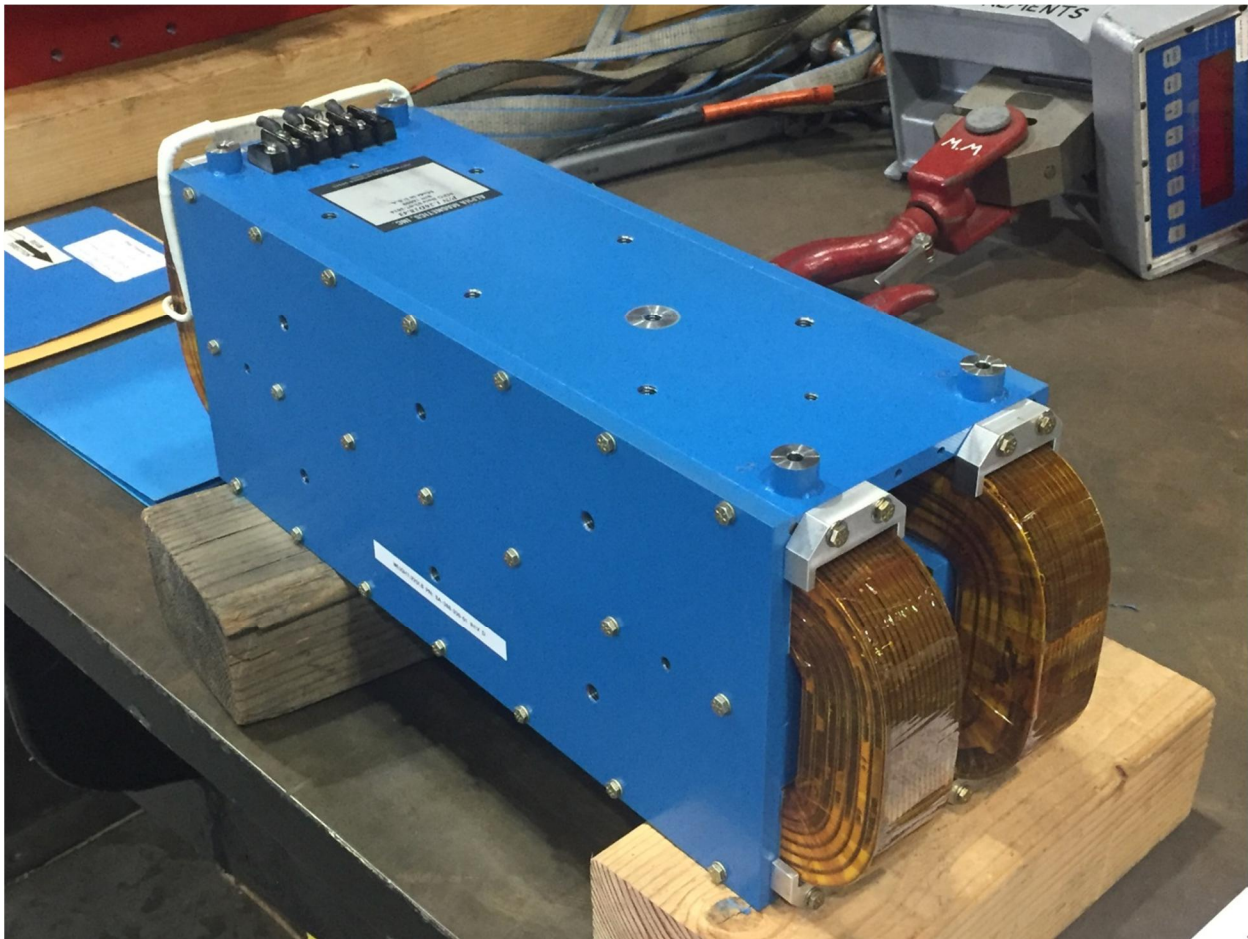


LCLS II Magnet Fiducialization Report

1.26D18.43 Dipole Magnets



Inspector : AEG
Engineer : J. Amann
Drawing No. : SA-388-330-01
Barcode # : 4507
Mfg. S/N : 16089

Coordinate System Setup

Measured 6 planes:

Left and Right pole faces, Upstream and Downstream of both poles combined, Top and Bottom of both poles combined.

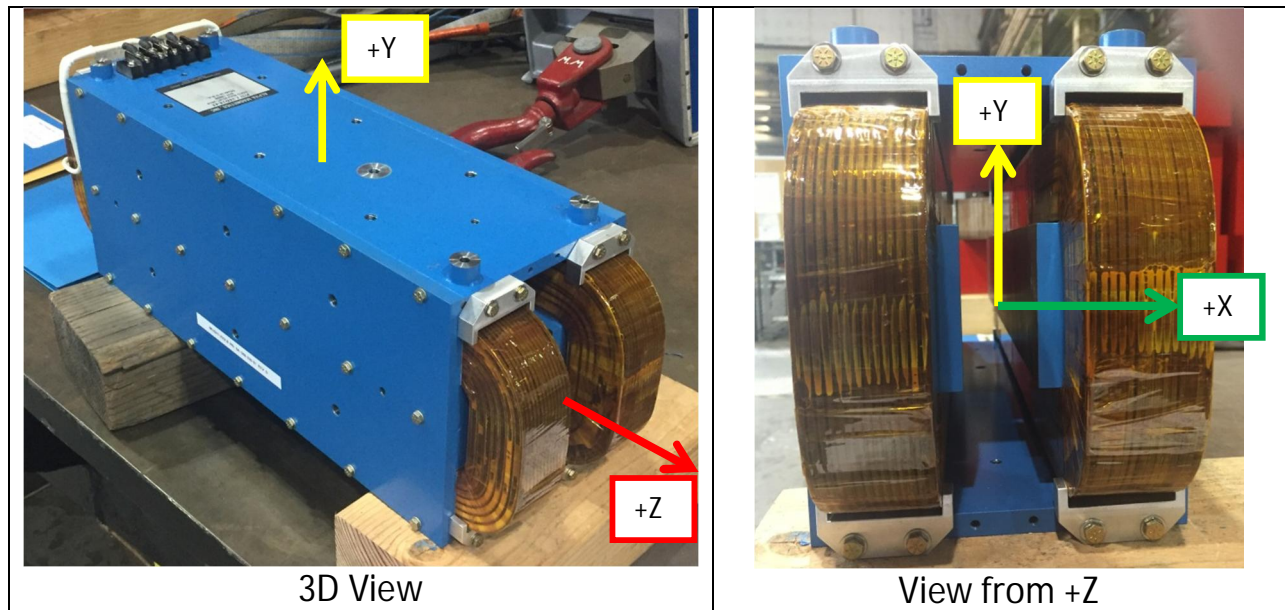
Constructed 3 mid planes from:

Left and Right, US and DS, Top and Bottom

Intersected the 3 mid planes to construct the Origin.

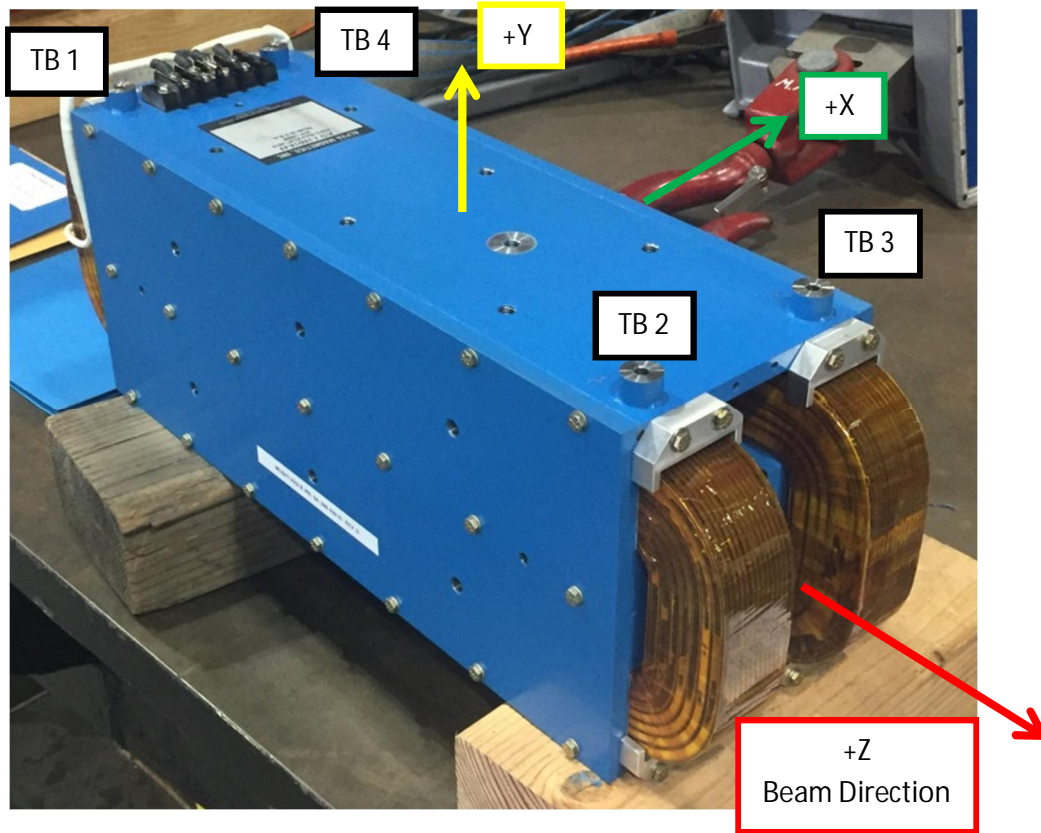
Primary axis is vector of Left/Right(Roll and Yaw).

Secondary axis is vector of Top/Bottom (Pitch).



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Tooling Ball Locations



Tooling Ball	Z(in)	X(in)	Y(in)
TB 1	-8.7432	-2.1881	5.4116
TB 2	8.7475	-2.1875	5.4137
TB 3	8.7524	2.1908	5.4148
TB 4	-8.7457	2.1849	5.4098
TB A	-8.7423	-2.1875	4.7244
TB B	8.7509	-2.1876	4.7263
TB C	8.7544	2.1907	4.728
TB D	-8.7448	2.1848	4.7228

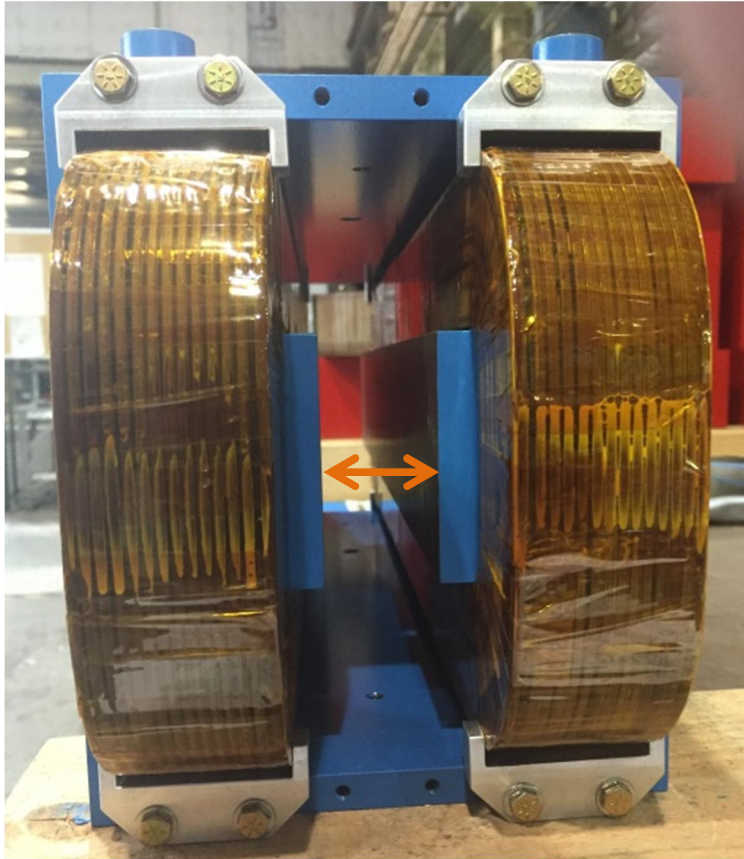
** Tooling Ball Locations (1-4) are 1 inch above top surface TB Socket

** Tooling Ball Locations (A-D) are 5/16 inch above top surface TB Socket

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Pole Tip Gap Measurements



Pole Tip view from +Z (Downstream End)

Location	Pole Tip Gap
Upstream End (1.260 Nom.)	1.2571
Downstream End (1.260 Nom.)	1.2571

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