



Jefferson Lab Alignment Group

Data Transmittal

To : E. Dalv. B. Carpenter

Date : September 11. 2002

From : C. Gould

Checked :

: Z808

Details :

Below are the results of the SNS cryomodule end can surveys performed September 09, 2002. Return and supply end cans 8 and 9 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.

Drawing Number : CRM9008010-1072

Supply End Can 08

Description	X	Y	Z
Primary Bayonet Pos.	20.18	13.91	20.68
Shield Supply Bayonet	20.29	13.86	32.63
Primary JT Position	15.23	17.89	27.76
Secondary JT Position	15.27	18.01	16.46
Bayonet Box Offset	10.78		
End Plate Sealing Surface Flatness	0.011		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.005		

Supply End Can 09

Description	X	Y	Z
Primary Bayonet Pos.	20.07	13.83	20.77
Shield Supply Bayonet	20.17	13.95	32.69
Primary JT Position	15.07	17.68	27.75
Secondary JT Position	15.20	17.73	16.46
Bayonet Box Offset	10.71		
End Plate Sealing Surface Flatness	0.004		
Warm-to-Cold Beampipe Sealing Surface Flatness	0.005		

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Drawing Number : CRM9008020-1115**Return End Can 08**

Description	X	Y	Z
Primary Bayonet Pos.	20.12	14.03	7.76
Shield Return Bayonet	20.16	14.01	19.72
Relief Stack Position	15.05	32.05	15.73
Cooldown JT Position	19.91	36.49	29.85
Cooldown Outlet Flange	20.03	28.10	4.73

Bayonet Box Offset 10.66

End Plate Sealing 0.006
Surface FlatnessWarm-to-Cold 0.004
Beampipe Sealing
Surface Flatness**Return End Can 09**

Description	X	Y	Z
Primary Bayonet Pos.	20.08	14.17	7.65
Shield Return Bayonet	20.15	14.13	19.60
Relief Stack Position	14.89	32.02	15.84
Cooldown JT Position	20.06	36.69	30.02
Cooldown Outlet Flange	20.03	28.33	4.47

Bayonet Box Offset 10.74

End Plate Sealing 0.002
Surface FlatnessWarm-to-Cold 0.006
Beampipe Sealing
Surface Flatness