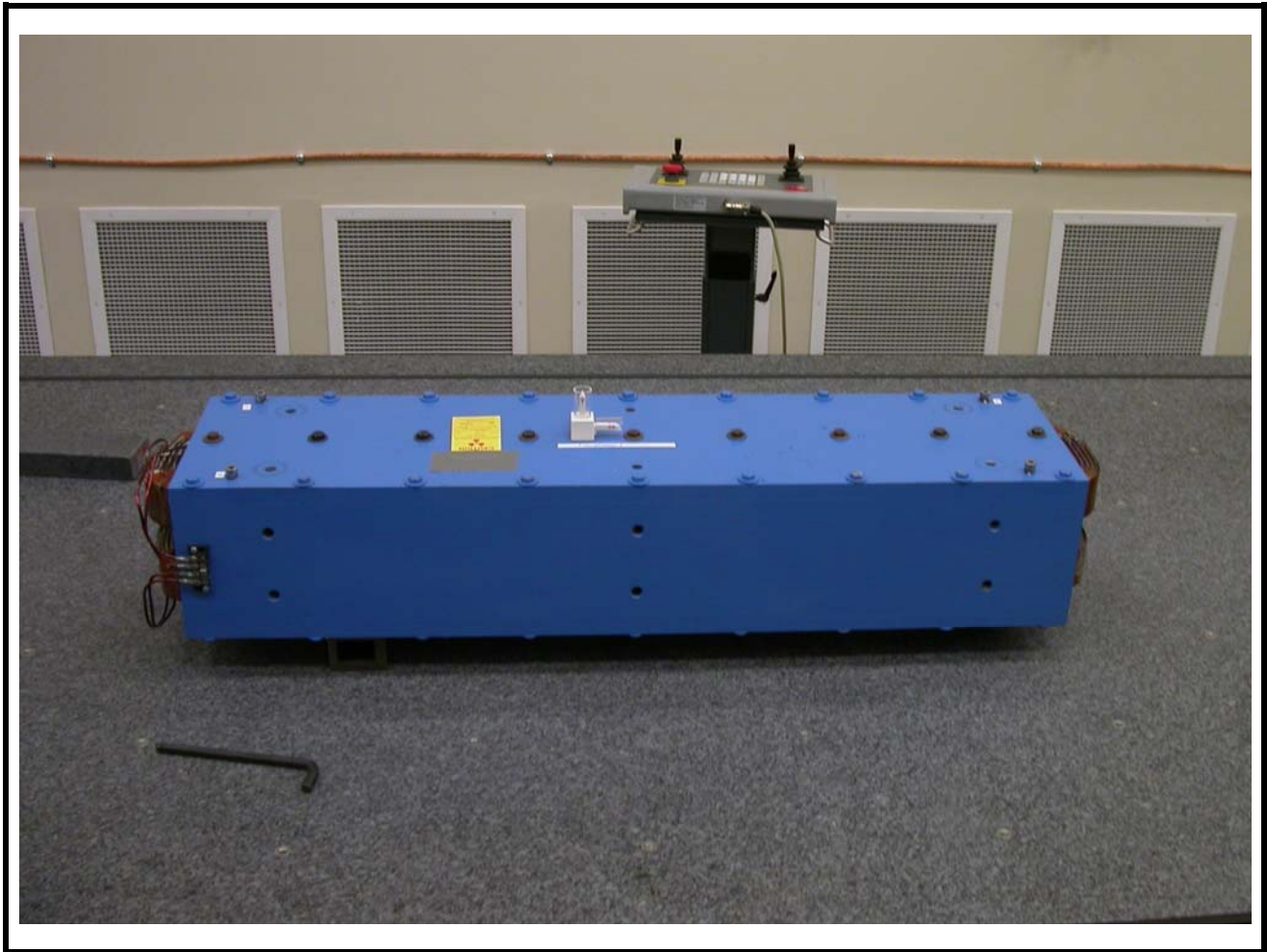


LCLS Dipole Magnet FIDUCIALIZATION REPORT



Inspector: Ed Reese
Responsible Engineer: Carl Rago
Date: Monday, February 12, 2007
Work Order/Charge No.: 21697-1
Serial Number 000354
URL of Fiducial Report: \\Web002\www-group\met\Quality\FIDUCIAL_REPORTS\LCLS_DIPOLE\000354.PDF

Part Set-up – Coordinate System Set-up

Planar Alignment

- Symmetry Axis between inner side plates of housing

Spatial Alignment

- Symmetry Plane between upper and lower poles

“Z” Zero

- Symmetry Point between faces perpendicular to beam

“X” Zero

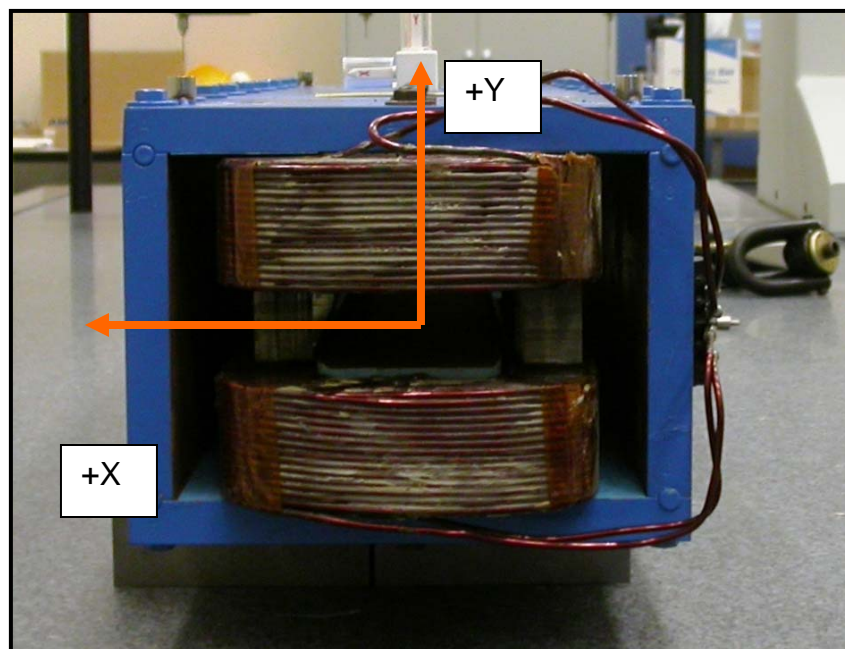
- Symmetry Axis between Inner side plate of housing

“Y” Zero

- Symmetry Plane between upper and lower poles



-Z End View



Tooling Ball Measurements/Locations



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB 1	0.00002	0.50000	3.87609	5.16472	-17.03492
TB 2	0.00046	0.49832	-3.85739	5.16609	-16.97847
TB 3	0.00013	0.49758	3.92304	5.16869	16.97503
TB 4	0.00011	0.49921	-3.86078	5.16535	16.99323

Additional Requested Measurements

LOCATION	POLE DISTANCE
-X/-Z	1.37563
+X/-Z	1.37646
-X/+Z	1.37886
+X/+Z	1.38027