

LCLS II Magnet Fiducialization Report

3D39 Dipole



Barcode # : 4501
MFG S/N:16080
Part Num: AD 253-623-30 R1

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

Symmetry Plane between Upper and Lower plates of magnet housing

Coordinate Origins

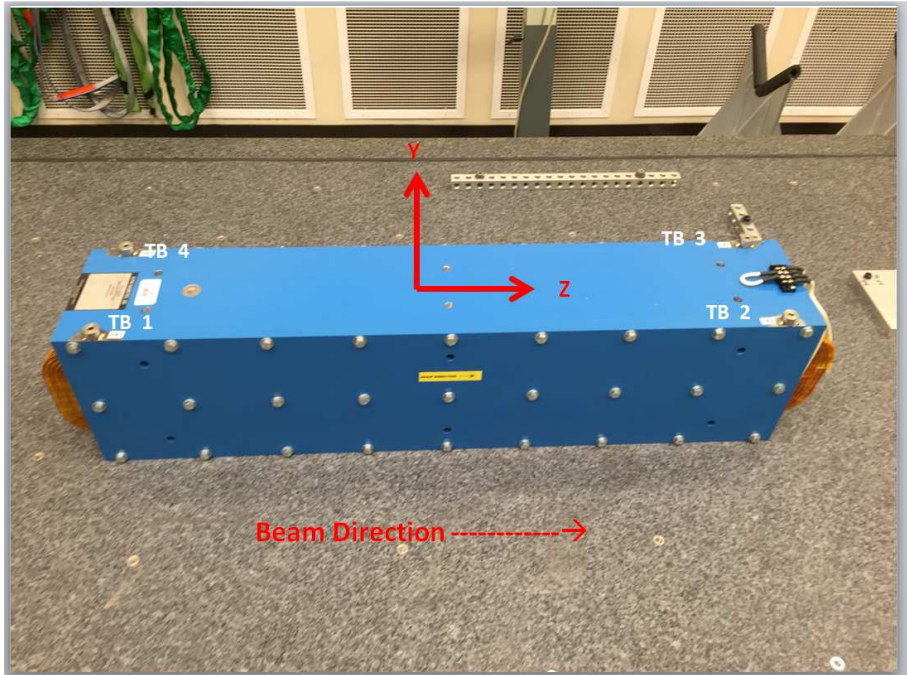
X Origin - Symmetry Plane between poles

Y Origin - Symmetry Plane between Top and Bottom housing plates

Z Origin - Symmetry plane between Up Stream and Down Stream end surfaces

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Tooling Ball Locations



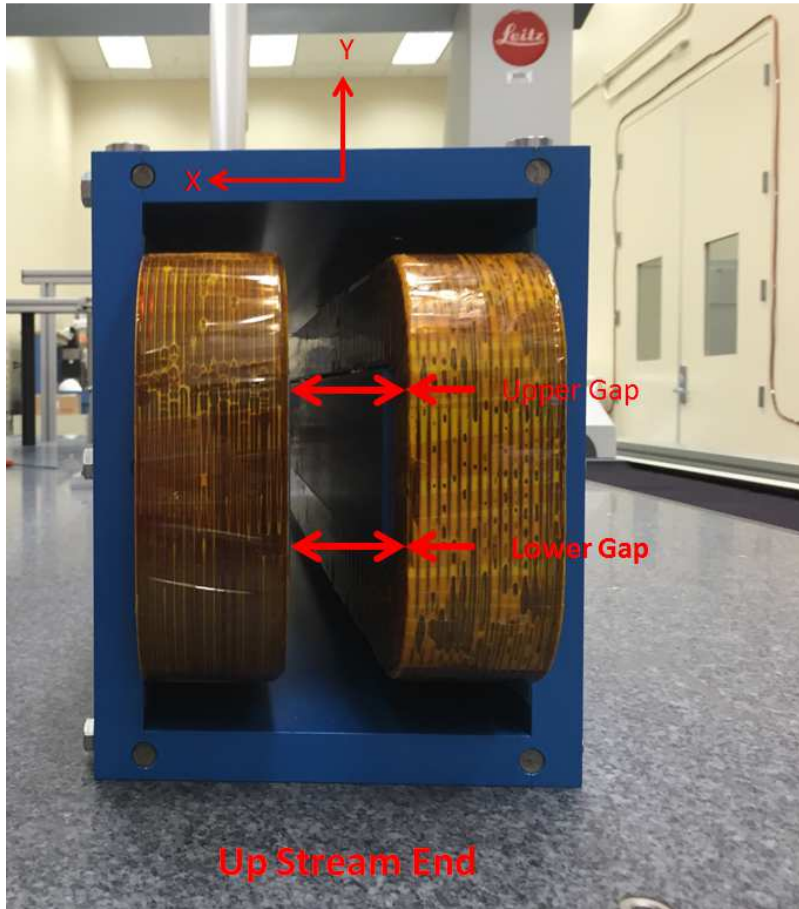
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	-3.28565	6.25749	-17.48993
TB 2	-3.30190	6.25649	17.51330
TB 3	3.29033	6.25482	17.54064
TB 4	3.30273	6.25228	-17.50223
TB A	-3.28540	5.56999	-17.49070
TB B	-3.30158	5.56897	17.51333
TB C	3.29040	5.56739	17.53992
TB D	3.30221	5.56495	-17.50206

Tooling Ball Locations (1-4) are 1 inch above top surface TB socket
 Tooling Ball Locations (A-D) are 5/16 inch above top surface TB socket

Dimensions in Inch

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Pole Tip Gap Measurements



Pole Tips looking Down Stream

Location	Measured Gap
Upstream Lower	1.37631
Upstream Upper	1.37633
Downstream Lower	1.37631
Downstream Upper	1.37633

Dimensions in Inch

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