

Fiducials for BM2 Std. Vac. Chamber

BM2008

Date:

11/13/02

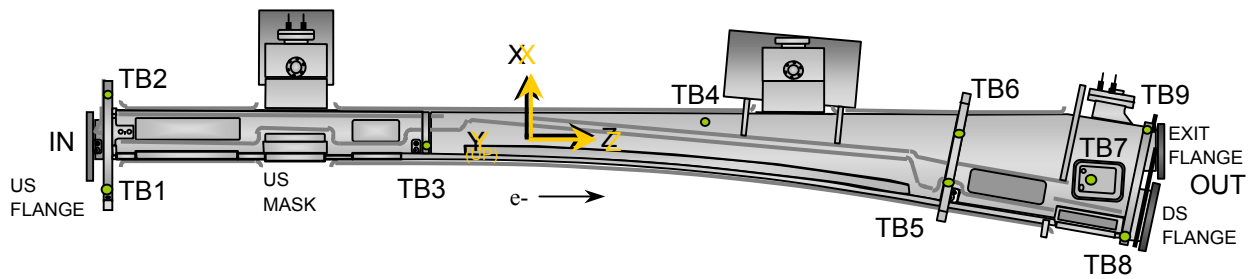
Chamber:

BM2008

Operator(s):

F. Gaudreault
L. Griffin

Notes:



Fiducial Coordinates for BM2 Standard Vacuum Chamber: (inches)

Fiducial	Z	X	Y
TB1			
TB2			
TB3			
TB4			
TB5			
TB6			
TB7	53.910	-4.301	0.000
TB8			
TB9			

Nominal Deltas For H1 Absorber (TB7)		
Z	X	Y
53.910	-4.301	0.000
-----	-----	-----

Y?

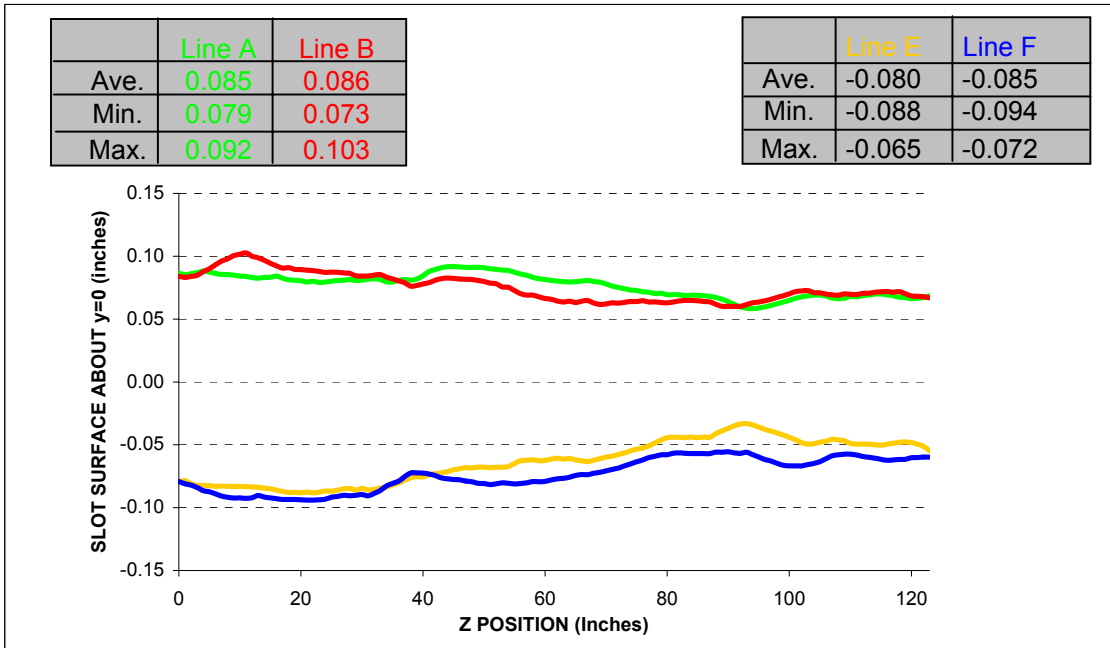
inches inches inches Source Heights

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	-----

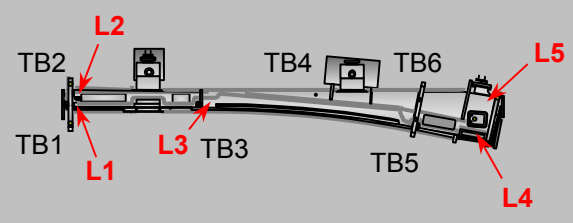
Inverted Mouse Slot Calibration	
Ideal	0.511
Meas.	
Delta	-----



Step 1: Heights for BM2 Std. Vac. Chamber

Fiducial	Y
TB1	4.383
TB2	4.378
TB3	4.380
TB4	2.373
TB5	4.377
TB6	4.381

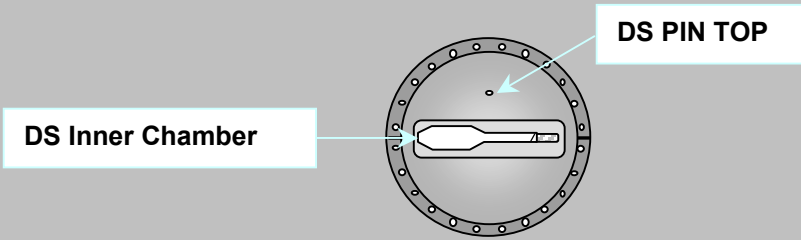
inches



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			
Nominal	62.859	1.836	2.282
Difference (inches)	-----	-----	-----

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

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

DS Flange Attitude		
	yaw	pitch
Measured		
Nominal	0.0	0.0
Difference		
	mrad	mrad

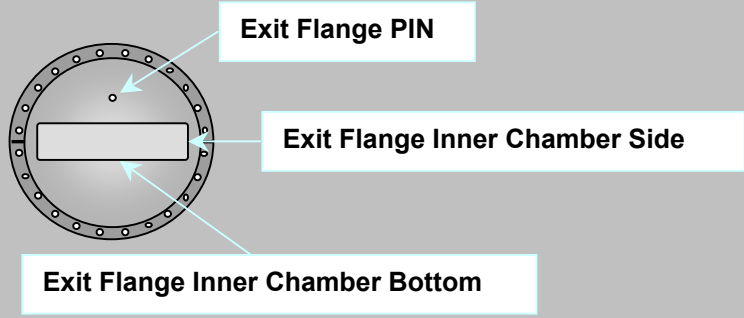
DS Flange Diameter	
	DIA
Measured	
Nominal	11.500
Difference	
	inches

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			
Nominal	63.422	0.000	1.782
Difference (inches)	-----	-----	-----

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

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

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

EXIT FLANGE Attitude		
	yaw	pitch
Measured		
Nominal	0.0	0.0
Difference		
	mrاد	mrاد

EXIT FLANGE Diameter	
	DIA
Measured	
Nominal	9.500
Difference	
	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			
TB2			
TB3			
TB4			
TB5			
TB6			
TB7			
TB8			
TB9			

inches inches inches

Description:
Fiducial values based on established chamber datum.

