



Jefferson Lab Alignment Group

Data Transmittal

TO: S. Mandal

DATE: 27 May 2015

FROM: Chris Gould

Checked:

: B1644

DETAILS:

Below are the results of the recent Region 4 Support Tube inspection. The coordinate system was established using the bottom flange to define the XY plane. Roll was controlled by a line through holes 3 & 6 on the top flange and the origin was defined by the ID of the top flange. It should be noted that the threaded bolt holes for "BC's 13.5 and 17.125" were located by placing a sphere in the hole and projecting down to their respective planes. Values are in inches and degrees.

CIRCLE CONST.	X	Y	Z	Dia
Top Ring ID	0.000	0.000	0.000	13.003
13.5" B.C.	0.000	-0.003	0.000	13.500
16.5" B.C.	-0.009	0.004	-41.506	16.499
17.125" B.C.	-0.044	-0.008	-41.506	17.136
BOLT HOLES	X	Y	Z	ANGLES °
13.5" B.C.				
1	3.375	5.843	-0.005	59.99
2	-3.372	5.841	-0.001	-60.00
3	-6.754	-0.001	0.004	-0.01
4	-3.377	-5.844	0.005	59.98
5	3.373	-5.848	0.001	-60.02
6	6.752	-0.001	-0.004	-179.99
16.5" B.C.				
1	4.100	7.157	-41.506	60.19
2	-4.149	7.140	-41.506	-59.84
3	-8.258	-0.014	-41.506	-0.09
4	-4.118	-7.148	-41.506	60.06
5	4.131	-7.133	-41.506	-59.92
6	8.240	0.020	-41.506	-0.14
17.125" B.C.				
1	-2.946	8.051	-41.506	-20.10
2	-2.911	-8.085	-41.506	19.80
3	2.945	-8.035	-41.506	-20.13
4	2.898	8.042	-41.506	19.82
Overall Length	41.506			
// to Datum A	0.004			
Flatness Datum A	0.001			