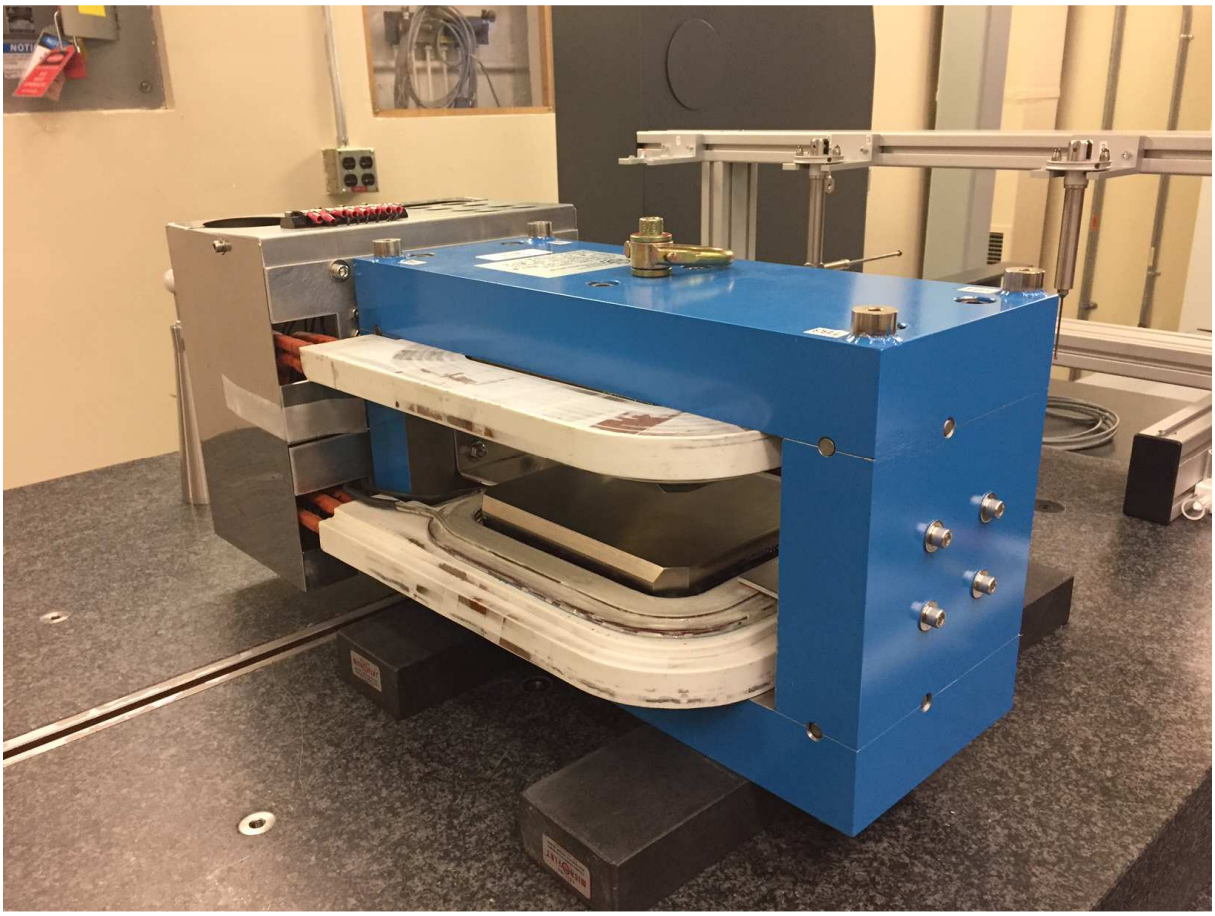
LCLS II Magnet Fiducialization Report

1.69D6.28T Dipole



Inspector : K. Caban

Engineer : J. Amann

Drawing No. : SA-388-320-05 R1

Barcode # : 4514

Mfg. S/N : 004

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

Symmetery Plane between the side planes of (2X) Poles

Coordinate Origins

X Origin - Symmetry Plane between poles

Y Origin - Symmetery Plane between the side planes of (2X) Poles

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

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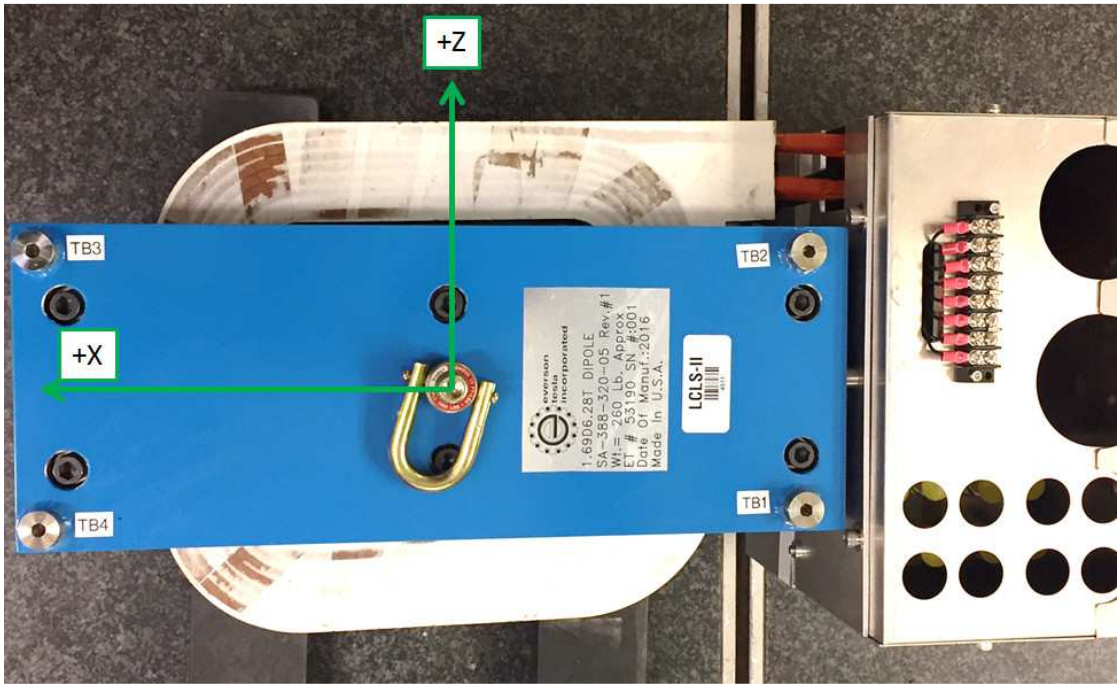
Tooling Ball Locations



Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	-7.26839	6.22444	-2.63507
TB 2	-7.26261	6.22538	2.62778
TB 3	7.75608	6.22518	2.63322
TB 4	7.73656	6.22440	-2.63165
TB A	-7.26818	5.53748	-2.63361
TB B	-7.26413	5.53810	2.62909
TB C	7.75450	5.53803	2.63414
TB D	7.73558	5.53710	-2.63107

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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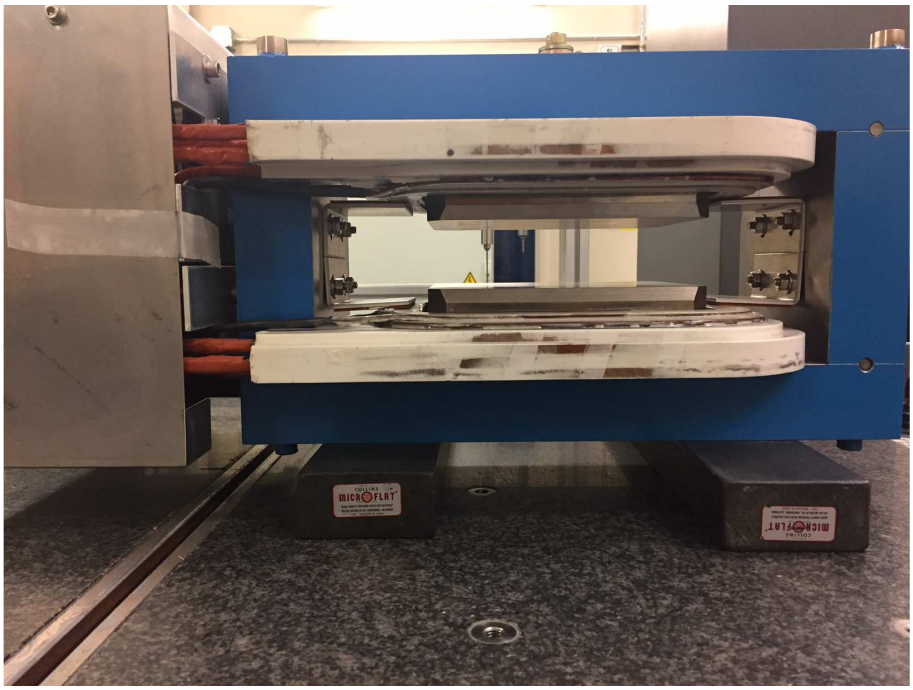
Pole Gap Measurements



	Nominal Gap	Average Gap	Minimum Gap	Pole Parallelism
Pole Gap	1.693 ± 0.002	1.69486	1.69488	0.00101

Dimensions in Inch

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