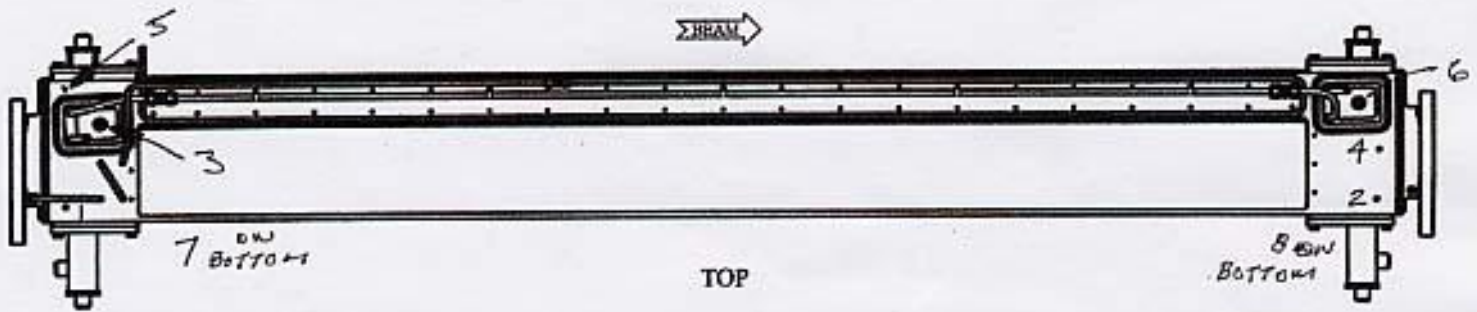


SSRL

11/05

BL5 ID CHAMBER



	X	Y	Z
1	-2.495	+2.208	-45.055
2	-2.500	+2.209	+45.067
3	+3.264	+2.186	-42.371
4	+1.000	+2.209	+45.063
5	+5.807	+2.199	-45.057
6	+4.196	+2.205	+43.810
7	+0.001	-2.189	—
8	-0.002	-2.189	—

* USE SHORT SHANK T/B *

check
Jm

SSRL
ID 5 VACUUM CHAMBER

10-17-05
J.M., L.G.

(X)

3.500

3.500

20.000

22.884

21.674

22.884

30.000

- 26.384 WS

25.850

22.874

22.880

1) 22.889

1.000

23.889

- 26.384

-2.495

2) 22.884

1.000

23.884

- 26.384

-2.500

3) 21.091

8.557

29.648

- 26.384

+3.264

4) 26.384

1.000

27.384

- 26.384

+1.000

5) 23.434

8.557

32.191

- 26.384

+5.807

6) 29.573

1.000

30.573

- 26.384

+4.189

7) 25.385

1.000

26.385

- 26.384

+0.001

8) 25.382

1.000

26.382

- 26.384

-.002

* CHAMBER HAD LEAK PIECE
WITH #6 TAKEN OFF & WELDED
ON AGAIN GAVE VALUE
IN THE FIELD

Check on

SSRL
ID 5 VACUUM CHAMBER
LAB DAT

10-17-05
J.M., L.G.

(Y)

$$\begin{array}{r}
 6.346 \\
 1.000 \text{ ft} \\
 \hline
 7.346 \\
 1.320 \text{ TOP POCKET} \\
 \hline
 + 7.666 \text{ HI}
 \end{array}$$

$$\begin{array}{r}
 14.862 \text{ REF.} \\
 7.666 \text{ HI} \\
 \hline
 7.196 \text{ E} \\
 3.825 \\
 \hline
 - 3.371 \text{ HF for 7,8}
 \end{array}$$

$$\begin{array}{r}
 1) 4.458 \\
 1.000 \\
 \hline
 5.458 \\
 7.666 \\
 \hline
 +2.208
 \end{array}$$

$$\begin{array}{r}
 2) 4.457 \\
 1.000 \\
 \hline
 5.457 \\
 7.666 \\
 \hline
 +2.209
 \end{array}$$

$$\begin{array}{r}
 3) 4.480 \\
 1.000 \\
 \hline
 5.480 \\
 7.666 \\
 \hline
 +2.186
 \end{array}$$

$$\begin{array}{r}
 4) 4.457 \\
 1.000 \\
 \hline
 5.457 \\
 7.666 \\
 \hline
 +2.209
 \end{array}$$

$$\begin{array}{r}
 5) 4.467 \\
 1.000 \\
 \hline
 5.467 \\
 7.666 \\
 \hline
 +2.199
 \end{array}$$

$$\begin{array}{r}
 6) 4.448 \\
 1.000 \\
 \hline
 5.448 \\
 7.666 \\
 \hline
 +2.218
 \end{array}$$

* SHORT SHANK *

SEE NOTE ON
"X" SHEET

$$\begin{array}{r}
 7) .932 \\
 .250 \\
 \hline
 1.182 \\
 3.371 \\
 \hline
 -2.189
 \end{array}$$

$$\begin{array}{r}
 8) .932 \\
 .250 \\
 \hline
 1.182 \\
 3.371 \\
 \hline
 -2.189
 \end{array}$$

check on

SSRL
I D S VACUUM CHAMBER
LAB DATA

10-17-05
J.M., L.G.

(7)

$$\begin{array}{r}
 \text{U/S FACE) } 10.861 \\
 \quad 48.785 \frac{1}{2} \text{ CH.} \\
 - \quad 59.646 \text{ LOS} \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 1) \quad 6.034 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 14.591 \\
 59.646 \\
 \hline
 \end{array}$$

$$-45.055$$

$$\begin{array}{r}
 3) \quad 8.718 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 17.275 \\
 59.646 \\
 \hline
 \end{array}$$

$$-42.371$$

$$\begin{array}{r}
 5) \quad 6.032 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 14.589 \\
 59.646 \\
 \hline
 \end{array}$$

$$-45.057$$

$$\begin{array}{r}
 \text{D/S FACE) } 12.915 \\
 \quad 48.785 \frac{1}{2} \text{ CH} \\
 + \quad 61.700 \text{ LOS} \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 2) \quad 8.076 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 16.633 \\
 61.700 \\
 \hline
 \end{array}$$

$$+45.067$$

$$\begin{array}{r}
 4) \quad 8.080 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 16.637 \\
 61.700 \\
 \hline
 \end{array}$$

$$+45.063$$

$$\begin{array}{r}
 6) \quad 9.322 \\
 \quad 8.557 \\
 \hline
 \end{array}$$

$$\begin{array}{r}
 17.879 \\
 61.700 \\
 \hline
 \end{array}$$

$$+43.821$$

SEE NOTE ON
"X" SHEET

SSRL
 IDS VAL. CHAM.
FLANGES

10-17-15
 J.M., LIC.

check
 2/11

① +7.666 HI

Ø9.965

$$\begin{array}{r}
 u/s) \quad 7.666 \\
 \quad 4.983 \\
 \hline
 \quad 2.683 \text{ s/r} \\
 \quad 2.660 \\
 \hline
 \boxed{+0.023}
 \end{array}$$

$$\begin{array}{r}
 d/s) \quad 7.666 \\
 \quad 4.983 \\
 \hline
 \quad 2.683 \text{ s/r} \\
 \quad 2.676 \\
 \hline
 \boxed{-0.007}
 \end{array}$$

② -26.384 LOS

$$\begin{array}{r}
 u/s) \quad 26.384 \\
 \quad 4.983 \\
 \hline
 \quad 21.401 \text{ s/r} \\
 \quad 21.386 \\
 \hline
 \boxed{-0.015}
 \end{array}$$

$$\begin{array}{r}
 d/s) \quad 21.401 \text{ s/r} \\
 \quad 21.386 \\
 \hline
 \boxed{-0.015}
 \end{array}$$

③ +7.666 HI

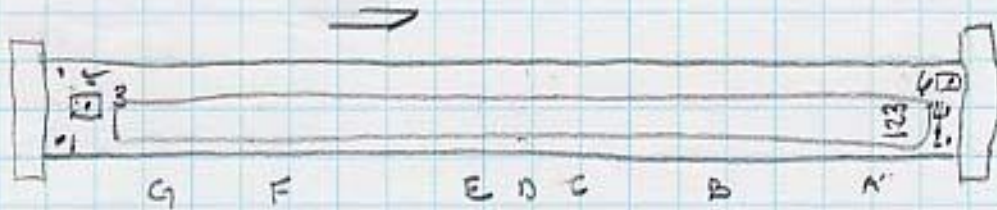
4 CORNERS

<u>u/s</u>		<u>d/s</u> (1.2)	
(+) 6.466	(-) 6.460	(+) 6.452	(-) 6.461
7.666	7.666	7.666	7.666
$\boxed{+1.200}$	$\boxed{+1.206}$	$\boxed{+1.214}$	$\boxed{+1.205}$
0	+0.006	+0.014	+0.005

I D 5 VACUUM CHAMBER

10-17-05
J.M., L.G.

CLEAN ROOM



LEVELLED TO A1, A3 & G2

A	
1	6.346
2	6.346
3	6.346

B		C	
6.356	-10	6.360	-14
6.354	-8	6.358	-12
6.352	-6	6.358	-12

D	
6.362	-16
6.358	-12
6.358	-12

E	
1.	6.361 -15
2.	6.360 -14
3.	6.359 -13

F	
6.358	-12
6.356	-10
6.356	-10

G	
6.344	0
6.347	-1
6.351	-5

14.862 REF. BLADE

$$\begin{array}{r} 14.862 \\ - 7.666 \\ \hline 7.196 = \Delta \\ - 4.100 \\ \hline -3.096 \text{ HI} \end{array}$$

$$\begin{array}{r} -3.096 \\ + .320 \\ \hline 2.776 \\ + 1.000 \\ \hline 1.776 \text{ S/R} \end{array}$$

$$\begin{array}{r} 6.346 \\ + .320 \text{ to BL} \\ \hline 6.666 \text{ HI} \\ + 1.000 \\ \hline 7.666 \text{ HI} \\ \text{Y} \end{array}$$

+ .32 FLAT
.230 ELL

#2's

A	1.770	-6
B	1.755	-21
C	1.747	-29
D	1.747	-29
E	1.747	-29
F	1.757	-19
G	1.771	-5

$$\begin{array}{r} \text{u/s END} \\ 7.196 \Delta \\ + .230 \\ \hline 7.426 \text{ TO TOP} \\ + .003 \end{array}$$

$$\begin{array}{r} 7.196 \Delta \\ + .230 \\ \hline 6.966 \text{ TO BOT.} \\ + .001 \end{array}$$

-001 TOP

Bot

Station:	TPBL5C	Difference units =		Inches	
Operator:	FG	Gopher #1:	LG	Gopher #2:	none
SC12ID21	0.07544	0.00013	-0.00146	DR	
SC12ID22	-0.01700	-0.00573	0.00238	DR	
SC12ID23	0.00000	0.00000	0.00000		
SC12ID24	-0.01437	-0.00726	0.00269	DR	
SC12ID25	0.00280	-0.00566	2.99515	DR	
SC12ID2M	43.80957	4.19563	2.20482	DR	
SC12ID2M	-35.97189	0.36581	1.04687		
SC12ID2M	-0.01181	0.20031	1.02799		
SC12ID2M	0.02991	0.25733	1.02469		

SPEAR 3

TB6 ON CHAMBER

BL 5 WIGGLER

Final As Built PostionsDate: 11-08-2005

Time: 15:26

Station:	TPRLSD	Difference units =		Inches
Operator:	PG	Gopher #1:	MP Gopher #2:	none
SC12ID21	0.06854	-0.00138	0.00901	DR
SC12ID22	-0.02409	-0.00628	0.00647	DR
SC12ID24	-0.01645	0.00246	0.00776	DR
SC12ID25	0.07461	-0.01389	3.00693	DR
SC12ID2M	-0.03161	0.33023	1.04666	
SC12ID2M	0.00000	0.00000	0.00000	
SC12ID2M	0.00000	0.00000	0.00000	
SC12ID2M	0.00000	0.00000	0.00000	
SC12ID2M	0.00000	0.00000	0.00000	

SPEAR3
FINAL CHAMBER POSITION
POL 5