



Jefferson Lab Alignment Group

Data Transmittal

TO: D. Machie

DATE: 10 Jul 2015

FROM: J. Dahlberg

Checked:

: L1658

DETAILS:

Data: Inspection\Inj\150707a

Below are the results from the recent measurements carried out on the electrode insulator assembly. Two sets of data are shown. The first is based on a perpendicular axis from the center of the upstream face of the flange and the second set is from the downstream face. The rotation about the Z axis was fixed on the flange alignment key as marked on the flange. Values are in millimeters and degrees.

MEASUREMENT	UPSTREAM FACE	DOWNSTREAM FACE
Opposite face of flange	24.71	-24.71
Downstream copper face	454.25	429.54
X offset of copper end	0.43	0.44
Y offset of copper end	-0.48	-0.42
Pitch angle of copper end	0.048	0.040
Yaw angle of copper end	0.089	0.089
X offset of knife edge	0.05	0.05
Y offset of knife edge	0.00	0.00
Top copper center radius X	1.08	1.08
Bottom copper center radius X	-0.27	-0.25
Top copper center radius Y	44.29	44.35
Bottom copper center radius Y	-45.28	-45.22
Top copper center radius Z	449.79	425.08
Bottom copper center radius Z	449.58	424.88
Left inside face angle of copper end	24.993	24.970
Right inside face angle of copper end	24.992	24.970