

LCLS II Magnet Fiducialization Report XLEAP Dipole Magnet - 11mm Gap



Inspector : K. Caban
Engineer : J. Amann
Drawing No. : DRW-20171114-8425
Barcode # : 4551-BCXXL2
Mfg. S/N : SLM3_02

Coordinate System Setup

Spatial Alignment

Constructed using the Midplane of Upper (+Y) and Lower (-Y) Pole with the Midplane of the 2 Poles sets Y Zero and the Y+ Direction points towards the Tooling Balls/Terminal Strip.

Planar Alignment

Constructed using the Upstream (-Z) and Downstream (+Z) Ends of the poles. The Midplane from both ends sets Z Zero and +Z points towards TB 3/4 Side.

Coordinate Origins

X Origin - Symetry Plane between side poles planes (planes parallel to the Coils)

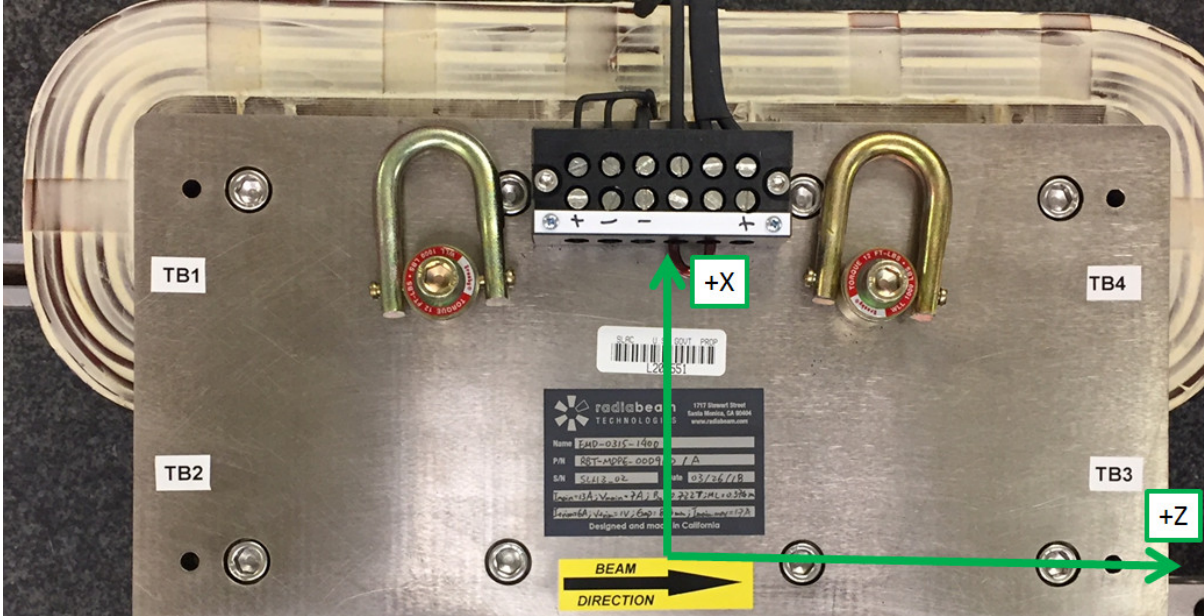
Y Origin - Symetry Plane between the Poles (.315 Gap Symetry)

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

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Tooling Ball Locations



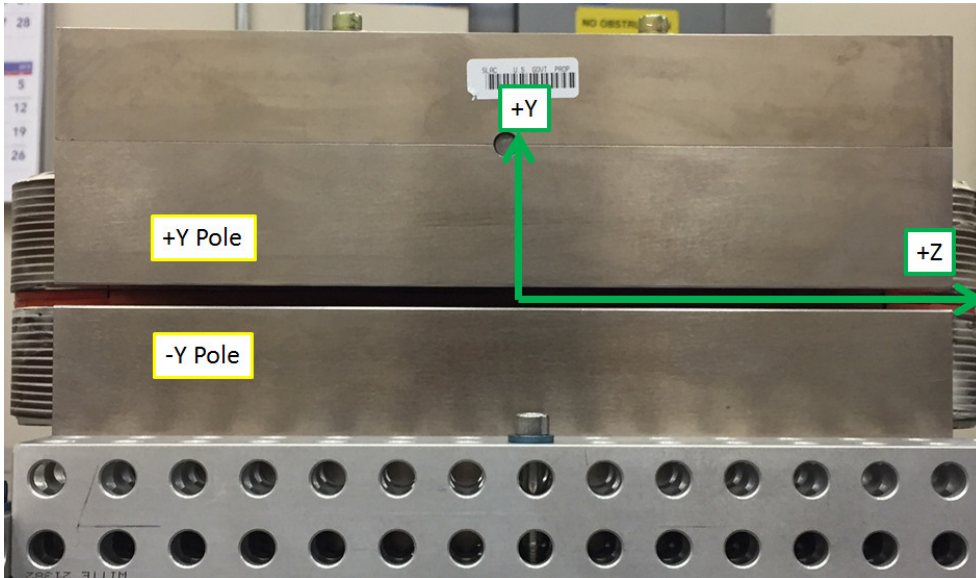
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	4.9868	5.1359	-6.2494
TB 2	0.0004	5.1360	-6.2488
TB 3	-0.0001	5.1362	6.2504
TB 4	4.9872	5.1361	6.2511
TB A	4.9871	4.4484	-6.2486
TB B	0.0002	4.4485	-6.2487
TB C	-0.0003	4.4487	6.2506
TB D	4.9869	4.4486	6.2511

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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Pole Gap Measurements, Flatness & Parallelism



	-Y Pole Fltns	+Y Pole Fltns	Pole Parallel	Avg. Gap	Min. Gap	Max. Gap
POLE DATA	0.0006	0.0004	0.0007	0.4328	0.4323	0.4334

Dimensions in Inch

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