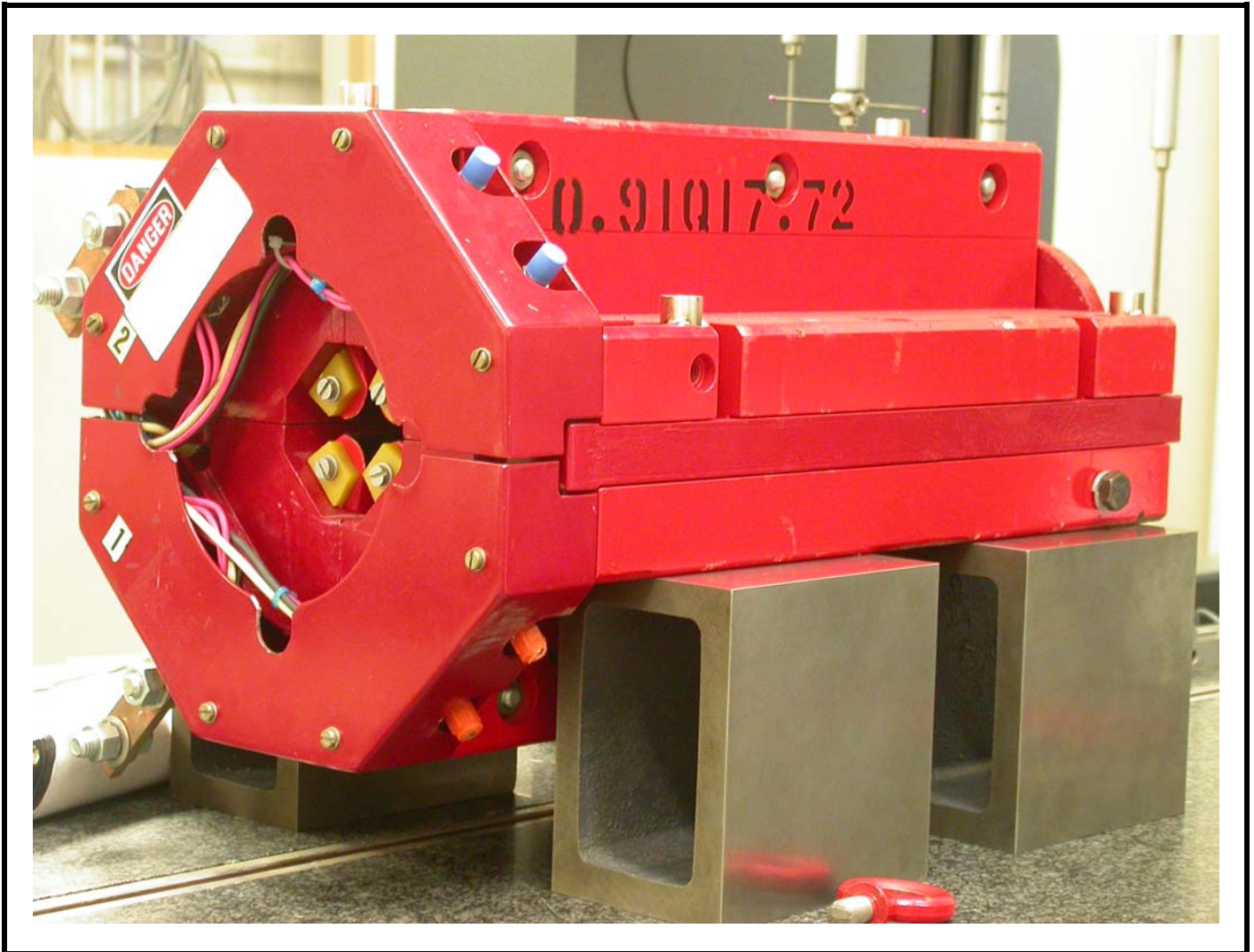


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Thursday, March 01, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000322
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000322.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

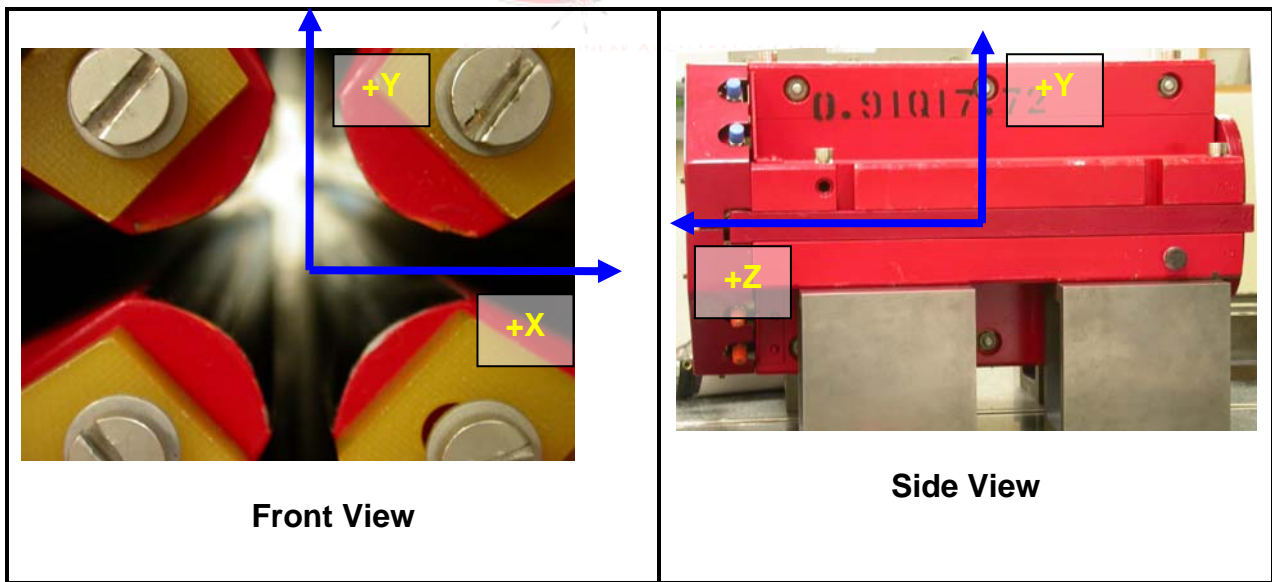
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

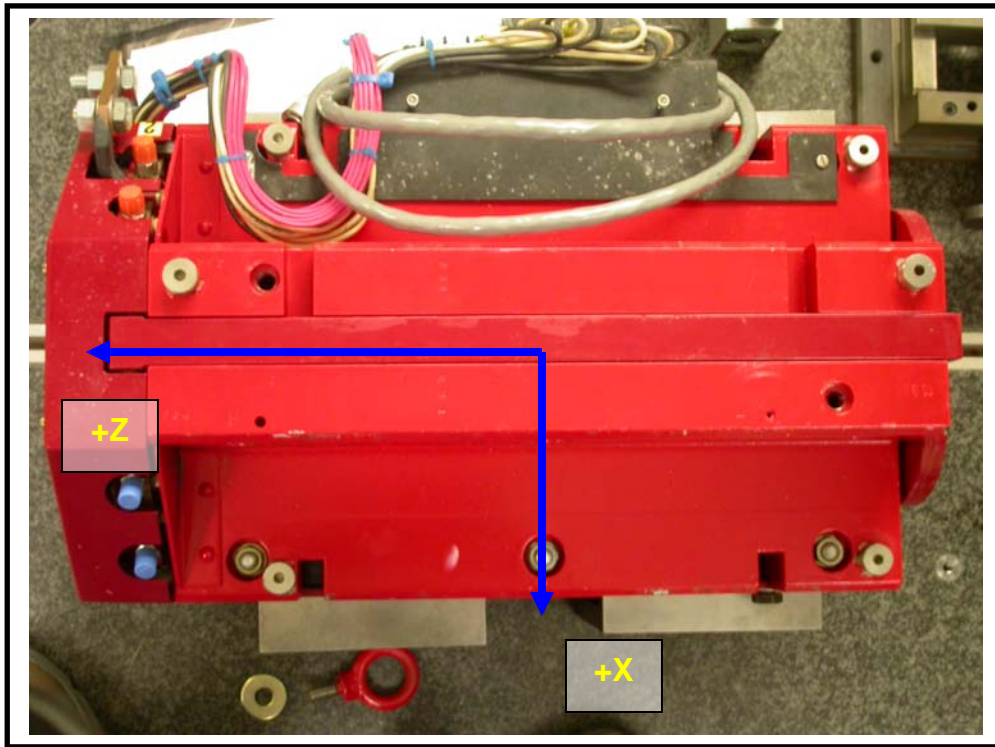


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00032	0.49766	5.02721	3.70244	-8.04899
TB B	0.00004	0.49883	-1.42687	7.32835	-8.06191
TB C	0.00007	0.49849	-5.05671	3.70402	-8.05395
TB D	0.00028	0.49937	-5.24656	3.70324	6.31254
TB E	0.00015	0.49840	-1.39451	7.32800	8.11396
TB F	0.00029	0.49717	5.25541	3.70221	6.28085

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90633	0.90575	0.00058
B-D	0.90689	0.90698	0.00009

