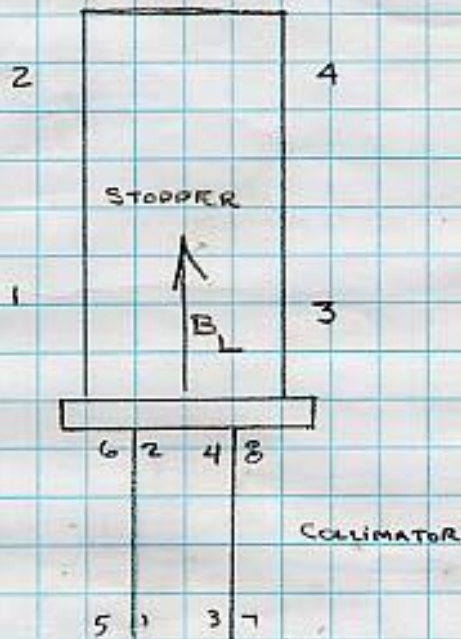


SSRL B/L 5 STOPPER TANK

8/4/03
MR LG



	X	Y	Z
1	+12.558	-0.757	+5.885
2	+6.883	+0.123	+24.905
3	-12.529	-1.009	+5.971
4	-6.857	+0.126	+25.020

ASSIGNED NEW X & Y VALUES
TO T/B 1 & 3 AFTER WELDING

SSRL B/L 5

REASSIGN T/B'S 143 T/B'S AFTER WELD

8/4/03

MR LG

(Y)

8/4/03

TANK

Coll.

2) +.123

$$12.186$$

$$12.185$$

$$\underline{1.000}$$

$$13.185 \checkmark$$

$$(+).123$$

$$13.308 \checkmark$$

4) +.126

$$12.181$$

$$12.182$$

$$\underline{1.000}$$

$$13.182 \checkmark$$

$$(+).126$$

$$13.308 \checkmark$$

2) -.750

$$.627$$

$$\underline{- .123 \checkmark}$$

$$(-).007$$

$$\underline{- .130 \checkmark}$$

$$13.308$$

$$(-).130$$

$$13.4385/R \checkmark$$

$$13.440$$

$$\boxed{- .002 \checkmark}$$

4) - 750 offset

$$.627 \text{ 1/2 coll}$$

$$\underline{- .123 \checkmark}$$

$$(-).007 \text{ SET}$$

$$\underline{- .130 \checkmark \text{ FROM TANK}}$$

$$13.308$$

$$(-).130$$

$$13.4385/R \checkmark$$

$$13.440$$

$$\boxed{- .002 \checkmark}$$

13.308 HI

3) 13.317

$$\underline{1.000}$$

$$14.317 \checkmark$$

$$13.308$$

$$\boxed{- 1.009 \checkmark}$$

1) 13.065

$$\underline{1.000}$$

$$14.065 \checkmark$$

$$13.308$$

$$\boxed{- .757 \checkmark}$$

✓ 8/4/03
me

SSRL B/L S STOPPER

8/04/03

CHECKING T/B'S 1 & 3 AFTER WELDING M.R., L.G.
ON BLOCKS

① 2) 6.883

2 coll) 1.9776,004 = 1.981

~~9.977+1
15.887
15.892+φ
9.985+1
15.906+φ
11.036-1
15.938
17.919LOS~~

~~1) 4.350
1.000
5.350
17.919LOS
+12.569~~

2) 6.883

2 coll) 1.9776,004 = 1.973

13.000+1
17.645+φ
8.000+1
14.134+φ

9.752-1
14.662-φ 15.370
16.635LOS ✓

1) 3.077
1.000

4.077 ✓
16.635

+12.558 ✓

1) -6.857

4 coll) -1.9776,004 = -1.981

10.000+1
15.843+φ
9.000+1
15.153+1

3) 4.222
1.000

5.222 ✓
17.751

-12.529 ✓

10.894-1
15.770-φ
-17.751 LOS ✓

SSRL B/L 5

STOPPER

LAB DATA

7/31/03

MR LJ

1 INCH TOOLING BALLS

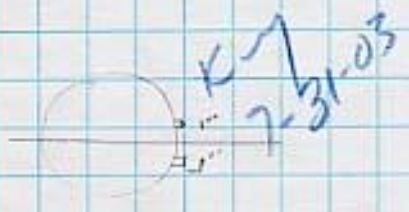
D/S FLANGE $13.260/2 = 6.630$

$\Delta = .828$

Y)

U/S FLANGE $Y = 11.604/2 = 5.802$ ✓

X $11.530/2 = 5.765$ ✓



U/S FLANGE

7.558

5.802

13.360 ✓

H.I.

D/S FLANGE

6.730

6.630

13.360 ✓

1) 13.122

1

14.122 ✓

13.360

-0.762

2) 12.237

1

13.237 ✓

13.360

+0.123 ✓

3) 13.373

1

14.373 ✓

13.360

-1.013 ✓

NEW T/B

4) 12.234

1

13.234 ✓

13.360

+0.126 ✓

NEW VALUES AFTER WELD

VALUES OF TANK DO NOT INCLUDE THE .750 VERTICAL OFFSET

SSRL B/L 5
STOPPER

7/31/03
MR LJ

X) $U/S \ 11.530/2 = 5.765$ ✓
 $D/S \ 13.260/2 = 6.630$ ✓

kin
7/31/03

FAR V	6.630	✓
NEAR V	5.765	✓
1F	14.000	
1N	14.278	
2F	8.000	
2N	9.779	
S/R F	11.654	✓
S/R N	12.519	✓
LOS	18.284	✓

1)
$$\begin{array}{r} 4.726 \\ 1 \\ \hline 5.726 \\ 18.284 \\ \hline +12.558 \end{array}$$
 ✓

2)
$$\begin{array}{r} 10.401 \\ 1 \\ \hline 11.401 \\ 18.284 \\ \hline +6.883 \end{array}$$
 ✓

↑
NEW VALUES
AFTER WELD

FAR V	-6.630	✓
NEAR V	-5.765	✓
1F	19.000	
1N	19.317	
2F	15.000	
2N	16.412	
S/R F	17.114	✓
S/R N	17.979	✓
LOS	-23.744	✓

3)
$$\begin{array}{r} 10.217 \\ 1 \\ \hline 11.217 \\ 23.744 \\ \hline -12.527 \end{array}$$
 ✓

NEW TOOLING BALL

4)
$$\begin{array}{r} 15.887 \\ 1 \\ \hline 16.887 \\ 23.744 \\ \hline -6.857 \end{array}$$
 ✓

SSRL B/L 5
STOPPERS

7/31/03
MR LJ

2) Z ϕ is U/S FACE

U/S FLANGE
- 7.168 LOS

✓
7/31/03

$$\begin{array}{r} 1) \quad 12.053 \\ \quad \quad 1. \text{---} \\ \hline \quad 13.053 \quad \checkmark \\ - 7.168 \\ \hline \boxed{+5.885} \quad \checkmark \end{array}$$

$$\begin{array}{r} 3) \quad 12.139 \\ \quad \quad 1. \text{---} \\ \hline \quad 13.139 \quad \checkmark \\ - 7.168 \\ \hline \boxed{+5.971} \quad \checkmark \end{array}$$

READ T/B 3

$$\begin{array}{r} 34990 \\ \quad \quad 1. \text{---} \\ \hline 35990 \quad \checkmark \\ \quad \quad 5971 \\ \hline 41.961 \text{ LOS} \quad \checkmark \end{array}$$

$$\begin{array}{r} 2) \quad 6.527 \\ \quad 10.529 \\ \hline \quad 17.056 \quad \checkmark \\ \quad 41.961 \\ \hline \boxed{+24.905} \quad \checkmark \end{array}$$

$$\begin{array}{r} 4) \quad 6.412 \\ \quad 10.529 \\ \hline \quad 16.941 \quad \checkmark \\ \quad 41.961 \\ \hline \boxed{+25.020} \quad \checkmark \end{array}$$