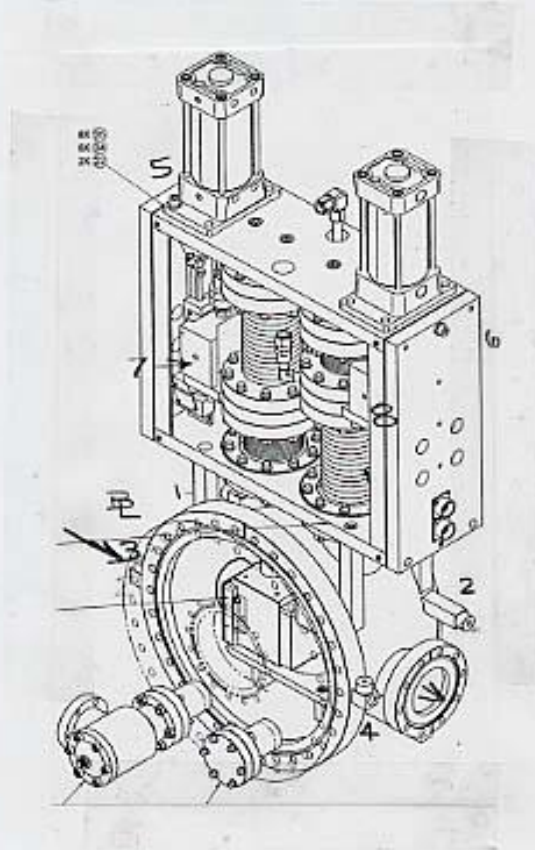


SSRL B/L 7-1
 HUTCH STOPPER

DATE 6/13/05
 CREW MR JME



$X + Y = 0$ = ϕ OF ENTRANCE + EXIT FLANGE

	X	Y	Z (TAPED)
1	+2.185 ✓	+2.835 ✓	-8.780 ✓
2	+2.191 ✓	+2.858 ✓	+8.780 ✓
3	-3.841 ✓	+3.387 ✓	-7.050 ✓
4	-3.790 ✓	+3.378 ✓	+7.050 ✓
5	+3.017 ✓	+13.668 ✓	—
6	+2.962 ✓	+13.668 ✓	—
7	-2.988 ✓	+13.688 ✓	—
8	-3.043 ✓	+13.671 ✓	—

5-8 VALUES ARE DOWN
 POSITION

SSRLB/L7-1
HUTCH STOPPER

6/13/05
MR JMC

check
Jm

Y) SETTING STOPPERS IN Y

5.499 H.I.

14.229 READ

8.730 ♀ READING

1.625 1/2 BLOCK

7.105 S/R BOTT BLOCK

4/5 BLOCK

7.105

7.105 ♂

D/5 BLOCK

7.105

7.105 ♂

READ TOP TOOLING BALLS FOR Y TRAVEL

W/S		D/S	
IN	OUT	IN	OUT
5082	2071	5.105	2094
<u>1</u>	<u>1</u>	<u>1</u>	<u>1</u>
6082	3071	6.105	3094
19.783	19.783	19.783	19.783
+13.701	+16.712	+13.678	+16.689
3.011 TRAVEL		3.011 TRAVEL	

28.513 READ
8.730 ♀ READ
19.783 H.I.

3) 19.783
13.387
16.396
1
15.396

Z) TAPED FROM CENTER TANK

- 1) **-8.780** 2) **+8.780** 3) **-7.050** 4) **+7.050**

950906-0

SSRL B/L 7-1 HUTCH STOPPER

6/13/05
MR JMS

Check JM

Y) 4.626 DIA 2.313
 3.186 READ
 2.313 DIA
 5.499 H.I.
 (X + Y \square = ENTRANCE & EXIT FLANGES)

1) 1.664
 1
 2.664
 5.499
 +2.835

2) 1.641
 1
 2.641
 5.499
 +2.858

3) 1.112
 1
 2.112
 5.499
 +3.387

4) 1.121
 1
 2.121
 5.499
 +3.378

X)

F 2.313
 N 2.313
 1F 5.000 19.194 = 24.194
 1N 5.170 19.194 = 24.364
 2F 10.000 19.194 = 29.194
 2N 9.419 19.194 = 28.613
 25.326 6.132
 25.326 6.132
 -27.639 LOS

DOWN POSITION OF UPPER TRAVEL BLOCKS
 U/S 24.643 D/S 24.592

UP POSITION OF UPPER TRAVEL BLOCKS
 U/S 24.653 D/S 24.592

FACE OF FLANGE (FOR ROLL)

TOP	BOTTOM
23.258	23.258

U/S BLOCK (Roll of Block) For Foot Also		D/S BLOCK	
TOP 24.995 (2625)	-0.19	TOP 24.979	-0.35
BOT 24.993	-0.21	BOT 24.987	-0.27

SSRLB/L7-1
HUTCH STOPPER

6/13/05
MR JME
check
✓

X) YAW OF BLOCKS IN THE IN (DOWN) POSITION
(ONLY 4 BOLTS TIGHT)

U/S +Z(U/S) 27.639 <u>1.625</u> 26.014 S/R <u>25.964</u> -0.50 26.023 +009	-Z(U/S) 26.014 S/R <u>25.979</u> -0.35 26.000 -014	D/S +Z(D/S) - Z(U/S) 26.014 S/R <u>25.954</u> -0.60 25.993 -0.21 ^S 26.000 ⁻⁰¹⁶ -14	26.014 S/R <u>25.982</u> -0.32 26.003 ⁰ -0.14 25.994 -20
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ROLL OF BLOCKS IN THE IN (DOWN) POSITION

U/S BLOCK		D/S BLOCK	
TOP	BOTT	TOP	BOTT
27.639 <u>1.625</u> 26.014 <u>1</u> 25.014	25.014 <u>24.978</u> -0.36	25.014 <u>24.979</u> -0.36	25.014 <u>24.988</u> -0.26
24.984 <u>24.984</u> -0.30			

TOOLING BALLS

1) 28.824 <u>1</u> 29.824 27.639 <u>+2.185</u>	2) 28.830 <u>1</u> 29.830 27.639 <u>+2.191</u>	3) 22.798 <u>1</u> 23.798 27.639 <u>-3.841</u>	4) 22.849 <u>1</u> 23.849 27.639 <u>-3.790</u>
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check
SA

SSRL B/L 7-1 HUTCH STOPPER

6/15/05
MR JMS

VALUES OF BLOCKS IN DOWN POSITION

$$\begin{array}{r} 4) \quad 1.743 \\ \quad \underline{1} \\ \quad 2.743 \\ \quad \underline{3.378} \\ \quad 6.121 \end{array}$$

$$\begin{array}{r} 3) \quad 1.734 \\ \quad \underline{1} \\ \quad 2.734 \\ \quad \underline{3.387} \\ \quad 6.121 \end{array}$$

$$\begin{array}{r} 1) \quad 2.286 \\ \quad \underline{1} \\ \quad 3.286 \\ \quad \underline{2.835} \\ \quad 6.121 \end{array}$$

$$\begin{array}{r} 14.833 \\ \quad \underline{6.121} \\ \quad 8.712 \\ \quad \underline{28.143} \\ \quad 19.431 \text{ H.I.} \end{array}$$

$$\begin{array}{r} 5) \quad 4.763 \\ \quad \underline{1} \\ \quad 5.763 \\ \quad \underline{19.431} \\ \quad \boxed{+13.668} \end{array}$$

$$\begin{array}{r} 6) \quad 4.763 \\ \quad \underline{1} \\ \quad 5.763 \\ \quad \underline{19.431} \\ \quad \boxed{+13.668} \end{array}$$

$$\begin{array}{r} 7) \quad 4.743 \\ \quad \underline{1} \\ \quad 5.743 \\ \quad \underline{19.431} \\ \quad \boxed{+13.688} \end{array}$$

$$\begin{array}{r} 8) \quad 4.760 \\ \quad \underline{1} \\ \quad 5.760 \\ \quad \underline{19.431} \\ \quad \boxed{+13.671} \end{array}$$

$$\begin{array}{l} -3.790 \\ -3.841 \\ 26,000 + 1 = 27,000 \\ 25,260 + 1 = 26,260 \\ 21,000 + 1 = 22,000 \\ 20,917 + 1 = 21,917 \\ 21,756 - 1 = 20,756 \\ 21,705 - 1 = 20,705 \\ 25,546 \end{array}$$

$$\begin{array}{r} 7) \quad 21.558 \\ \quad \underline{1} \\ \quad 22.558 \\ \quad \underline{25.546} \\ \quad \boxed{-2.988} \end{array}$$

$$\begin{array}{r} 8) \quad 21.503 \\ \quad \underline{1} \\ \quad 22.503 \\ \quad \underline{25.546} \\ \quad \boxed{-3.043} \end{array}$$

$$\begin{array}{r} 5) 7 \quad 6.505 \\ \quad \underline{500} \\ \quad 6.005 \\ \quad \underline{2.988} \\ \quad \boxed{+3.017} \end{array}$$

$$\begin{array}{r} 6) 8 \quad 6.505 \\ \quad \underline{500} \\ \quad 6.005 \\ \quad \underline{-3.043} \\ \quad \boxed{+2.962} \end{array}$$