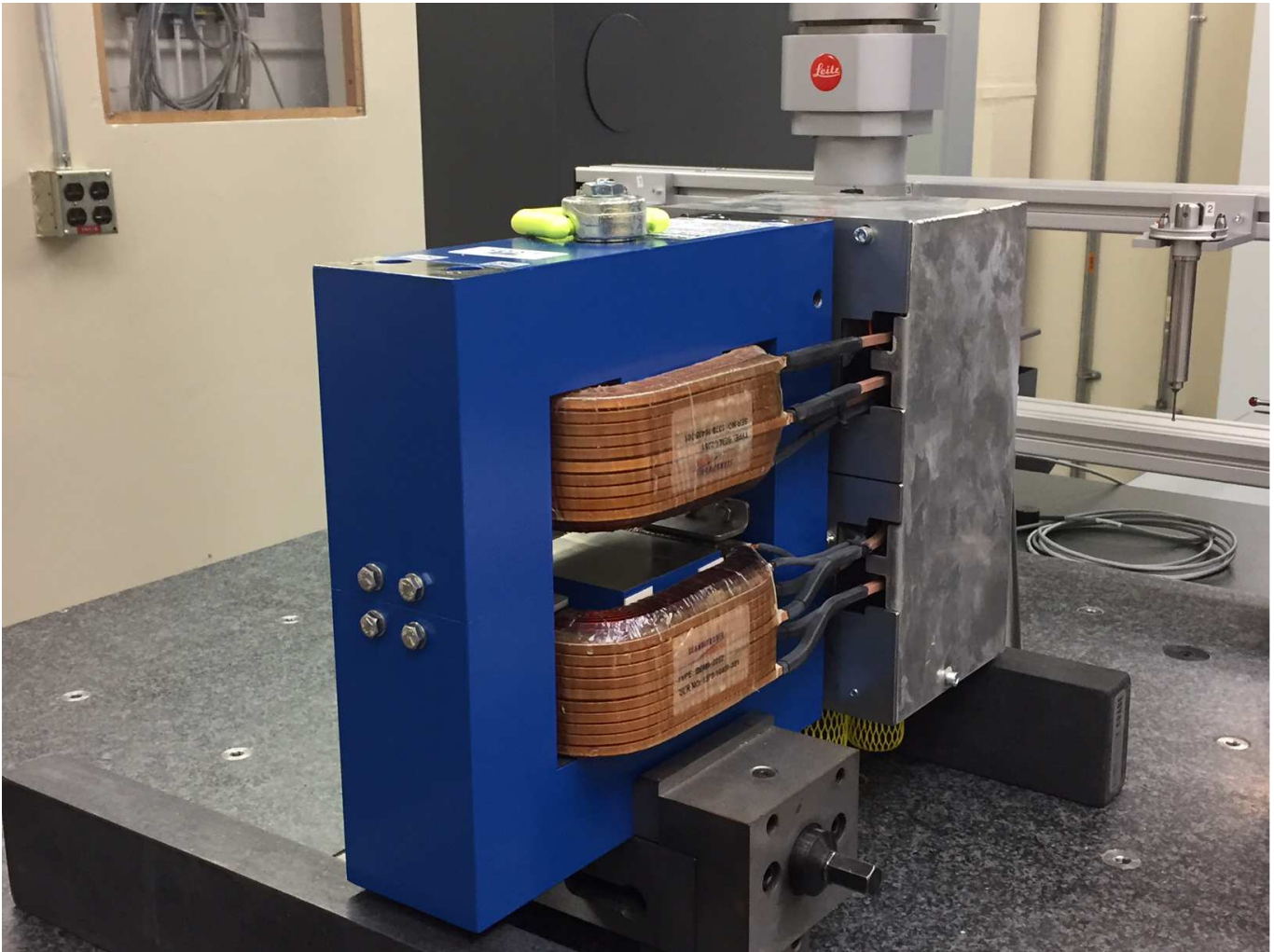


LCLS II Magnet Fiducialization Report Injector Laser Heater Chicane 5D3.9 Dipole



Inspector : K. Caban
Engineer : J. Amann
Drawing No. : SA-380-331-12
Barcode # : 4515
Mfg. S/N : 16082-1

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

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

Coordinate Origins

X Origin - Symmetry Plane between poles

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

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

Barcode # : 4515

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Tooling Ball Locations



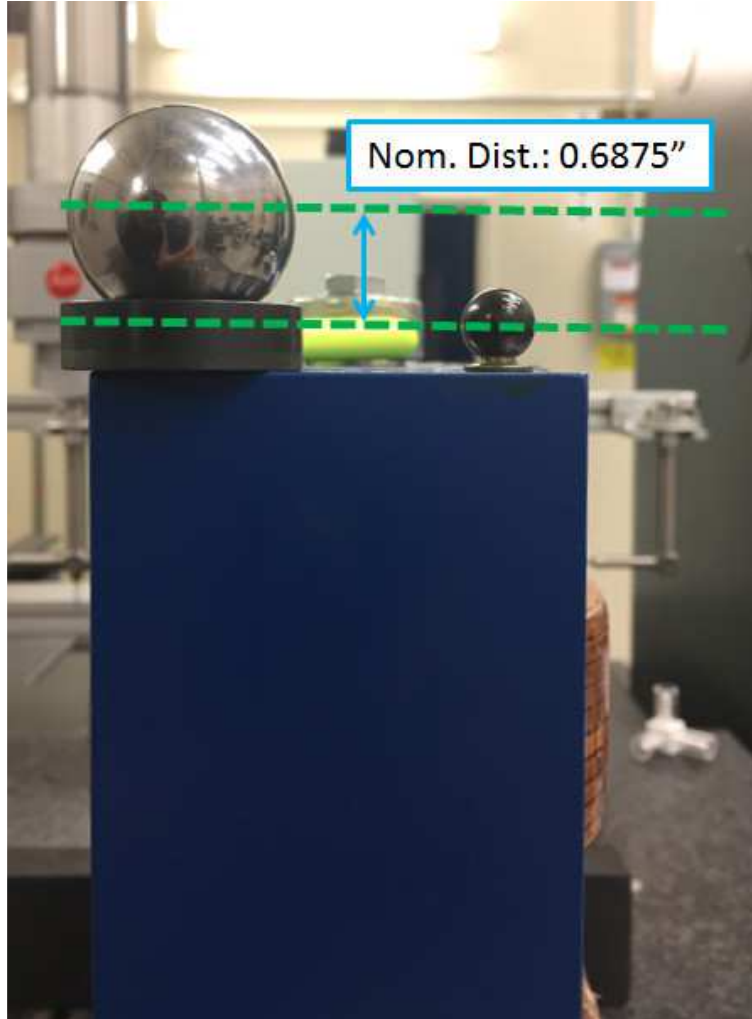
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	5.1980	6.5145	-1.0596
TB 2	5.1996	6.5166	1.0651
TB 3	-5.1945	6.5157	1.0569
TB 4	-5.1963	6.5148	-1.0638
TB A	5.2001	5.8290	-1.0569
TB B	5.1998	5.8303	1.0665
TB C	-5.1943	5.8294	1.0562
TB D	-5.1942	5.8293	-1.0663

Tooling Ball Locations (1-4) are 1 inch above Tooling Ball Plane
 Tooling Ball Locations (A-D) are 5/16 inch above Tooling Ball Plane
 Dimensions in Inch

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1" Tooling Ball to 5/16" Tooling Ball Difference



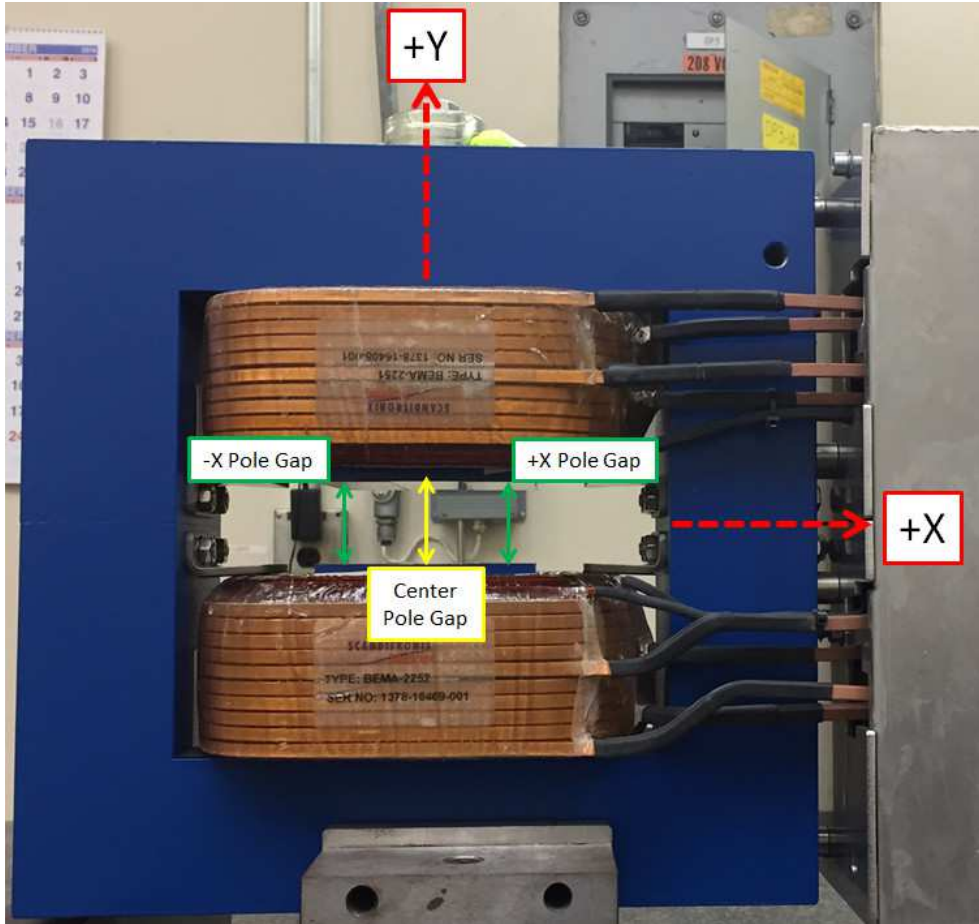
Tooling Ball	Nom Dist.	Actual Dist.	ACT-NOM
TB 1	0.6875 ± 0.001	0.6855	-0.0020
TB 2	0.6875 ± 0.001	0.6863	-0.0012
TB 3	0.6875 ± 0.001	0.6863	-0.0012
TB 4	0.6875 ± 0.001	0.6855	-0.0020

Dimensions in Inch

Barcode # : 4515

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Pole Gap Measurements



	U/S -X	U/S +X	D/S -X	D/S +X	U/S CENTER	D/S CENTER
GAP DIST.	1.18171	1.18172	1.18188	1.18187	1.19707	1.19719

Dimensions in Inch

Barcode # : 4515

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