



Jefferson Lab Alignment Group

Data Transmittal

TO: Ed Daly, Brian Carpenter	DATE : Nov 26, 2002
FROM: Chris Gould	Checked: # Z830

Details:

Below are the results of the re-manufactured SNS cryomodule return end cap 06 and bridging ring survey performed on November 26, 2002. A coordinate system was established with the central axis running through the aperture of the end plate. An average line constructed between the primary and shield return bayonet was used to control roll. The end plate sealing surface was used to define Z = 0. The bridging ring results are based on stick mic measurements taken every 45 degrees clockwise looking upstream with 0-180 at 12 o'clock. Values are in inches.

Drawing Number : CRM9008020 -1115

Description	X	Y	Z
Primary Bayonet Pos.	20.08	13.97	7.82
Shield Return Bayonet	20.17	13.78	19.76
Relief Stack Position	15.07	31.90	15.71
Cool Down JT Position	19.93	36.29	29.67
Cool Down Outlet Flange	19.99	27.96	4.83

Drawing Number : CRM9008020 - 0000

Bayonet Box Offset 10.66

Drawing Number : CRM9008020 - 1028

End Plate Sealing 0.005
Surface Flatness

Warm-to-Cold 0.008
Beampipe Sealing
Surface Flatness

Drawing Number : CRM9008010 – 1036 & CRM9008020 – 1100

Bridging Ring 1036-010(6r) 0-180	45-225	90-270	135-315	
0" from Vacuum Tank	42.54	42.42	42.65	42.54
6" from Vacuum Tank	42.51	42.46	X	42.52
12" from Vacuum Tank	42.41	42.46	42.51	42.49