Jefferson Lab Alignment Group

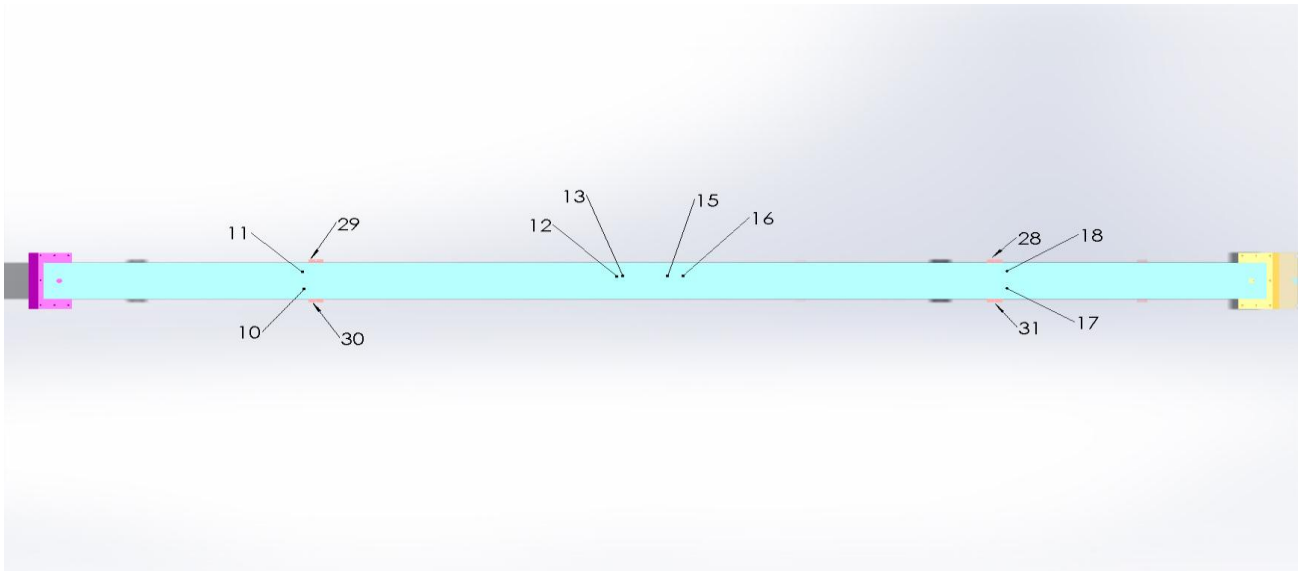
Data Transmittal

TO: O. Pastor		**DATE:** 04 Nov 2014
FROM: Jacob Walker	**Checked:** CWG	**# :** B1581

DETAILS:

Data: Inspection\HallB\Cold Bars\141104A

The following data is for the downstream cold bar. All data is given in millimeters.



Feature Name	Ideal	Found	Deltas
17	34.00	34.64	-0.64
18	-34.00	-33.34	-0.66
28	-84.10	-83.76	-0.34
29	-84.10	-83.75	-0.35
30	84.10	84.46	-0.36
31	84.10	84.56	-0.46
17 to 18	68.00	67.98	0.02
31 to 28	168.30	168.32	-0.02
16 to 15	50.80	50.77	0.03
12 to 13	25.40	25.39	0.01
30 to 29	168.30	168.21	0.09
29 to top right corner	949.10	949.61	-0.51
30 to top right corner	949.10	949.48	-0.38

THIN FLANGE	IDEALS			MEASURED			DELTAS	
	X	Y		X	Y		X	Y
H20	-103.50	-89.00		-102.61	-87.95		0.89	1.05
H21	-103.50	3.40		-102.58	4.40		0.92	1.00
H22	-103.50	95.80		-102.61	96.75		0.89	0.95
H23	0.00	95.80		0.83	96.79		0.83	0.99
H24	103.50	95.80		104.30	96.98		0.80	1.18
H25	103.50	3.40		104.33	4.56		0.83	1.16
H26	103.50	-89.00		104.45	-87.87		0.95	1.13
TOP EDGE TO CL		109.80			110.69			0.89
BOTT TO TOP		222.20			222.18			-0.02
SIDE TO SIDE	235.00			234.96			-0.04	
BR EDGE TO CL	117.50			116.76			-0.74	

The angle between the centerline of the square beam and the outer face of the thin flange is 59.99°.

The flatness of the thin flange is 0.05mm.

THICK FLANGE	IDEALS			MEASURED			DELTAS	
	X	Y		X	Y		X	Y
H1	103.50	-95.90		104.19	-96.40		0.69	-0.50
H2	103.50	-3.50		104.13	-4.12		0.63	-0.62
H3	103.50	88.90		104.11	88.18		0.61	-0.72
H4	0.00	88.90		0.59	88.17		0.59	-0.73
H5	-103.50	88.90		-102.89	88.16		0.61	-0.74
H6	-103.50	-3.50		-102.87	-4.19		0.63	-0.69
H7	-103.50	-95.90		-102.76	-96.44		0.74	-0.54
TOP EDGE TO CL		102.80			102.46			-0.34
BOTT TO TOP		222.20			222.24			0.04
SIDE TO SIDE	235.00			234.99			-0.01	
BR EDGE TO CL	117.50			116.64			-0.86	

The angle between the centerline of the square beam and the outer face of the thick flange is 59.95°.

The flatness of the thick flange is 0.05mm.