

LCLS BC 1 Magnet FIDUCIALIZATION REPORT

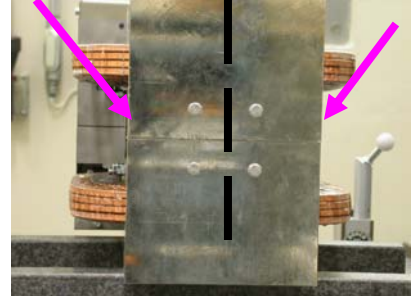


Inspector: Keith Caban
Responsible Engineer: Jose Chan
Date: Wednesday, August 30, 2006
Work Order/Charge No.: 92-4223-2
Serial Number: 001079
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS BC1 MAGNETS\LCLS BC1 001079.pdf>

Part Set-up – Coordinate System Set-up

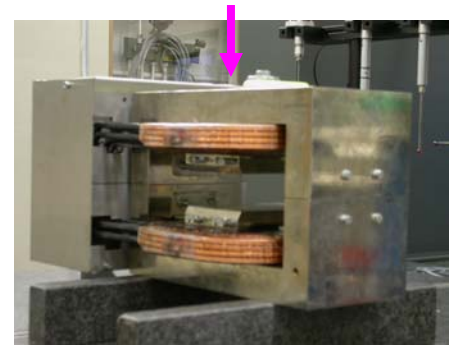
Planar Alignment

- Mid-Plane of the magnet



Spatial Alignment

- Top of magnet where label is.



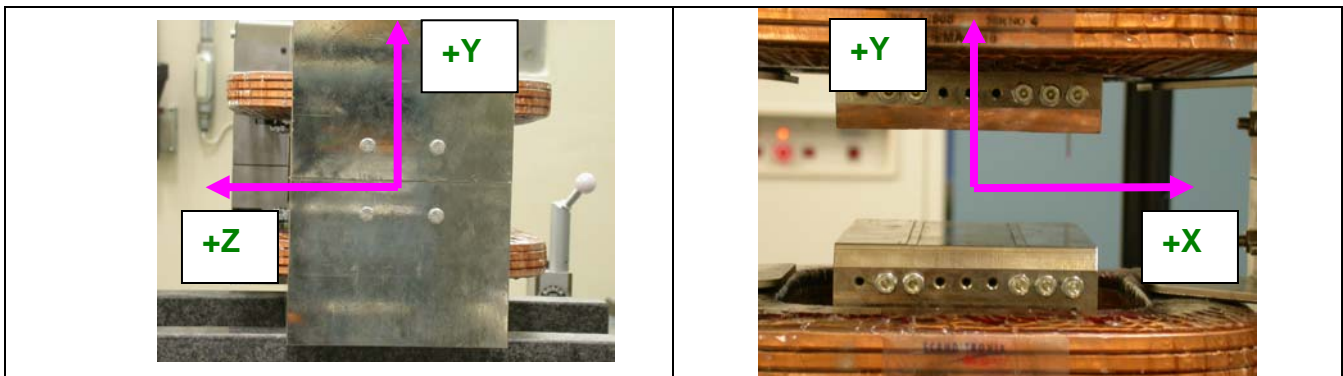
“Z” Zero

- Mid-Plane of the magnet.

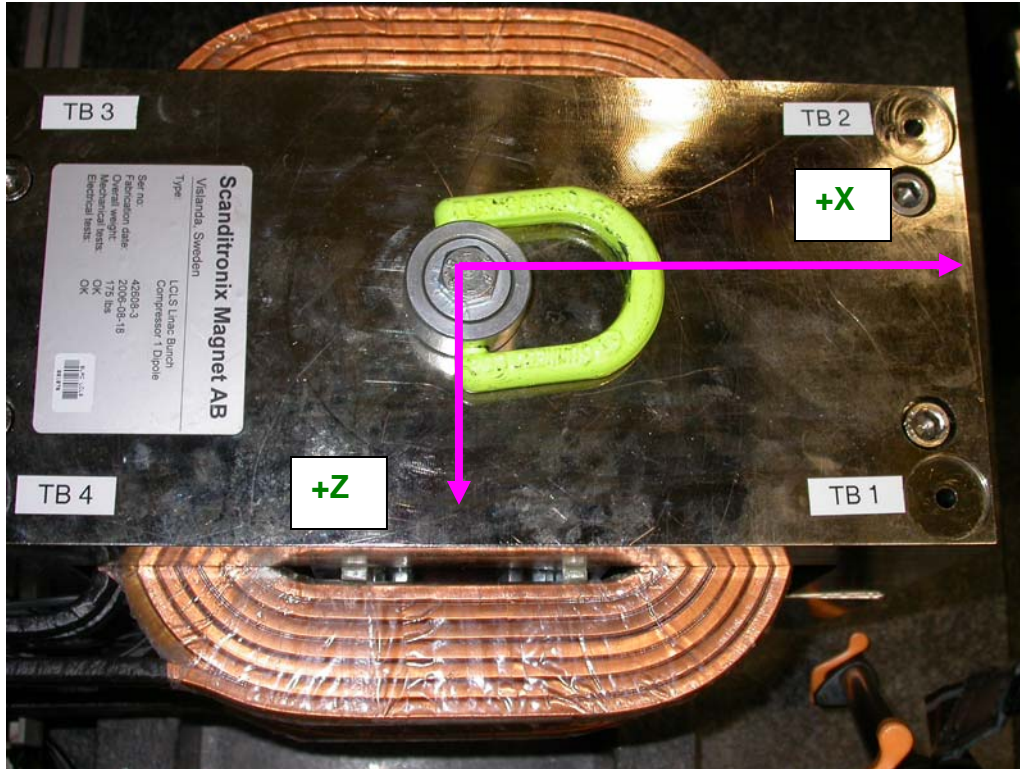


“X” & “Y” Zero

- 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	0.00175	0.49348	6.04664	5.67496	2.53349
TB 2	0.00156	0.49437	6.04706	5.67498	-2.53959
TB 3	0.00118	0.49697	-6.04133	5.67492	-2.53203
TB 4	0.00138	0.49555	-6.04619	5.67602	2.52562