

[1] 準備

データ表 (注: CALX, CALY: 検定用ビームとアライメント用ビームの校正係数の比)

Dmm: C1 基準点からの距離 (mm)

DD: C1U からの距離 (mm)

Ratio: $(L - L_{C1U}) / (L_{21U} - L_{C1U})$

OFX: X オフセット生データ (検定ビーム用目盛単位) (0.006 mm/目盛)

OFY: Y オフセット生データ (検定ビーム用目盛単位) (0.006 mm/目盛)

OFXmm: X オフセットデータ (mm 単位)

OFYmm: Y オフセットデータ (mm 単位)

DOFX: $(OFX_{21U} - OFX_{C1U}) * CALX$ (アライメントビーム用目盛単位)

DOFY: $(OFY_{21U} - OFY_{C1U}) * CALY$ (アライメントビーム用目盛単位)

X: X 測定値 (アライメントビーム用目盛単位)

Y: Y 測定値 (アライメントビーム用目盛単位)

XC1U: C1U での X 測定値 (アライメントビーム用目盛単位)

YC1U: C1U での Y 測定値 (アライメントビーム用目盛単位)

X21U: 21U での X 測定値 (アライメントビーム用目盛単位)

Y21U: 21U での Y 測定値 (アライメントビーム用目盛単位)

DXC1U: $XC1U - OFX_{C1U} * CALX$, 現場計算 (アライメントビーム用目盛単位)

DYC1U: $YC1U - OFY_{C1U} * CALY$, 現場計算 (アライメントビーム用目盛単位)

TGX: $-[Ratio * (X_{21U} - X_{C1U} + DOFX) + DXC1U]$, 目標計算値 (アライメントビーム用目盛単位)

TGY: $-[Ratio * (Y_{21U} - Y_{C1U} + DOFY) + DYC1U]$, 目標計算値 (アライメントビーム用目盛単位)

FX: X 最終測定値 (アライメントビーム用目盛単位)

FY: Y 最終測定値 (アライメントビーム用目盛単位)

KALEIDA GRAPH 数式添付ノート

m0: 0.006 mm/目盛 (検定用ビームでの校正係数)

m1: 0.055 mm/目盛 (アライメント用ビームでの X 校正係数) \leq 再測定し記入する

m2: 0.070 mm/目盛 (アライメント用ビームでの Y 校正係数) \leq 再測定し記入する

m3: $m0/m1 = CALX$ (検定とアライメント用の X 校正係数の比)

m4: $m0/m2 = CALY$ (検定とアライメント用の Y 校正係数の比)

[2] 測定

- (1) 校正係数の測定 (C1U と 11U の二ヶ所) \Rightarrow m1, m2 を記入する
- (2) 現状測定 \Rightarrow X, Y を記入する
- (3) 基準測定 \Rightarrow 同時に XC1U, YC1U, X21U, Y21U を記入する
- (4) 目標値計算 \Rightarrow KALEIDA GRAPH 数式添付ノートを実行する
- (5) 目標値に合うようにアライメントを調整する

[3] 人員

KALEIDA GRAPH 計算及びレーザー調節係	1 人	ギャラリ C1
基準点測定係 (各場所 1 人)	2 人	トンネル C1U, 21U
アライメント測定、実行係	3 人	トンネル

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m0=0.006;  
m1=0.055;  
m2=0.070;  
m3=m0/m1;  
m4=m0/m2;  
c8=(cell(47,4)-cell(5,4))*m3;  
c9=(cell(47,5)-cell(5,5))*m4;  
c16=c12-cell(5,4)*m3;  
c17=c13-cell(5,5)*m4;  
c18=-(c3*(c14-c12+c8)+c16);  
c19=-(c3*(c15-c13+c9)+c17);
```

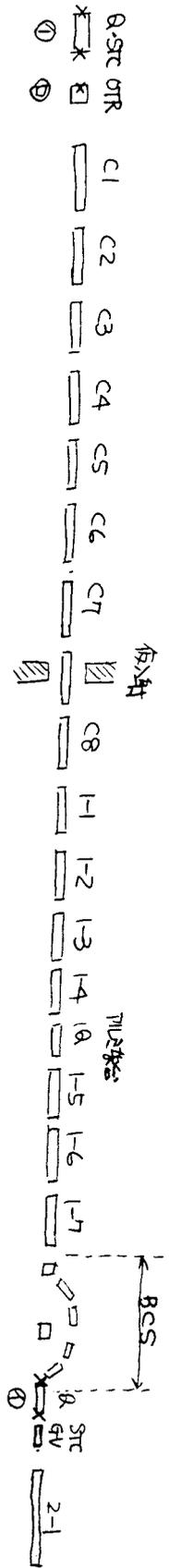

98.09.03

FF入射巻B改造 H10-量工事 ターゲットBOX 検定結果

- 1. 検定作業 H10.9.1~3.
- 2. 検定範囲 C1~2-1エントまで 計40² ----- P2参照
- 3. 除外品 旧e+架台利用箇所 ----- 2ゾーン 3台 5²
 (C1上流部 2台:3²)
 (BCST下流部 1台:2²)
- 4. 検定法 検定治具に取付サ. L-サ-ESetし. 90°ずつ回転させて指示値を
読み取り. メカニカルとL-サ-受光とのずれを修正.
- 5. 検定結果 (P3参照)
 - (1) 測定結果をパターンに表示し. メカニカルとL-サ-受光とのずれを求めた.
 - (2) 40²中の最大のずれは L4/026 ⇒ H:24μ, V:156μ.
 - (3) パターンのおかしいもの 10²あり ⇒ 25%.
- 6. 測定データ P4~P6.
- 7. パターン図 P7~P12
- 8. 当座の対応 ずれ量が余り大きくないのでそのまま使う事とする.
パターン評価より「おかしい」と判定したものを. そのまま使う事とする.
- 9. 今後の対策
 - (1) 検定治具を改善して. H, V 両方のリニアリニア-E計測出来る様にして
判定基準を強化ね.
 - (2) 同様な機能を有する L-サ-マシン上の検定治具を別に用意して
実際のL-サ-ビームを使って修正する.
 - (3) 機能不良のターゲットBOXの修理を行なう. ----- 材料セル等の準備要.

(以上)

4-个站BOX配置图



C1~C8	$8^{\text{台}} \times 2^{\text{寸}} = 16^{\text{寸}}$
伍ヶ所付番	$1^{\text{台}} \times \text{寸} = 2$
1-1~1-7	$7^{\text{台}} \times \text{寸} = 14$
1-7 下流部	$1^{\text{台}} \times \text{寸} = 2$
BCS 中央部	$1^{\text{台}} \times \text{寸} = 2$
2-1 上流部	$1^{\text{台}} \times \text{寸} = 2$
2-1	$1^{\text{台}} \times \text{寸} = 2$

計 40 ^寸	

NOTE-1

① ② は旧設備で4ヶ所BOXの取付は不可. 現状での位置は各台の位置を.

①: 14608 台

②: 4m 中央台.

取付位置	おれ量		1/4-ン良否	はめ合い状態	備考	
	H	V				
C1	上流用	R11	Ø10	○	○	
	下流用	R20	U2	○	○	
C2	上流用	R11	Ø1	○	○	
	下流用	R17	Ø11	○	○	
C3	上流用	R20	Ø12	○	○	
	下流用	L2	Ø7	○	○	
C4	上流用	R7	±0	○	○	
	下流用	R3	Ø5	○	○	
C5	上流用	R18	Ø19	○	△△	
	下流用	R16	Ø12	○	△△	
C6	上流用	R5	U4	○	△△	
	下流用	±0	U6	○	○	
C7	上流用	R9	U4	○	○	
	下流用	L1	U5	X	○	
仮入射部	上流用	±0	U6	X	○	
	下流用	±0	±0	○	○	
C8	上流用	L6	U4	○	○	光軸管ランジ外れ(圧入状態)
	下流用	R4	Ø1	X	○	
1-1	上流用	R5	U23	○	○	光軸管スナサ-外れ(圧入状態)
	下流用	R18	U6	○	△△	
1-2	上流用	R2	U8	○	△△	
	下流用	R5?	Ø2?	X	○	
1-3	上流用	R9	U6	○	△△	
	下流用	R6	U3	○	△△	
1-4	上流用	R7	Ø1	X	△△	
	下流用	L7	U14	△	○△	
1/2上流台	上流用	L4	U7	○	○△	
	下流用	L12	U11	○	○	
1-5	上流用	R6	U4	○	△△	コネク-損傷(仮入射部)
	下流用	±0	Ø5	○	○	
1-6	上流用	R11	U6	○	○	
	下流用	R6	U9	○	○△	
1-7	上流用	R2	Ø3	X	○	
	下流用	L4	U5	○	○	
1/7下流台	上流用	R4	Ø4	○	○	
	下流用	±0	U2	△	○	
BCS中流台	上流用	R8	U12	○	○	
	下流用	±0?	±0?	X	○	
2-1上流台	上流用	R19	U6	○	△△	
	下流用	L4	U26	○	△△	
2-1	上流用	L14	Ø7	○	○	
	下流用	L5	Ø2	X	○	

NOTE-1. 1/4-ン良否の判定は四角形が太くおれているものをX, △はそれほどことくたりの状態を示す。

2. はめ合い状態とは、圧入が○, △はスナサバキ(かならずと無い)。2°記入されている所は左側が上流側, 右側が下流側を示す。

10年9月1日

加藤ニストL-型-アキ外用 7-11-1 BOX 検定記録

橋本, 小川, 生田, 倉野

設置箇所	区分	指示値 時計回り(七-レ-カ-32)					備考	
		0°	90°	180°	270°	360°		
C1	① 上流	H	R2	±0	L20	L19	R1	
		V	±0	U20	U19	D2	D1	
	② 下流	H	±0	L23	(L38)	L19	R1	L7
		V	±0	U16	D5	D23	D3	D11
C4	④ 上流	H	±0	L7	(L15)	L9	±0	L6
		V	±0	U7	±0	D7	±0	D3
	③ 下流	H	R1	R2	L5	L7	R1	R17
		V	U3	U10	U10	U2	U1	U6
C3	⑤ 上流	H	±0	L9	(L39)	L30	R1	L17) 7.11.10.11.12.13.14.15.16.17.18.19.20.21.22.23.24.25.26.27.28.29.30.31.32.33.34.35.36.37.38.39.40.41.42.43.44.45.46.47.48.49.50.51.52.53.54.55.56.57.58.59.60.61.62.63.64.65.66.67.68.69.70.71.72.73.74.75.76.77.78.79.80.81.82.83.84.85.86.87.88.89.90.91.92.93.94.95.96.97.98.99.100.101.102.103.104.105.106.107.108.109.110.111.112.113.114.115.116.117.118.119.120.121.122.123.124.125.126.127.128.129.130.131.132.133.134.135.136.137.138.139.140.141.142.143.144.145.146.147.148.149.150.151.152.153.154.155.156.157.158.159.160.161.162.163.164.165.166.167.168.169.170.171.172.173.174.175.176.177.178.179.180.181.182.183.184.185.186.187.188.189.190.191.192.193.194.195.196.197.198.199.200.201.202.203.204.205.206.207.208.209.210.211.212.213.214.215.216.217.218.219.220.221.222.223.224.225.226.227.228.229.230.231.232.233.234.235.236.237.238.239.240.241.242.243.244.245.246.247.248.249.250.251.252.253.254.255.256.257.258.259.260.261.262.263.264.265.266.267.268.269.270.271.272.273.274.275.276.277.278.279.280.281.282.283.284.285.286.287.288.289.290.291.292.293.294.295.296.297.298.299.300.301.302.303.304.305.306.307.308.309.310.311.312.313.314.315.316.317.318.319.320.321.322.323.324.325.326.327.328.329.330.331.332.333.334.335.336.337.338.339.340.341.342.343.344.345.346.347.348.349.350.351.352.353.354.355.356.357.358.359.360.361.362.363.364.365.366.367.368.369.370.371.372.373.374.375.376.377.378.379.380.381.382.383.384.385.386.387.388.389.390.391.392.393.394.395.396.397.398.399.400.401.402.403.404.405.406.407.408.409.410.411.412.413.414.415.416.417.418.419.420.421.422.423.424.425.426.427.428.429.430.431.432.433.434.435.436.437.438.439.440.441.442.443.444.445.446.447.448.449.450.451.452.453.454.455.456.457.458.459.460.461.462.463.464.465.466.467.468.469.470.471.472.473.474.475.476.477.478.479.480.481.482.483.484.485.486.487.488.489.490.491.492.493.494.495.496.497.498.499.500.501.502.503.504.505.506.507.508.509.510.511.512.513.514.515.516.517.518.519.520.521.522.523.524.525.526.527.528.529.530.531.532.533.534.535.536.537.538.539.540.541.542.543.544.545.546.547.548.549.550.551.552.553.554.555.556.557.558.559.560.561.562.563.564.565.566.567.568.569.570.571.572.573.574.575.576.577.578.579.580.581.582.583.584.585.586.587.588.589.590.591.592.593.594.595.596.597.598.599.600.601.602.603.604.605.606.607.608.609.610.611.612.613.614.615.616.617.618.619.620.621.622.623.624.625.626.627.628.629.630.631.632.633.634.635.636.637.638.639.640.641.642.643.644.645.646.647.648.649.650.651.652.653.654.655.656.657.658.659.660.661.662.663.664.665.666.667.668.669.670.671.672.673.674.675.676.677.678.679.680.681.682.683.684.685.686.687.688.689.690.691.692.693.694.695.696.697.698.699.700.701.702.703.704.705.706.707.708.709.710.711.712.713.714.715.716.717.718.719.720.721.722.723.724.725.726.727.728.729.730.731.732.733.734.735.736.737.738.739.740.741.742.743.744.745.746.747.748.749.750.751.752.753.754.755.756.757.758.759.760.761.762.763.764.765.766.767.768.769.770.771.772.773.774.775.776.777.778.779.780.781.782.783.784.785.786.787.788.789.790.791.792.793.794.795.796.797.798.799.800.801.802.803.804.805.806.807.808.809.810.811.812.813.814.815.816.817.818.819.820.821.822.823.824.825.826.827.828.829.830.831.832.833.834.835.836.837.838.839.840.841.842.843.844.845.846.847.848.849.850.851.852.853.854.855.856.857.858.859.860.861.862.863.864.865.866.867.868.869.870.871.872.873.874.875.876.877.878.879.880.881.882.883.884.885.886.887.888.889.890.891.892.893.894.895.896.897.898.899.900.901.902.903.904.905.906.907.908.909.910.911.912.913.914.915.916.917.918.919.920.921.922.923.924.925.926.927.928.929.930.931.932.933.934.935.936.937.938.939.940.941.942.943.944.945.946.947.948.949.950.951.952.953.954.955.956.957.958.959.960.961.962.963.964.965.966.967.968.969.970.971.972.973.974.975.976.977.978.979.980.981.982.983.984.985.986.987.988.989.990.991.992.993.994.995.996.997.998.999.1000.1001.1002.1003.1004.1005.1006.1007.1008.1009.1010.1011.1012.1013.1014.1015.1016.1017.1018.1019.1020.1021.1022.1023.1024.1025.1026.1027.1028.1029.1030.1031.1032.1033.1034.1035.1036.1037.1038.1039.1040.1041.1042.1043.1044.1045.1046.1047.1048.1049.1050.1051.1052.1053.1054.1055.1056.1057.1058.1059.1060.1061.1062.1063.1064.1065.1066.1067.1068.1069.1070.1071.1072.1073.1074.1075.1076.1077.1078.1079.1080.1081.1082.1083.1084.1085.1086.1087.1088.1089.1090.1091.1092.1093.1094.1095.1096.1097.1098.1099.1100.1101.1102.1103.1104.1105.1106.1107.1108.1109.1110.1111.1112.1113.1114.1115.1116.1117.1118.1119.1120.1121.1122.1123.1124.1125.1126.1127.1128.1129.1130.1131.1132.1133.1134.1135.1136.1137.1138.1139.1140.1141.1142.1143.1144.1145.1146.1147.1148.1149.1150.1151.1152.1153.1154.1155.1156.1157.1158.1159.1160.1161.1162.1163.1164.1165.1166.1167.1168.1169.1170.1171.1172.1173.1174.1175.1176.1177.1178.1179.1180.1181.1182.1183.1184.1185.1186.1187.1188.1189.1190.1191.1192.1193.1194.1195.1196.1197.1198.1199.1200.1201.1202.1203.1204.1205.1206.1207.1208.1209.1210.1211.1212.1213.1214.1215.1216.1217.1218.1219.1220.1221.1222.1223.1224.1225.1226.1227.1228.1229.1230.1231.1232.1233.1234.1235.1236.1237.1238.1239.1240.1241.1242.1243.1244.1245.1246.1247.1248.1249.1250.1251.1252.1253.1254.1255.1256.1257.1258.1259.1260.1261.1262.1263.1264.1265.1266.1267.1268.1269.1270.1271.1272.1273.1274.1275.1276.1277.1278.1279.1280.1281.1282.1283.1284.1285.1286.1287.1288.1289.1290.1291.1292.1293.1294.1295.1296.1297.1298.1299.1300.1301.1302.1303.1304.1305.1306.1307.1308.1309.1310.1311.1312.1313.1314.1315.1316.1317.1318.1319.1320.1321.1322.1323.1324.1325.1326.1327.1328.1329.1330.1331.1332.1333.1334.1335.1336.1337.1338.1339.1340.1341.1342.1343.1344.1345.1346.1347.1348.1349.1350.1351.1352.1353.1354.1355.1356.1357.1358.1359.1360.1361.1362.1363.1364.1365.1366.1367.1368.1369.1370.1371.1372.1373.1374.1375.1376.1377.1378.1379.1380.1381.1382.1383.1384.1385.1386.1387.1388.1389.1390.1391.1392.1393.1394.1395.1396.1397.1398.1399.1400.1401.1402.1403.1404.1405.1406.1407.1408.1409.1410.1411.1412.1413.1414.1415.1416.1417.1418.1419.1420.1421.1422.1423.1424.1425.1426.1427.1428.1429.1430.1431.1432.1433.1434.1435.1436.1437.1438.1439.1440.1441.1442.1443.1444.1445.1446.1447.1448.1449.1450.1451.1452.1453.1454.1455.1456.1457.1458.1459.1460.1461.1462.1463.1464.1465.1466.1467.1468.1469.1470.1471.1472.1473.1474.1475.1476.1477.1478.1479.1480.1481.1482.1483.1484.1485.1486.1487.1488.1489.1490.1491.1492.1493.1494.1495.1496.1497.1498.1499.1500.1501.1502.1503.1504.1505.1506.1507.1508.1509.1510.1511.1512.1513.1514.1515.1516.1517.1518.1519.1520.1521.1522.1523.1524.1525.1526.1527.1528.1529.1530.1531.1532.1533.1534.1535.1536.1537.1538.1539.1540.1541.1542.1543.1544.1545.1546.1547.1548.1549.1550.1551.1552.1553.1554.1555.1556.1557.1558.1559.1560.1561.1562.1563.1564.1565.1566.1567.1568.1569.1570.1571.1572.1573.1574.1575.1576.1577.1578.1579.1580.1581.1582.1583.1584.1585.1586.1587.1588.1589.1590.1591.1592.1593.1594.1595.1596.1597.1598.1599.1600.1601.1602.1603.1604.1605.1606.1607.1608.1609.1610.1611.1612.1613.1614.1615.1616.1617.1618.1619.1620.1621.1622.1623.1624.1625.1626.1627.1628.1629.1630.1631.1632.1633.1634.1635.1636.1637.1638.1639.1640.1641.1642.1643.1644.1645.1646.1647.1648.1649.1650.1651.1652.1653.1654.1655.1656.1657.1658.1659.1660.1661.1662.1663.1664.1665.1666.1667.1668.1669.1670.1671.1672.1673.1674.1675.1676.1677.1678.1679.1680.1681.1682.1683.1684.1685.1686.1687.1688.1689.1690.1691.1692.1693.1694.1695.1696.1697.1698.1699.1700.1701.1702.1703.1704.1705.1706.1707.1708.1709.1710.1711.1712.1713.1714.1715.1716.1717.1718.1719.1720.1721.1722.1723.1724.1725.1726.1727.1728.1729.1730.1731.1732.1733.1734.1735.1736.1737.1738.1739.1740.1741.1742.1743.1744.1745.1746.1747.1748.1749.1750.1751.1752.1753.1754.1755.1756.1757.1758.1759.1760.1761.1762.1763.1764.1765.1766.1767.1768.1769.1770.1771.1772.1773.1774.1775.1776.1777.1778.1779.1780.1781.1782.1783.1784.1785.1786.1787.1788.1789.1790.1791.1792.1793.1794.1795.1796.1797.1798.1799.1800.1801.1802.1803.1804.1805.1806.1807.1808.1809.1810.1811.1812.1813.1814.1815.1816.1817.1818.1819.1820.1821.1822.1823.1824.1825.1826.1827.1828.1829.1830.1831.1832.1833.1834.1835.1836.1837.1838.1839.1840.1841.1842.1843.1844.1845.1846.1847.1848.1849.1850.1851.1852.1853.1854.1855.1856.1857.1858.1859.1860.1861.1862.1863.1864.1865.1866.1867.1868.1869.1870.1871.1872.1873.1874.1875.1876.1877.1878.1879.1880.1881.1882.1883.1884.1885.1886.1887.1888.1889.1890.1891.1892.1893.1894.1895.1896.1897.1898.1899.1900.1901.1902.1903.1904.1905.1906.1907.1908.1909.1910.1911.1912.1913.1914.1915.1916.1917.1918.1919.1920.1921.1922.1923.1924.1925.1926.1927.1928.1929.1930.1931.1932.1933.1934.1935.1936.1937.1938.1939.1940.1941.1942.1943.1944.1945.1946.1947.1948.1949.1950.1951.1952.1953.1954.1955.1956.1957.1958.1959.1960.1961.1962.1963.1964.1965.1966.1967.1968.1969.1970.1971.1972.1973.1974.1975.1976.1977.1978.1979.1980.1981.1982.1983.1984.1985.1986.1987.1988.1989.1990.1991.1992.1993.1994.1995.1996.1997.1998.1999.2000.2001.2002.2003.2004.2005.2006.2007.2008.2009.2010.2011.2012.2013.2014.2015.2016.2017.2018.2019.2020.2021.2022.2023.2024.2025.2026.2027.2028.2029.2030.2031.2032.2033.2034.2035.2036.2037.2038.2039.2040.2041.2042.2043.2044.2045.2046.2047.2048.2049.2050.2051.2052.2053.2054.2055.2056.2057.2058.2059.2060.2061.2062.2063.2064.2065.2066.2067.2068.2069.2070.2071.2072.2073.2074.2075.2076.2077.2078.2079.2080.2081.2082.2083.2084.2085.2086.2087.2088.2089.2090.2091.2092.2093.2094.2095.2096.2097.2098.2099.2100.2101.2102.2103.2104.2105.2106.2107.2108.2109.2110.2111.2112.2113.2114.2115.2116.2117.2118.2119.2120.2121.2122.2123.2124.2125.2126.2127.2128.2129.2130.2131.2132.2133.2134.2135.2136.2137.2138.2139.2140.2141.2142.2143.2144.2145.2146.2147.2148.2149.2150.2151.2152.2153.2154.2155.2156.2157.2158.2159.2160.2161.2162.2163.2164.2165.2166.2167.2168.2169.2170.2171.2172.2173.2174.2175.2176.2177.2178.2179.2180.2181.2182.2183.2184.2185.2186.2187.2188.2189.2190.2191.2192.2193.2194.2195.2196.2197.2198.2199.2200.2201.2202.2203.2204.2205.2206.2207.2208.2209.2210.2211.2212.2213.2214.2215.2216.2217.2218.2219.2220.2221.2222.2223.2224.2225.2226.2227.2228.2229.2230.2231.2232.2233.2234.2235.2236.2237.2238.2239.2240.2241.2242.2243.2244.2245.2246.2247.2248.2249.2250.2251.2252.2253.2254.2255.2256.2257.2258.2259.2260.2261.2262.2263.2264.2265.2266.2267.2268.2269.2270.2271.2272.2273.2274.2275.2276.2277.2278.2279.2280.2281.2282.2283.2284.2285.2286.2287.2288.2289.2290.2291.2292.2293.2294.2295.2296.2297.2298.2299.2300.2301.2302.2303.2304.2305.2306.2307.2308.2309.2310.2311.2312.2313.2314.2315.2316.2317.2318.2319.2320.2321.2322.2323.2324.2325.2326.2327.2328.2329.2330.2331.2332.2333.2334.2335.2336.2337.2338.2339.2340.2341.2342.2343.2344.2345.2346.2347.2348.2349.2350.2351.2352.2353.2354.2355.2356.2357.2358.2359.2360.2361.2362.2363.2364.2365.2366.2367.2368.2369.2370.2371.2372.2373.2374.2375.2376.2377.2378.2379.2380.2381.2382.2383.2384.2385.2386.2387.2388.2389.2390.2391.2392.2393.2394.2395.2396.2397.2398.2399.2400.2401.2402.2403.2404.2405.2406.2407.2408.2409.2410.2411.2412.2413.2414.2415.2416.2417.2418.2419.2420.2421.2422.2423.2424.2425.2426.2427.2428.2429.2430.2431.2432.2433.2434.2435.2436.2437.2438.2439.2440.2441.2442.2443.2444.2445.2446.2447.2448.2449.2450.2451.2452.2453.2454.2455.2456.2457.2458.2459.2460.2461.2462.2463.2464.2465.2466.2467.2468.2469.2470.2471.2472.2473.2474.2475.2476.2477.2478.2479.2480.2481.2482.2483.2484.2485.2486.2487.2488.2489.2490.2491.2492.2493.2494.2495.2496.2497.2498.2499.2500.2501.2502.2503.2504.2505

10年9月2日

加算機用 L-型-アライメント用 7-ケタ BOX 検定記録

西井 倉典

設置箇所	区分	指示値					備考		
		0°	90°	180°	270°	360°			
C5	上流	H	R1	L6	(L32)	L24	R2	はめ合、両側 スキヤバキ	
		V	D1	U26	U16	D10	D1		
	下流	H	R2	R3	L16	L18	R2		線径不収 1/4 以上 (25mm 30mm)
		V	U1	U20	U20	U1	0		
C6	上流	H	L1	L10	L10	L1	L1	はめ合、両側 スキヤバキ	
		V	R2	R2	R10	D12	R4		
	下流	H	0	L6	0	R6	0		R4
		V	0	R6	D12	D6	0		
C7	上流	H	R2	R2	L16	(R L12)	R4	L4	
		V	R2	U12	U12	D6	R4		U12
	下流	H	L2	L10	L2	R4	L2		R8
		V	0	D12	D20	D2	0		
復入射部	上流	H	0	L6	0	R6	0	L2	
		V	0	R2	R6	D1	0		U6
	下流	H	R1	0	0	0	R2		0
		V	0	0	U2	0	0		
C8	上流	H	0	R4	R12	R10	0	R8 光軸管 外れな!!	
		V	0	D12	D10	U2	0		0
	下流	H	0	L4	L16	L10	0		L4
		V	0	U10	U2	U6	R2		
1-1	上流	H	R2	L26	L8	R20	0	R4 光軸管 スイッチ 外れな!!	
		V	D2	D18	D46	D28	0		D28
	下流	H	R2	L10	L12	R2	R2		L2
		V	0	U4	D10	D12	U2		
1-2	上流	H	0	L10	L4	R6	0	R6	
		V	0	D8	D16	D10	0		D4
	下流	H	0	0	L10	L10	0		L4
		V	D2	U10	U10	0	D2		
1-3	上流	H	0	L12	L18	0	0	0	
		V	0	0	D14	D18	R2		D12
	下流	H	0	L10	L16	L2	0		0
		V	0	0	D8	D10	0		
1-4	上流	H	0	L2	L10	L2	R2	R4	
		V	0	U2	0	D8	D6		U2
	下流	H	0	L10	R10	R20	0		R8
		V	0	R20	D20	D10	0		
1-4.1号 取上げ台	上流	H	0	L2	R8	R10	0	L2	
		V	0	D12	D14	0	0		U6
	下流	H	0	0	R24	R20	0		R6
		V	0	D26	D22	0	0		

NOTE-1. H: HORIZONTAL. V: VERTICAL.

-2. 指示値の頭には各 R: LEFT, R: RIGHT / D: DOWN, U: UP の頭文字を入れる。

加配したL-型-アライメント用7-テストBOX検定記録

設置箇所	区分	指示値					備考	
		0°	90°	180°	270°	360°		
1-5	上流	H	0	L14	L14	L4	0	L22. コネクターのネジ部分が太い
		V	0	U2	R10	R10	0	U2 ほか合、アライメント
	下流	H	0	R6	0	L4	0	R14
		V	0	U6	U12	U6	0	U8
1-6	上流	H	0	L16	L20	L6	0	L10
		V	0	U4	R10	R8	0	R12
	下流	H	0	L16	L14	R4	0	R2
		V	0	R4	R20	R14	0	R8 ほか合、アライメント 下流側
1-7	上流	H	0	0	L8	L10	0	R8
		V	0	U6	U10	U12	R2	U14
	下流	H	0	L4	R6	R6	0	R6
		V	0	R10	R8	0	0	R12
1-7 下流台	上流	H	0	L20	L16	R4	0	R6
		V	0	R6	R4	R20	0	R8
	下流	H	0	L16	L22	L6	0	L4
		V	0	U6	R8	U16	0	U8
BCS 中央台	上流	H	0	0	L10	L10	0	R2
		V	0	U10	U12	U4	0	U8
	下流	H	0	L2	0	0	0	R6
		V	0	R4	R8	R6	R4	R10
2-1 上流台	上流	H	0	L24	L6	L12	0	L16
		V	0	U14	R12	R24	0	R6 ほか合、アライメント 両側
	下流	H	0	L22	R6	R30	0	R20
		V	0	R30	R48	R20	0	R20 ほか合、アライメント 両側
Z-1	上流	H	0	R20	R24	R6	L2	R6
		V	0	R8	U12	U20	R2	U28
	下流	H	0	R6	R4	R2	0	L4
		V	0	R4	U2	U6	0	R20
2-1 (再測定)	上流	H	0	R12	R22	R10	0	R8
	V	0	R8	U4	U14	0	0	
仮入射 部 (再測定)	上流	H	0	L8	L10	0	0	L24
		V	0	U4	R6	R8	0	R10 ほか合、アライメント
	下流	H						
		V						
C-8 (再測定)	上流	H						
		V						
	下流	H	0	L6	L14	L10	0	0
		V	0	U8	U2	R6	0	R2

7-9の
元入
部

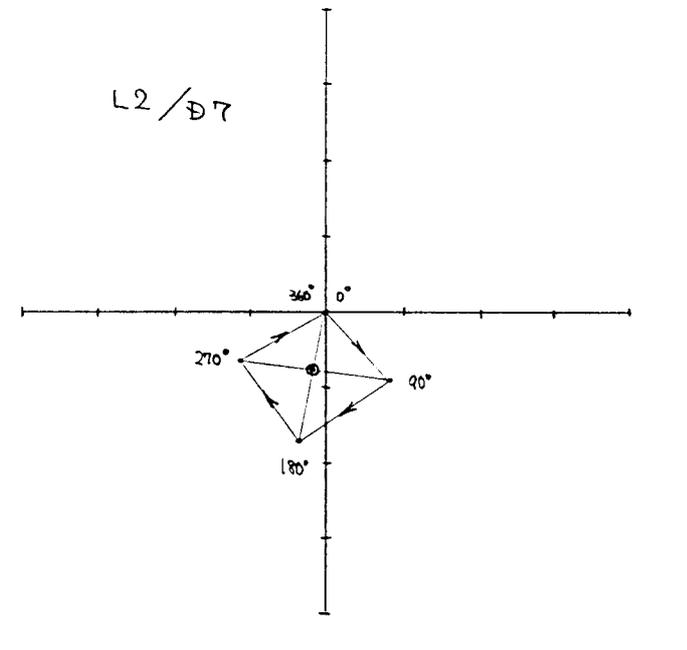
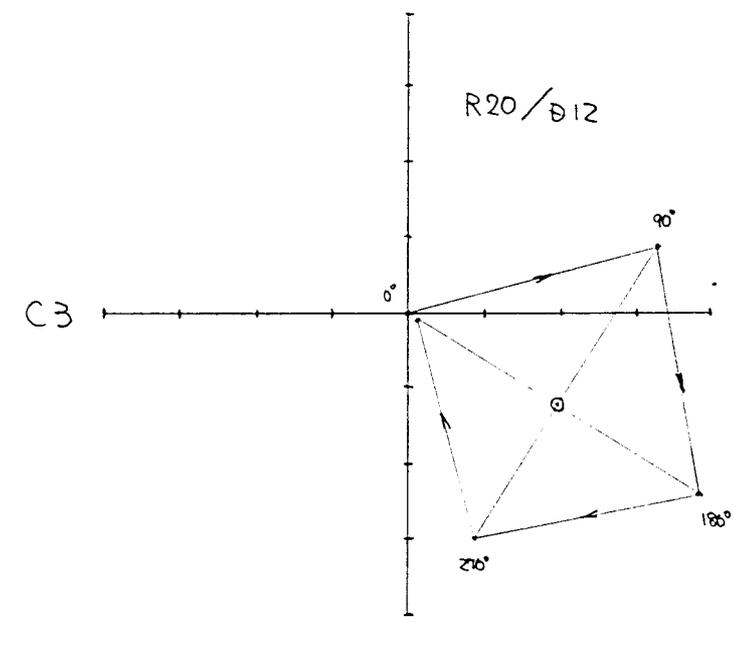
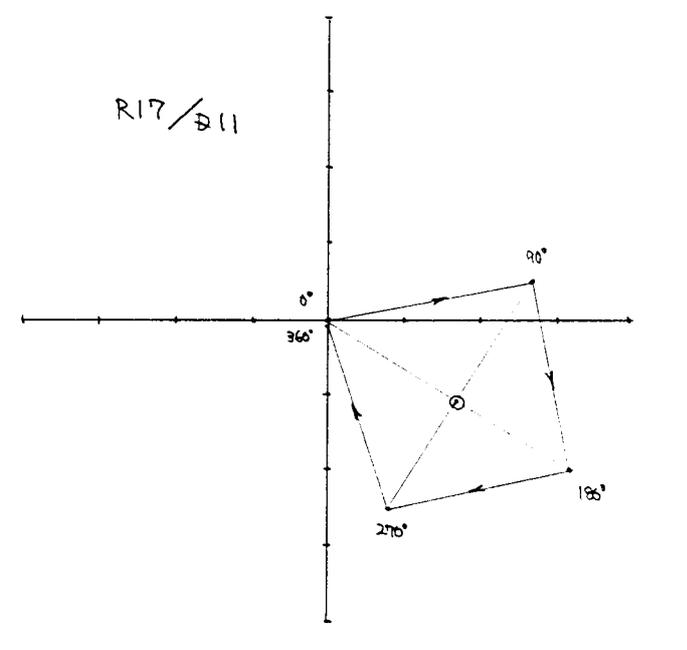
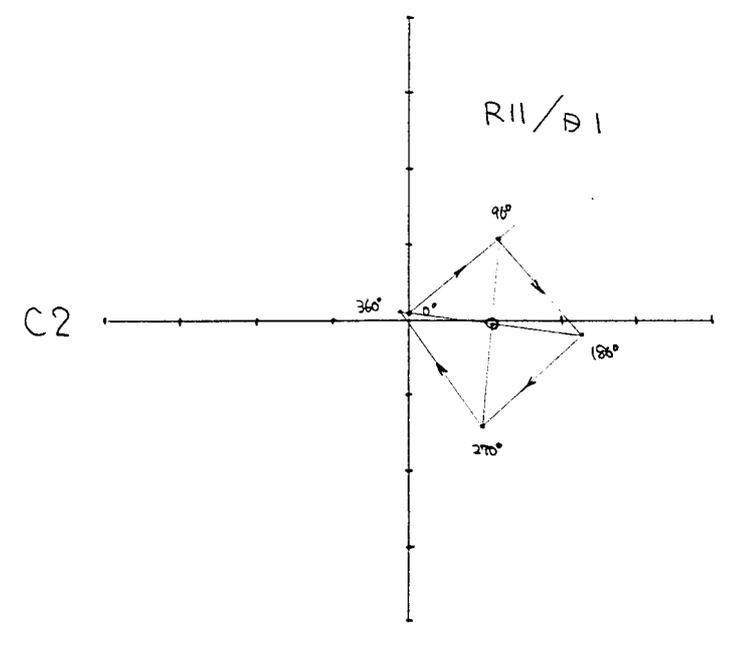
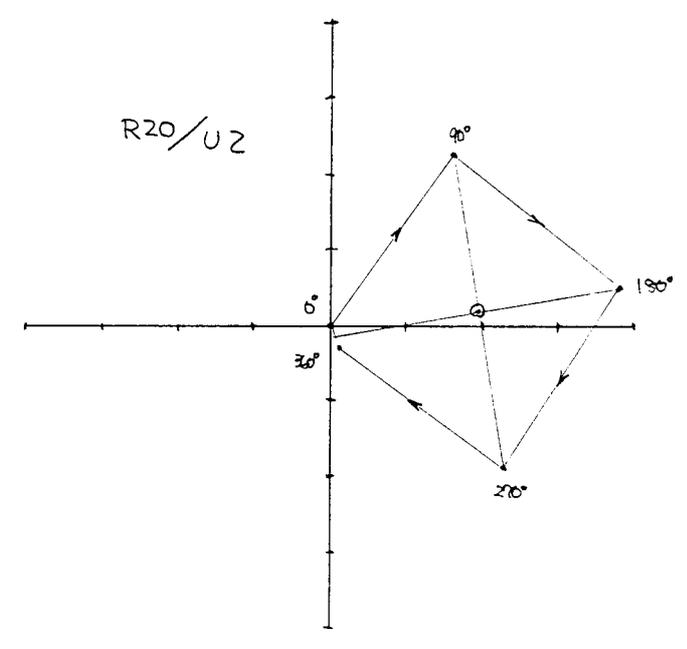
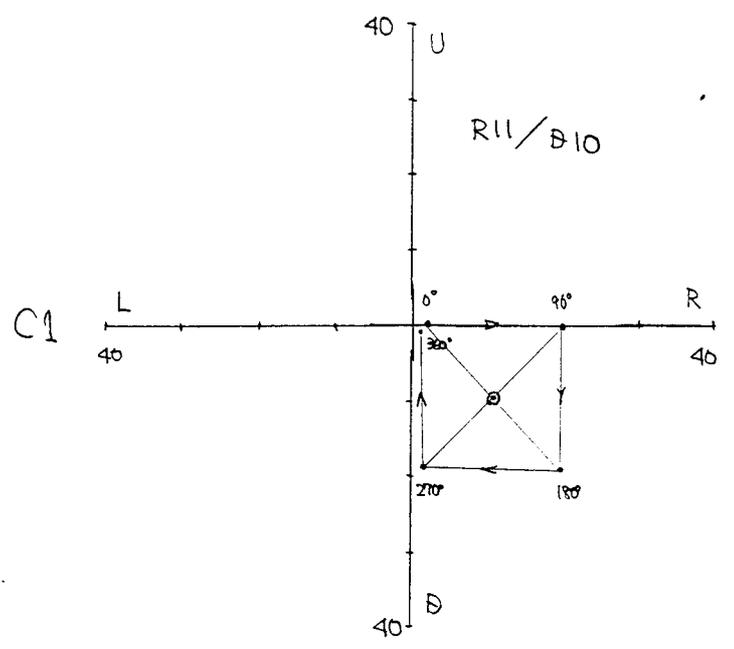
9/3

NOTE-1. H: HORIZONTAL. V: VERTICAL.

2. 指示値の題には各R. L: LEFT, R: RIGHT / D: DOWN, U: UP の頭文字を付ける。

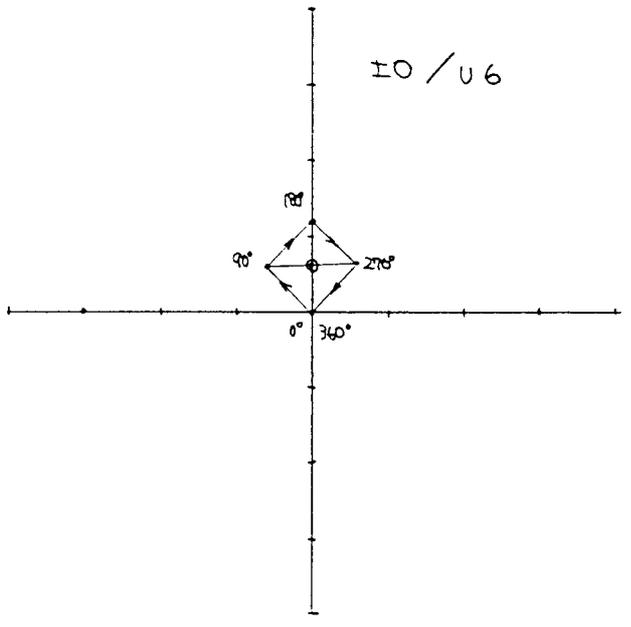
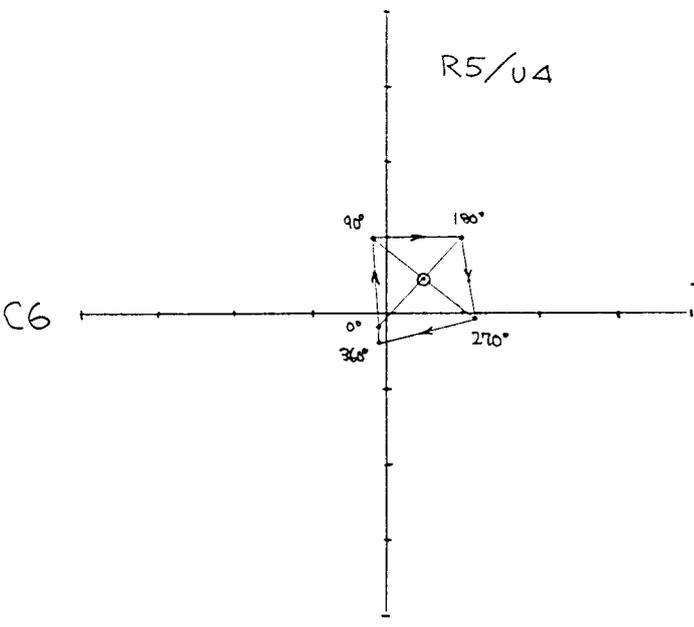
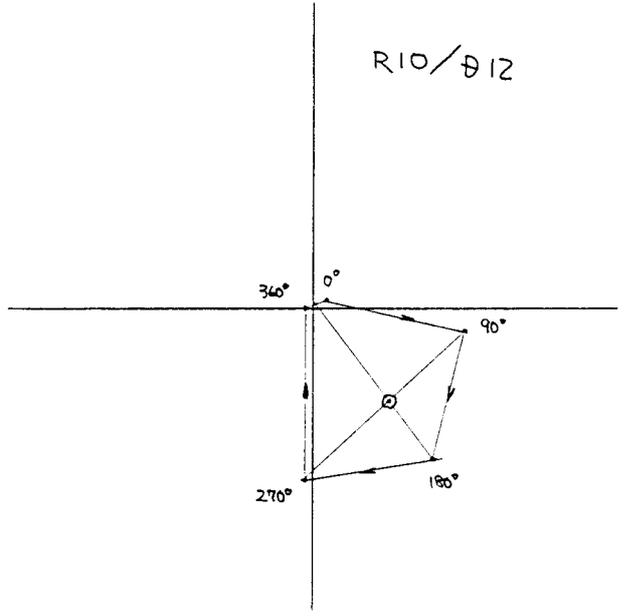
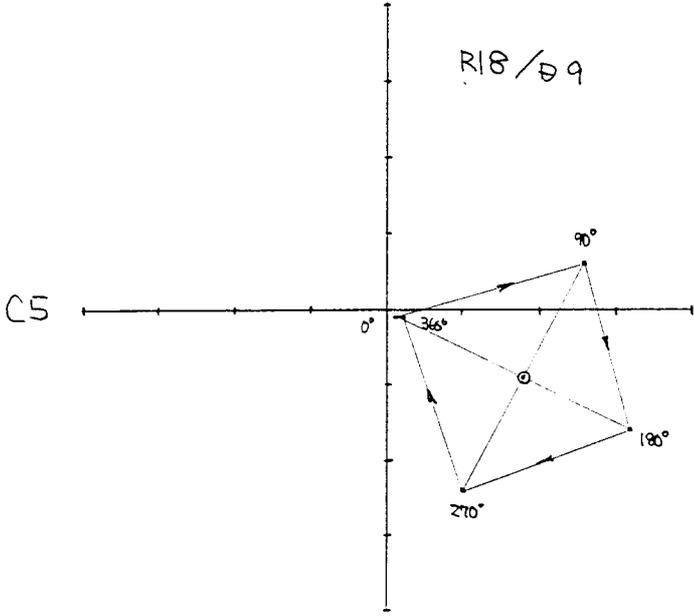
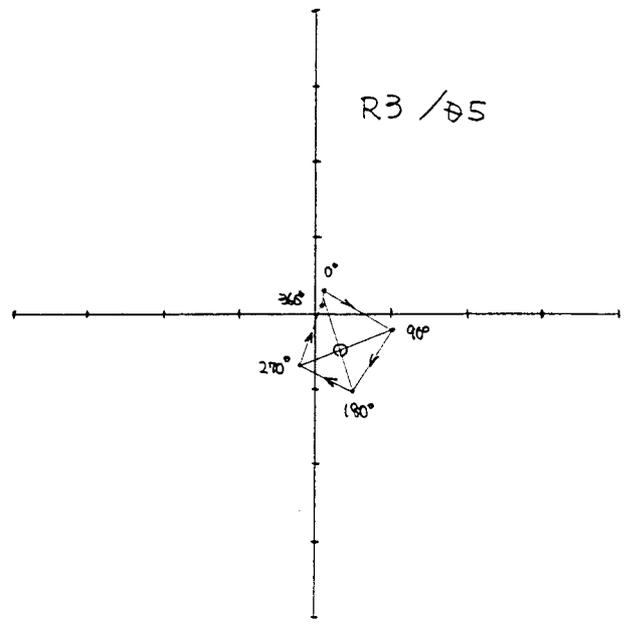
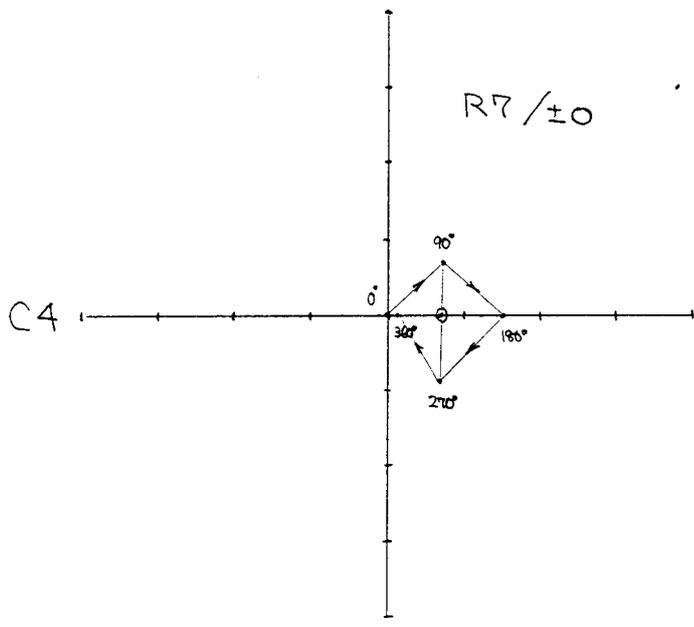
上流用

下流用



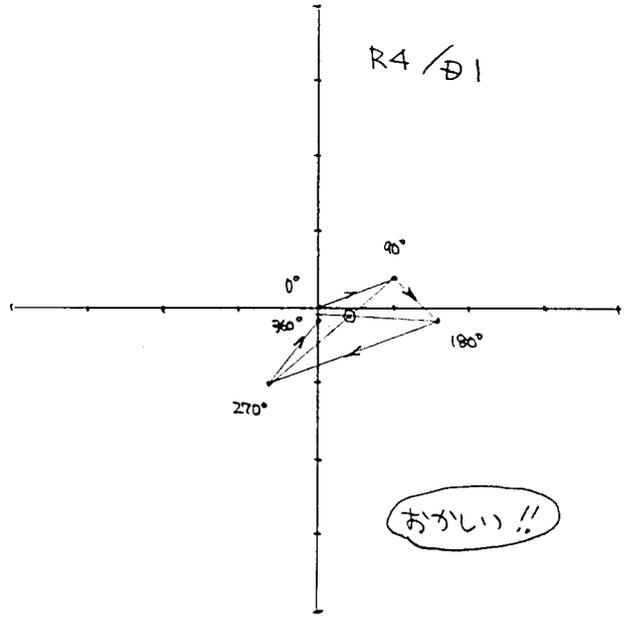
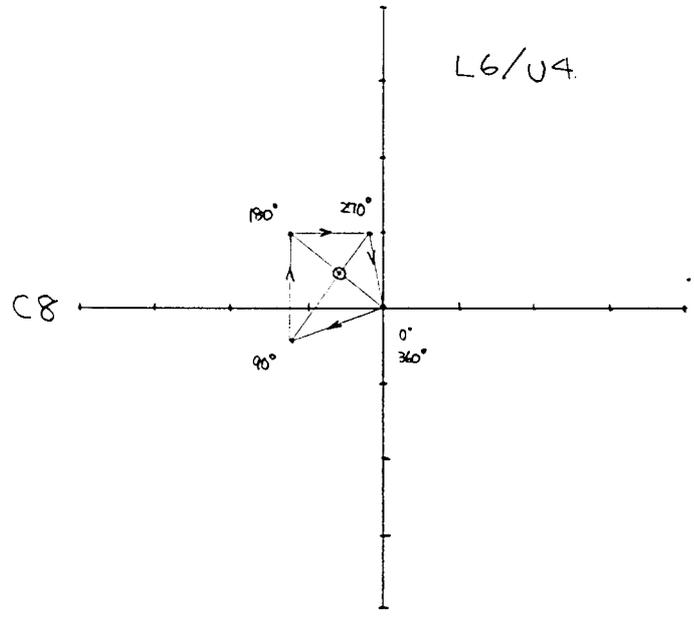
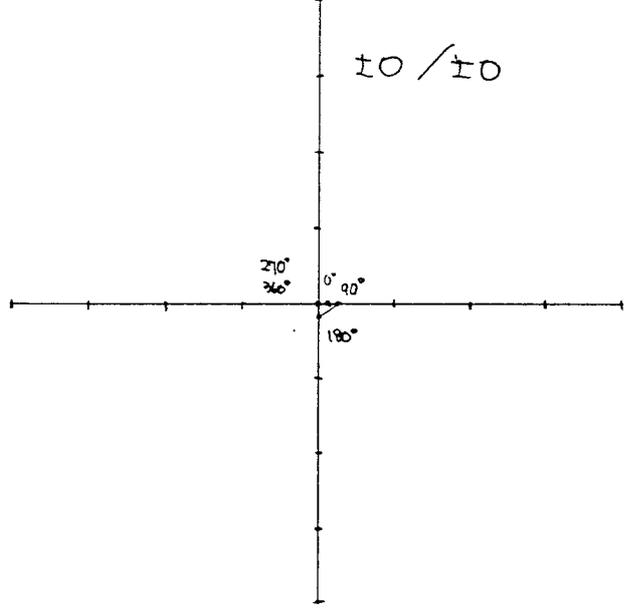
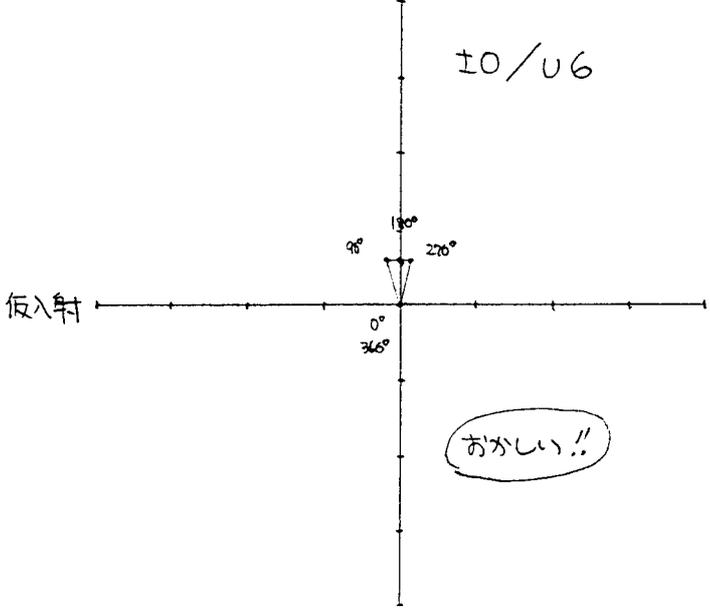
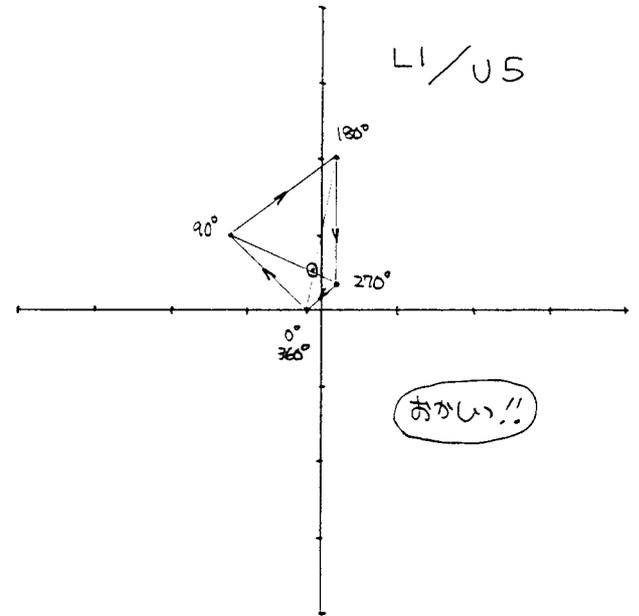
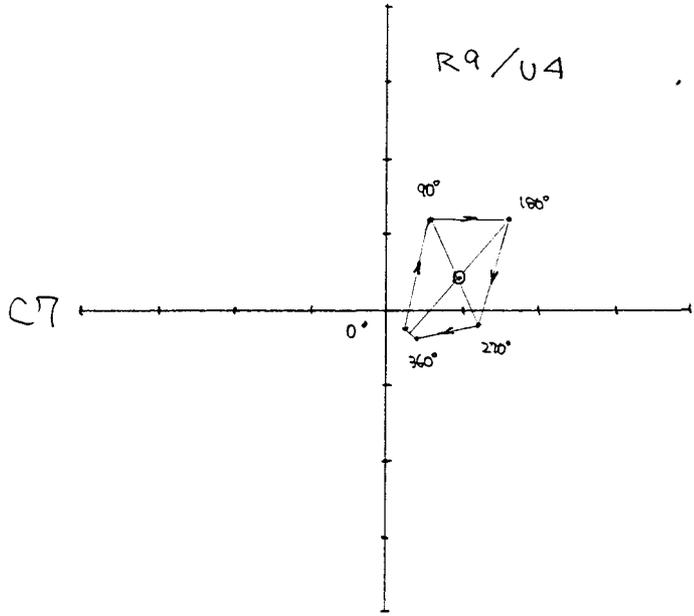
上流用

下流用



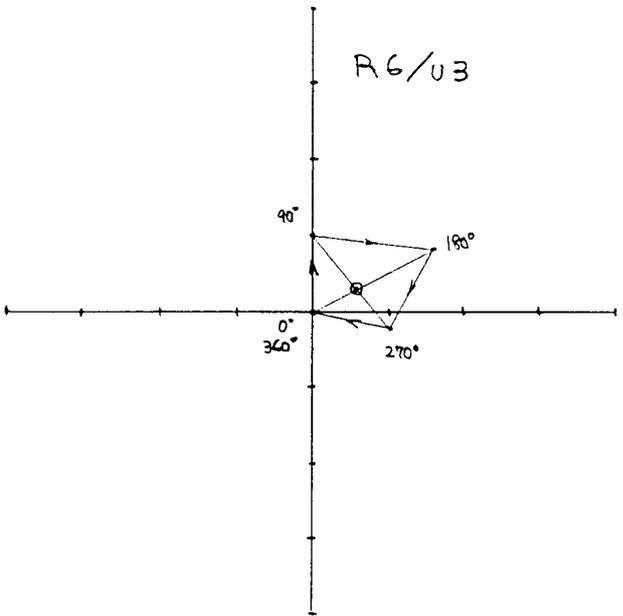
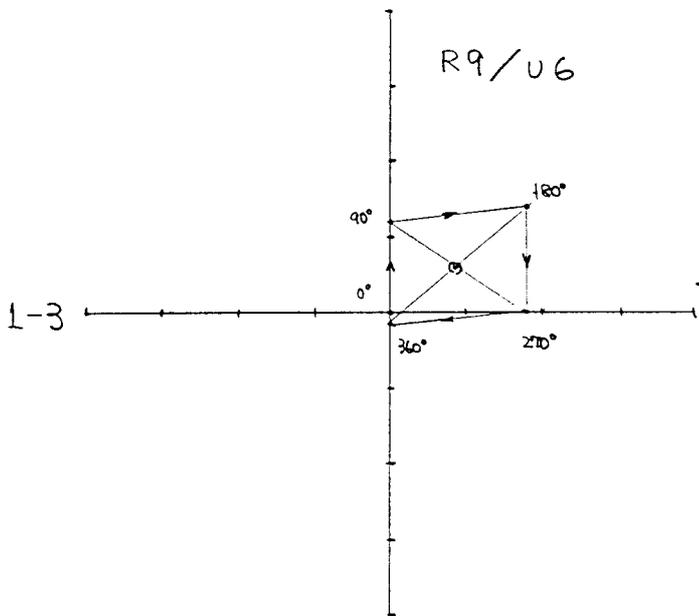
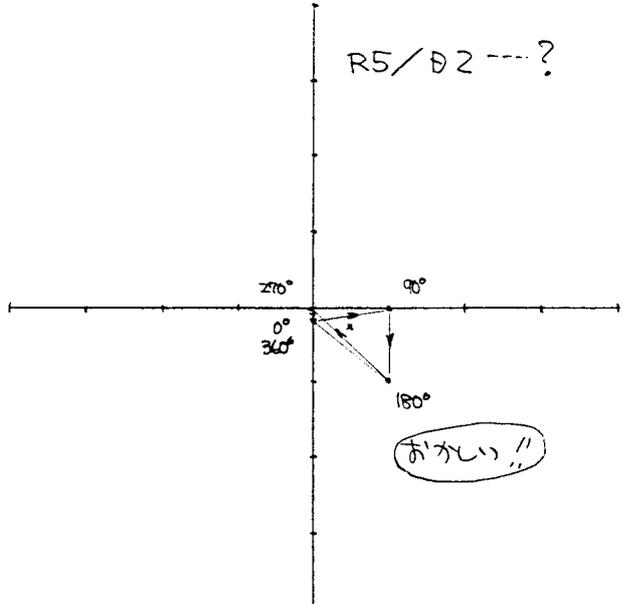
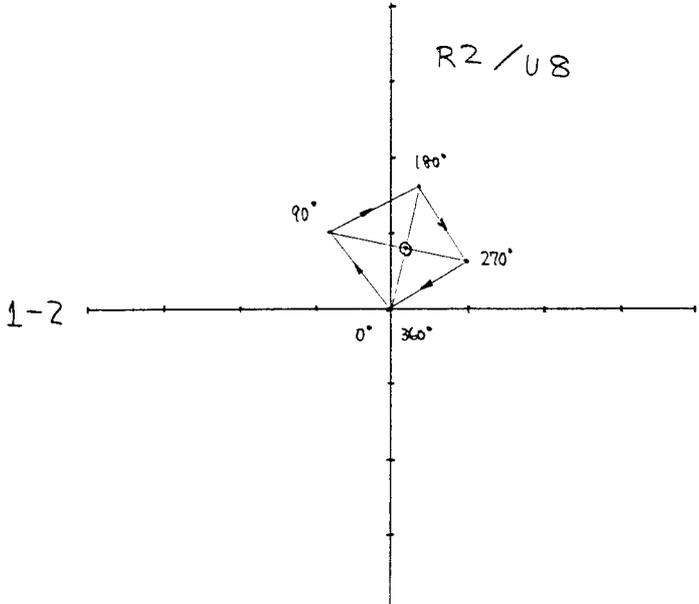
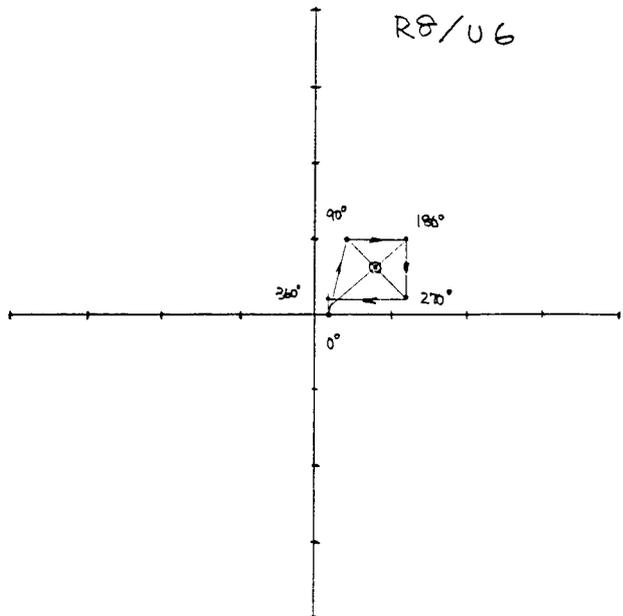
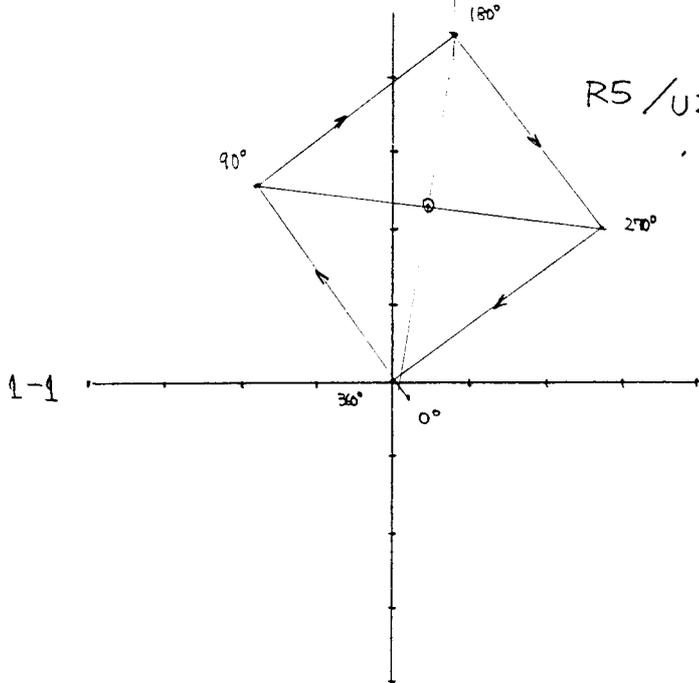
上流用

下流用



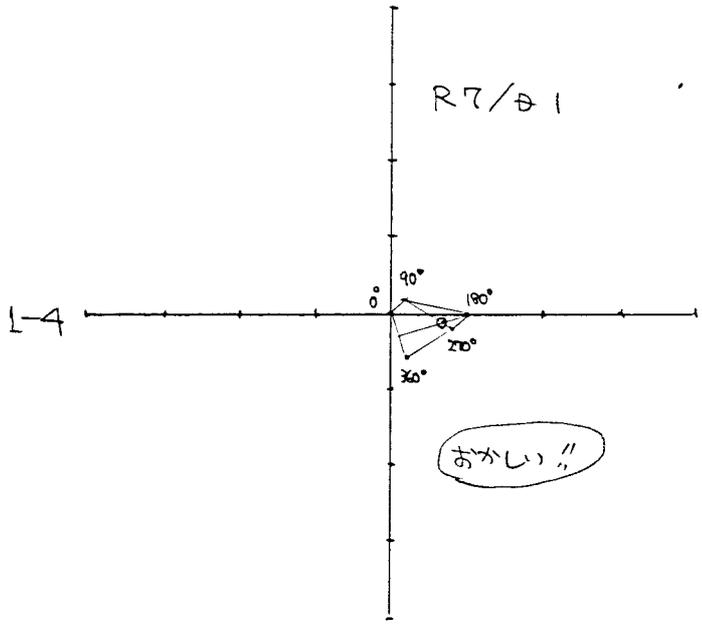
上流用

下流用

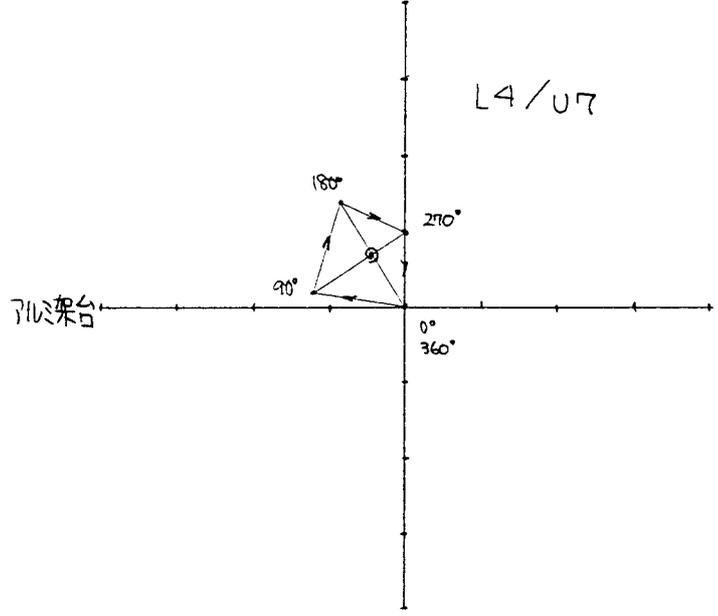
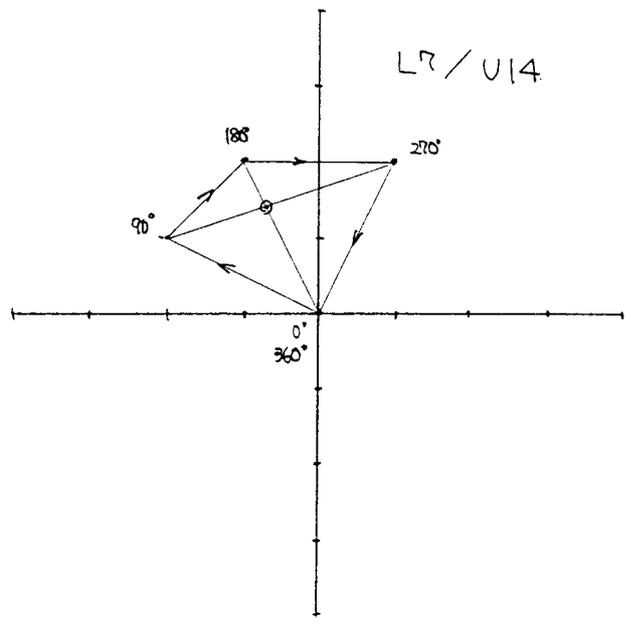


上系用

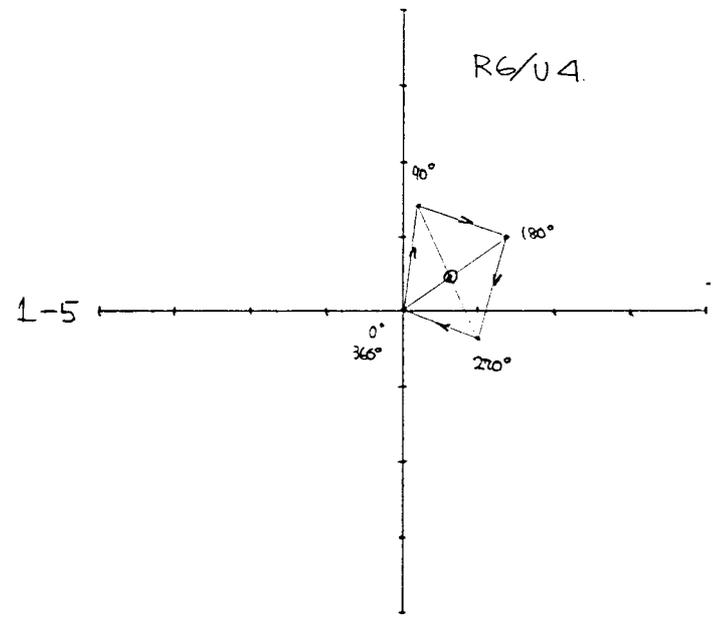
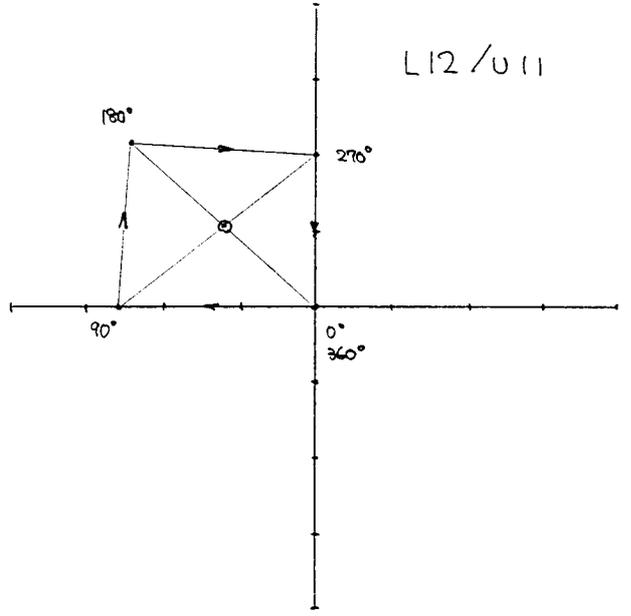
下系用



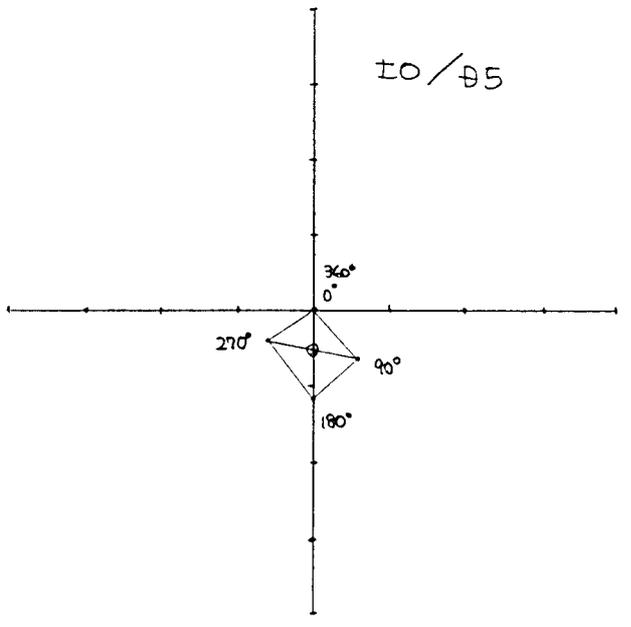
おかしい!!



アハ架台

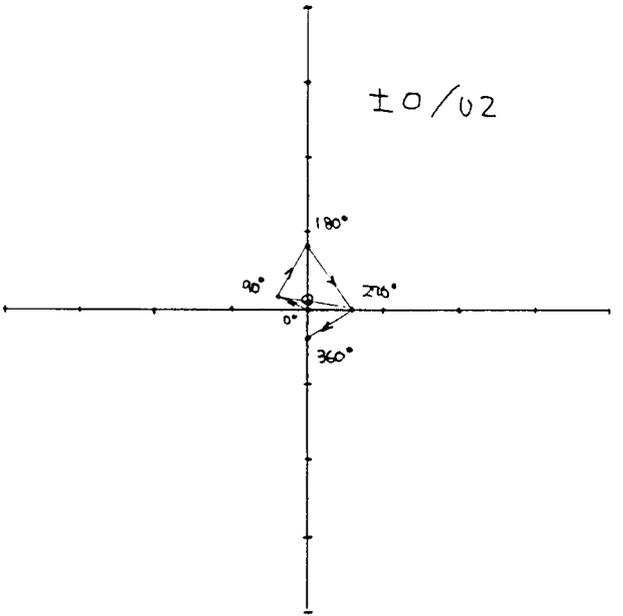
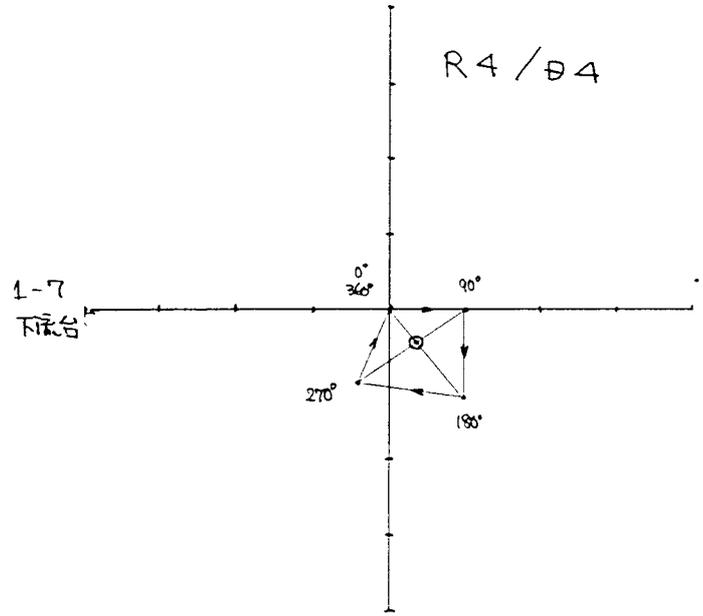
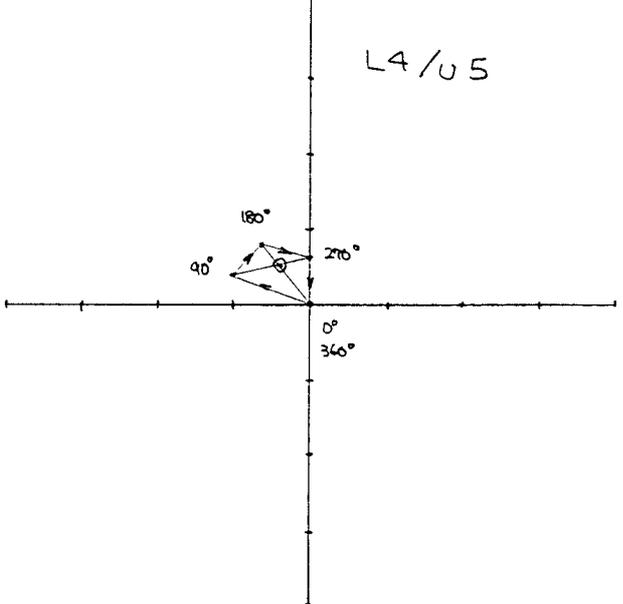
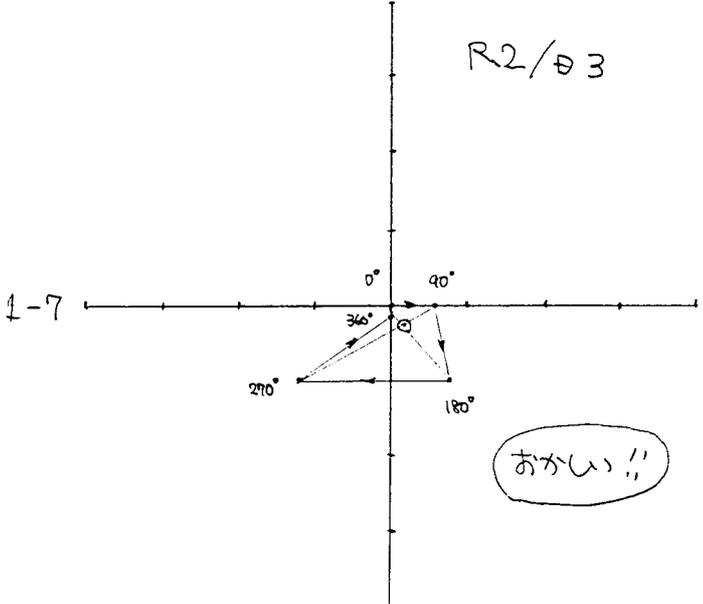
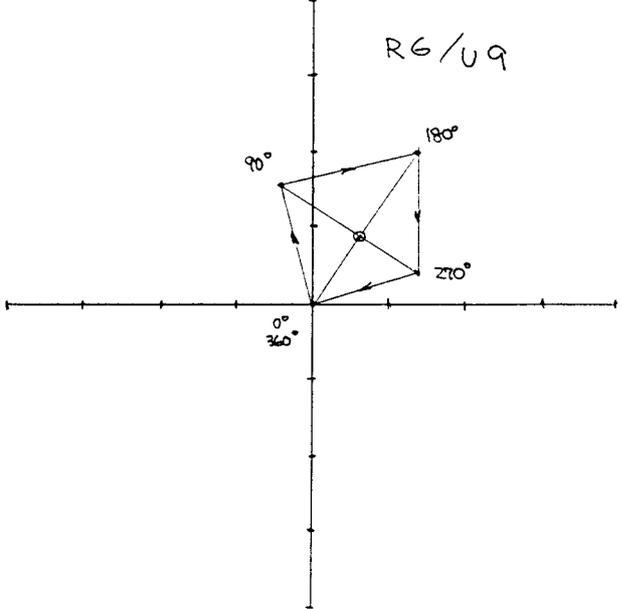
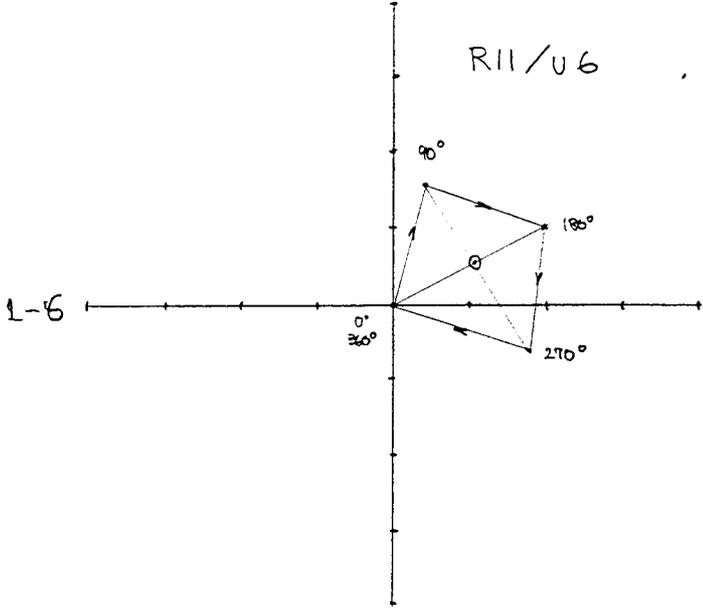


L-5



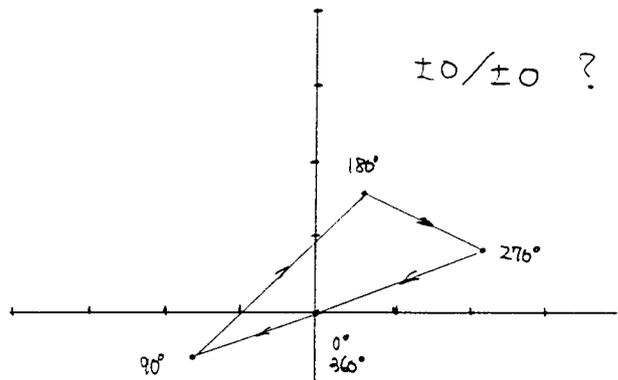
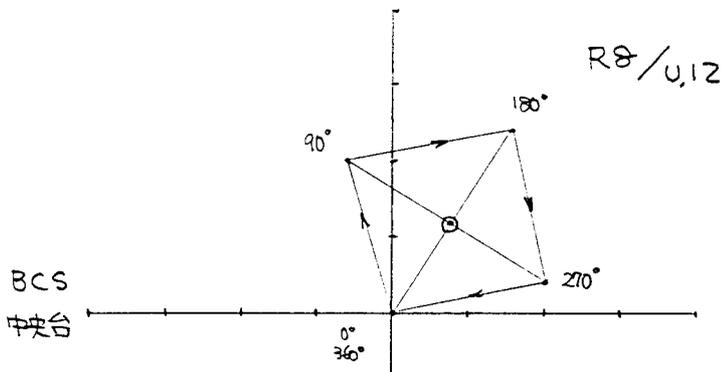
上流用

下流用

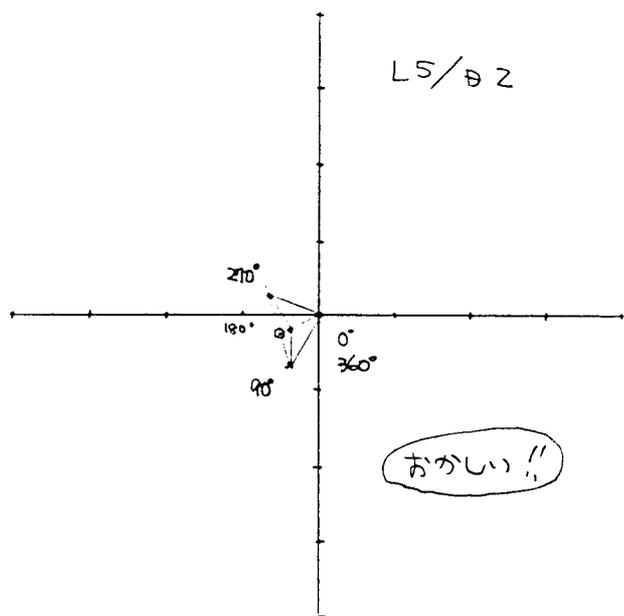
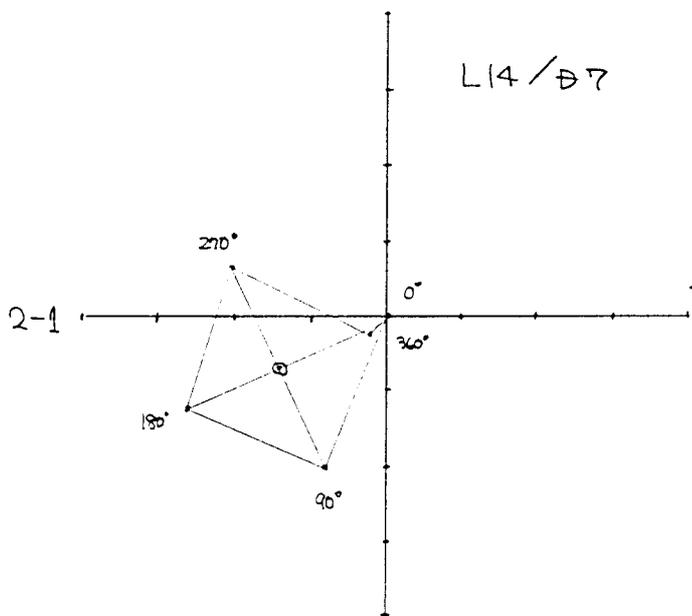
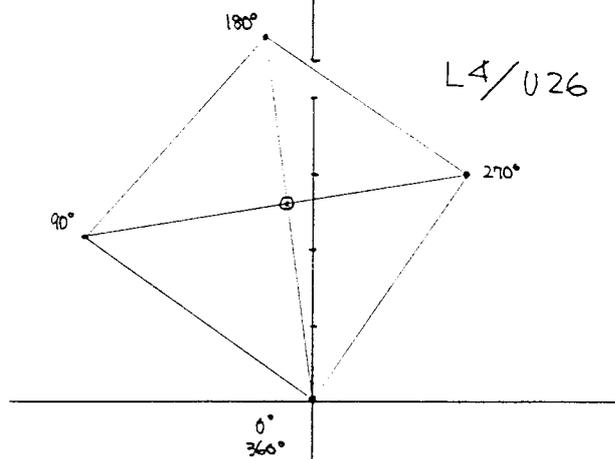
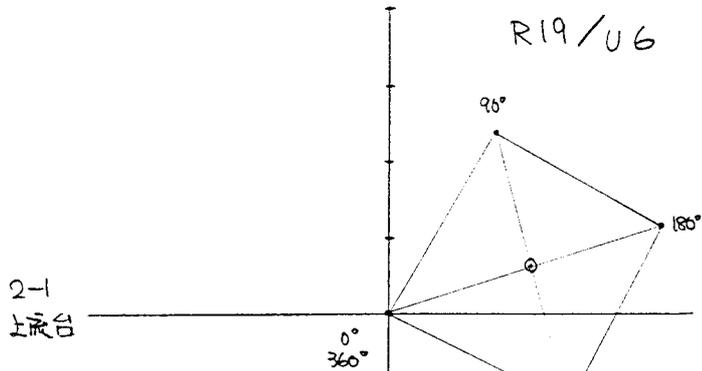


上流用

下流用



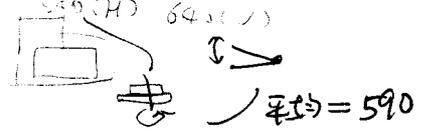
おかし!!



おかし!!

1998.9.3

C1 上流塔塔足からのまわり

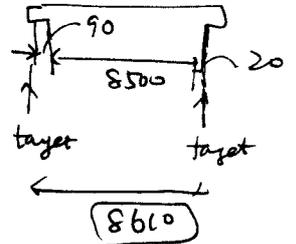


laser $2537 + 192.5 + 354.9 + 150 + 135 + 220 + 1998.5 + 1500 + 530 + 515 + 1000 + 85 + 85$
 $+ 4250 + 1495.5 + 100 + (590) = -15613.4$

LT $-13717.9 \rightarrow -13718$

~~63~~
 @D R0_63U $2537 + 192.5 + 354.9 + 150 + 135 + 220 = -3589.4$
 \rightarrow D $2537 - 50 - 90 - 85 - 43 = -2269$

OTR $+10006$
 -1007



C1U	435	410 (221)	$9600 - 600$	
C1D		-600 (From C2 塔塔足)		9000
C2U		+390	$9600 + 390 =$	9990
C2D		-600	$9600 \times 2 - 600 =$	18600
C3U		+390	$9600 \times 2 + 390 =$	19590
C3D		-600 (-600)	$9600 \times 3 - 600 =$	28195 (28200)
C4U		+390	$9600 \times 3 + 390 =$	29190
C4D		-600	$9600 \times 4 - 600 =$	37800
C5U		+390	$9600 \times 4 + 390 =$	38790
C5D		-600	$9600 \times 5 - 600 =$	47400
C6U		+390	$9600 \times 5 + 390 =$	48390
C6D		-600	$9600 \times 6 - 600 =$	57000
C7U		+390 + 600 = +450	$9600 \times 6 + 450 =$	58050

C7D			$58050 + 8610 =$	66660
GPBBU			$66660 + 1105 - 90 =$	67675
CPBBU			$3970 + 90 + 20$	
C8U			$67675 + 2544 =$	70219
C8D			$71536 + 410 - 90 =$	71856
11U			$80146 + 8610 =$	88756
11D			$81466 + 1410 - 90 =$	82886
12U			$90076 + 8610 =$	98686
12D			$91106 + 1120 - 90 =$	92136
13U			$99716 + 8610 =$	108326
13D			$100726 + 1100 - 90 =$	101736
14U			$109336 + 8610 =$	117946
			$109336 + 1110 - 90 =$	110356

721
85

14 D $110356 + \cancel{8610} = 118966$ 119430
 Q-14 4U $118966 + 1670 - 90 = 120546$ 121010
 D $120546 + \cancel{2610} = 122672$ 123136 123620
 15 U $122672 + 1300 - 90 = 123882$ 124346 124830 eq?
 15 D $123882 + 8610 = 132492$ 133440
 16 U $132492 + 1100 - 90 = 133502$ 134450
 16 D $133502 + 8610 = 142112$ 143060
 17 U $142112 + 1100 - 90 = 143122$ 144070
 17 D $143122 + 8610 = 151732$ 152680

~~19 4U~~
 SX-17-4U $151732 + 1030 = 152762$ 153710
 D $152762 + 400 = 153162$ 154110

BCS MV $+3299$ 156461 157409
 MD $+480$ 156941 157889

Q-17-04U $+340$ 160342 161290
 CSD $+1350$ 161692 162640 163520
 $\frac{2100}{168020}$

SX-21-TU $+588$ 162280 163228
 D $+890$ 163170 164118

21U Target U (210) $+350$ 163520 164468 165300 eq?
 $+280$ 166020 166004 include
 166968 X

164468
 21U 165277
 Target 165777
 166468
 166024

既計算 $Ratio = \frac{L - L_{CIU}}{L_{2IU} - L_{CIU}}$

∴ $DOFX = OFFSETX_{2IU} - OFFSETX_{CIU}$

$DOFY = OFFSETY_{2IU} - OFFSETY_{CIU}$

既入 $\left. \begin{matrix} X \\ Y \end{matrix} \right\}$ 測定値 (X-対指示値) \Rightarrow 理想値 (参考)

~~$DX = X - OFFSETX$~~

~~$DY = Y - OFFSETY$~~

既入 $\left. \begin{matrix} X_{CIU} \\ Y_{CIU} \end{matrix} \right\}$ 測定値 (X-対指示値)

既入 $\left. \begin{matrix} X_{2IU} \\ Y_{2IU} \end{matrix} \right\}$ 測定値 (Y-対指示値)

現場
計算

$DX_{CIU} = X_{CIU} - OFFSETX_{CIU}$

$DY_{CIU} = Y_{CIU} - OFFSETY_{CIU}$

理想
計算

$TGX = - \left[Ratio \cdot (X_{2IU} - X_{CIU}) \right] + DX_{CIU}$

$TGY = - \left[Ratio \cdot (Y_{2IU} - Y_{CIU}) \right] + DY_{CIU}$

目標値

$\left. \begin{matrix} FX \\ FY \end{matrix} \right\}$ 測定値 (指示値)