

LIST OF MATERIAL

TYPE/LEVEL	QTY	ITEM NO.	NAME/DESCRIPTION	NOTE DRAWING NUMBER OR PART. I.D. NUMBER	MATERIAL	MATERIAL SPECIFICATION STD/NUMBER
ASM	1	1	SHIELDED CONTAINER ASSEMBLY	165-F-026-WI		
PRT	1	2	BASE	165-F-026-W5	CS	SEE NOTE 2
PRT	1	3	OUTER SHELL	165-F-026-W5	CS	SEE NOTE 4
PRT	1	4	INNER SHELL	165-F-026-W5	CS	SEE NOTE 4
PRT	1	5	FLANGE	165-F-026-W2	CS	SEE NOTE 2
PRT	1	6	LID	165-F-026-W2	CS	SEE NOTE 2
PRT	1	7	SEAL	165-F-026-W3	SEE NOTE 3	SEE NOTE 2
PRT	1	8	LEAD SHIELD	165-F-026-W1	LEAD	SEE NOTE 21
PRT	1	9	FILTER SHIELD PLUG	165-F-026-W2	LEAD	SEE NOTE 21
PRT	1	10	FILTER SHIELD CAP	165-F-026-W2	CS	SEE NOTE 4
PRT	3	11	PLUG	165-F-026-W3	CS	SEE NOTE 4
PRT	2	12	SCOTTED SPRING PIN, $\phi 3/8$ X 1-1/4 LG.	A 9138X712	CS	ASME B18-8.2
PRT	1	13	PROTECTIVE SPRING PIN, $\phi 3/8$ X 1-1/4 LG.	A 9138X712	BLK AS	ASTM F912
PRT	15	14	PROTECTIVE SPRING PIN, $\phi 3/8$ X 1-1/4 LG.	A 4491K47	LOPE	
PRT	1	15	FLANGE HEX HD CAP SCREW, 1/2-13UNC X 1 LG.	A 4491K42	BLK AS	SAE J429, GR 8
PRT	3	16	PROTECTIVE PLUG, 1/2 PIPE PRESS-FIT		LOPE	

SUPPLIERS

- A. IMA MASTER CARR OR APPROVED EQUIVALENT
- B. IPOTEC INC. (ISS20) OR APPROVED EQUIVALENT

NOTES

- CONTINUES ON SH. 2
- ALL WELLS SHALL CONFORM TO THE LEAD SHIELDING SPECIFICATIONS OF AWS D11.1. SHEET MATERIALS MAY BE JOINED FROM ONE OR MORE PIECES UTILIZING COMPLETE JOINT PENETRATION (CJP) WELDS AND SHALL BE MADE AND VISUALLY INSPECTED PER THE ABOVE REQUIREMENTS.
 - MATERIAL: ASTM A516, GR 2 (PLATE) NORMALIZED TO FINE GRAIN PRACTICE OR ASTM A286, GR 2 (FORGING) NORMALIZED TO FINE GRAIN PRACTICE MEDIUM-SOFT.
 - MATERIAL: SILLICONE SPONGE ADHESIVE ONE SIDE, CLOSED-CELL.
 - MATERIAL: ASTM A106, GR. AS (STRUCTURAL STEEL). (OPTIONAL FOR OTHERS: ASTM A333, GR. 3; ASTM A307, GR. B; ASTM A714, CL. 4, GR. 1).
 - INSTALL USING A CLASS FRP FORCE FIT PER ANSI B4.1. OR OPTIONALLY, LEAD WOOL MAY BE USED AS REQUIRED FOR TIGHT FIT.
 - RECOMMENDED FOR LIFTING: UTILIZE A 1/2 HEAVY-DUTY SAFETY HOIST RING, IMA MASTER CARR, P/N 3052187 OR ENGINEER APPROVED EQUAL.
 - BODY ASSEMBLY INVERTED FOR LEAD POUR CONFIGURATION.
 - CONTAINER SHALL BE EQUIPPED WITH THE SUPPLIED LIFT KIT PER DOCUMENT 08-5384 IN ACCORDANCE WITH SECTION 2.3 OF THE CH-TRAMPAC.
 - AFTER LEAD POUR, CUT RISERS OFF BASE, FLUSH.
 - STENCIL AFTER PAINTING WITH 1/4 IN. MIN HIGH CONTRASTING CHARACTERS: (WHERE SHOWN)
 - ALIGNMENT PIN MARKS (AS SHOWN)
 - "ALIGNMENT PIN" (2X)
 - "LIFT INTERFERENCE" (3X)
 - "LEAD INTERFERENCE" (3X)
 - UP TO 1/32 WELD REINFORCEMENT ALLOWED.
 - BLAST AND PAINT/COAT ALL EXPOSED EXTERIOR SURFACES, EXCLUDING INTERFACING/THEADED HOLES AND ASSOCIATED COUNTERBORES.
 - MACHINED (FROM LEAD) PLATE.
 - LEAD GATE IN ACCORDANCE WITH WASHINGTON TRU SOLUTIONS SPECIFICATION 14. LEAD GATE USE IN ACCORDANCE WITH NP 08-PT 16.

REVISED PER ADD. #2

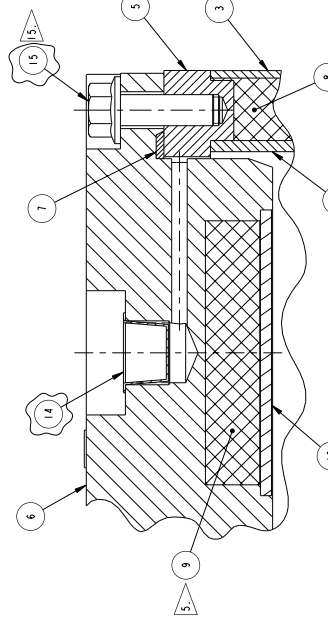
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A	REVISED PER ADD. #1	9/13/07	9/14/07	9/14/07	11834	N/A

U.S. DEPARTMENT OF ENERGY

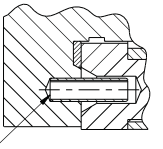
Washington TRU Solutions LLC

SHIELDED CONTAINER ASSEMBLY

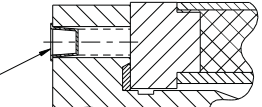
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DWG NO	165-F-026-WI
SCALE	1:4
REV	B



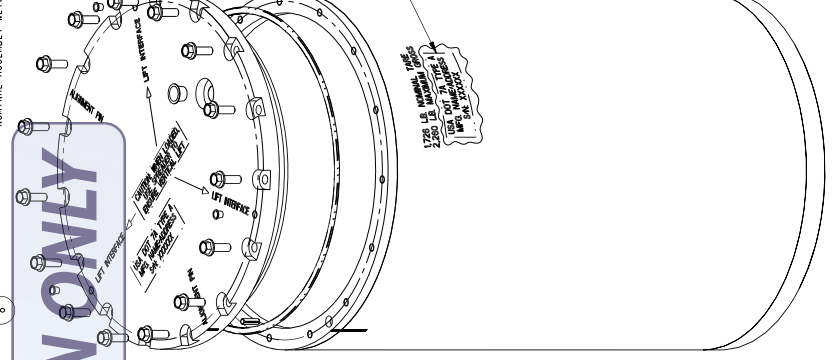
SECTION B-B SCALE 1:1



SECTION B-B SCALE 1:1



SECTION C-C SCALE 1:1



REFERENCE VIEW

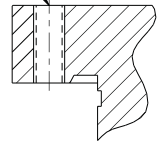
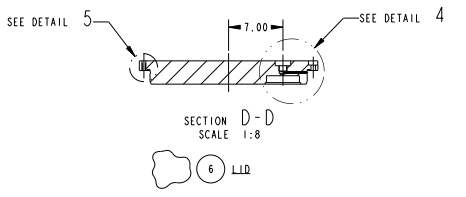
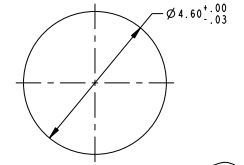
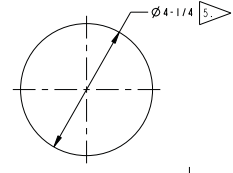
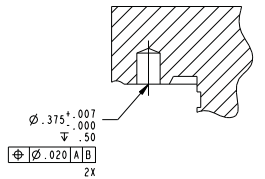
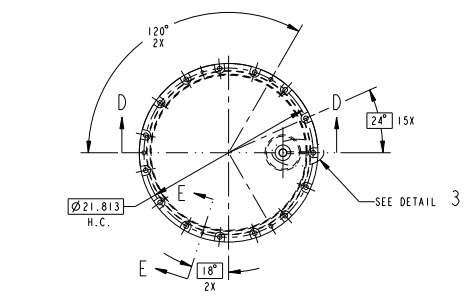
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1	SHIELDED CONTAINER ASSEMBLY

SYSTEM	WBE	DWG TYPE	CL	VENDOR
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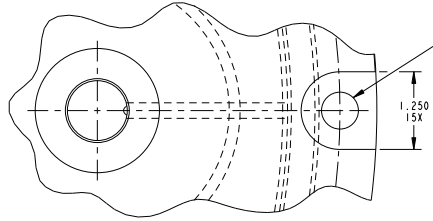
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165-F-026-WI

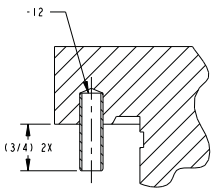
SECTION E-E
SCALE 1:1
INFORMATION ONLY
1/2-13UNC-2B THRU
Ø21.81 H.C.



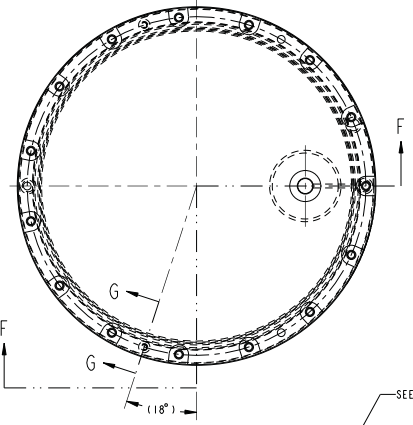
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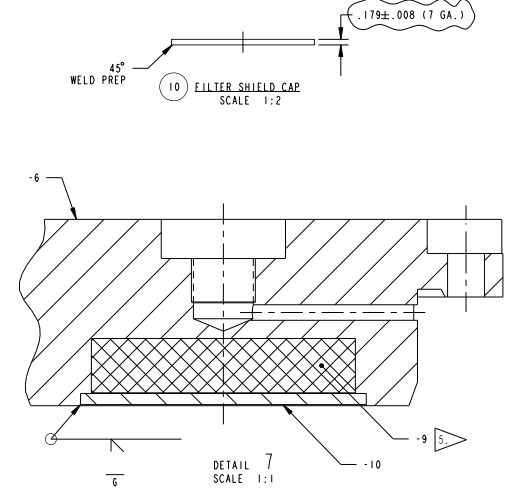
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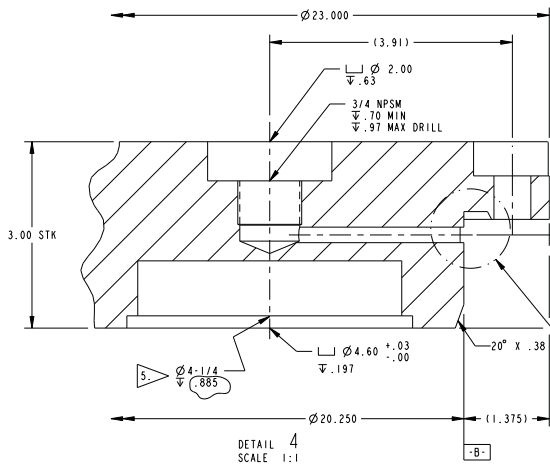
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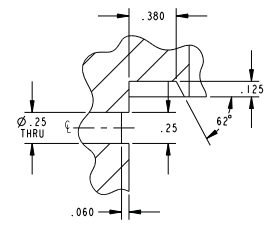
SECTION F-F
LID ASSEMBLY



DETAIL 7
SCALE 1:1



DETAIL 4
SCALE 1:1



DETAIL 6
SCALE 2:1

INDEX CODE NUMBER			
SYSTEM	WBE	DWG TYPE	CL VENDOR
PT03	165	01300	44 240

- NOTES** CONTINUES ON SHIT. 3
- TIGHTEN CAP SCREWS (ITEM 15) TO 85±10 LB-FT TORQUE DURING FINAL ASSEMBLY.
 - SEAL (ITEM 7) SHALL BE ONE-PIECE CONSTRUCTION AND INSTALLED WITHOUT STRETCHING.
 - FABRICATION OPTION: CHAMFER 60° X .130 (FROM HORIZONTAL) LEAD-IN TO AID IN ASSEMBLY.
 - CAUTION: FOR USE OF THREADED LIFT INTERFACE HOLES IN THE LID, ENSURE THREADED FASTENERS OF LIFT ATTACHMENT DO NOT PROTRUDE BEYOND THE BOTTOM FACE OF THE LID FLANGE DURING ASSEMBLY.
 - RESTRAINED OR P1-TAPE MEASUREMENT PERMITTED FOR VERIFICATION.

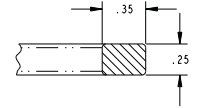
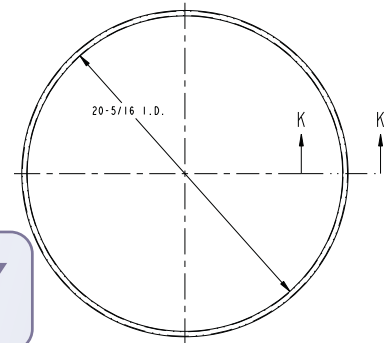
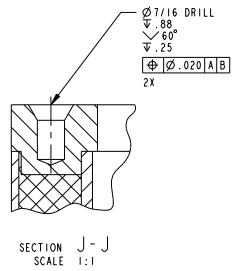
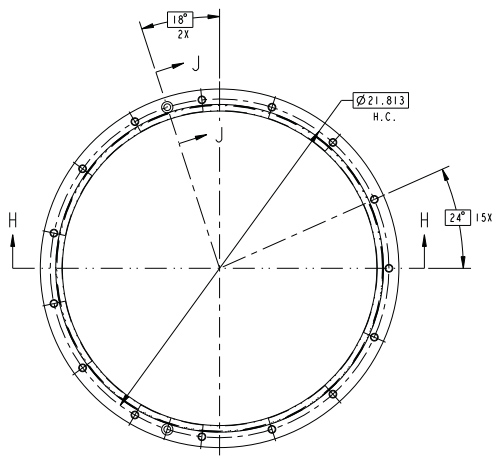
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A	REVISED PER ADD. #1	JMN	BAD	TD	BB	11834	N/A
REV	ISSUE DESCRIPTION	DFTR	CHRR	COG	DFTG MGR	ECO	PWR

THIS DRAWING CREATED BY ENGINEERING CHANGE ORDER (ECO): 11834 PWR: N/A
 DFTR: J.M. NEVAREZ 7/18/07
 CHRR: B. DAY FOR RAJ 8/9/07
 COG: ANTHONY DONNER 8/9/07
 CM: TODD SELLMER 8/13/07
 QA: BRUCE G. FAULK 8/13/07
 U.S. DEPARTMENT OF ENERGY
Washington
 TRU Solutions LLC
 State Isolation Pilot Plant
 Carlsbad, NM

DIM. IN INCHES U.N.O.		SFTY: N/A	TITLE
[] DENOTES mm U.N.O.		APPD: N/A	SHIELDED CONTAINER ASSEMBLY LID
UNLESS OTHERWISE SPECIFIED TOLERANCES		APPD: N/A	
2 PL DEC 3 PL DEC ANGLES 125		DM: BOB BEEMAN 8/13/07	
±.03 ±.010 ±.5°		DOE: N/A	
FRACTIONS: ±/116		CAD SOURCE	SIZE SYS: D
		PRO/ENGINEER	DWG NO: 165-F-026-W2
			SCALE: 1:4
			INTERPRET DWG PER ANSI Y14
			REV B

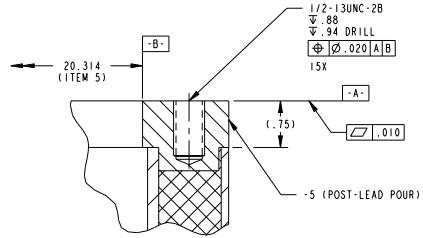
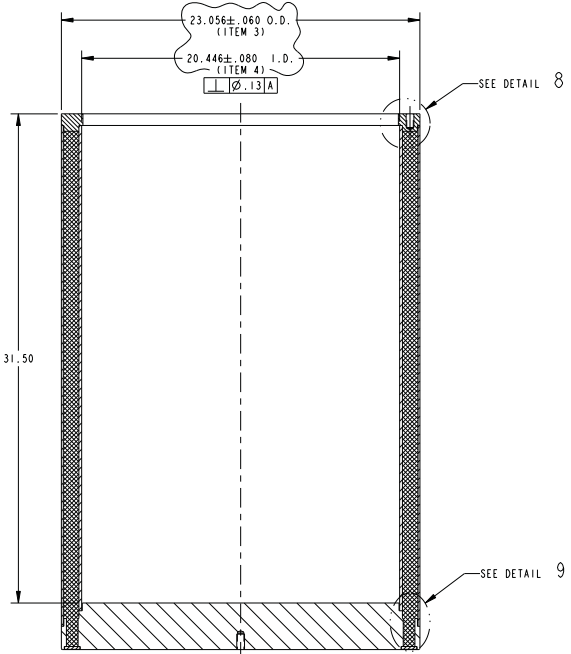
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INFORMATION ONLY

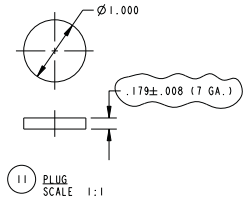


16 SEAL SCALE 1:4

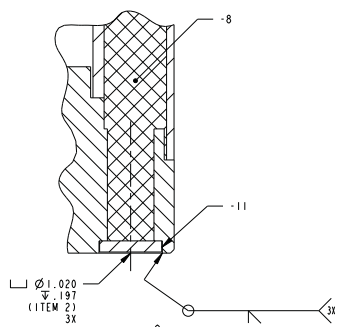
SECTION K-K SCALE 2:1



DETAIL 8 SCALE 1:1



11 PLUG SCALE 1:1



DETAIL 9 SCALE 1:1

- NOTES**
- 20. SEAM WELD APPLICABLE TO ROLLED AND WELDED PLATE ONLY.
 - 21. ASTM B29. OPTIONALLY UTILIZE RADIOACTIVELY-CONTAMINATED (RECYCLED) LEAD MEETING THE MINIMUM STRUCTURAL REQUIREMENTS OF ASTM B29.
 - 22. OPTIONAL: CONICAL TAPER CUP DESIGN OR USE OF BELL REDUCER(S) ARE ALLOWED IN LIEU OF CYLINDRICAL CUP CONFIGURATION AS SHOWN.
 - 23. MARK AS SHOWN USING 1/2 IN. MIN. HIGH CHARACTERS, RAISED OR INDENTED BY FORGING OR DIE-STAMPING INTO THE SURFACE. UNIQUE 6-DIGIT SERIAL NUMBER SHALL BE MATCHED TO BODY AND LID ASSEMBLY. BODY OPTION: WELD-ON STAMPED TAG OR STENCIL WITH HIGH VISIBILITY PAINT.

REV	ISSUE DESCRIPTION	DATE	DATE	DATE	DATE	ECO	PWR
B	REVISED PER ADD. #2	JMN	BAD	TD	BB	11834	N/A
A	REVISED PER ADD. #1	JMN	BAD	TD	BB	11834	N/A

THIS DRAWING CREATED BY ENGINEERING CHANGE ORDER (ECO): 11834 PWR: N/A
 DFR: J.M.NEVAZ 7/18/07
 CHRR: B.DAY FOR RAJ 8/9/07
 COG: ANTHONY DONNER 8/9/07
 CM: TODD SELLMER 8/13/07
 QA: BRUCE G. FAULK 8/13/07

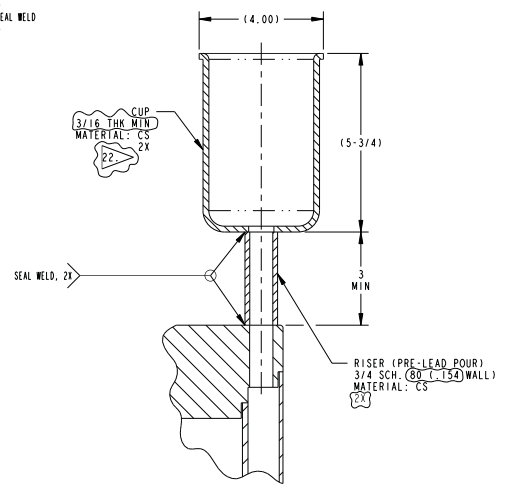
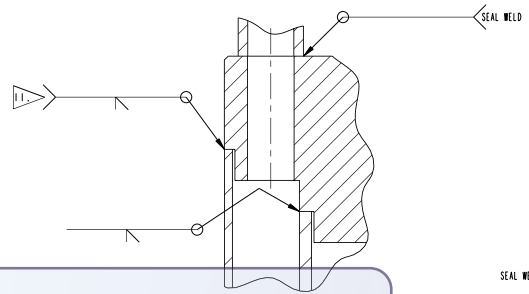
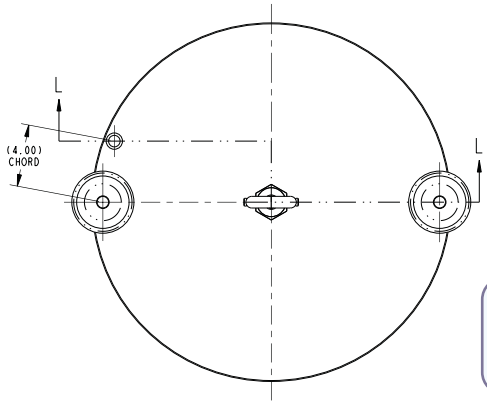
U.S. DEPARTMENT OF ENERGY
Washington
 TRU Solutions LLC

INDEX CODE NUMBER			
SYSTEM	WBE	DWG TYPE	CL VENDOR
PT03	165	01300	44 240

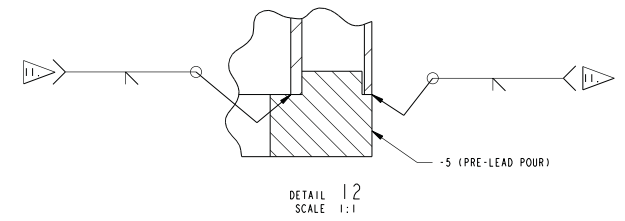
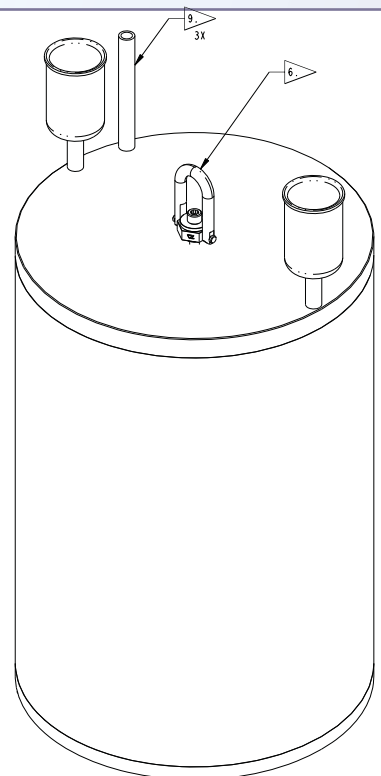
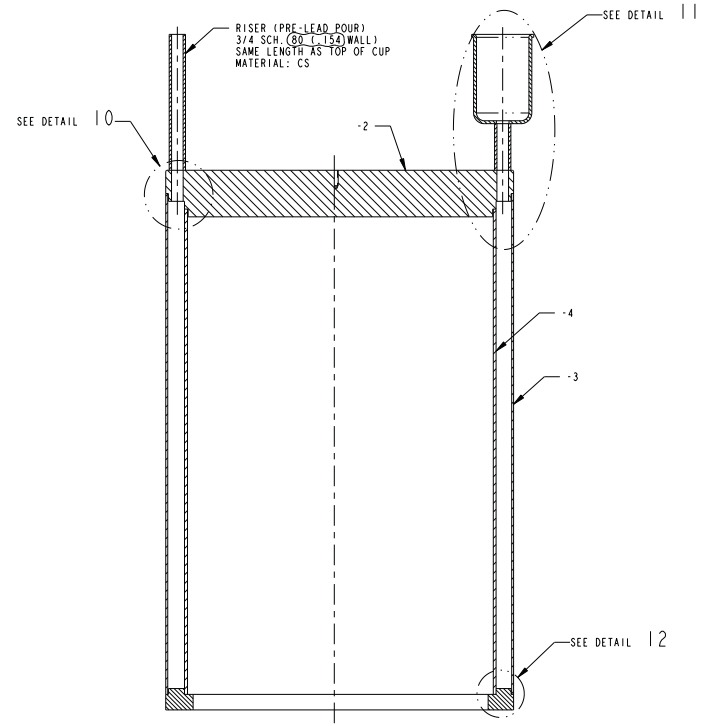
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UNLESS OTHERWISE SPECIFIED TOLERANCES	APPD: N/A
2 PL DEC(3 PL DEC) ANGLES 125	DM: BOB BEEMAN 8/13/07
±.03 ±.010 ±.5°	DOE: N/A
FRACTIONS: ±1/16	CAD SOURCE
	PRO/ENGINEER

TITLE	SIZE SYS	DWG NO	REV
SHIELDED CONTAINER ASSEMBLY BODY (POST-LEAD POUR)	D	PT03	B
SCALE: 1:4	INTERPRET DWG PER ANSI Y14	165-F-026-W3	

THIS DRAWING TAKEN FROM: N/A
 VENDOR: N/A



INFORMATION ONLY



SECTION L-L

7. BODY, (PRE-LEAD POUR)
(HOIST RING REMOVED FOR CLARITY)

7. REFERENCE VIEW

INDEX CODE NUMBER				
SYSTEM	WBE	DWG TYPE	CL	VENDOR
PT03	165	01300	44	240

DIM. IN INCHES U.N.O.	SFTY: N/A
() DENOTES mm U.N.O.	APPD: N/A
UNLESS OTHERWISE SPECIFIED TOLERANCES	APPD: N/A
2 PL DEC 3 PL DEC ANGLES 125	DM: BOB BEAMAN 8/13/07
FRACTIONS: ±.03 ±.010 ±.5°	DOE: N/A
±1/16	CAD SOURCE
	PRO/ENGINEER

REV	ISSUE DESCRIPTION	DATE	CHDR	DATE	COG	DATE	DFTG MGR	DATE	ECO	PWR
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A	REVISED PER ADD. #1	9/13/07	JMN	9/14/07	BAD	9/14/07	TO	BB	11834	N/A

THIS DRAWING CREATED BY ENGINEERING CHANGE ORDER (ECO): 11834 PWR: N/A

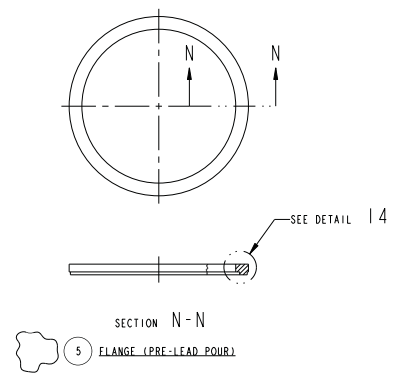
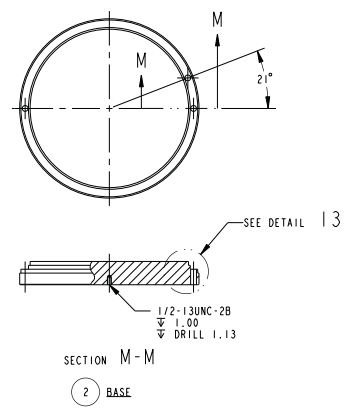
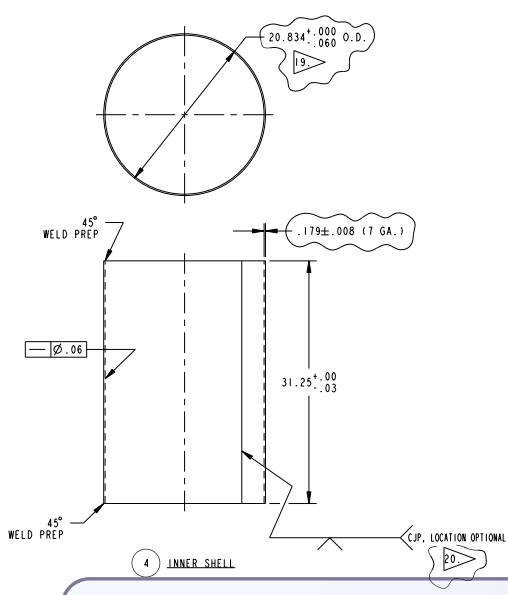
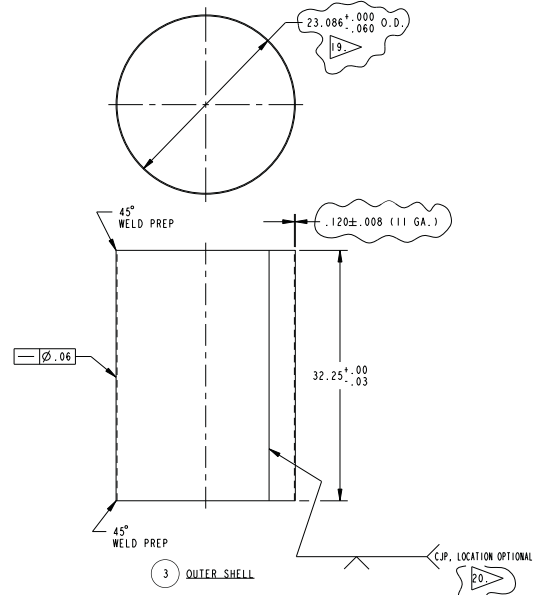
DFTG: J.M. NEVAREZ 7/18/07
 CHDR: B. DAY FOR RAJ 8/9/07
 COG: ANTHONY DONNER 8/9/07
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U.S. DEPARTMENT OF ENERGY
Washington
 TRU Solutions LLC

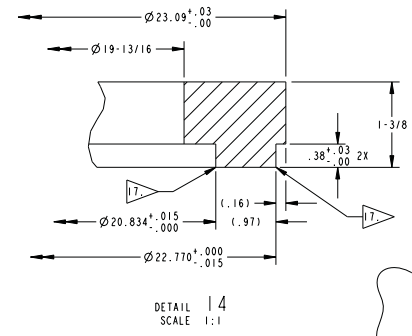
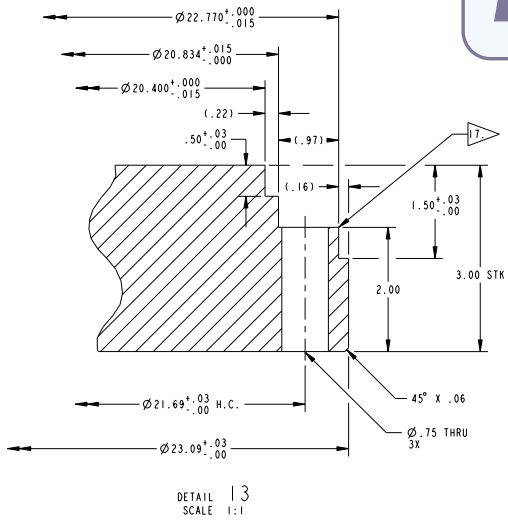
Shielded Container Assembly
 Body (Pre-Lead Pour)

SIZE SYS: D	PT03	DWG NO: 165-F-026-W4	REV: B
SCALE: 1:4		INTERPRET DWG PER ANSI Y14	

THIS DRAWING TAKEN FROM: N/A
 VENDOR: N/A



INFORMATION ONLY



B	REVISED PER ADD. #2	JMN	BAD	TD	BB	11834	N/A	
A	REVISED PER ADD. #1	JMN	BAD	TD	BB	11834	N/A	
REV	ISSUE DESCRIPTION	DFTR	CHRR	COG	DFTG MGR	ECO	PWR	
		DATE	DATE	DATE	DATE			
THIS DRAWING CREATED BY ENGINEERING CHANGE ORDER (ECO):							11834	PWR: N/A
DFTR: J.M.NEVAEZ 7/18/07		U.S. DEPARTMENT OF ENERGY						
CHRR: B.DAY FOR RAJ 8/9/07		Washington						
COG: ANTHONY DONNER 8/9/07		TRU Solutions LLC						
CM: TODD SELLMER 8/13/07		Title: Shielded Container Assembly Body Parts (Pre-Lead Pour)						
QA: BRUCE G. FAULK 8/13/07		Scale: 1:8						
DIM. IN INCHES U.N.O.		SFTY: N/A		TITLE				
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UNLESS OTHERWISE SPECIFIED TOLERANCES		APPD: N/A		BODY PARTS (PRE-LEAD POUR)				
2 PL DEC(3 PL DEC) ANGLES 125		DM: BOB BEEMAN 8/13/07		SIZE SYS: D		DWG NO: 165-F-026-W5		
±.03 ±.010 ±.5°		DOE: N/A		SCALE: 1:8		REV B		
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THIS DRAWING TAKEN FROM: N/A								
VENDOR: N/A								

INDEX CODE NUMBER			
SYSTEM	WBE	DWG TYPE	CL VENDOR
PT03	165	01300	44 240