



Jefferson Lab Alignment Group

Data Transmittal

TO: J. Preble, J. Hogan

DATE : Nov. 4, 2003

FROM: J. Dahlberg

Checked:

Z901

DETAILS:

Below are the results of the recent survey performed on the cryomodule assembly room control points. The values are estimated to be accurate to 0.05 millimeters. Note that the measured distances below are as much as 0.45 mm larger than the ideal distance of 1854.20 mm. This error would directly effect the alignment between two flanges if measured from opposite sides of the cryomodule.

If necessary, adjustments can be made to the control points to place them parallel and at the correct distance from the cryomodule support rails. The supports for the line scopes can also be adjusted so that the lines of sight are centered on the far targets. All points can be placed within 0.05 mm from ideal and the line scopes can be aligned to 1 arc second. This survey would take approximately two and a half days for each assembly bay.

NW corner TH2-TH3	1854.40
SW corner TH1-TH4	1854.65
NE corner TH6-TH7	1854.58
SE corner TH5-TH8	1854.65