



Notes:  
 Attach and carefully align items 3, Pole Inserts to item 1, Core - (machined) and use items 5 and 6 to secure. Use 1/4 inch holes in items 3 to locate holes for item 4, 1/4 inch dia. x 1/2 inch long dowels. Match drill and insert dowels.

Assemble coil to core and use items 7. Locate items 7, coil holder blocks. Mark location of 1/4-20 threaded holes. Drill and tap at marked locations. Assemble items 7 and attach using items 8, socket head capscrews.

REV	DESCRIPTION	DWN	CHKR	APV	DATE

REV	ITEM	PART NO.	DESCRIPTION
8	8	---	1 inch long 1/4-20 NC Sk. Head Capscrews
4	7	LCLS422A	Coil Holder Block
8	6	---	1/4 inch Washer
8	5	---	1.25 inch long 1/4-20 NC Hex Head Bolt
4	4	---	Stainless Dowel --- 0.25 dia. x 0.50 long
2	3	LCLS072A	POLE INSERT
1	2	LCLS2006A	UPPER COIL BRAZEMENT ASSEMBLY
1	1	LCLS066-1	Upper CORE - MACHINING DETAIL

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED	SHOP ORDERS	DEGREASE	TAG	PATENT CLEAR	DWG. TYPE	SHOW ON	SCALE	QUARTER	DO NOT SCALE
X ± .1 XX ± .01 XXX ± .001	FRAC ± 1/64 ANGLES ± 1° FINISH 125	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES: BREAK EDGES 0.005-0.015 INTERNAL CORNERS R.015 MAX FRACTIONS 1/16 DEC .XX ± --- .XXX ± --- .XXXX ± --- ANGLE ± --- ALL SURF.	TAG Jack Tanabe 07-31-06 00:00:00	PATENT CLEAR Dwg No. 000000 9999-99	DWG. TYPE Detail 9999-99	SHOW ON 000000 999999	SCALE Quarter	QUARTER LCLS436	DO NOT SCALE SIZE A

DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ASME Y14.5M-1994. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES: BREAK EDGES 0.005-0.015 INTERNAL CORNERS R.015 MAX FRACTIONS 1/16 DEC .XX ± --- .XXX ± --- .XXXX ± --- ANGLE ± --- ALL SURF.	SCALE: NONE DO NOT SCALE DRAWING CAD FILE NAME: sa38031743-0.dft STANFORD LINEAR ACCELERATOR CENTER U.S. DEPARTMENT OF ENERGY STANFORD UNIVERSITY STANFORD, CALIFORNIA PROPRIETARY DATA OF STANFORD UNIVERSITY AND/OR U.S. DEPARTMENT OF ENERGY. RECIPIENT SHALL NOT PUBLISH THE INFORMATION WITHIN UNLESS GRANTED SPECIFIC PERMISSION OF STANFORD UNIVERSITY.	LCLS MAGNET SYSTEMS BXS MAGNET ASSY UPPER HALF MAG SUBASSY LBL-LCLS436 A DRAWING NUMBER: SA-380-317-43 REVISION NUMBER: 0 SIZE: E
---	---	---

SA-380-317-43 0 E