

## LCLS BC 1 Magnet FIDUCIALIZATION REPORT

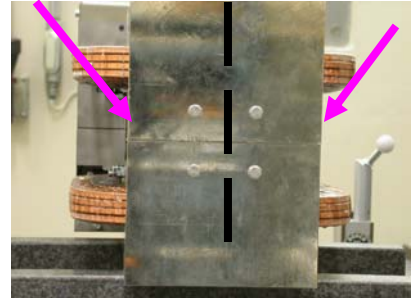


Inspector: Keith Caban  
Responsible Engineer: Jose Chan  
Date: Wednesday, August 30, 2006  
Work Order/Charge No.: 92-4223-2  
Serial Number: 001077  
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS BC1 MAGNETS\LCLS BC1 001077.pdf>

## Part Set-up – Coordinate System Set-up

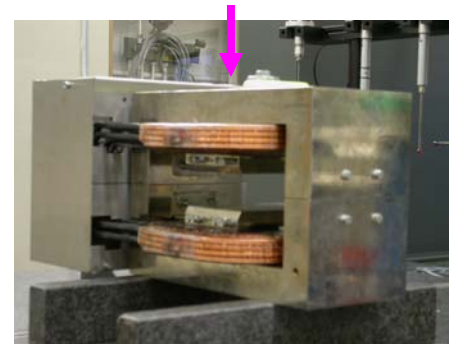
### Planar Alignment

- Mid-Plane of the magnet



### Spatial Alignment

- Top of magnet where label is.



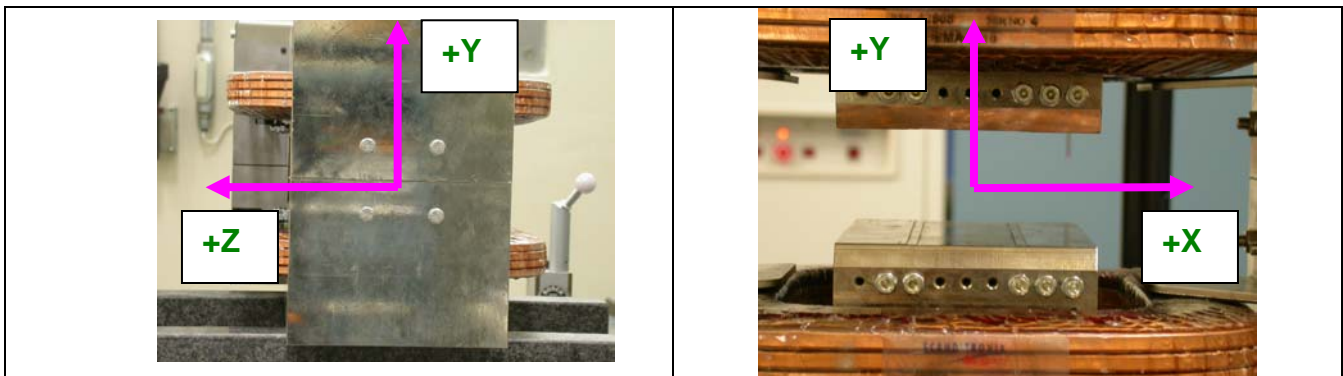
### “Z” Zero

- Mid-Plane of the magnet.

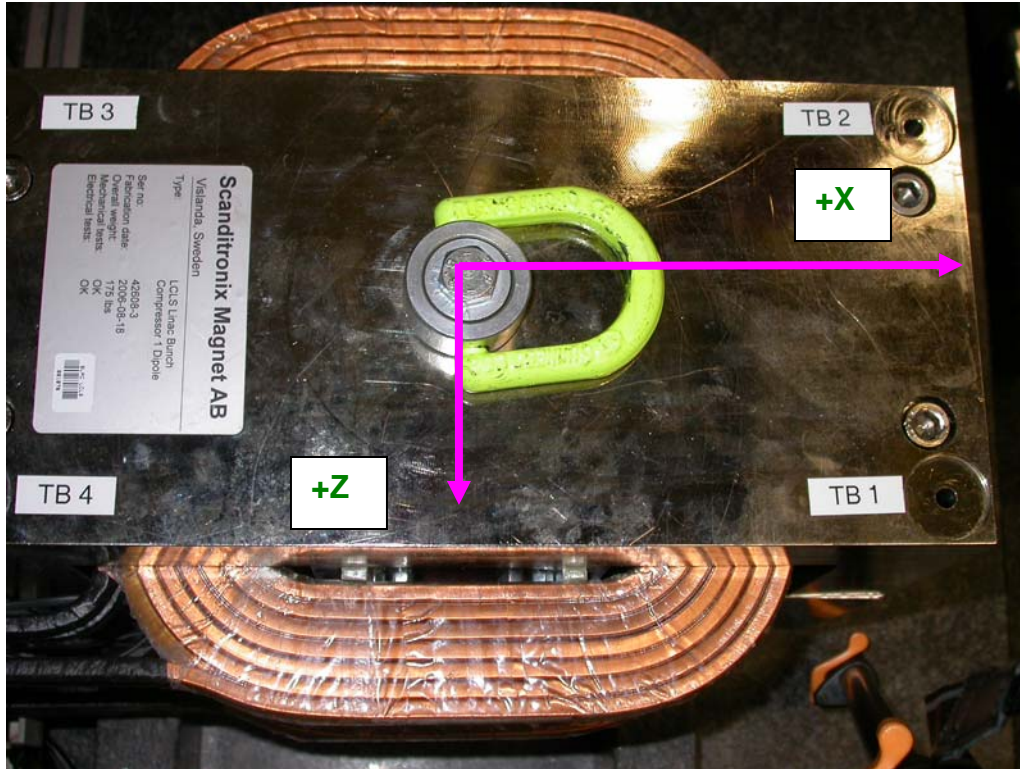


### “X” & “Y” Zero

- X zero is created by the symmetry point of the inner stainless steel where coils lie.
  - Both ends of both sides.
    - Create lines which is y axis.
      - This Creates X- zero
- Symmetry of pole planes
  - This creates Y- zero



## Tooling Ball Measurements/Locations



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB 1	0.00012	0.50007	6.02220	5.66767	2.53197
TB 2	0.00013	0.50010	6.02276	5.66858	-2.53030
TB 3	0.00519	0.49440	-6.06162	5.67290	-2.53617
TB 4	0.00094	0.49660	-6.06150	5.67420	2.52897