

# Asset

11 OCT 2004  
M. Rogers  
H. Imfeld

①

W/S BPM  
 $11.693 + .5 = 12.193$

D/S BPM  
 $12.331 + .5 = 12.831$

②

F	.5			
N	.5			
1st F	<del>1.9</del>	<del>18.276</del>	18.267	
1st N	<del>18.433</del>	<del>18.756</del>	18.286	
2nd F		<del>18.263</del>	18.300	
2nd N		<del>18.273</del>	18.293	
S/R F	<del>18.276</del>	<del>18.267</del>	18.291	
S/R N			18.291 ✓	
LDS			18.791	

③

	1	2	7	8
	12.193	12.193	12.193	12.193
	2.286	2.370	2.312	2.352
Slope	9.907	9.823	9.881	9.841
	(-1.134)	(-1.134)	(-1.444)	(-1.444)
	10.041	9.957	10.325	10.285
FT	1	1	1	1
S/R	9.041	8.957	9.325	9.285
END	9.047	8.971	9.333	9.298
	<span style="border: 1px solid black;">-006</span>	<span style="border: 1px solid black;">-014</span>	<span style="border: 1px solid black;">-008</span>	<span style="border: 1px solid black;">-013</span>
Move	.043	.043	.059	.059
S/R	9.090	9.014	9.392	9.357
SET	9.090	9.014	9.398	9.359
	<span style="border: 1px solid black;">+004</span>	<span style="border: 1px solid black;">-006</span>	<span style="border: 1px solid black;">-002</span>	<span style="border: 1px solid black;">-002</span>

moves  
W/S  
-1.1 mm  
D/S  
-1.5 mm

④

	2	8
LDS	-18.791	-18.791
	-3.312	-3.406
	-15.479	-15.385
	1	1
S/R	-14.479	-14.385
END	14.451	14.357
	<span style="border: 1px solid black;">-028</span>	<span style="border: 1px solid black;">-028</span>
Move	.047	.051
S/R	14.498	14.408
SET	14.502	14.414
	<span style="border: 1px solid black;">+004</span>	<span style="border: 1px solid black;">+004</span>

moves  
W/S  
+1.2 mm  
D/S  
+1.3 mm

-14.275

# ASSET

9/30/04  
FG, HL, CB

Z = 0      U/S BPM  
15" Radius

$$\begin{array}{r} 8.375 \\ + .5 \\ \hline 8.875 = HI \end{array}$$

$$\begin{array}{r} 9.004 \\ + .5 \\ \hline 9.504 \end{array}$$

D/S BPM  
Z = 119"

$$.629 / 119 = .0053$$

Z=0 To TB 1 & 2 = 25.3  
25.3" x .0053 = .134

Z To 3 & 4 = .134 + .128 = .262

Z To TB 6,5 = 10.2 x .0053 = .54 + .262 = .316

To TB 7,8 = .316 + .128 = .444

<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>
8.875	8.875	8.875	8.875
<u>2.286</u>	<u>2.370</u>	<u>2.311</u>	<u>2.356</u>
6.589	6.505	6.564	6.519
<u>1</u>	<u>1</u>	<u>1</u>	<u>1</u>
5.599	5.505	5.564	5.519
<u>.134</u>	<u>.134</u>	<u>.1262</u>	<u>.1262</u>
S/R 5.723	S/R 5.639	S/R 5.826	5.781
5.725 +2	5.648 -9	5.829 -3	5.794 -13

<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>
8.875	8.875	8.875	8.875
<u>2.329</u>	<u>2.333</u>	<u>2.312</u>	<u>2.352</u>
6.546	6.542	6.563	6.523
<u>1</u>	<u>1</u>	<u>1</u>	<u>1</u>
5.546	5.542	5.563	5.523
<u>.134</u>	<u>.1316</u>	<u>.1444</u>	<u>.1444</u>
S/R 5.860	S/R 5.658	6.007	5.967
5.864 +2	5.860 -8	6.008 -4	5.967 6.065 +2

$$X) \quad \begin{array}{l} F. V. = .5 \\ N. V. = .5 \end{array}$$

$$\begin{array}{l} 1ST \quad F = 4 + 16 = 20 \\ 1ST \quad N = 5.308 + 16 = 21.308 \end{array}$$

$$\begin{array}{l} 2ND \quad F = 5.997 + 16 = 21.997 \\ 2ND \quad N = 5.742 + 16 = 21.742 \end{array}$$

$$\begin{array}{l} S/R \quad F = 21.671 - 16 = 5.671 \\ S/R \quad N = \quad \quad \quad 5.671 \end{array}$$

$$LOS \quad 22.171$$

$$\begin{array}{r} \underline{2} \\ 22.171 \\ \underline{3.312} \\ 18.859 \\ \underline{1} \\ 17.859 \\ 17.861 - 2 \end{array}$$

$$\begin{array}{r} \underline{4} \\ 22.171 \\ \underline{3.342} \\ 18.829 \\ \underline{1} \\ 17.829 \\ 17.828 - 1 \end{array}$$

$$\begin{array}{r} \underline{6} \\ 22.171 \\ \underline{3.334} \\ 18.837 \\ \underline{1} \\ 17.837 \\ 17.866 \\ 17.836 - 1 \end{array}$$

$$\begin{array}{r} \underline{8} \\ 22.171 \\ \underline{3.406} \\ 18.765 \\ \underline{1} \\ 17.765 \\ 17.760 \\ 17.767 \\ + 2 \end{array}$$

SPHERE(1)  
X= 3.36462  
Y= 2.28561  
Z= -1.34328

SPHERE(2)  
X= -3.31235  
Y= 2.37027  
Z= -1.32266

SPHERE(3)  
X= 3.36249  
Y= 2.31086  
Z= 22.85216

SPHERE(4)  
X= -3.34235  
Y= 2.35646  
Z= 22.89461

SPHERE(5)  
X= 3.38591  
Y= 2.32866  
Z= -1.35634

SPHERE(6)  
X= -3.33392  
Y= 2.33302  
Z= -1.38442

SPHERE(7)  
X= 3.38168  
Y= 2.31172  
Z= 22.78875

SPHERE(8)  
X= -3.40640  
Y= 2.35232  
Z= 22.77104

4th LTR  
QW m 610

QC0436\_101\_EVA\_ONLY.ASC

DATUM(1)  
2.40161  
0.00011  
0.00000  
0.00000  
0.09059

DATUM(2)  
2.40143  
0.00017  
0.00000  
0.00000  
21.36039

X  
Y  
Z  
SPHERE(1)  
0.00017  
0.49995  
-3.36462  
-2.28561  
-1.34328

SPHERE(2)  
0.00017  
0.49989  
3.31235  
-2.37027  
-1.32266

SPHERE(3)  
0.00056  
0.50003  
-3.36249  
-2.31086  
22.85216

SPHERE(4)  
0.00029  
0.49985  
3.34235  
-2.35646  
22.89461

DATUM(3)  
2.40135  
0.00020  
0.00000  
0.00000  
0.09049

DATUM(4)  
2.40153  
0.00053  
0.00000  
0.00000  
21.36033

SPHERE(5)  
0.00010  
0.49974  
-3.38591  
-2.32866  
-1.35634

QC0436\_101\_EVA\_ONLY.ASC

SPHERE(6)  
0.00029  
0.49988  
3.33392  
-2.33302  
-1.38442

SPHERE(7)  
0.00018  
0.49984  
-3.38168  
-2.31172  
22.78875

SPHERE(8)  
0.00029  
0.49979  
3.40640  
-2.35232  
22.77104

PRB1  
0.98422  
0.00012  
-0.00001  
-0.00001  
-0.00001

PART NAME .....: CELL STRUCTURE\_1

DRAWING NO. ....:  
SHOP NO. ....: 10-1534-6

SERIAL NO. ....: 101  
VENDOR .....: KLYSTRON

OPERATOR .....: FENSKE  
MEASURING DEVICE : XCL 7 10 6

PROGRAM NAME ...: QC0436  
TEST DATE .....: 28-SEP-2004 14:11

REMARKS .....: CHECK LEVELING AND STRAIGHTNESS.

TEXT	EVAL.	ACTUAL	NOMINAL	U.TOL.	L.TOL.	ACT-NOM	GRAPHIC
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!----- DATUM DIAMETERS AT STRUCTURE AT INPUT END.

DATUM(1)

DM 2.40161  
FORM 0.00011  
X 0.00000  
Y 0.00000  
Z 0.09059

DATUM(2)

DM 2.40143  
FORM 0.00017  
X 0.00000  
Y 0.00000  
Z 21.36039

!----- SPHERES AT STRUCTURE AT INPUT END.

SPHERE(1)

FORM 0.00017  
DM 0.49995  
X -3.36462  
Y -2.28561  
Z -1.34328

SPHERE(2)

FORM 0.00017  
DM 0.49989  
X 3.31235  
Y -2.37027  
Z -1.32266

SPHERE(3)

FORM 0.00056  
DM 0.50003  
X -3.36249  
Y -2.31086  
Z 22.85216

SPHERE(4)

FORM 0.00029  
DM 0.49985  
X 3.34235  
Y -2.35646  
Z 22.89461

DATE: 28-SEP-2004 TIME: 14:11:45 QC0436 S/N:101 PAGE: 1

DATE: 28-SEP-2004		TIME: 14:11:45		QC0436		PAGE: 2	
TEXT	EVAL.	ACTUAL	NOMINAL	U.TOL.	L.TOL.	ACT-NOM	GRAPHIC

!----- DATUM DIAMETERS AT STRUCTURE OPPOSITE INPUT END.

DATUM(3)

DM	2.40135
FORM	0.00020
X	0.00000
Y	0.00000
Z	0.09049

DATUM(4)

DM	2.40153
FORM	0.00053
X	0.00000
Y	0.00000
Z	21.36033

!----- SPHERES AT STRUCTURE OPPOSITE INPUT END.

SPHERE(5)

FORM	0.00010
DM	0.49974
X	-3.38591
Y	-2.32866
Z	-1.35634

SPHERE(6)

FORM	0.00029
DM	0.49988
X	3.33392
Y	-2.33302
Z	-1.38442

SPHERE(7)

FORM	0.00018
DM	0.49984
X	-3.38168
Y	-2.31172
Z	22.78875

SPHERE(8)

FORM	0.00029
DM	0.49979
X	3.40640
Y	-2.35232
Z	22.77104

!----- TEST PROBE ON REF. SPHERE - 25.0004MM / .98427 INCHES.

PRB1

DM	0.98422	0.98427	-0.00004
FORM	0.00012		
X	-0.00001		
Y	-0.00001		
Z	-0.00001		

DATE: 28-SEP-2004		TIME: 14:11:45		QC0436		S/N:101		PAGE: 2	
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QC0436\_101\_EVA.ASC

FILENAME:QC0436

B/P:DOUBLE CELL STRUCTURE

SERIAL NUMBER:101

FEATURE:DATUM(1)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
DM					2.40161		S VN	
FORM					0.00011		FN	
X					0.00000		DN	
Y					0.00000		DN	
Z					0.09059		S DN	

FEATURE:DATUM(2)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
DM					2.40143		S VN	
FORM					0.00017		FN	
X					0.00000		DN	
Y					0.00000		DN	
Z					21.36039		S DN	

FEATURE:SPHERE(1)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00017		FN	
DM					0.49995		S VN	
X					-3.36462		S DN	
Y					-2.28561		S DN	
Z					-1.34328		S DN	

FEATURE:SPHERE(2)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00017		FN	
DM					0.49989		S VN	
X					3.31235		S DN	
Y					-2.37027		S DN	
Z					-1.32266		S DN	

FEATURE:SPHERE(3)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00056		FN	
DM					0.50003		S VN	
X					-3.36249		S DN	
Y					-2.31086		S DN	
Z					22.85216		S DN	

FEATURE:SPHERE(4)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
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QC0436\_101\_EVA.ASC

FORM					0.00029			FN	
DM					0.49985			S VN	
X					3.34235			S DN	
Y					-2.35646			S DN	
Z					22.89461			S DN	

FEATURE: DATUM(3)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
DM					2.40135		S VN	
FORM					0.00020		FN	
X					0.00000		DN	
Y					0.00000		DN	
Z					0.09049		S DN	

FEATURE: DATUM(4)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
DM					2.40153		S VN	
FORM					0.00053		FN	
X					0.00000		DN	
Y					0.00000		DN	
Z					21.36033		S DN	

FEATURE: SPHERE(5)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00010		FN	
DM					0.49974		S VN	
X					-3.38591		S DN	
Y					-2.32866		S DN	
Z					-1.35634		S DN	

FEATURE: SPHERE(6)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00029		FN	
DM					0.49988		S VN	
X					3.33392		S DN	
Y					-2.33302		S DN	
Z					-1.38442		S DN	

FEATURE: SPHERE(7)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00018		FN	
DM					0.49984		S VN	
X					-3.38168		S DN	
Y					-2.31172		S DN	
Z					22.78875		S DN	

QC0436\_101\_EVA.ASC  
 FEATURE: SPHERE(8)

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
FORM					0.00029		FN	
DM					0.49979		S VN	
X					3.40640		S DN	
Y					-2.35232		S DN	
Z					22.77104		S DN	

FEATURE: PRB1

EVAL.	NOMINAL	N.T	U.TOL.	L.TOL.	ACTUAL	A-N	CONTR.	TEXT
DM	0.98427				0.98422	0.0000	VN	
FORM					0.00012		FN	
X					-0.00001		DN	
Y					-0.00001		DN	
Z					-0.00001		DN	