

Jefferson Lab Alignment Group

DATA TRANSMITTAL

TO: Tim Whitlach, Brian Carpenter

DATE: Feb 22, 2002

FROM: Chris Gould

Checked: # : Z743

DETAILS:

Below are the results of the SNS cryomodule supply end cap and bridging ring survey performed on Feb 21, 2002. A coordinate system was established with the central axis running through the aperture of the end plate. The bayonet box was used to control roll. The end plate sealing surface was used to define Z = 0. Values are in inches and degrees.

Drawing Number : CRM9008010 -1072

Description	X	Y	Z
Primary Bayonet Pos.	20.05	13.91	20.63
Shield Supply Bayonet	20.00	13.93	32.62
Primary JT Position	15.01	17.85	27.62
Secondary JT Position	15.05	17.95	16.38

Drawing Number : CRM9008010 - 0000

Bayonet Box Offset 10.67

Drawing Number : CRM9008010 - 1004

End Plate Sealing 0.007
Surface Flatness

Warm-to-Cold 0.004
Beampipe Sealing
Surface Flatness

Drawing Number : CRM9008010 – 1036 & CRM9008020 – 1100

Bridging Ring 0" (Angles are clockwise looking downstream)

0	0.00	21.20	0.11
45	-14.92	15.03	0.11
90	-21.43	0.00	0.11
135	-14.81	-15.03	0.11
180	0.00	-21.28	0.12
225	15.08	-15.02	0.11
270	21.21	0.00	0.11
315	15.13	15.03	0.11
Roundness	0.33		

DATA TRANSMITTAL (cont.)

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Description	X	Y	Z
Bridging Ring 6" (Angles are clockwise looking downstream)			
(Note: angels at 90 and 270 were not taken due to port hole location)			
0	0.00	21.16	6.00
45	-14.92	15.03	6.00
135	-14.87	-15.03	6.00
180	0.00	-21.27	6.00
225	15.05	-15.03	6.00
315	15.08	15.02	6.01
Roundness	0.07		

Bridging Ring 12" (Angles are clockwise looking downstream)			
0	0.00	21.05	12.00
45	-14.91	15.03	12.00
90	-21.20	0.00	12.01
135	-14.93	-15.03	12.00
180	0.00	-21.25	12.00
225	14.99	-15.03	12.00
270	21.20	0.00	12.00
315	15.01	15.02	12.01
Roundness	0.16		

