



Jefferson Lab Alignment Group

Data Transmittal

TO: B. Metzger	DATE: 13 Nov 2015
FROM: Chris Gould	Checked: (kjt) # : C1683

DETAILS:

M:\align\DATA\STEP1\HallC\Pivot Flange\151112A

Below are the results of the Hall C pivot flange alignment. The results show the flange location before and after the flange was tack welded to the target post. Six of the twelve Ø 0.81 thru holes on a 23.00 BCD were also measured. The coordinate system is relative to the Hall C Target with an ideal CEBAF elevation of 100 meters. A positive X is to the beam left, a positive Y is up and a positive Z is downstream. Values are in inches and degrees.

FINALS	Ideals			Measured			Deltas		
	X	Y	Z	X	Y	Z	X	Y	Z
PVTF LGPA	9.750	-50.317	0.000	9.758	-50.335	0.009	0.008	-0.018	0.009
PVTF LGPB	-4.875	-50.317	8.444	-4.870	-50.327	8.456	0.005	-0.010	0.012
PVTF LGPC	-4.875	-50.317	-8.444	-4.876	-50.337	-8.437	-0.001	-0.020	0.007
BH CIRCLE	0.000	-50.630	0.000	0.007	-50.653	0.008	0.007	-0.023	0.008
FLANGE PRE WELD									
PITCH	ROLL	DIST. TO TARGET CL		IDEAL DIST.	DELTA				
0.0066°	90.0235°	50.625		50.630	-0.005				
PITCH DIST	ROLL DIST								
0.003	0.011								
FLANGE POST WELD									
PITCH	ROLL	DIST. TO TARGET CL		IDEAL DIST.	DELTA				
-0.0240°	89.9999°	50.653		50.630	0.023				
PITCH DIST	ROLL DIST								
0.011	0.000								
THRU HOLES 23.00 BCD									
	X	Y	Z	MEAS. RADIUS	IDEAL RADIUS	DELTA			
BH1	-2.967	-50.034	11.123	11.512	11.500	0.012			
BH2	8.144	-50.047	8.143	11.517	11.500	0.017			
BH3	11.122	-50.048	-2.970	11.512	11.500	0.012			
BH4	2.985	-50.044	-11.105	11.499	11.500	-0.001			
BH5	-8.131	-50.052	-8.126	11.495	11.500	-0.005			
BH6	-11.107	-50.047	2.986	11.501	11.500	0.001			