

Fid. Data Summary for 145D-2 Rafts

145D-55

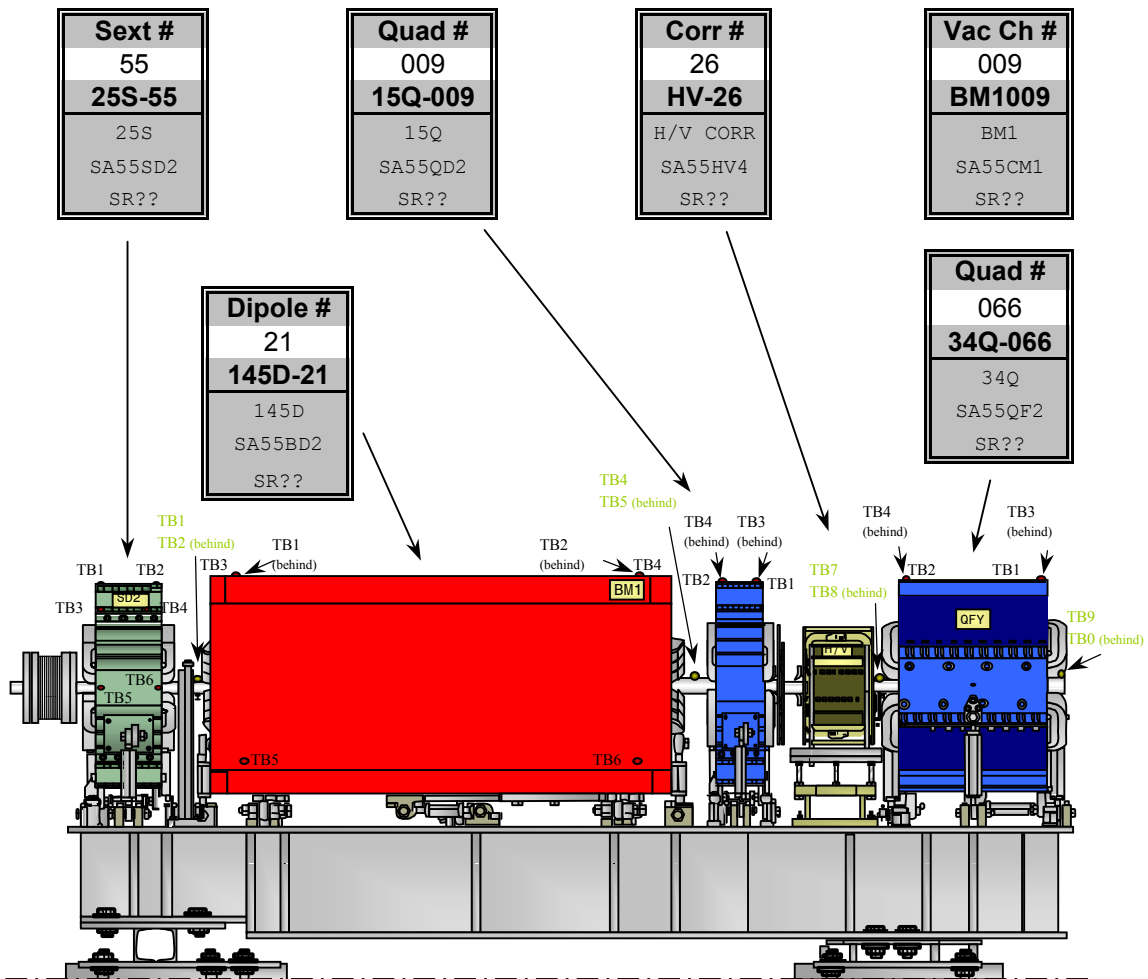
Raft Description:

Date April 18, 2002

Raft # 55 145D-55	Type 2 145D T-2	Bld. 750 Name SA55	S3 Ring Name SR??
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Notes:

The above date represents the latest fiducial date of all components listed below.
 Chamber As-Built show TRUE position after correcting for INSIGHT / NAM error.



Sextupole: Fiducial Values for 25S Sextupole

Fiducial	Z	X	Y
TB1	-4.316	4.250	15.510
TB2	4.333	4.200	15.509
TB3	-4.417	-10.551	12.506
TB4	3.439	-10.522	12.527
TB5	-4.504	-15.063	0.019
TB6	4.589	-15.061	0.048

inches inches inches

Use Index Flats on Six Poles Each End to Establish z=0.

Weld 2 1.5 inch Target Mounts

Weld 2 Standard Target Mounts on "Full" Ears

Weld 2 Standard Target Mounts

25S Length = 210 mm=8.3 inch

25S Length = 250 mm=9.8 inch

SEXTUPOLE

25S-55

SA55SD2
SR??

7/9/01

Description:
Fiducials based on values posted on web-page. (Check for updates.)

Gradient Dipole: Fiducial Values for Dipole (145D)

Fiducial	Z	X	Y
TB1	-26.556	3.434	16.999
TB2	26.539	3.448	16.998
TB3	-26.569	-22.417	16.995
TB4	26.534	-22.420	16.998
TB5	-26.539	-24.253	-11.356
TB6	26.439	-24.272	-11.656

inches inches inches

Weld 4 Target Mounts Outside of y-graves

1590 Overall Length = 140.9 inch

1550 Overall Length = 121.7 inch

4 inches Typical 4 Places

Weld 2 Target Mounts

4 inches Typical 2 Places

End Plate Thickness = 2 inch

GRADIENT DIPOLE

145D-21

SA55BD2
SR??

9/26/01

Description:
Fiducials based on values posted on web-page. (Check for updates.)

Quadrupole: Fiducial Values for Upstream (15Q) Quadrupole

Fiducial	Z	X	Y
TB1	-2.565	11.263	16.207
TB2	2.577	11.257	16.202
TB3	-2.574	-11.250	16.206
TB4	2.567	-11.244	16.200
TB5	-1.546	-15.205	-4.748
TB6	2.372	-15.201	-4.836

inches inches inches

Weld 4 Target Mounts Outside of "V" grooves
 Manifolds on Aisle Side Weld 2 Target Mounts on "Full" Ears
 15Q Length = 150 mm = 5.9 inch
 31Q Length = 310 mm = 12.4 inch
 RH Coordinates
 Index Flats
 Chamfers
 Face -A-
 Use Index Flats

QUADRUPOLE
15Q-009

SA55QD2
SR??

6/14/01

Description:
Fiducials based on values posted on web-page. (Check for updates.)

H/V Corrector: Fiducial Values for Corrector

Fiducial	Z	X	Y
1	-0.003	-0.323	-10.196
2	-0.002	-10.046	-10.205
A	0.000	-20.003	0.000
B	0.000	-20.003	0.000
C	0.000	-20.003	0.000
D	0.000	-20.003	0.000
E	0.000	0.000	17.935
F	0.000	0.000	17.935

inches inches inches

H/V CORRECTOR
HV-26

SA55HV4
SR??

No Date

Description:
Fiducials based on known nominal values.

Quadrupole: Fiducial Values for Downstream (34Q) Quadrupole

Fiducial	Z	X	Y
TB1	-6.315	11.247	16.202
TB2	6.314	11.250	16.201
TB3	-6.322	-11.247	16.203
TB4	6.263	-11.240	16.211
TB5	-5.177	-15.202	-4.968
TB6	4.612	-15.206	-4.929

inches inches inches

SA55QF2
SR??

8/22/01

Description:
Fiducials based on values posted on web-page. (Check for updates.)

Vacuum Chamber: Fiducial Values for BM1 Vacuum Chamber

Fiducial	Z	X	Y
TB1	-34.874	1.527	4.351
TB2	-34.823	8.407	4.375
TB3	11.000	4.155	2.342
TB4	34.550	-4.952	4.367
TB5	36.599	6.165	4.364
TB6	52.473	-1.892	2.298
TB7	55.681	-11.179	3.043
TB8	59.436	8.940	3.031
TB9	74.659	-20.306	4.382
TB0	76.955	-8.249	4.393

inches inches inches

SA55CM1
SR??

4/18/02

Description:
Fiducials based on values posted on web-page. (Check for updates.)

Building 750 Deck: Positions of Component Origins

750 Name	Z	X	Y	Yaw
SA55SD2	1.367	0.000	0.000	0.0000
SA55CM1	2.450	0.000	0.000	0.0000
SA55BD2	2.447	-0.034	0.000	-5.2941
SA55QD2	3.485	-0.194	0.000	-10.5882
SA55QF2	4.114	-0.311	0.000	-10.5882
	meters	meters	meters	degrees

Date of Deck File: September 9, 2002

145D-55

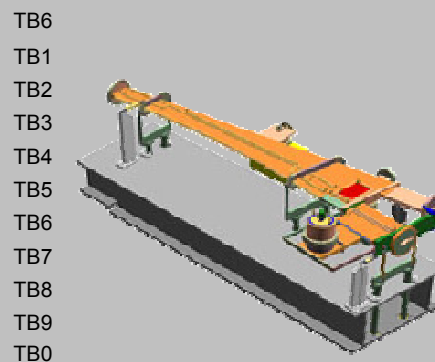
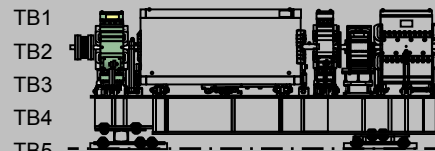
Location of Raft: EAST

Description:

Deck coordinates representing origin of the specific component's coordinate system.

Building 750 As-Built: (TABLE 1 of 2)

750 Name	delta Z	delta X	delta Y (delta H)
SA55SD2	-0.001	0.002	0.002
	-0.003	-0.002	0.004
	-0.002	0.005	0.000
	-0.002	0.003	0.002
	0.002	0.002	-0.002
	-0.001	0.001	0.001
SA55CM1	-0.006	0.004	-0.002
	-0.004	0.000	0.000
	missing	missing	missing
	0.000	-0.005	0.003
	-0.003	-0.006	0.007
	-0.005	-0.005	-0.009
	-0.007	-0.008	-0.009
	-0.003	-0.007	-0.008
	-0.007	0.012	0.001
	-0.023	0.012	0.010
	inches	inches	inches



Latest File Date: September 26, 2002

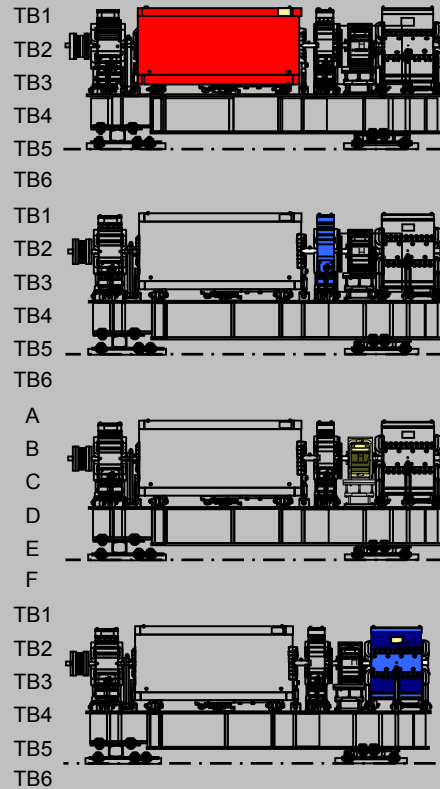
145D-55

Description:

Values representing the difference between the design and actual fiducial measurements.

Building 750 As-Built: (TABLE 2 of 2)

750 Name	delta Z	delta X	delta Y (delta H)
SA55BD2	-0.008	-0.005	-0.003
	-0.010	-0.001	-0.003
	-0.006	-0.001	-0.001
	-0.007	0.004	-0.001
	-0.005	-0.002	-0.001
	-0.006	0.001	0.000
SA55QD2	0.013	-0.004	0.000
	0.013	-0.002	-0.002
	-0.005	0.004	0.000
	-0.013	-0.003	0.000
	-0.030	-3.001	0.005
	-0.030	-0.005	-0.001
SA55HV4		-0.003	
		-0.002	
		0.001	
		-0.007	
			0.006
SA55QF2			0.008
	0.003	0.004	0.001
	0.001	0.003	0.000
	-0.004	-0.002	0.002
	-0.005	-0.004	-0.001
	-0.005	0.001	-0.002
	0.000	0.000	
	inches	inches	inches



Latest File Date: September 26, 2002

145D-55

Description:

Values representing the difference between the design and actual fiducial measurements.