

Fiducials for BM2 Std. Vac. Chamber

BM2009

Date:

10/31/02

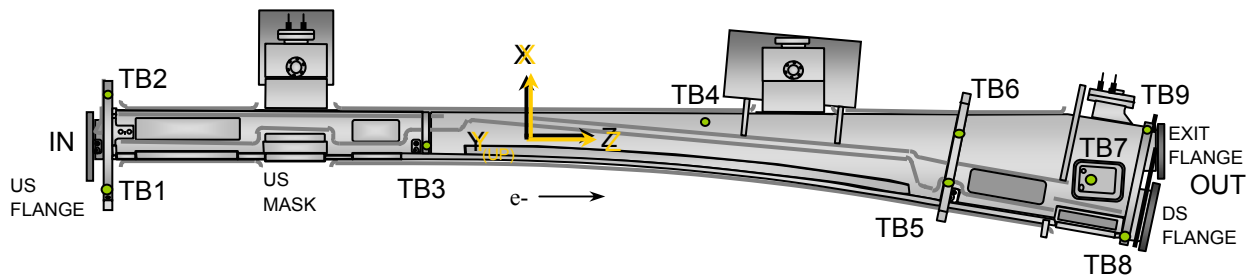
Chamber:

BM2009

Operator(s):

M. Gaydosh
H. Imfeld

Notes:



Fiducial Coordinates for BM2 Standard Vacuum Chamber: (inches)

Fiducial	Z	X	Y
TB1	-77.160	-6.218	4.371
TB2	-77.252	7.283	4.382
TB3	-34.863	0.074	4.371
TB4	-0.666	4.029	2.397
TB5	34.499	-4.629	4.388
TB6	35.801	2.552	4.392
TB7	53.850	-4.279	2.419
TB8	58.006	-12.527	2.929
TB9	60.945	3.045	2.955

Nominal Deltas For H1 Absorber (TB7)		
Z	X	Y
53.850	-4.279	2.419
53.933	-4.302	2.408
-0.083	0.023	0.011

inches inches inches

Source

FINAL

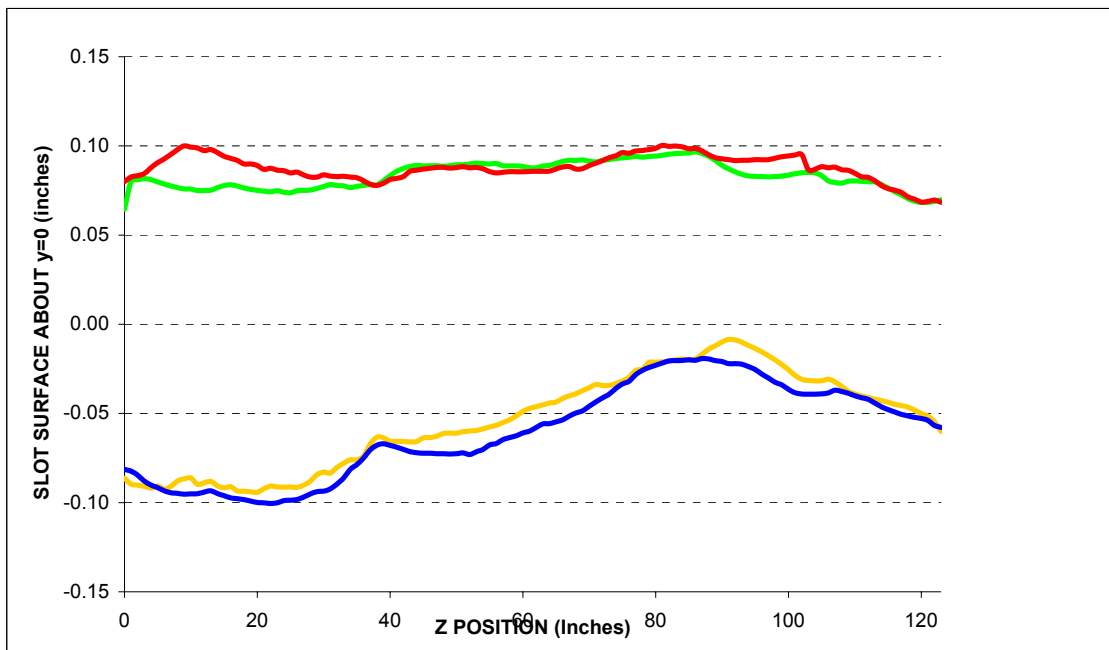
Description:

Fiducial vals based on established chamber datum. Source="Final" indicates final data.

Fiducialization Step: (Traveler Step # 1380)

Slot Calibration	
Ideal	0.511
Meas.	
Delta	-----

Inverted Mouse Slot Calibration	
Ideal	0.511
Meas.	
Delta	-----



BM2009

Step 1: Heights for BM2 Std. Vac. Chamber

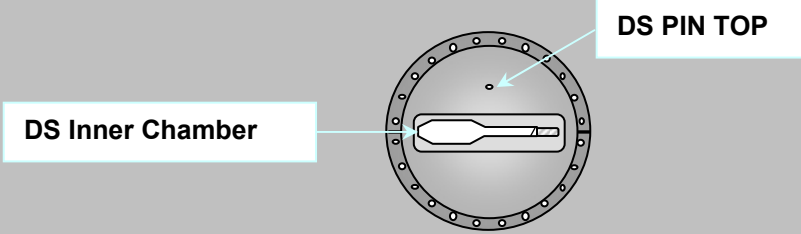
Fiducial	Y
TB1	4.371
TB2	4.383
TB3	4.370
TB4	2.386
TB5	4.388
TB6	4.392

inches

Description:
 Fiducial heights of the six tooling balls are based on leveled datum as defined by outside surface measurements. (L1 through L5)

DS Flange Position

Step 3: DownStream Flange Postion



DS PIN TOP	Z	X	Y
Measured	62.744	1.807	2.278
Nominal	62.859	1.836	2.282
Difference (inches)	-0.115	-0.029	-0.004

DS Inner Chamber	Z	X	Y
Measured	N/A	-1.430	0.000
Nominal	N/A	-1.404	0.000
Difference (inches)	N/A	-0.026	0.000

DS Flange Position	Plane	From Circle Fit	
	Z	X	Y
Measured	63.277	1.823	-0.007
Nominal	63.393	1.836	0.000
Difference (inches)	-0.116	-0.013	-0.007
	inches	inches	inches

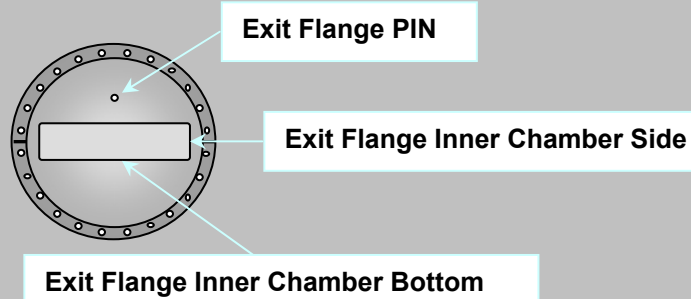
DS Flange Attitude		
	yaw	pitch
Measured	-7.0	-4.8
Nominal	0.0	0.0
Difference	-7.0	-4.8
	mrad	mrad

DS Flange Diameter	
	DIA
Measured	11.472
Nominal	11.500
Difference	-0.028
	inches

Description:
 Meas. vs. nom. values for DS flange expressed in a ROTATED FRAME FINAL coordinate system (10.5882°). Tol +/- 10mils and +/- 3 mrad. Values in **BOLD** or **RED** are most critical.

Exit Port Flange Position (DownStream)

Step 3: DownStream EXIT PORT Flange Position



EXIT FLANGE PIN	Z	X	Y
Measured	63.318	0.010	1.808
Nominal	63.422	0.000	1.782
Difference (inches)	-0.104	0.010	0.026

EXIT FLANGE Inner Chamber Side	Z	X	Y
Measured	N/A	2.458	0.071
Nominal	N/A	2.453	0.000
Difference (inches)	N/A	0.005	0.071

EXIT FLANGE Inner Chamber Bottom	Z	X	Y
Measured	N/A	0.143	-0.196
Nominal	N/A	0.000	-0.219
Difference (inches)	N/A	0.143	0.023

EXIT Flange Position	Plane	From Circle Fit	
	Z	X	Y
Measured	63.878	0.007	0.017
Nominal	63.956	0.000	0.000
Difference (inches)	-0.078	0.007	0.017
	inches	inches	inches

EXIT FLANGE Attitude		
	yaw	pitch
Measured	-0.2	-12.0
Nominal	0.0	0.0
Difference	-0.2	-12.0
	mrاد	mrاد

EXIT FLANGE Diameter	
	DIA
Measured	9.479
Nominal	9.500
Difference	-0.021
	inches

Description:

Meas. vs. nom. values for exit flange expressed in the FRAME FINAL coordinate system.
 Tol +/- 10mils and +/- 3 mrad. Values in **BOLD** or **RED** are most critical.

Final Fiducial Coordinates for BM2 Standard Vacuum Chamber

Final: Fiducial Coordinates for BM2 Std. Vac. Chamber

Fiducial	Z	X	Y
TB1	-77.160	-6.218	4.371
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inches inches inches

Description:
Fiducial values based on established chamber datum.

