**CDC Endplate Alignment Procedure**

This document describes the procedures to align the endplates of the CDC. The procedure will utilize a large layout table in the clean room and a transit that can be read with an overall accuracy that is better than 5 mil, but no better than 2 mil.

All survey information will be recorded in a written logbook, and then transcribed to an electronic document after alignment in complete.

* The endplates will be mounted on the support axle with the inner shell loosely attached and the support rods inserted.
* Tighten the support rods.
* Relative alignment and rotation is now checked by surveying with the transit.
* We start an iterative procedure where we torque the endplates and check the alignment. This is repeated until we are satisfied the endplates are aligned within the tolerance possible with the transit.
* Perform the final tightening of the rods.
* Glue the inner shell into place.
* Frames are now moved into the vertical stringing position for insertion of straw tubes.