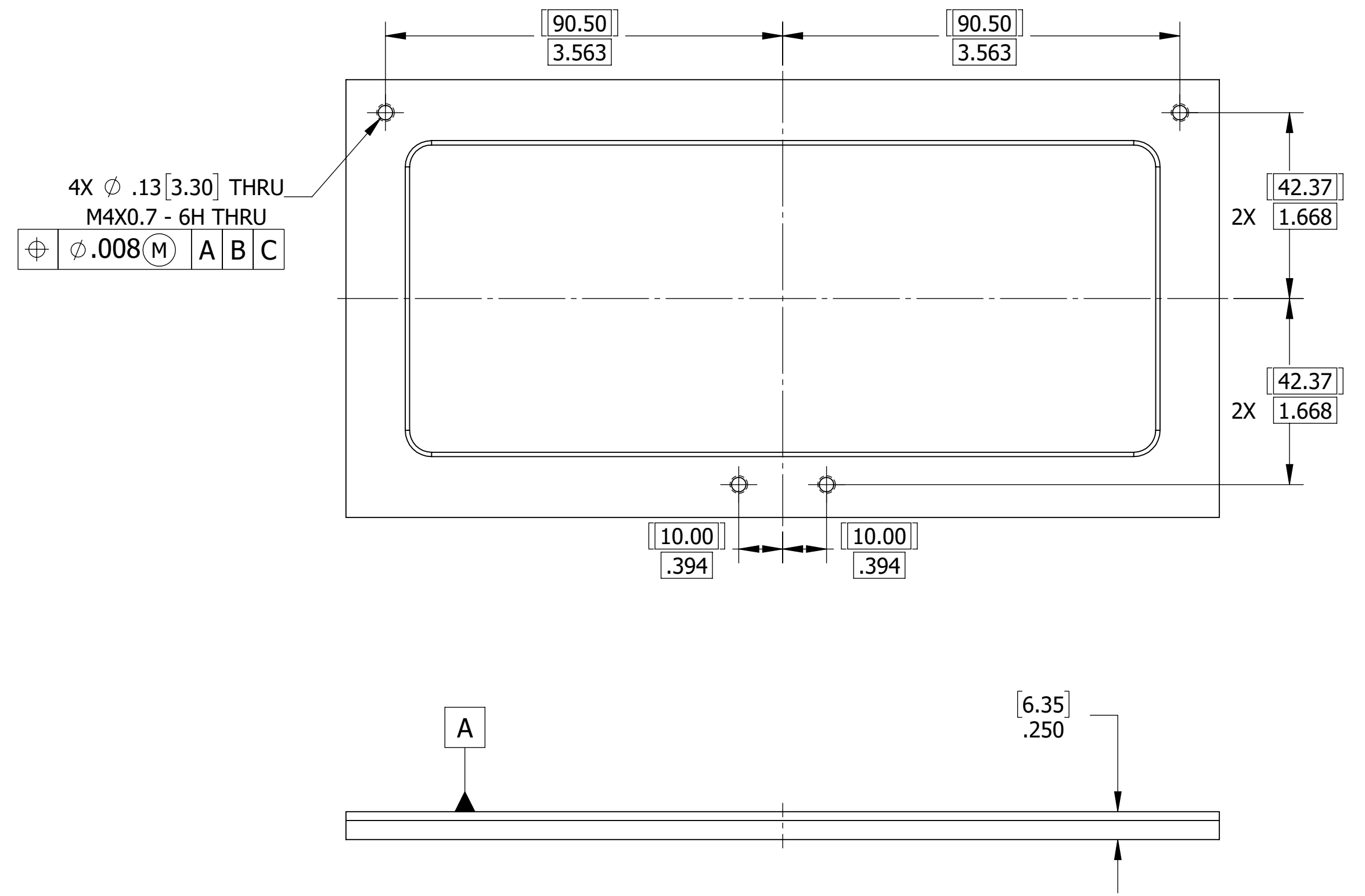
**EPC-FWD-HCL-DET-PRT-101**

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
4.97 LBS	1:1	D	1	1	EPC-FWD-HCL-DET-ASM-100	1

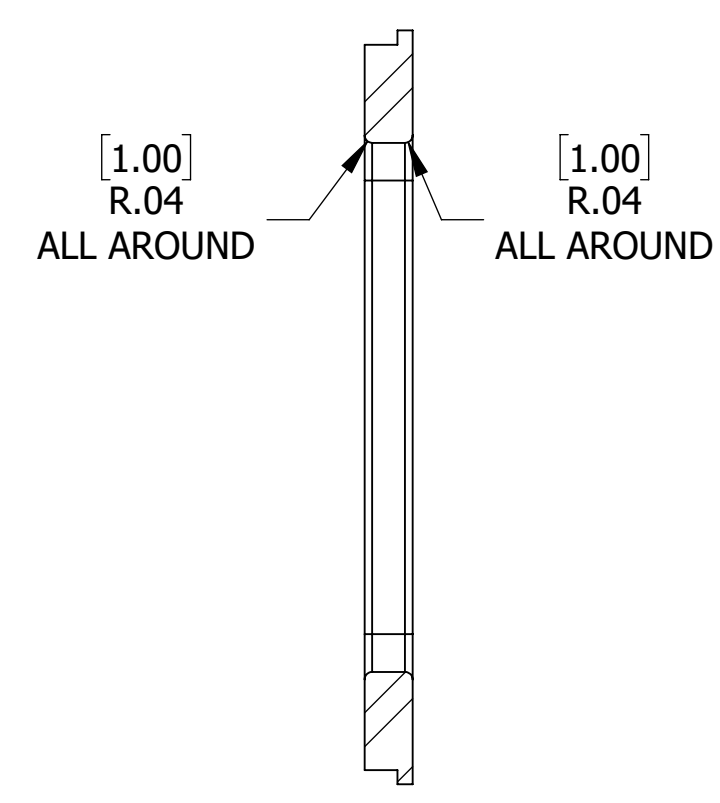
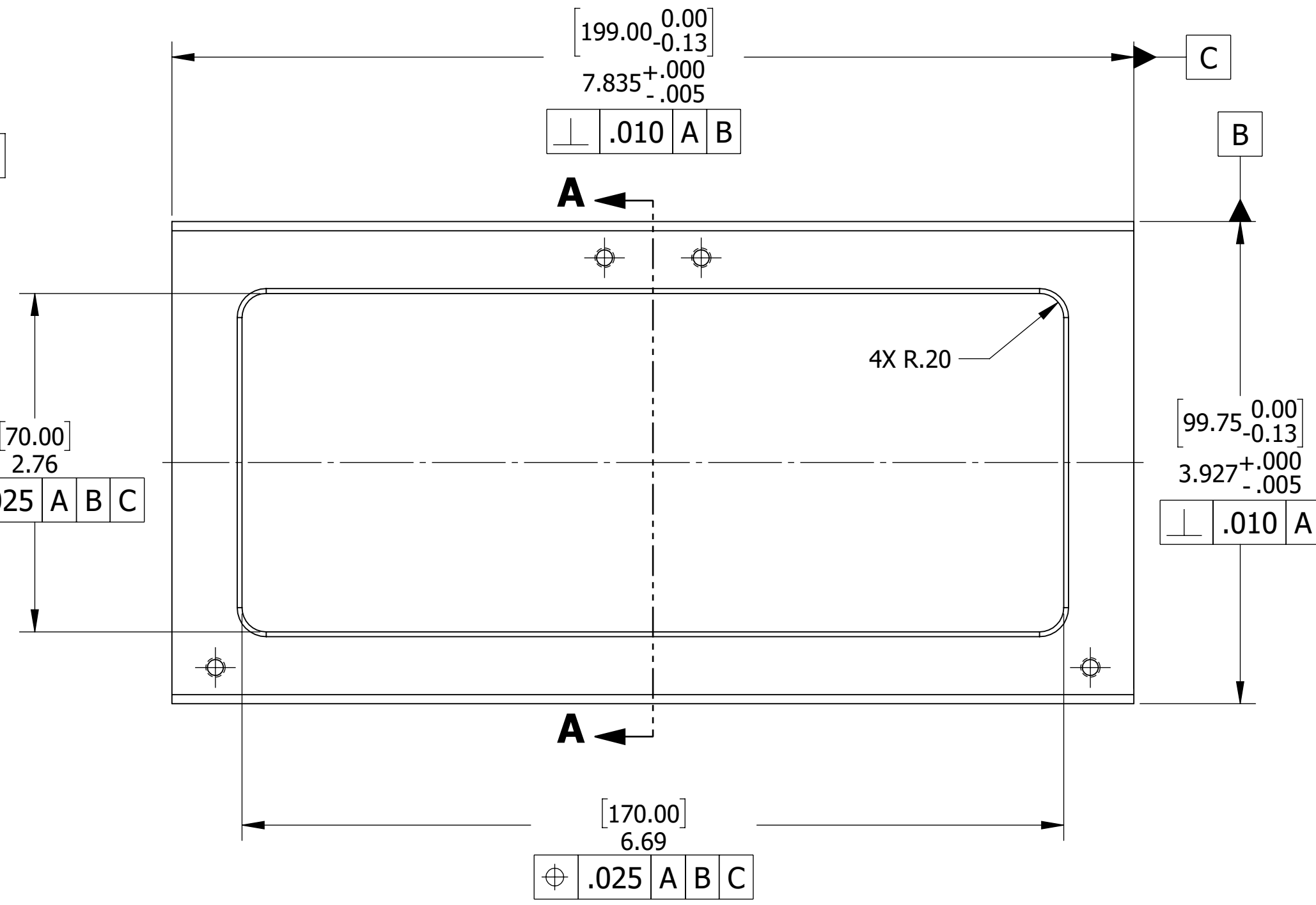
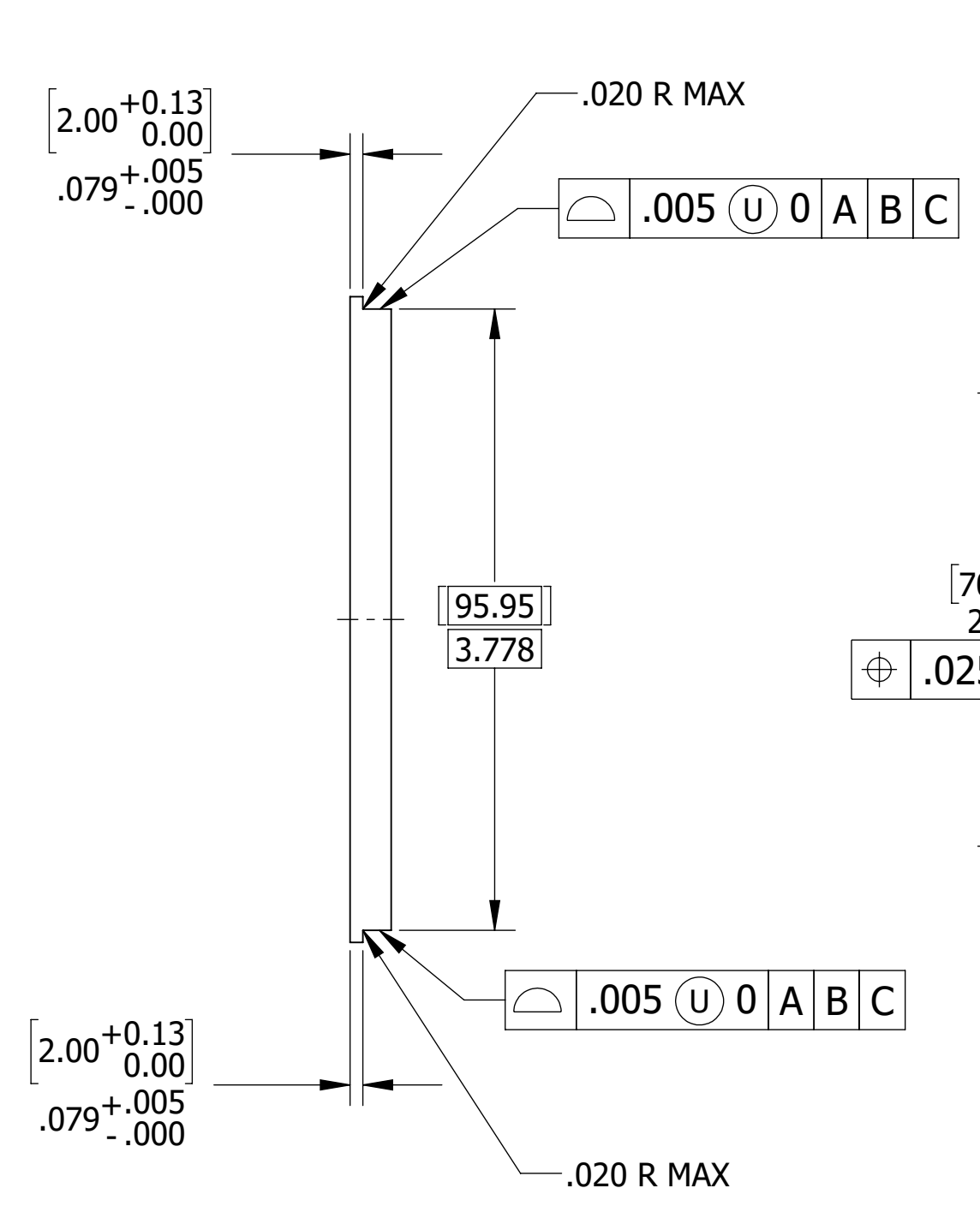
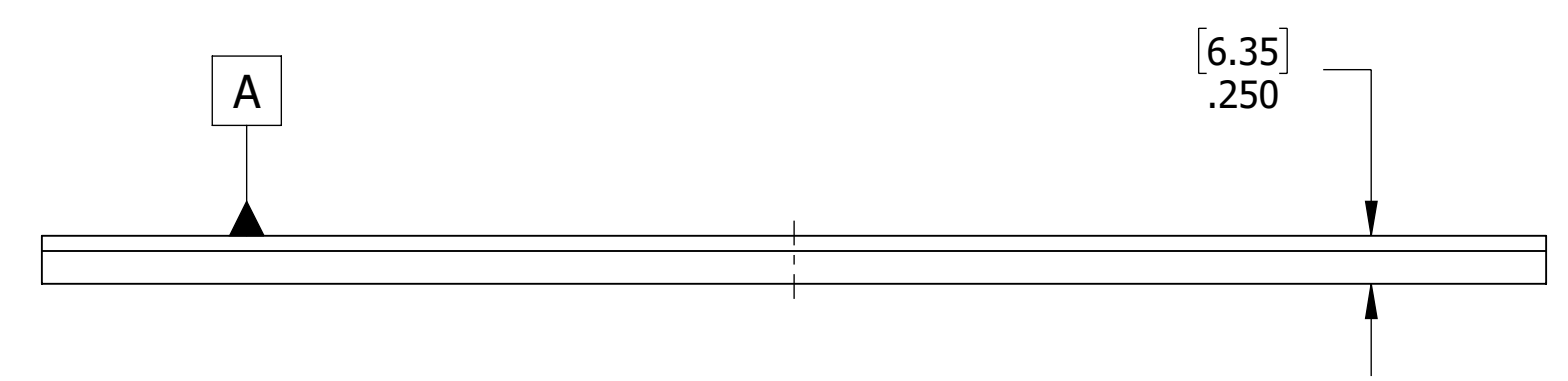
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**NOTES**

- 1. MATERIAL CERTIFICATIONS REQUIRED.



**ISOMETRIC VIEW**



**SECTION A-A**

**MATERIAL: AISI 1020 CARBON STEEL**

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
MATERIAL MILL TEST REPORT	<b>x</b>	FRACTION	± 1/64
LEAK TEST REPORT		XX DECIMALS	± 0.01
CLEANING CERT		XXX DECIMALS	± 0.005
WELD / BRAZE INSPECTION REPORT		ANGLES	± 0°-30'
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.
DIMENSIONAL REPORT		FINISH	125 RMS
MATERIAL SELLER CERT		ALL DIMENSIONS ARE IN INCHES	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
DEVIATION REQUEST	<b>x</b>	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	
NONCONFORMANCE REPORT	<b>x</b>		

DRAWN BY	ELLIOTT J. FOUNTAIN
DESIGN ENGINEER	ELLIOTT J. FOUNTAIN
DIRECTOR	DUSTIN C. OTTINGER
DESIGN REVIEW	DANIEL CACACE
ENGINEERING LEAD	RAHUL SHARMA
LIQUID SUBMITTER	FRIEDERIKE BOCK
SAFETY REVIEW	MICHAEL GAFFNEY
QA REVIEW	JOE ZIPPER
LEVEL 2 MANAGER	ELKE ASCHENAUER
LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE

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**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

**EPIC**  
**8M TOWER BODY ASSEMBLY**  
**BACK PLATE**  
**EPC-FWD-HCL-DET-PRT-102**

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
<b>0.82 LBS</b>	1:1	D	1	1	EPC-FWD-HCL-DET-ASM-100	<b>1</b>

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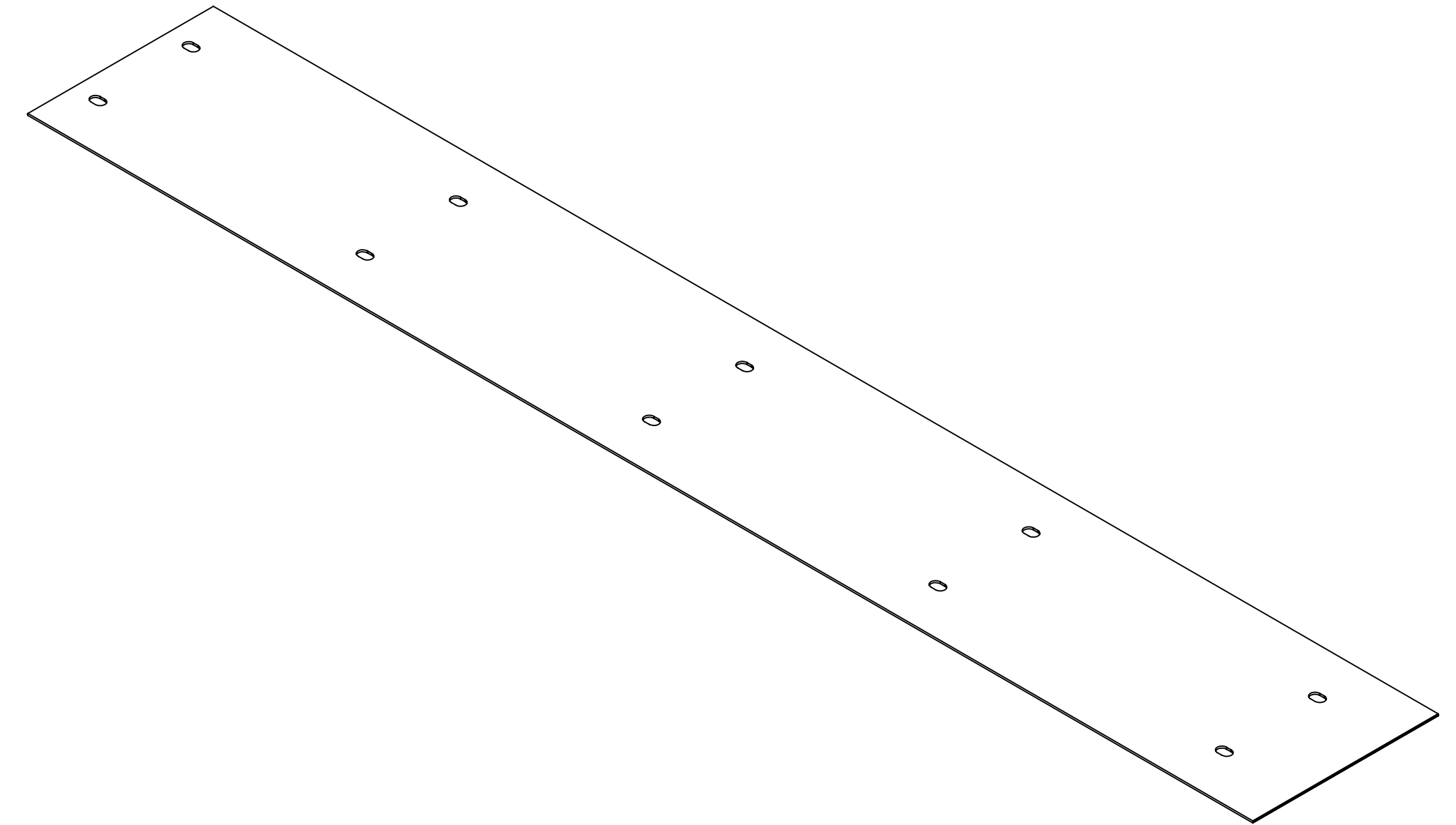
**NOTES**

- 1. MATERIAL CERTIFICATIONS REQUIRED.

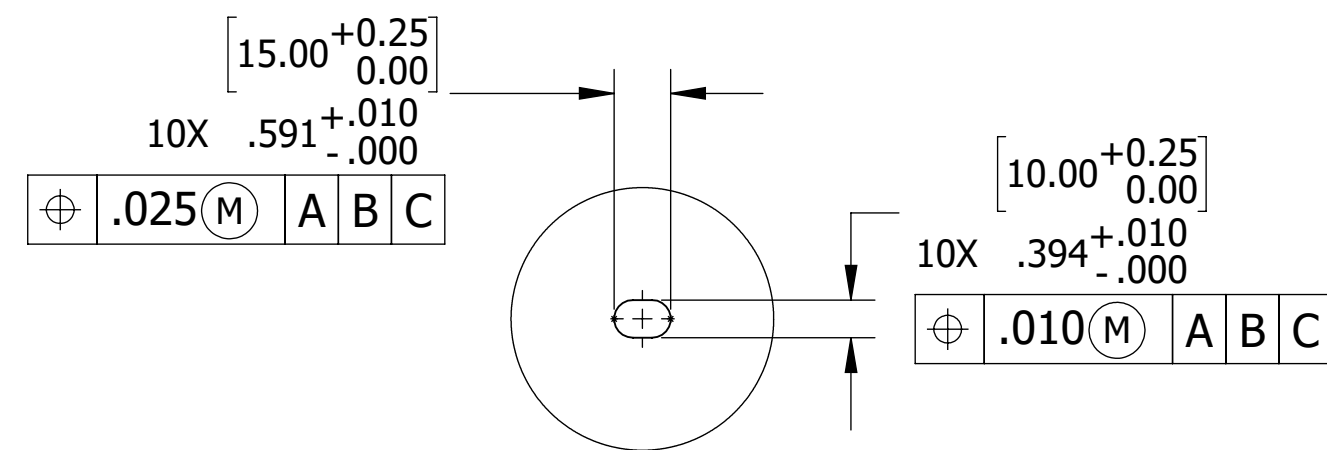
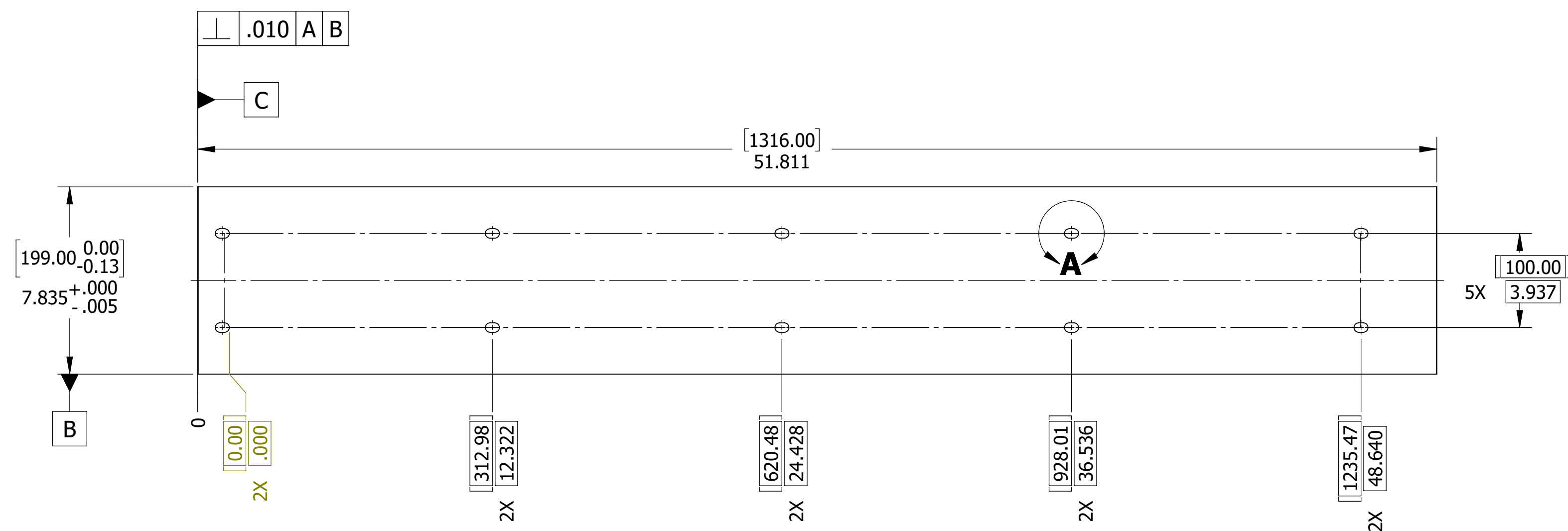
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**DETAIL A  
SCALE 1 : 1**

BREAK EDGES TO .025"  
FOR CORNER RELIEF  
TOP AND BOTTOM EDGES,  
BOTH ENDS



**ISOMETRIC VIEW**



**DETAIL A  
SCALE 1 : 2**

**MATERIAL: AISI 1020 CARBON STEEL**

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
MATERIAL MILL TEST REPORT	<b>x</b>	FRACTION	± 1/64
LEAK TEST REPORT		XX DECIMALS	± 0.01
CLEANING CERT		XXX DECIMALS	± 0.005
WELD / BRAZE INSPECTION REPORT		ANGLES	± 0°-30'
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.
DIMENSIONAL REPORT		FINISH	= 125 RMS
MATERIAL SELLER CERT		ALL DIMENSIONS ARE IN INCHES	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
DEVIATION REQUEST	<b>x</b>	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	
NONCONFORMANCE REPORT	<b>x</b>		

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LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE

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**REMOTE SYSTEMS GROUP**

**ePIC - Electron-Proton/Ion Collider**

**EPIC  
8M TOWER BODY ASSEMBLY  
TOP PLATE**

**EPC-FWD-HCL-DET-PRT-103**

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
<b>8.61 LBS</b>	1:4	D	1	1	EPC-FWD-HCL-DET-ASM-100	<b>1</b>

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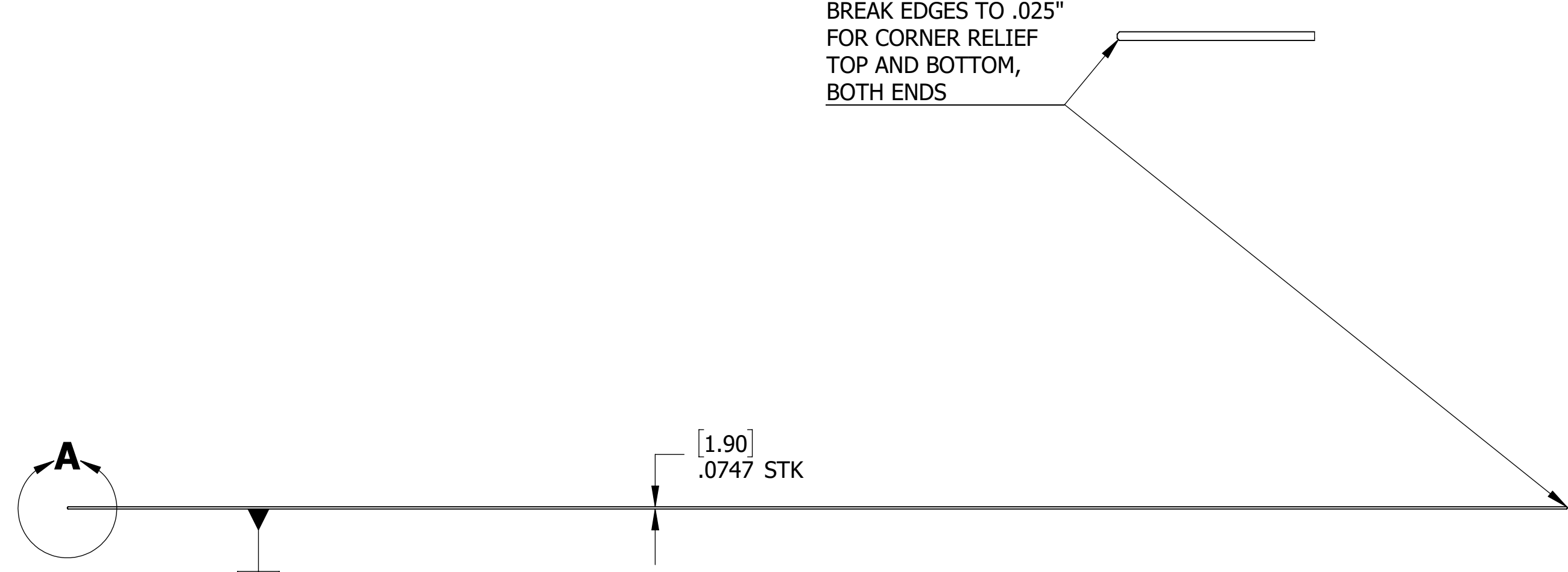
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**NOTES**

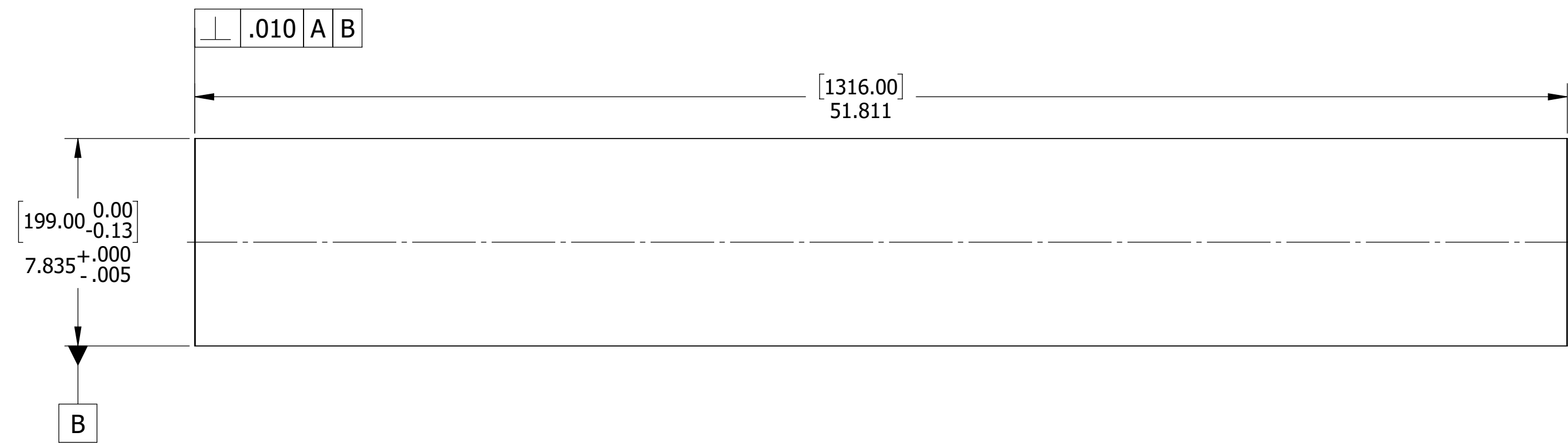
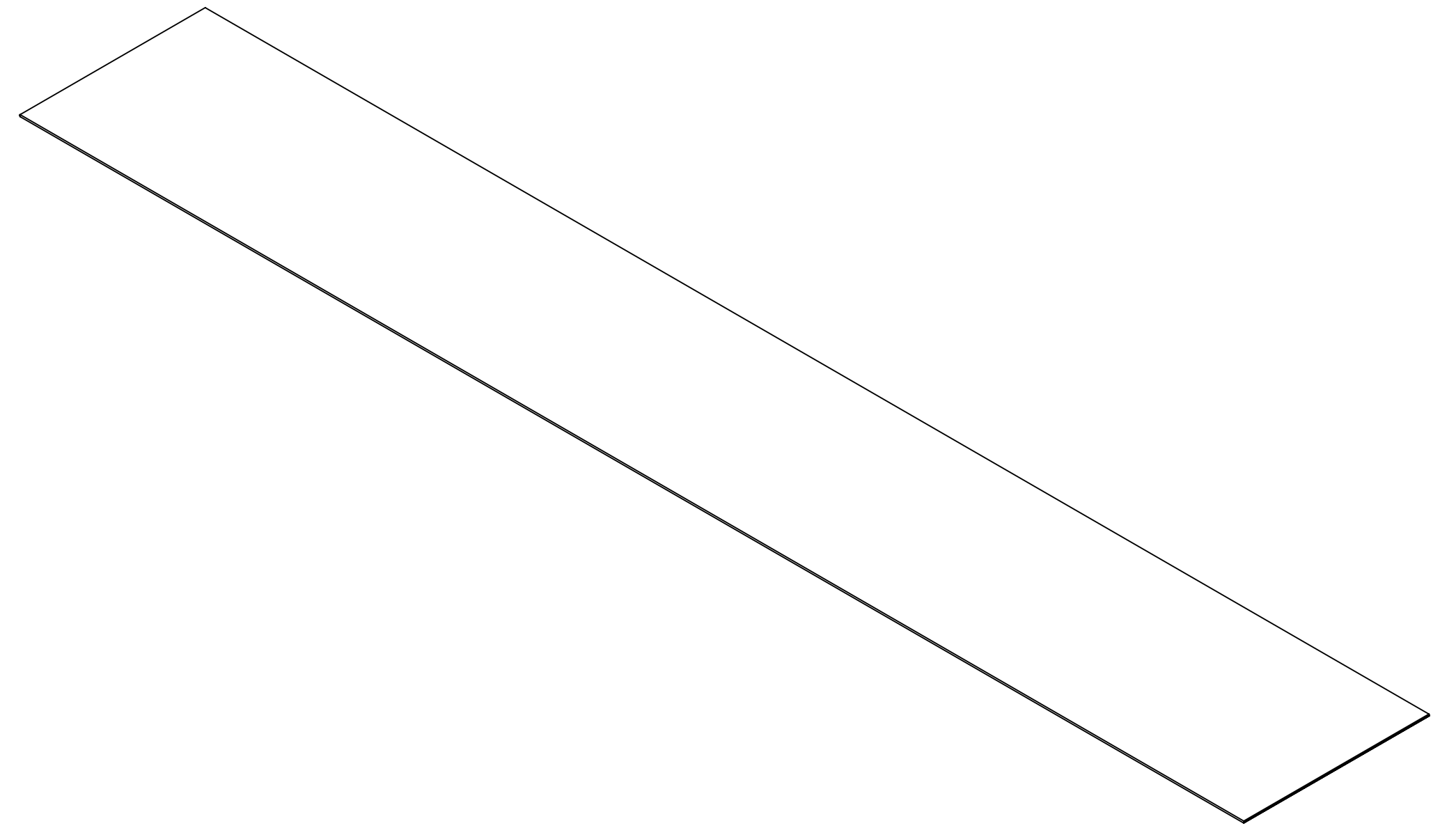
- 1. MATERIAL CERTIFICATIONS REQUIRED.

**DETAIL A  
SCALE 1 : 1**

BREAK EDGES TO .025"  
FOR CORNER RELIEF  
TOP AND BOTTOM,  
BOTH ENDS

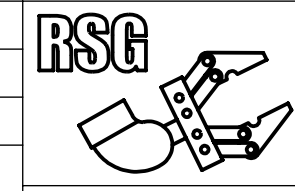


**ISOMETRIC VIEW**



**MATERIAL: AISI 1020 CARBON STEEL**

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**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

**EPIC  
8M TOWER BODY ASSEMBLY  
BOTTOM PLATE**

**EPC-FWD-HCL-DET-PRT-104**

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
MATERIAL MILL TEST REPORT	<b>x</b>	FRACTION	± 1/64
LEAK TEST REPORT		XX DECIMALS	± 0.01
CLEANING CERT		XXX DECIMALS	± 0.005
WELD / BRAZE INSPECTION REPORT		ANGLES	± 0°-30'
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.
DIMENSIONAL REPORT		FINISH	= 125 RMS
MATERIAL SELLER CERT		ALL DIMENSIONS ARE IN INCHES	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
DEVIATION REQUEST	<b>x</b>	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	
NONCONFORMANCE REPORT	<b>x</b>		

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DESIGN ENGINEER	ELLIOTT J. FOUNTAIN
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SAFETY REVIEW	MICHAEL GAFFNEY
QA REVIEW	JOE ZIPPER
LEVEL 2 MANAGER	ELKE ASCHENAUER
LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE

WEIGHT	8.65 LBS	SCALE	1:4	SIZE	D	SHEET	1	OF	1	NEXT ASSEMBLY:	EPC-FWD-HCL-DET-ASM-100	REV	1
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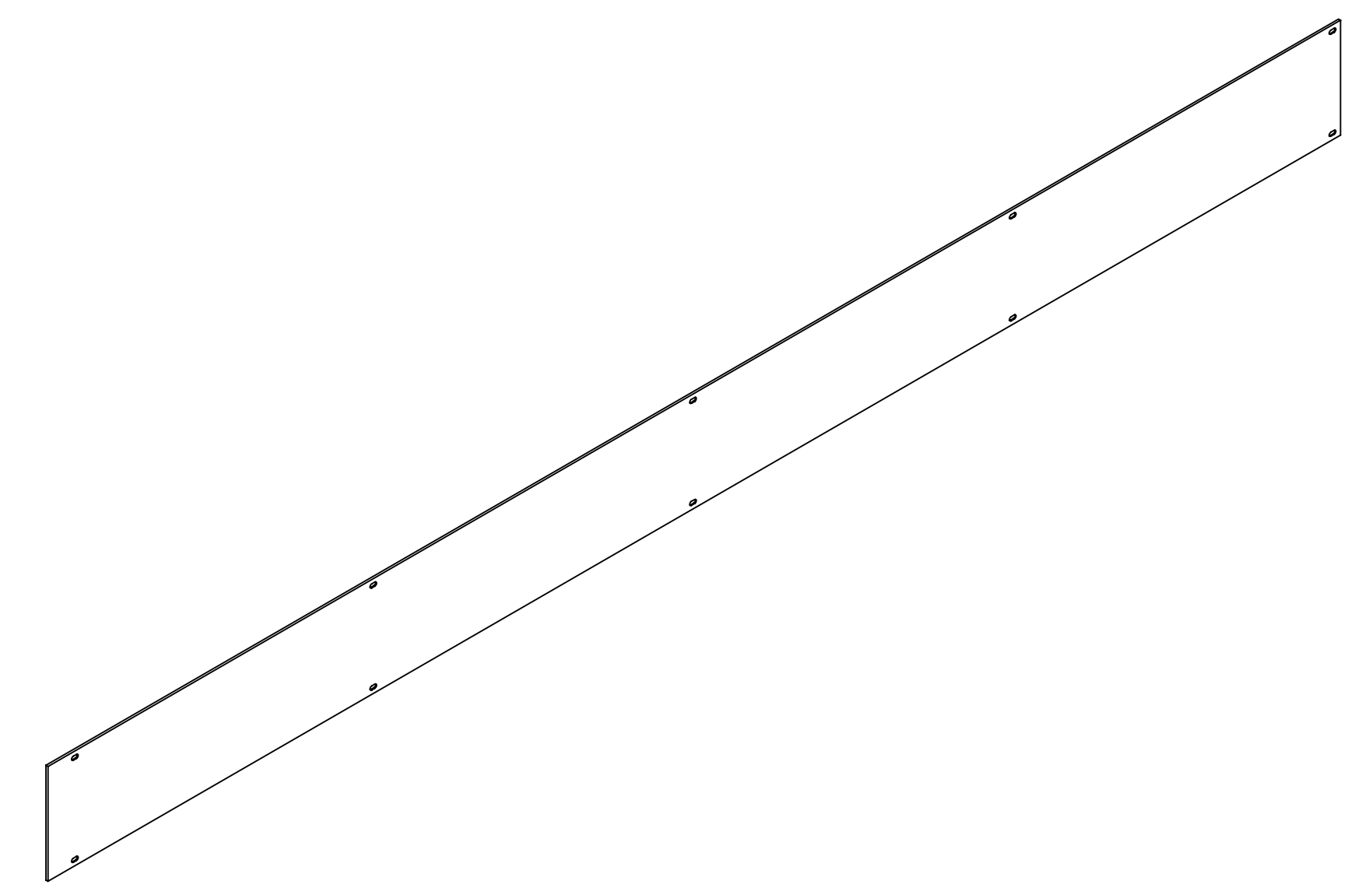
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**NOTES**

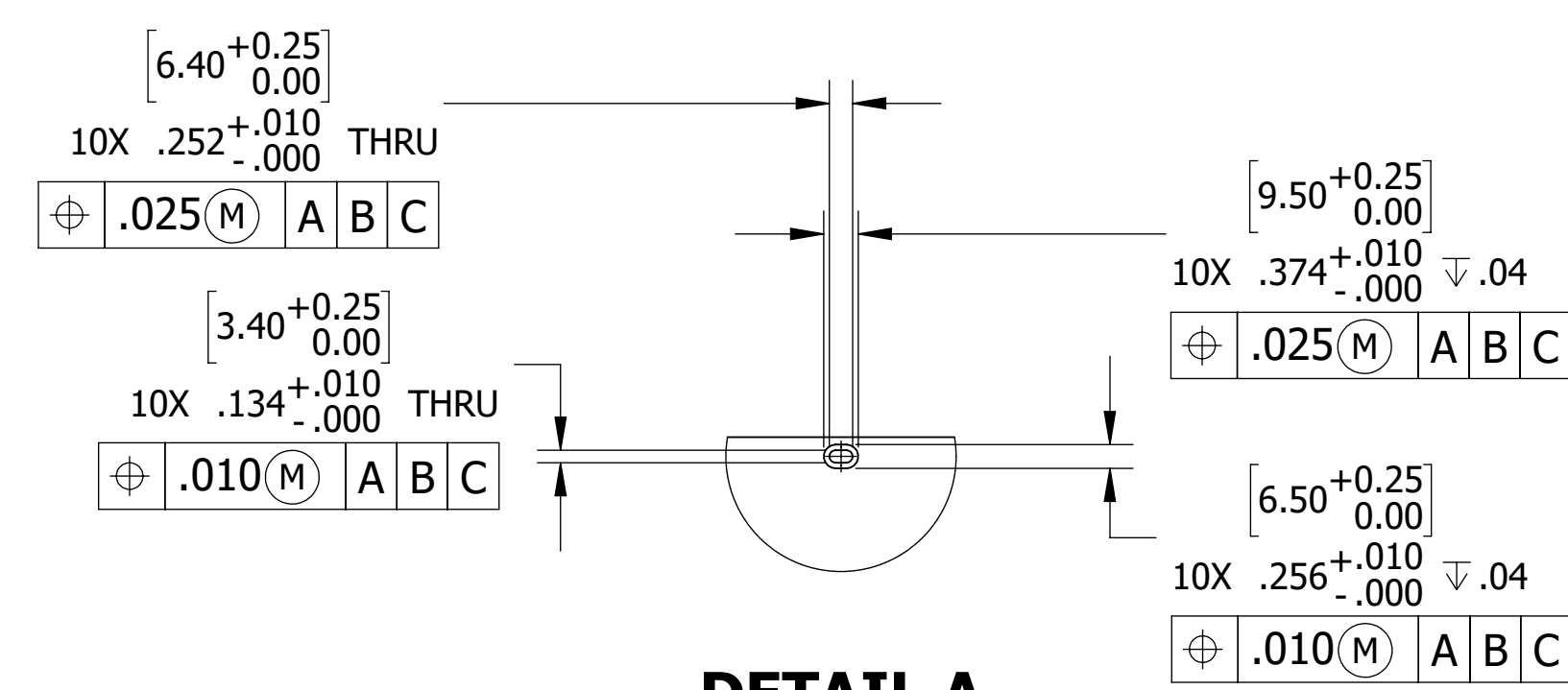
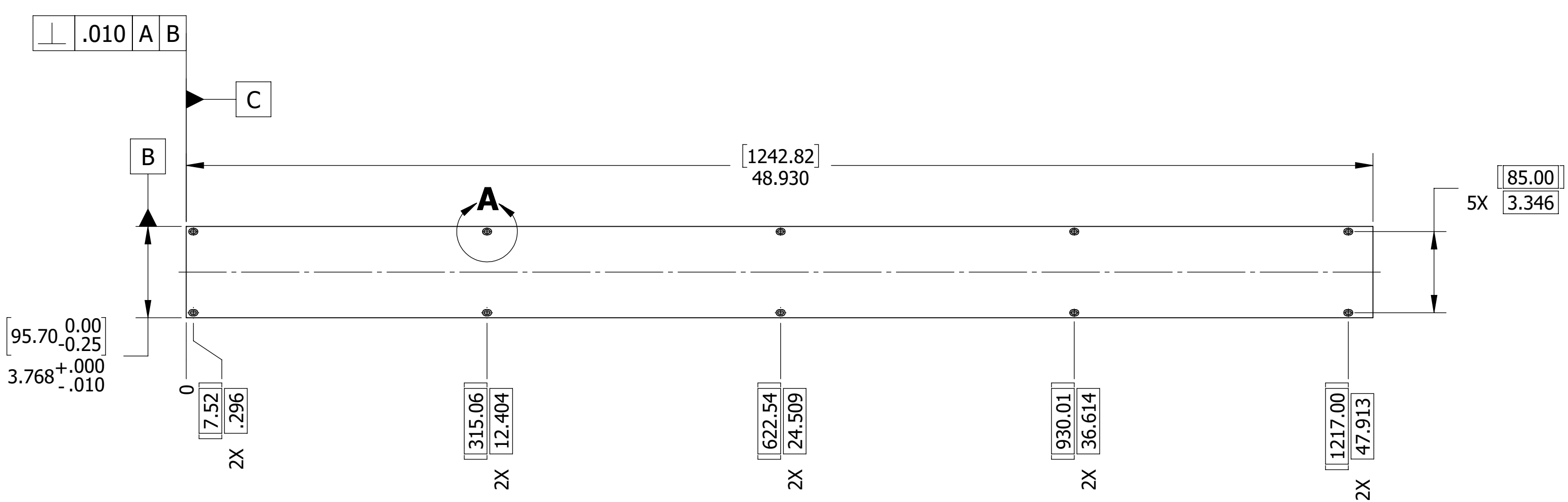
- 1. MATERIAL CERTIFICATIONS REQUIRED.



**ISOMETRIC VIEW**

[1.90]  
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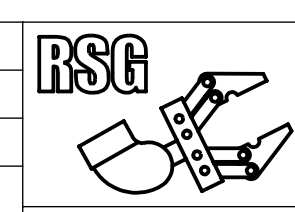
A



**DETAIL A  
SCALE 1 : 2**

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		TOLERANCE	DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED		DRAWN BY ELIOTT J. FOUNTAIN DESIGN ENGINEER ELIOTT J. FOUNTAIN CHECKER
MATERIAL MILL TEST REPORT	X		FRACTION	± 1/64	
LEAK TEST REPORT		XX DECIMALS	± 0.01	DESIGN REVIEW DANIEL CACACE	
CLEANING CERT		XXX DECIMALS	± 0.005	ENGINEERING LEAD RAHUL SHARMA	
WELD / BRAZE INSPECTION REPORT		ANGLES	± 0°-30'	LIQUID RUBEN PET FRIEDERIKE BOCK	
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.	SAFETY REVIEW MICHAEL GAFFNEY	
DIMENSIONAL REPORT		FINISH	125 RMS	QA REVIEW JOE ZIPPER	
MATERIAL SELLER CERT		ALL DIMENSIONS ARE IN INCHES		LEVEL 2 MANAGER ELKE ASCHENAUER	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED		LEVEL 3 MANAGER OLEG EYSER	
DEVIATION REQUEST	X	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018		SPECIAL REVIEW	
NONCONFORMANCE REPORT	X	DRAWING APPROVALS		DATE	

**MATERIAL: AISI 304 STAINLESS STEEL**



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OPERATED BY UT-BATTELLE FOR THE DEPARTMENT OF ENERGY UNDER U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725 OAK RIDGE, TENNESSEE

**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

EPIC  
8M TOWER BODY ASSEMBLY  
PCB SIDE COVER

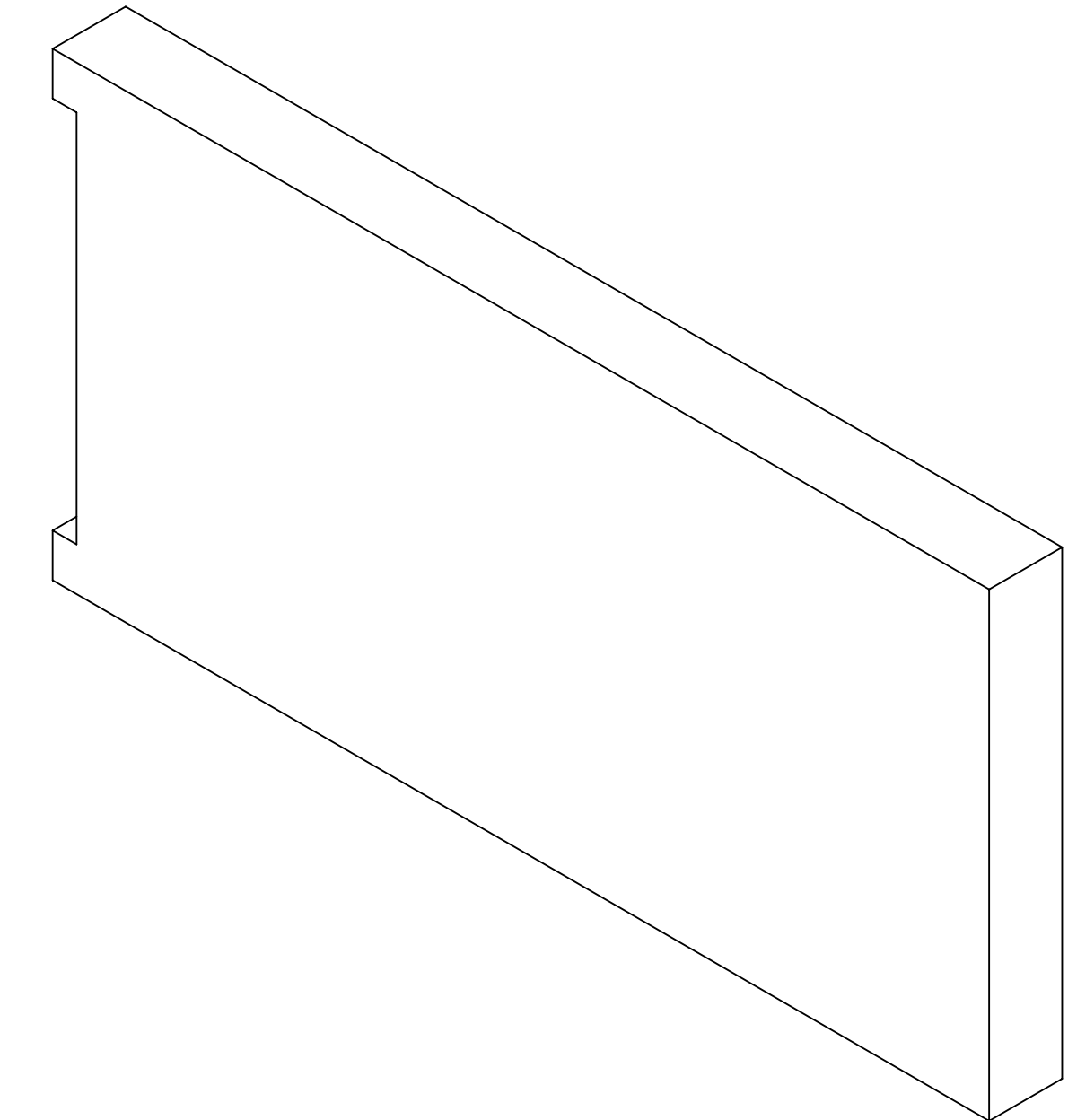
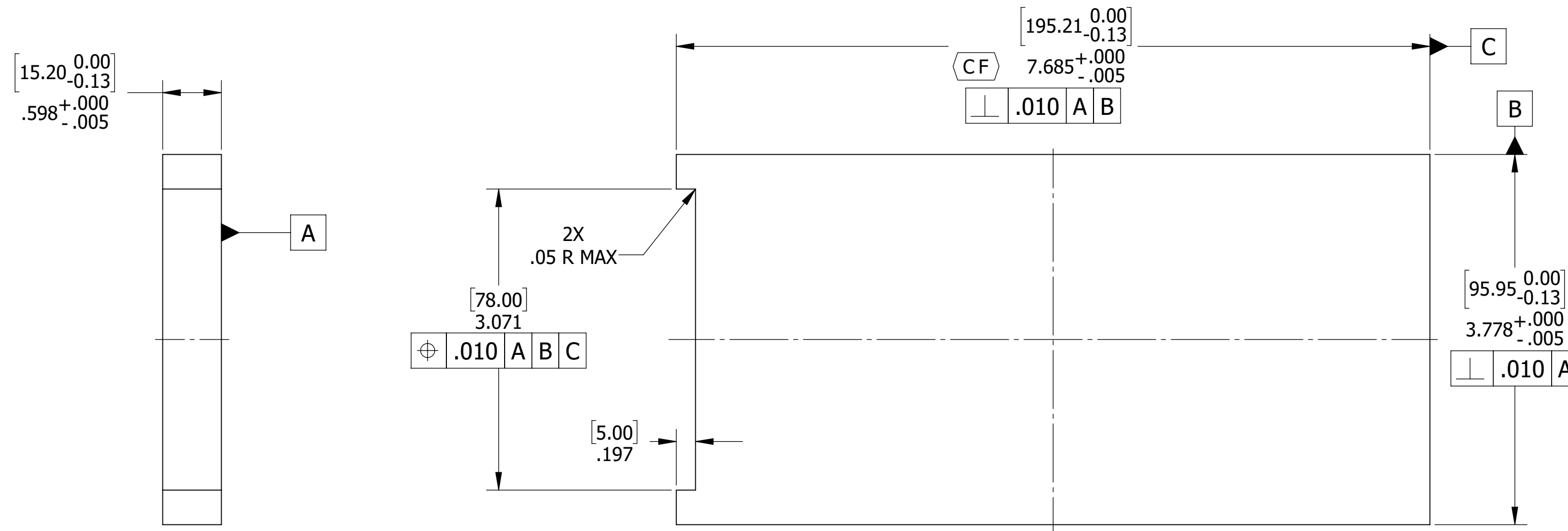
EPC-FWD-HCL-DET-PRT-105

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
3.97 LBS	1:4	D	1	1	EPC-FWD-HCL-DET-ASM-100	1

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**NOTES**

- 1. MATERIAL CERTIFICATIONS REQUIRED.



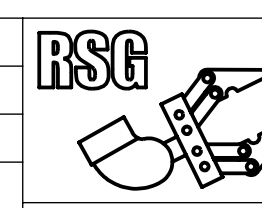
**ISOMETRIC VIEW**

**MATERIAL: AISI 1020 CARBON STEEL**

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

DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
FRACTION	± 1/64
XX DECIMALS	± 0.01
XXX DECIMALS	± 0.005
ANGLES	± 0°-30'
BREAK SHARP EDGES	1/64 MAX.
FINISH	= 125 RMS
ALL DIMENSIONS ARE IN INCHES	
WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	

DRAWN BY	ELLIOTT J. FOUNTAIN
DESIGN ENGINEER	ELLIOTT J. FOUNTAIN
CHECKER	
DESIGN REVIEW	DUSTIN C. OTTINGER
DESIGN REVIEW	DANIEL CACACE
ENGINEERING LEAD	RAHUL SHARMA
LIQUID SUBMITTER	FRIEDERIKE BOCK
SAFETY REVIEW	MICHAEL GAFFNEY
QA REVIEW	JOE ZIPPER
LEVEL 2 MANAGER	ELKE ASCHENAUER
LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE



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**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

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

**EPC-FWD-HCL-DET-PRT-106**

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY	REV
<b>4.86 LBS</b>	1:1	D	1	1	EPC-FWD-HCL-DET-ASM-100	<b>1</b>

8

7

6

5

4

3

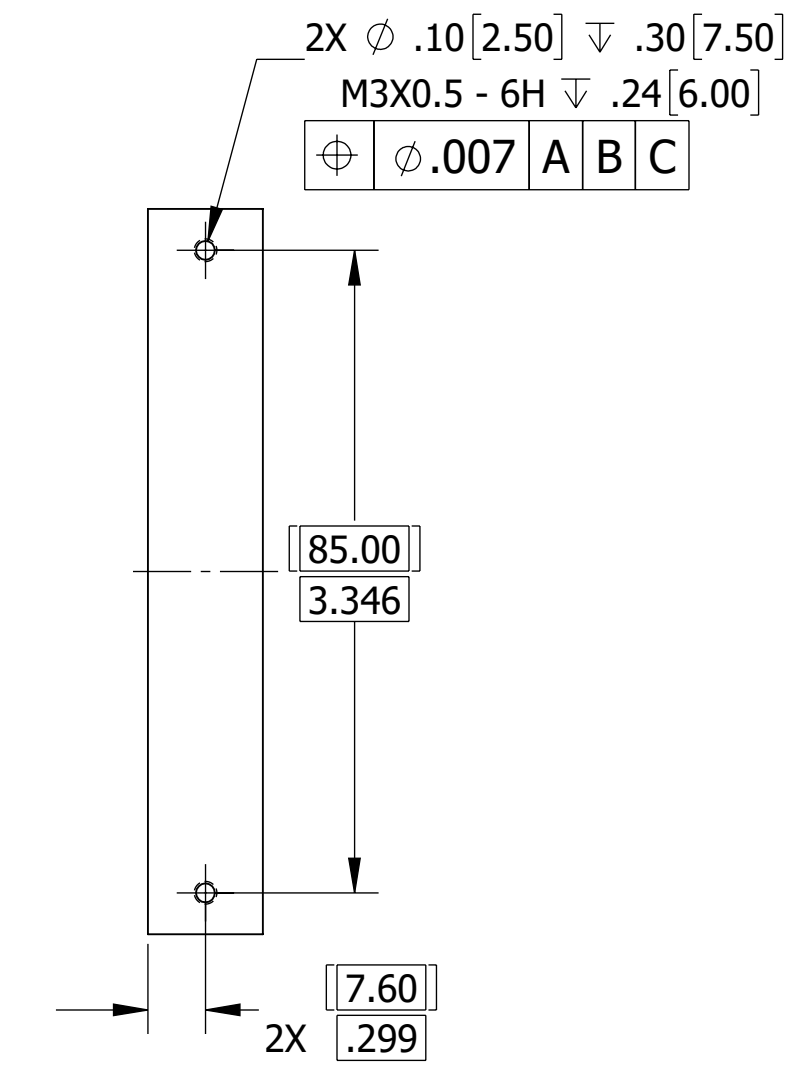
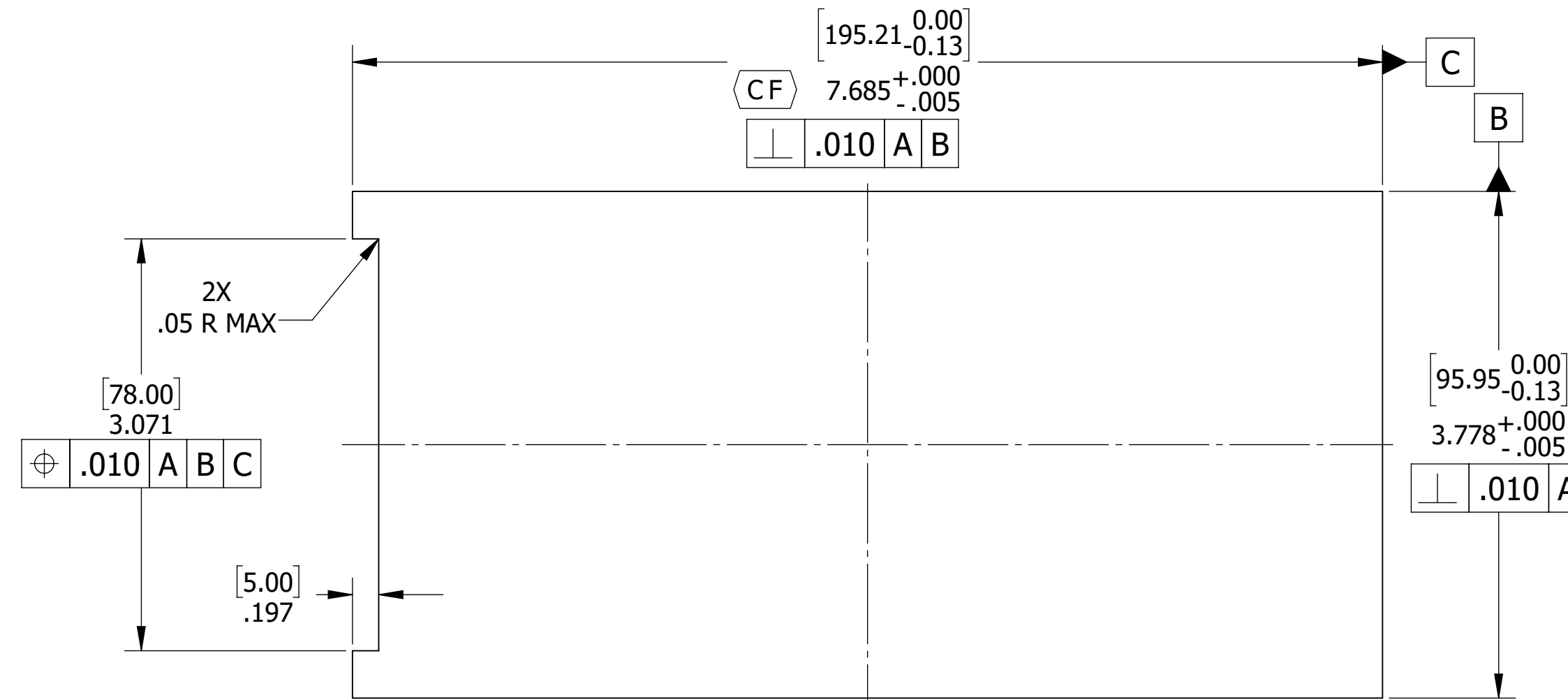
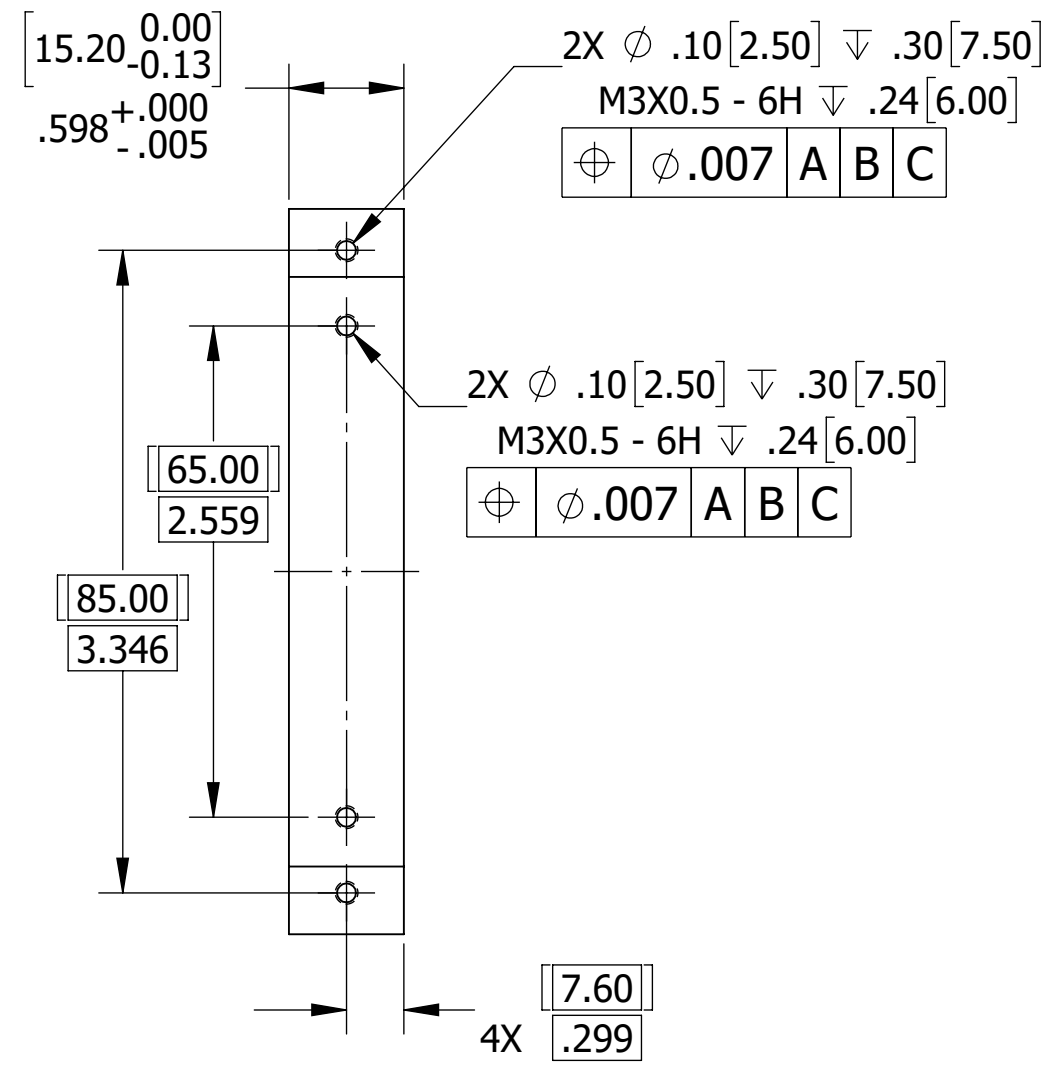
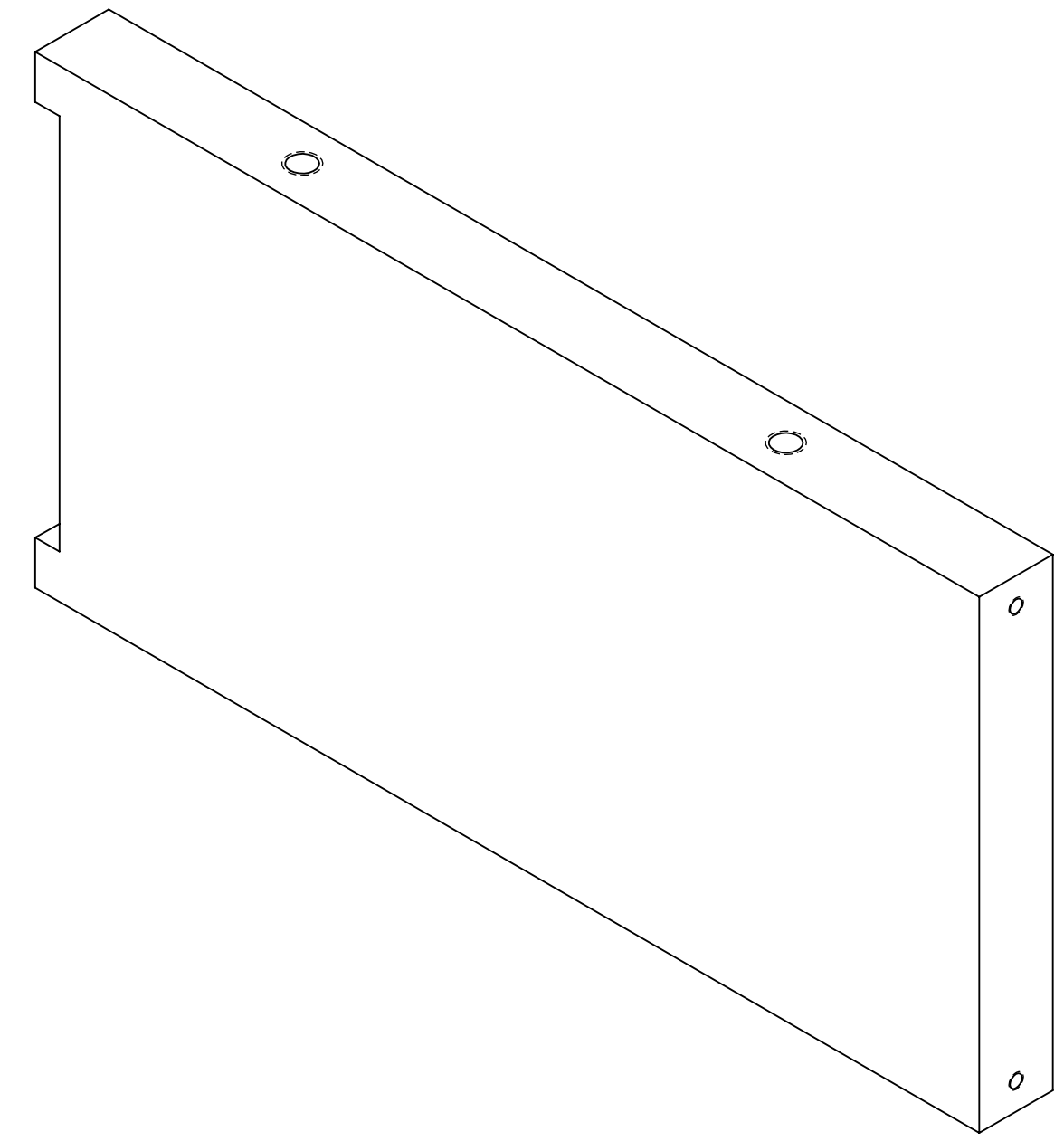
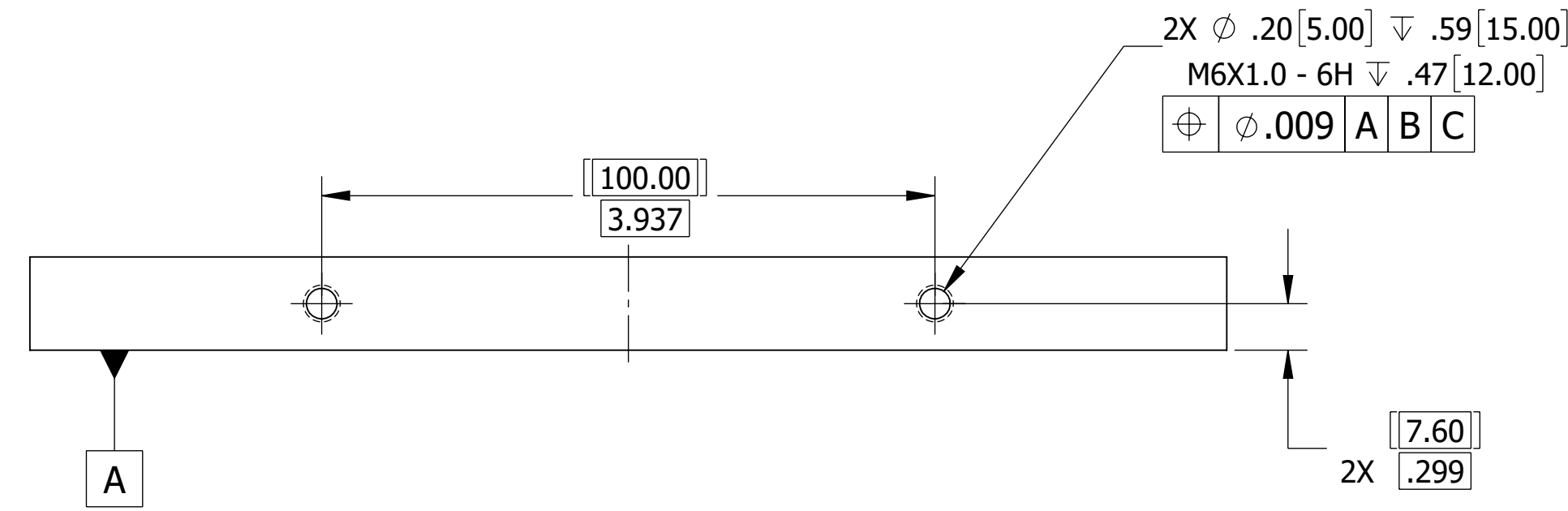
2

1

NOTES

- 1. MATERIAL CERTIFICATIONS REQUIRED.

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MATERIAL: AISI 1020 CARBON STEEL

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	
MATERIAL MILL TEST REPORT	x	FRACTION	$\pm$ 1/64
LEAK TEST REPORT		XX DECIMALS	$\pm$ 0.01
CLEANING CERT		XXX DECIMALS	$\pm$ 0.005
WELD / BRAZE INSPECTION REPORT		ANGLES	$\pm$ 0°-30'
HEAT TREAT REPORT		BREAK SHARP EDGES	1/64 MAX.
DIMENSIONAL REPORT		FINISH	= 125 RMS
MATERIAL SELLER CERT		ALL DIMENSIONS ARE IN INCHES	
FUNCTIONAL TEST REPORT		WHENEVER A MANUFACTURER'S NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	
DEVIATION REQUEST	x	THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	
NONCONFORMANCE REPORT	x		

DRAWN BY	ELLIOTT J. FOUNTAIN
DESIGN ENGINEER	ELLIOTT J. FOUNTAIN
CHECKER	DUSTIN C. OTTINGER
DESIGN REVIEW	DANIEL CACACE
ENGINEERING LEAD	RAHUL SHARMA
LEAD SUBJECT	FRIEDERIKE BOCK
SAFETY REVIEW	MICHAEL GAFFNEY
QA REVIEW	JOE ZIPPER
LEVEL 2 MANAGER	ELKE ASCHENAUER
LEVEL 3 MANAGER	OLEG EYSER
SPECIAL REVIEW	
DRAWING APPROVALS	DATE

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**REMOTE SYSTEMS GROUP**

ePIC - Electron-Proton/Ion Collider

EPIC  
 8M TOWER BODY ASSEMBLY  
 ABSORBER PLATE, TAPPED  
 EPC-FWD-HCL-DET-PRT-107

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
4.84 LBS	1:1	D	1	1	EPC-FWD-HCL-DET-ASM-100	1



8

7

6

5

4

3

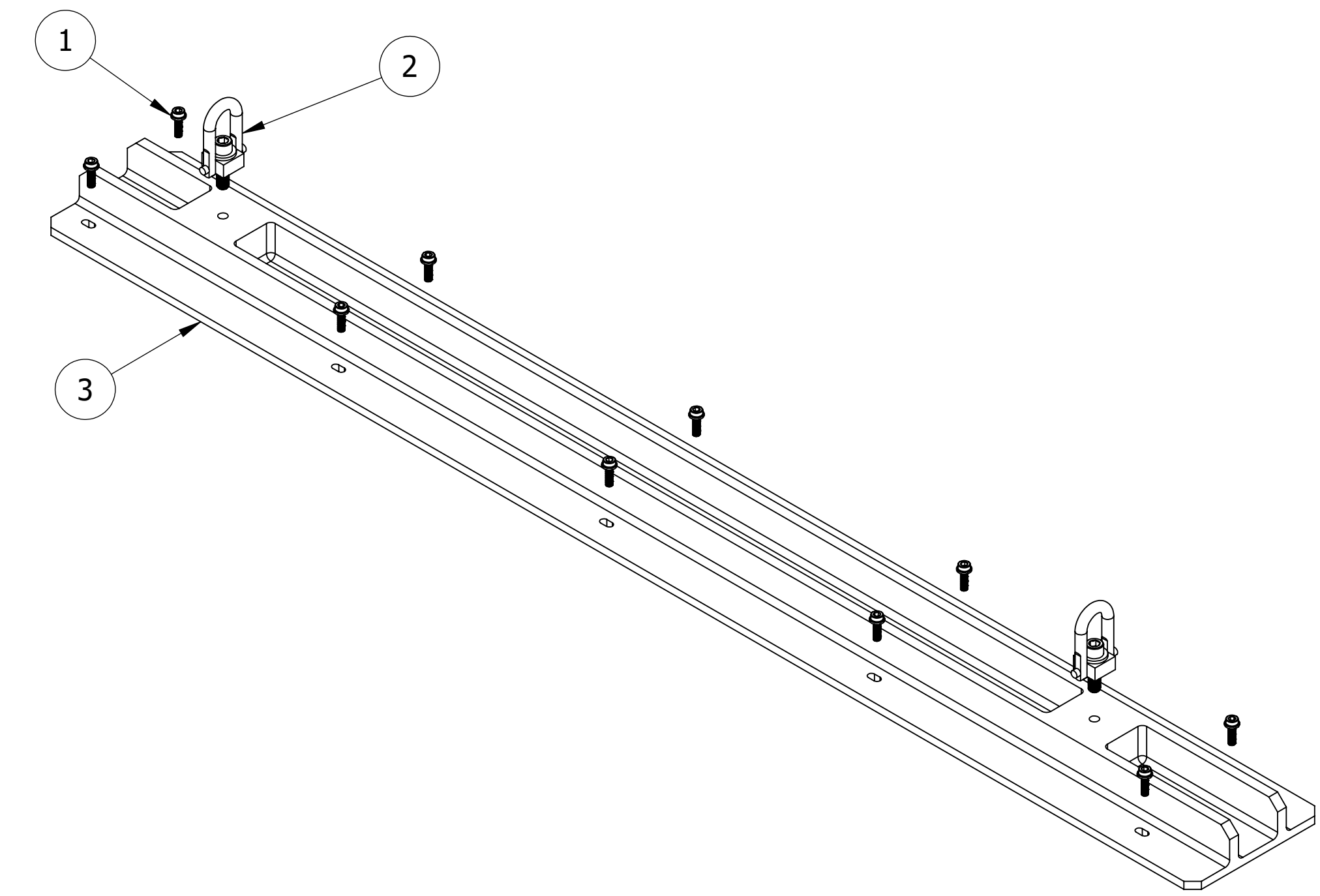
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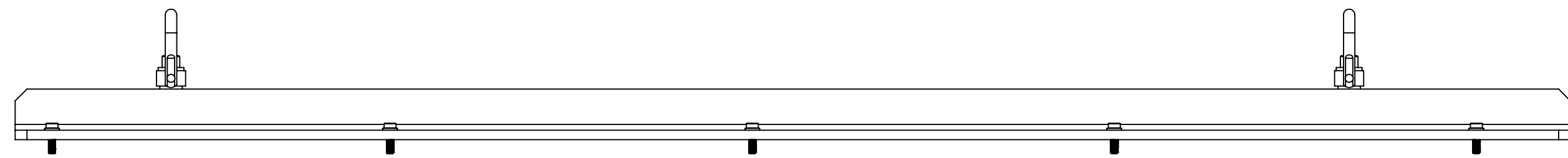
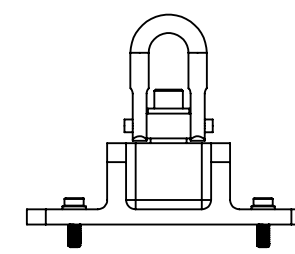
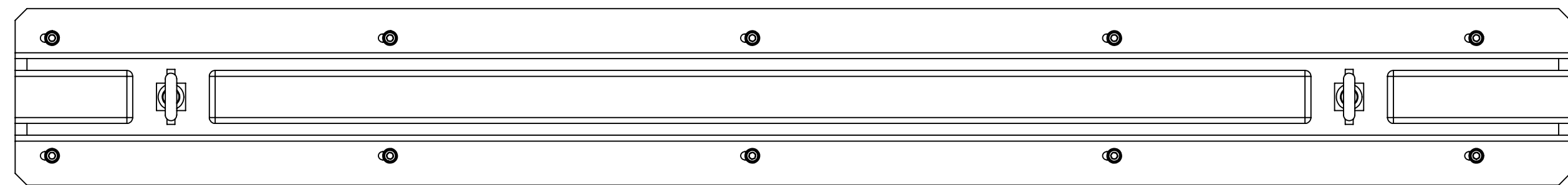
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**NOTES**

- 1. MATERIAL CERTIFICATIONS REQUIRED.



**EXPANDED VIEW**



ITEM	QTY.	NAME/PART NO	MATERIAL	DESCRIPTION	DWG
3	1	8M STRONGBACK	6061-T6 ALUMINUM ALLOY	MACHINED PART	EPC-FWD-HCL-FIX-PRT-101
2	2	MCMaster_3145T42	NICKEL PLATED ALLOY STEEL	M10-1.5 HOIST RING, 975 LB CAPACITY	COTS
1	10	MCMaster_92235A240	CLASS 12.9 ALLOY STEEL	M6-1.0 X 20MM LG SHCS	COTS

QUALITY VERIFICATION REQUIREMENTS DOCUMENTS		DEFAULT STANDARDS UNLESS OTHERWISE SPECIFIED	DRAWN BY
MATERIAL MILL TEST REPORT		FRACTION ± 1/64 XX DECIMALS ± 0.01 XXX DECIMALS ± 0.005 ANGLES ± 0°-30' BREAK SHARP EDGES 1/64 MAX. FINISH = 125 RMS	ELLIOTT J. FOUNTAIN
LEAK TEST REPORT			DESIGN ENGINEER
CLEANING CERT			ELLITT J. FOUNTAIN
WELD / BRAZE INSPECTION REPORT			DIRECTOR
HEAT TREAT REPORT			DUSTIN C. OTTINGER
DIMENSIONAL REPORT			DESIGN REVIEW
MATERIAL SELLER CERT	x		DANIEL CACACE
FUNCTIONAL TEST REPORT			ENGINEERING LEAD
DEVIATION REQUEST	x		RAHUL SHARMA
NONCONFORMANCE REPORT	x		LIQUID SUBMITTER
		ALL DIMENSIONS ARE IN INCHES	FRIEDERIKE BOCK
		WHENEVER A MANUFACTURERS NAME OR CATALOG NUMBER IS INDICATED, AN APPROVED EQUAL MAY BE SUBSTITUTED	SAFETY REVIEW
		THIS DRAWING CREATED IN ACCORDANCE WITH ASME Y14.5 - 2018	MICHAEL GAFFNEY
			JOE ZIPPER
			QA REVIEW
			ELKE ASCHENAUER
			LEVEL 3 MANAGER
			OLEG EYSER
			SPECIAL REVIEW
			DRAWING APPROVALS
			DATE

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--	--

WEIGHT	SCALE	SIZE	SHEET	OF	NEXT ASSEMBLY:	REV
17.13 LBS	1:4	D	1	1	N/A	1

