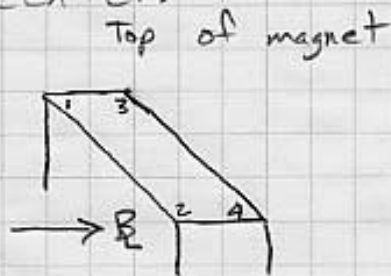
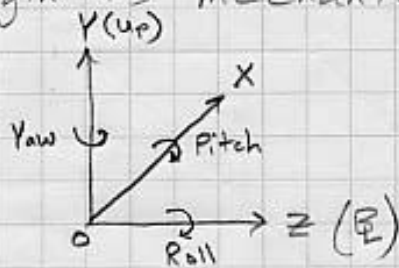


QE-N1

31 JAN 2005
H. Imfeld
X 3472

Datum

Origin is mechanical center.



X, Y, Pitch, + Yaw } Read dowel at U/S + D/S of magnet.
These two points define a line that is the mechanical Z axis.

Roll → 0 Roll is established from the vertical split plane created from the magnet pole tips on the U/S face.

Z → 0 Z is half the core length.

After the origin was established and the magnet was positioned, alignment made additional readings to perform some Q.C.

Top of magnet:

NEAR	TB1	TB2	TB3	TB4
5.905	5.910	5.907	5.917	

Top surface of bottom plate

Under	TB1	TB2	TB3	TB4
	-8.663	-8.665	-8.639	-8.639

Roll U/S = -0.4 mr
D/S = -0.9 mr
Pitch +X = -0.6 mr
-X = -2.2 mr

Roll U/S = +0.2 mr
D/S = 0.0 mr
Pitch +X = -3.4 mr
-X = -3.7 mr

Side of magnet:

-X Top = -5.905
-X Bottom = -5.906

Distance from Mounting Plate to top of magnet:

TB1	TB2	TB3	TB4
14.568	14.575	14.546	14.556

Roll = -0.1 mr

VS
21 JAN 2005
M. Rogers
H. Imfeld

QE-NI

12-1410-1

dowel $\Rightarrow \Phi = 1.250''$

W/S
9.220
Dowel read
in upper
poles

9.229
dowel read
in lower
poles



D/S
9.218
dowel in
upper poles

9.227
dowel in
lower poles

Roll removed from Vertical W/S split planes
Pitch from dowel in bottom & top poles
Yo from bottom & top poles w/ dowel.

W/S Avg. Read 9.2245
D/S Avg. Read 9.2225

✓ 1/31/05
MR

READ 9.224
Rad. .625
HI 9.849 ✓

	1	2	3	4
HI	9.849	9.849	9.849	9.849
READ	1.445	1.439	1.442	1.435
S/T	8.404 ✓	8.410 ✓	8.407 ✓	8.414 ✓
FT	1	1	1	1
VAL	7.404 ✓	7.410 ✓	7.407 ✓	7.414 ✓

Top of mag.

	A(1)	B(2)	C(3)	D(4)
HI	9.849	9.849	9.849	9.849
READ	3.944	3.939	3.942	3.932
VAL	5.905 ✓	5.910 ✓	5.907 ✓	5.917 ✓

Bottom Plate

	E(1)	F(2)	G(3)	H(4)
	9.849	9.849	9.849	9.849
	18.512	18.514	18.488	18.488
	-8.663 ✓	-8.665 ✓	-8.639 ✓	-8.639 ✓

(X) u/s davel @ bottom poles -8.860
 D/s davel @ bottom poles -8.858

READ -8.859
 RAD -0.625
 LOS -9.484 ✓

✓ 1/31/05
 MR

	1	2	3	4
LOS	-9.484	-9.484	-9.484	-9.484
READ	-14.143	-2.851	-14.130	-2.832
S/T	4.659 ✓	-6.633 ✓	4.646 ✓	-6.652 ✓
FT	-1	-1	-1	-1
VAL	5.659 ✓	-5.633 ✓	5.646 ✓	-5.652 ✓

	-X top	-X bot
LOS	-9.484	-9.484
READ	-5.579	-5.578
VAL	-5.905 ✓	-5.906 ✓

(E) Mic Z of mag = 4.312
1/2 = 2.156

Gun w/s of mag

7.008 +x Top
7.010 +x Bot
7.006 -x

READ -7.008
VAL -2.156
LOS -9.164 ✓

	1	2	3	4
LOS	-9.164	-9.164	-9.164	-9.164
READ	-6.288	-6.278	-9.530	-9.383
SIT	-2.876 ✓	-2.886	0.366	0.219
FT	-1	-1	-1	-1
VAL	-1.876 ✓	-1.886 ✓	1.366 ✓	1.219 ✓

✓ 1/31/05
MR

Base Plate Dimension
11 1/2 x 8 x 1 1/4