



Jefferson Lab Alignment Group

Data Transmittal

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Checked:

: L1923

DETAILS:

The following stands were torqued by the Alignment group during the Spring SAD. Some arc stands (noted) were torqued first at 36 ft. lb. then at 110 ft. lb. All others were at 110 ft. lb.

Torque Survey	Arc Stack	# Stands	2R		2T Stack	# Stands	
			Stands	# Stands			
<i>At 110 ft lb</i>	WA09	5	US_2R05	1	YA2T01	4	
	QC2A23,24,25	6	DS_2R05	1	YB2T02	2	
	WA10	4	US_2R06	1	QC2A01	2	
	QC2A26	2	DS_2R06	1	BP2T03	1	
	WA11	4	US_2R07	1	QL2T05	2	
	QC2A27,28,29	6	S12R02	1	QL2T06	2	
	WA16	5	S12R04	1	3R Stands		
	EA13	6	S12R06	1	S12T08	1	
	<i>At 36/110 ft lb</i>	WA12	5	S12R10	1	S12T10	1
		QC2A31	2	S12R12	1	S12T12	1
EA07		6	S12R14	1	S12T14	1	
QB1A17,18,19		6	S12R16	1	S12T16	1	
EA08		6	S12R18	1	S12T18	1	
			S12R20	1	S12T20	1	
			S12R22	1	S12T22	1	
					S12T24	1	
				S12T26	1		
	63		15		23		

The results are as follows, showing the number of bolts that were able to be moved (tightened), and the average and maximum movement (rotation).

SUMMARY	Stands	Bolts	Bolts Mov'd	Avg Mov't	Max Mov't
WA 32 stands to 110 ft lb:	32	122	122	1.00	3.00
WA 7 stands to 36 ft lb:	7	24	22	0.22	0.875
WA 7 stands to 110 ft lb:		24	24	0.60	1.00
EA 18 stands to 36 ft lb:	18	68	25	0.19	3.88
EA 18+6 stands to 110 ft lb:	6	92	92	0.83	3.75
NWCR (2R)	15	50	33	0.39	0.875
SWCR (2T)	23	78	62	0.44	2.00