

Jefferson Lab Alignment Group

DATA TRANSMITTAL

TO: Tim Whitlatch and Brian Carpenter

DATE: Sep 23, 02

FROM: Richard Schwartz

Checked: # : Z814r

DETAILS:

The following are the results of the inspection of SNS vacuum vessel 03 performed the week of Sept. 16th, 2002. A right hand coordinate system was established with the central axis running through the upstream and downstream reinforcing rings. The X axis was defined by a plane using the three top hat flanges. Positive X is to the beam left. Positive Y is up. Positive Z runs downstream with Z = 0 at the face of the upstream reinforcing ring. Values are in inches. Attached is the check sheet with measured values to the corresponding features.

Vacuum vessel overall straightness:

(CRM9003000-0000, 2/5)

	X	Y
Reinforcing Ring – Upstream	0.00	0.00
Reinforcing Ring – 2 nd	-0.01	0.00
Reinforcing Ring – 3 rd	-0.03	-0.01
Reinforcing Ring – 4 th	0.00	0.01
Reinforcing Ring – Downstream	0.00	0.00

Rail Position:

(CRM9003000-0000,4/5)

Station	Z	X	Y
Upstream	11.00	-10.44	-15.63
Downstream	107.25	-10.34	-15.70

Port Position	Z	X	Y
(CRM9003000-0000 4/5 3D)	85.15	11.50	16.38

DATA TRANSMITTAL (cont.)

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Top Hat Flange: (CRM9003000-0000, 4/5)

	Z	X	Y
Upstream	31.78	-0.02	-20.69
Middle	47.55	-0.03	-20.68
Downstream	93.11	-0.04	-20.68

Weld Disk: (CRM9003000-0002)

Upstream BL	3.87	17.32	-9.93
Upstream	3.87	-0.06	19.98
Upstream BR	3.87	-17.27	-10.05
2 nd BL	25.36	17.31	-9.94
2 nd	25.37	-0.08	19.96
2 nd BR	25.34	-17.28	-10.04
3 rd BL	54.28	17.29	-9.91
3 rd	54.28	-0.08	19.94
3 rd BR	54.27	-17.32	-10.05
4 th BL	74.46	17.23	-10.02
4 th	74.47	0.01	19.97
4 th BR	74.49	-17.34	-9.97
5 th BL	99.44	17.24	-10.02
5 th	99.45	0.03	19.97
5 th BR	99.47	-17.32	-9.98
Downstream BL	120.94	17.25	-10.01
Downstream	120.97	0.05	20.22
Downstream BR	120.97	-17.31	-9.99