



# Jefferson Lab Alignment Group

## Data Transmittal

**TO:** D. Machie, P. Adderley

**DATE:** 29 Mar 2017

**FROM:** Chris Gould

**Checked:**

**# :** L1782

**DETAILS:**

M:\align\DATA\Inspection\INJ170328A

Below are the results of the three T-Electrode ceramic assemblies. The measurements have and associated reference letter that is shown on the attached drawings. It should be noted that the keyway on the “Ceramic with Flange” was not assembled ~90° to the leak groove. Values are in inches and degrees.

PART	REFERENCE	IDEAL	MEASURED	DELTA	ANGLE
CERAMIC WITH FLANGE	A	6.342	6.337	-0.005	
	B	1.803	1.808	0.005	
	C	0.250	0.250	0.000	
	D	1.000	1.003	0.003	
	E	1.197	1.203	0.006	
	F	0.125	0.122	-0.003	
	CONCENT. Of 1.00			0.006	
	PERP. Of 1.00		0.003		0.156
NOTE: KEYWAY IS NOT ROT. ~90° TO LEAK	PERP. Of Keyway		0.011		0.608
					<b>INCL. ANGLE</b>
	TOP CONE				89.615
	BOTTOM CONE				10.977
PART	REFERENCE	IDEAL	MEASURED	DELTA	
CERAMIC W/O FLANGE	A		6.450		
	B	1.803	1.809	0.006	
	C	0.250	0.250	0.000	
	D	1.000	1.002	0.002	
	E	1.197	1.202	0.005	
	F	0.125	0.129	0.004	
	CONCENT. Of 1.00			0.001	
	PERP. Of 1.00		0.002		0.130
					<b>INCL. ANGLE</b>
	TOP CONE				89.599
	BOTTOM CONE				11.006

PART	REFERENCE	IDEAL	MEASURED	DELTA	ANGLE
CERAMIC AND ELECTRODE	A	8.000	7.985	-0.015	
	B	3.101	3.106	0.005	
	C	1.894	1.896	0.002	
	D	0.030	0.017	-0.013	
	E			0.014	
	F			0.004	0.141
	G			0.010	0.180



