

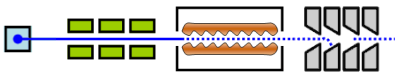
The Front End Test Stand Collaboration – FETS –

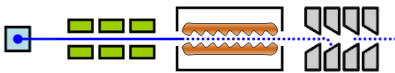
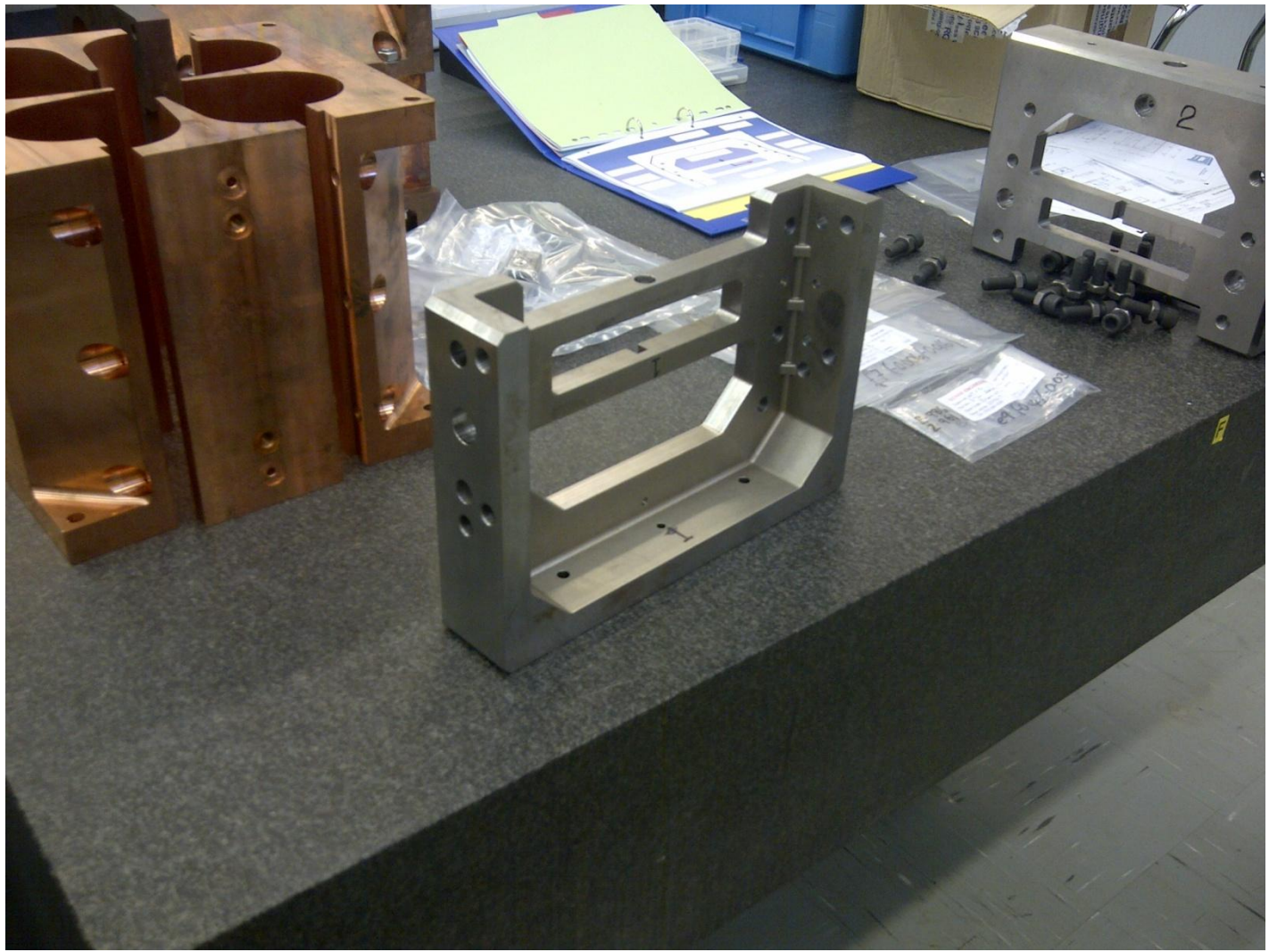
RFQ ALIGNMENT JIG – INSPECTION & METROLOGY

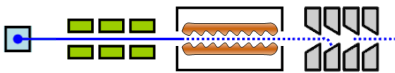
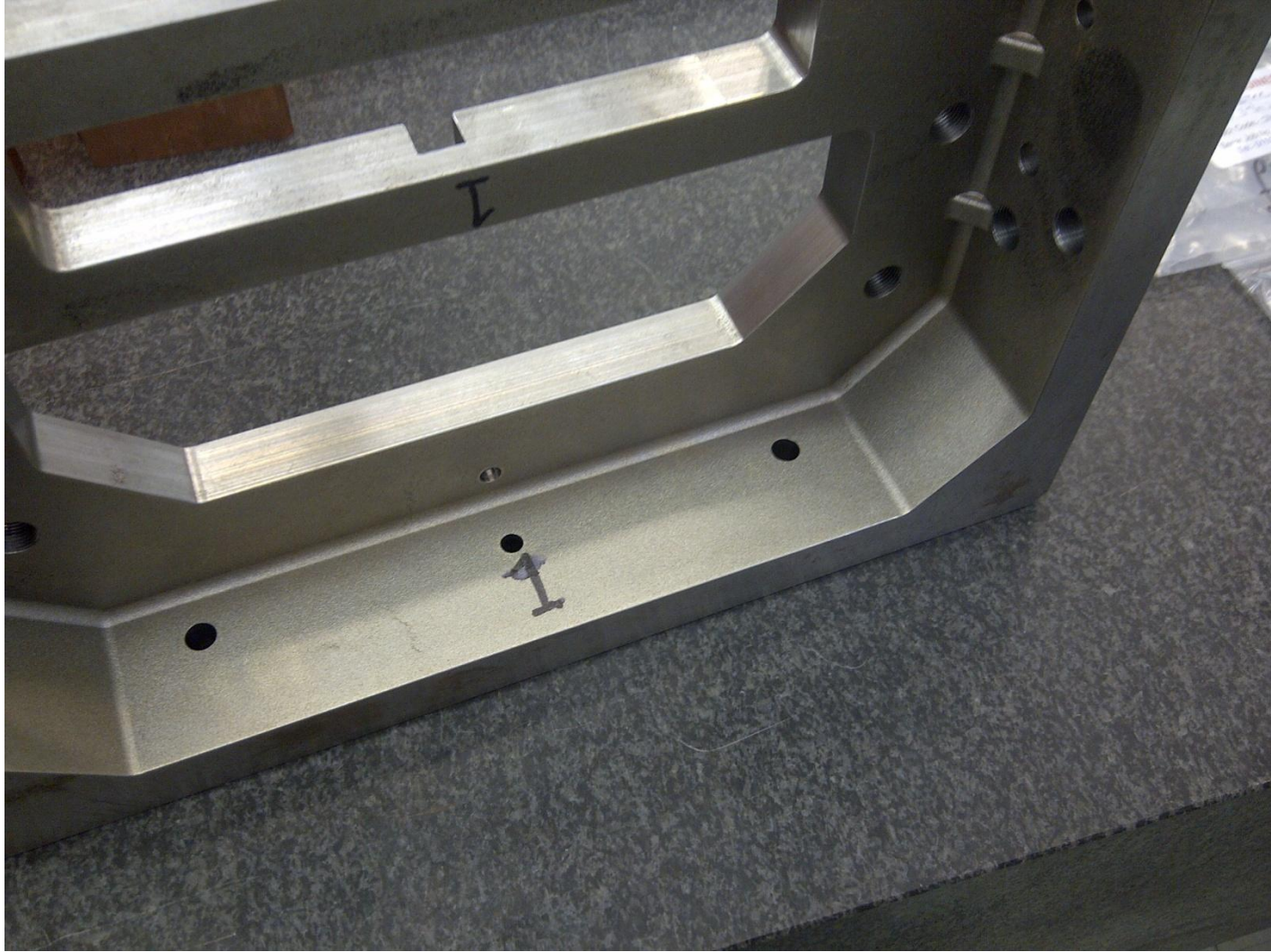
25th June 2012



PROGRESS

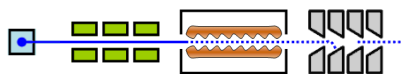


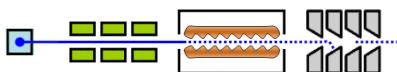
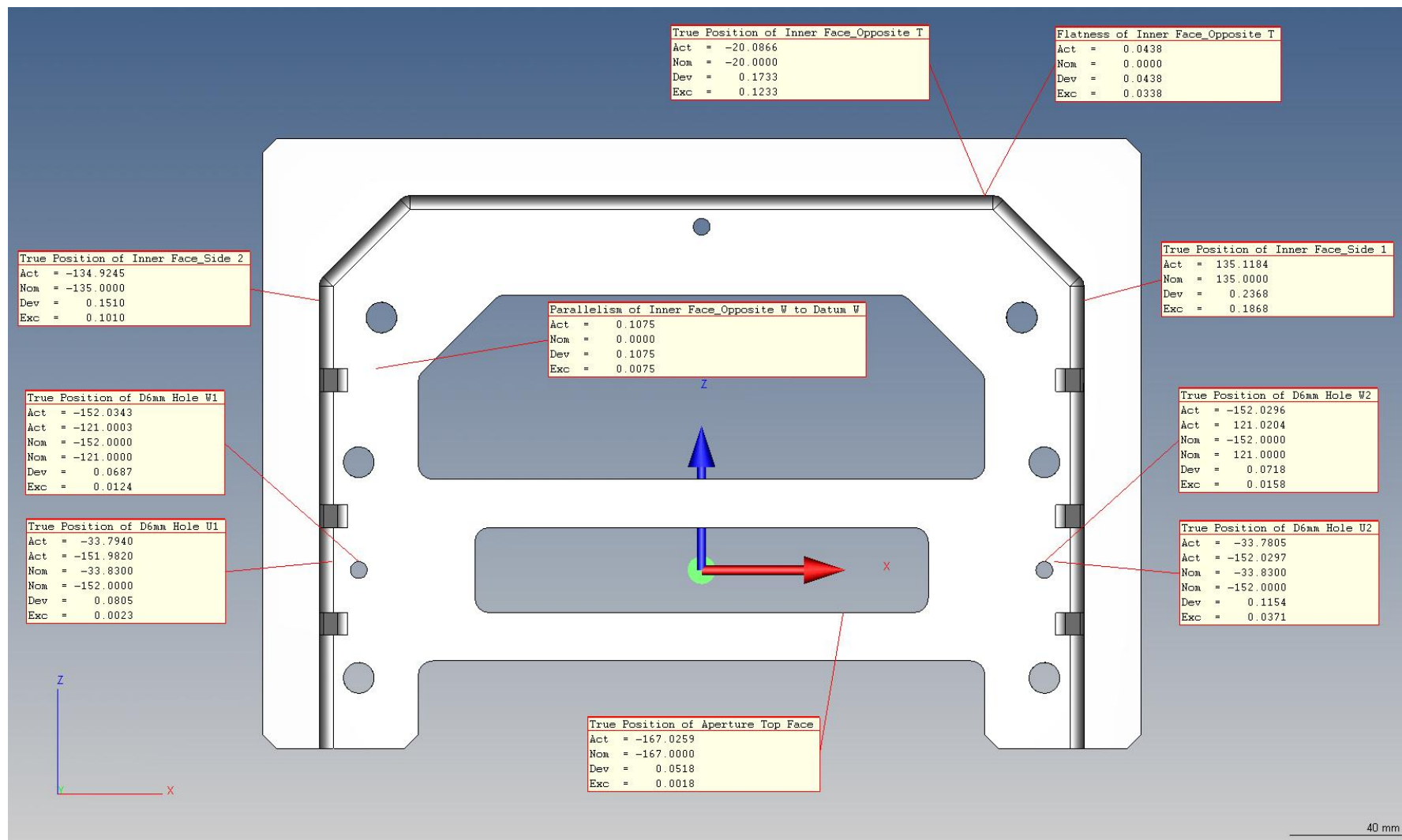


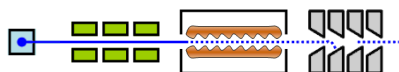
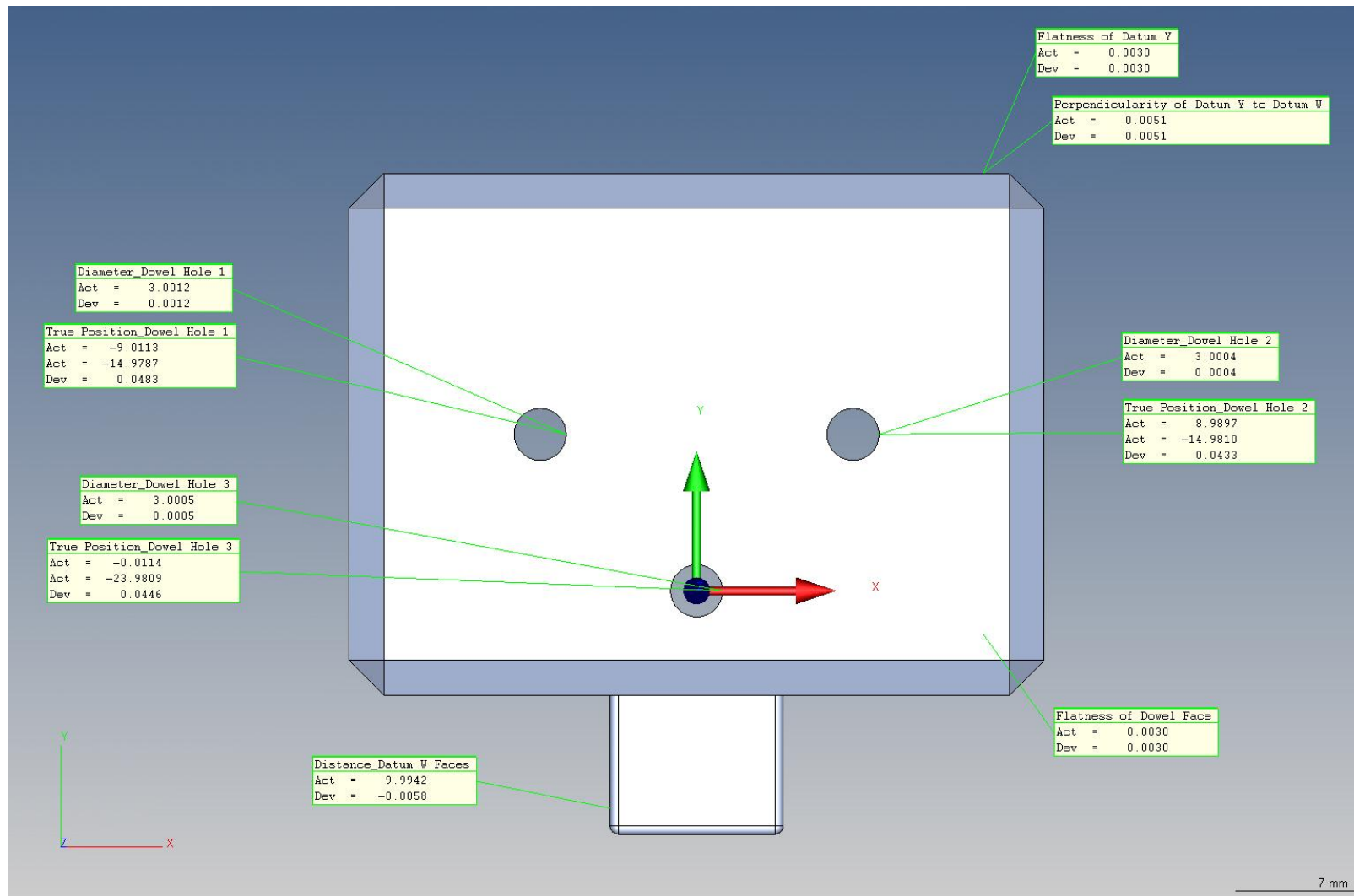




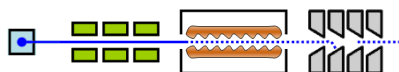
INSPECTION & METROLOGY #1







		Dimensional Metrology Facility			
Telephone: 01235 445472 Email: metrolab@stfc.ac.uk Date July 3, 2012 CMM No. 480014 VDI/VDE 2617 Cert No: 005460 MPE: U3=2.5µm+L(mm)/250		Rutherford Appleton Laboratory Harwell Science and Innovation Campus Building R12 Room 40			
CMM REPORT					
Drawing No.	Part Name	Part Number	Metrologist	Length unit	
	Dowel Pins Holder_v2	1	David Wilsher	MM	
	Actual	Nominal	Upper Tol.	Lower Tol.	Error Deviation
	Overall Result				
	All Characteristics:				
	Out of tolerance:				
	Over Warning Limit:				
	Not Calculated:				
	Flatness of Dowel Face				---
	0.0030	0.0000	0.0100		0.0030
	REF ONLY				
	Flatness of Datum Y				-
	0.0030	0.0000	0.0200		0.0030
	Perpendicularity of Datum Y to Datum W				-
	0.0051	0.0000	0.0500		0.0051
	Distance_Datum W Faces				----
	9.9942	10.0000	0.0000	-0.0500	-0.0058
	Envelope Requirement				
	Diameter_Dowel Hole 1				----
	3.0012	3.0000	0.0100	0.0000	0.0012
	MIC				
	Diameter_Dowel Hole 2				----
	3.0004	3.0000	0.0100	0.0000	0.0004
	MIC				
	Diameter_Dowel Hole 3				----
	3.0005	3.0000	0.0100	0.0000	0.0005
	MIC				
	True Position_Dowel Hole 1				----
	0.0483	0.0000	0.0500	0.0512	0.0483
	X -9.0113	-9.0000			-0.0113
	Y -14.9787	-15.0000			0.0213
	MMC & Projected 10mm				



COMING UP

- 06/08/12 :: DELIVERY OF SECTION 1 TO R12 – METROLOGY LAB
Alan? R12 – Metrology lab. Contact Richard Day for delivery, Dave is off. R12 rolling door EAST side.
- 21/08/12 :: INSPECTION & METROLOGY #2
feedback to August FETS Meeting
- 03-13/09/12 :: Inspection of RFQ Section 1 – Copper parts
- 13-14/09/12 :: Revision of both inspections and potential modifications
feedback to September FETS meeting
- 14-21/09/12 :: RFQ SECTION 1 ALIGNMENT AT METROLOGY'S LAB.
feedback to September FETS meeting

