T1300743-v1

PRM-04 ROC recalculation and tolerances

R. Martin and G. Billingsley

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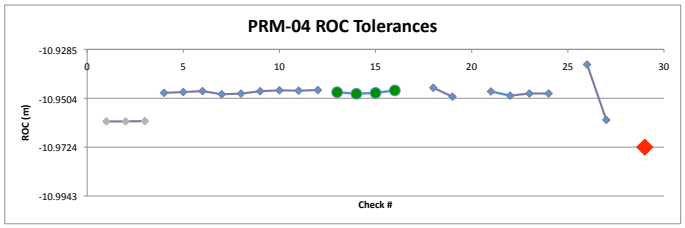
		Individual files												Average files at each rotation			
		0 deg, 120_007	0 deg, 120_001	0 deg, 120_013	0 deg, 120_007	0 deg, 120_001	0 deg, 120_013	90 deg, 120_005	90 deg, 120_019	180 deg, 120_011	180 deg, 120_020	270 deg, 120_006	270 deg, 120_017	Ave 0 deg	Ave 90 deg	Ave 180 deg	Ave 270 deg
Radius of curvature of TS	m	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.493	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933
Gap between TS and part to be measured	m	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192
Zernike power coefficient	nm	**-17.325**	**-17.299**	**-17.519**	**-12.301**	**-12.467**	**-12.668**	**-11.999**	**-12.139**	**-12.648**	**-12.833**	**-12.759**	**-12.884**	**-12.434**	**-12.108**	**-12.286**	**-12.816**
Part measured aperture	mm	50.1	50.1	50.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1
Wavefront "sag" at part plus power	mm	-0.028625	-0.0286248	-0.028625	-0.010344469	-0.010344801	-0.010345	-0.010344	-0.010344	-0.010345	-0.0103	-0.01035	-0.01035	-0.01034	-0.010344	-0.0103444	-0.0103455
Check#		***1***	***2***	***3***	***4***	***5***	***6***	***7***	***8***	***9***	***10***	***11***	***12***	***13***	***14***	***15***	***16***
Part radius	**m**	-10.9608	-10.9608	-10.9607	**-10.9480**	**-10.9476**	**-10.9472**	**-10.9486**	**-10.9483**	**-10.9473**	**-10.9469**	**-10.9470**	**-10.9468**	**-10.9477**	**-10.9484**	**-10.9480**	**-10.9469**
					-10.9475									**-10.9478**			

		Effect of Gap		Effect of mask position				Effect of ROC-TS tolerances		Before 9/11/13
		+2 mm	-2 mm	x0, y+2mm	x0, y-2mm	x+2mm, y0	x-2mm, y0	ROC-TS min	ROC-TS max	PRM-04_S1.dat
Radius of curvature of TS	m	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4933	-11.4808	-11.5058	-11.4933
Gap between TS and part to be measured	m	0.5212	0.5172	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192	0.5192
Zernike power coefficient	nm	**-12.434**	**-12.434**	**-12.589**	**-11.710**	**-12.156**	**-12.163**	**-12.434**	**-12.434**	**-0.810**
Part measured aperture	mm	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1	30.1
Wavefront "sag" at part plus power	mm	-0.0103466	-0.0103429	-0.010345	-0.010343	-0.010344	-0.010344192	-0.010356502	-0.010332992	-0.010321486
Check#		***18***	***19***	***21***	***22***	***23***	***24***	***26***	***27***	***29***
Part radius	**m**	**-10.9457**	**-10.9497**	**-10.9474**	**-10.9493**	**-10.9483**	**-10.9483**	**-10.9353**	**-10.9602**	**-10.9724**
		2.0	-2.0	0.3	-1.5	-0.6	-0.6	12.4	-12.4	
								Difference from Ave 0 deg		
								14.8		
								-17.1	(cumulative)	

Specified Radius	**m**	**-11.00**
	(+/-0.11)	**-10.89**
		-11.11

ROC (m) = -10.9478 m **Cumulative -17.1 mm**
Tolerances: 14.8 mm