



Jefferson Lab Alignment Group

Data Transmittal

To : E. Dalv. J. Preble. B. Carpenter

Date : August 26. 2002

From : C. Gould

Checked :

: Z803

Details :

Below are the results of the SNS cryomodule end can surveys performed the week of August 19, 2002. Return and supply end cans 2 through 7 were measured. A coordinate system was established with the Z axis running through the aperture of the end plate. An average line between the primary and shield return bayonets was used to control roll for the supply end cans. Only the shield bayonet was used to control roll for the return end cans. The end plate sealing surface was used to define Z = 0. Values are in inches.

Supply End Can 02

Description	X	Y	Z
Primary Bayonet Pos.	20.07	13.83	20.65
Shield Supply Bayonet	20.02	13.83	32.59
Primary JT Position	14.99	17.41	27.67
Secondary JT Position	15.04	17.55	16.33
Bayonet Box Offset	10.66		
End Plate Sealing Surface Flatness	0.005		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.009		

Supply End Can 03

Description	X	Y	Z
Primary Bayonet Pos.	20.07	13.76	20.71
Shield Supply Bayonet	20.08	13.71	32.67
Primary JT Position	15.14	17.60	27.83
Secondary JT Position	15.20	17.65	16.59
Bayonet Box Offset	10.66		
End Plate Sealing Surface Flatness	0.013		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.006		

Date : August 26, 2002

Transmittal # : Z803

Supply End Can 04

Description	X	Y	Z
Primary Bayonet Pos.	20.12	13.38	20.73
Shield Supply Bayonet	20.15	13.31	32.76
Primary JT Position	15.12	17.51	27.68
Secondary JT Position	15.11	17.51	16.43
Bayonet Box Offset	10.66		
End Plate Sealing Surface Flatness	0.006		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.003		

Supply End Can 05

Description	X	Y	Z
Primary Bayonet Pos.	20.03	13.55	20.77
Shield Supply Bayonet	19.95	13.66	32.75
Primary JT Position	15.04	17.71	27.73
Secondary JT Position	15.02	17.72	16.48
Bayonet Box Offset	10.63		
End Plate Sealing Surface Flatness	0.007		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.009		

Supply End Can 06

Description	X	Y	Z
Primary Bayonet Pos.	20.09	13.80	20.80
Shield Supply Bayonet	19.97	13.77	32.83
Primary JT Position	14.90	17.59	27.81
Secondary JT Position	14.97	17.48	16.51
Bayonet Box Offset	10.72		
End Plate Sealing Surface Flatness	0.005		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.007		

Date : August 26, 2002

Transmittal # : Z803

Supply End Can 07

Description	X	Y	Z
Primary Bayonet Pos.	20.10	13.65	20.78
Shield Supply Bayonet	20.13	13.55	32.75
Primary JT Position	15.15	17.55	27.72
Secondary JT Position	15.17	17.71	16.49

Bayonet Box Offset	10.65
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End Plate Sealing Surface Flatness	0.008
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Warm-to-Cold Beampipe Sealing Surface Flatness	0.007
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Return End Can 02

Description	X	Y	Z
Primary Bayonet Pos.	20.22	13.83	7.66
Shield Return Bayonet	20.18	13.95	19.53
Relief Stack Position	15.29	31.72	15.62
Cooldown JT Position	20.05	36.70	29.69
Cooldown Outlet Flange	20.10	28.25	4.67

Bayonet Box Offset	10.58
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End Plate Sealing Surface Flatness	0.013
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Warm-to-Cold Beampipe Sealing Surface Flatness	0.008
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Return End Can 03

Description	X	Y	Z
Primary Bayonet Pos.	20.12	14.02	7.71
Shield Return Bayonet	20.15	14.12	19.66
Relief Stack Position	14.83	31.70	15.64
Cooldown JT Position	19.65	37.01	29.67
Cooldown Outlet Flange	19.63	28.51	4.71

Bayonet Box Offset	10.59
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End Plate Sealing Surface Flatness	0.025
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Warm-to-Cold Beampipe Sealing Surface Flatness	0.007
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Date : August 26, 2002

Transmittal # : Z803

Return End Can 04

Description	X	Y	Z
Primary Bayonet Pos.	20.12	13.97	7.83
Shield Return Bayonet	20.05	13.84	19.79
Relief Stack Position	14.88	31.93	15.90
Cooldown JT Position	19.75	36.74	30.01
Cooldown Outlet Flange	19.80	27.97	4.77
Bayonet Box Offset	10.63		
End Plate Sealing Surface Flatness	0.006		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.006		

Return End Can 05

Description	X	Y	Z
Primary Bayonet Pos.	20.31	13.61	7.87
Shield Return Bayonet	20.27	13.32	19.79
Relief Stack Position	15.36	31.92	15.96
Cooldown JT Position	20.16	36.06	29.88
Cooldown Outlet Flange	20.40	27.55	4.71
Bayonet Box Offset	10.68		
End Plate Sealing Surface Flatness	0.006		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.007		

Date : August 26, 2002

Transmittal # : Z803

Return End Can 06

Description	X	Y	Z
Primary Bayonet Pos.	20.19	13.62	7.79
Shield Return Bayonet	20.17	13.53	19.76
Relief Stack Position	15.60	31.89	15.87
Cooldown JT Position	20.52	36.02	30.02
Cooldown Outlet Flange	20.25	27.67	4.66
Bayonet Box Offset	10.67		
End Plate Sealing Surface Flatness	0.008		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.007		

Return End Can 07

Description	X	Y	Z
Primary Bayonet Pos.	20.28	13.71	7.70
Shield Return Bayonet	20.20	13.58	19.69
Relief Stack Position	15.34	31.85	15.75
Cooldown JT Position	20.26	36.40	29.88
Cooldown Outlet Flange	20.30	27.90	4.66
Bayonet Box Offset	10.59		
End Plate Sealing Surface Flatness	0.002		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.005		