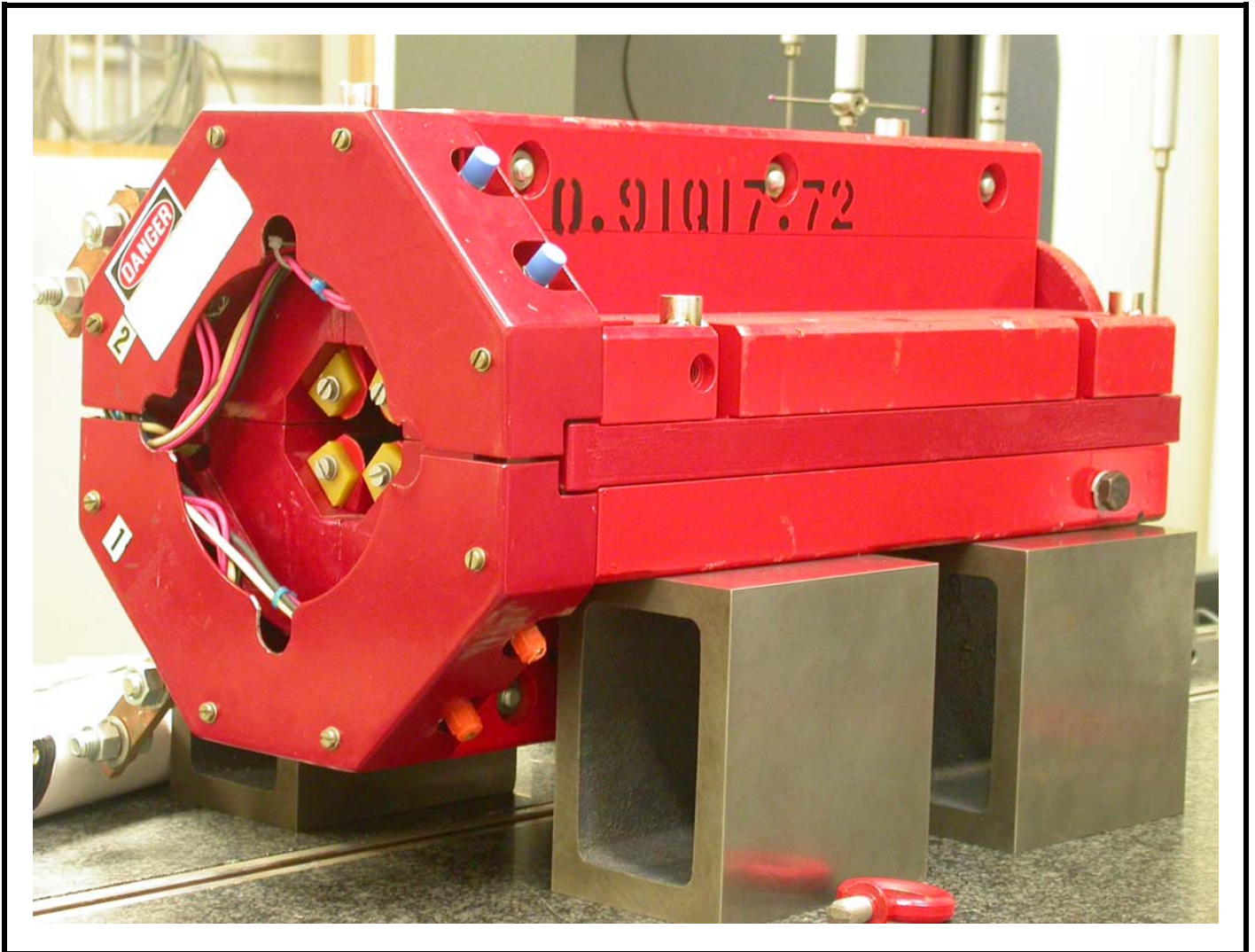


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Friday, February 23, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000218
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000218.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

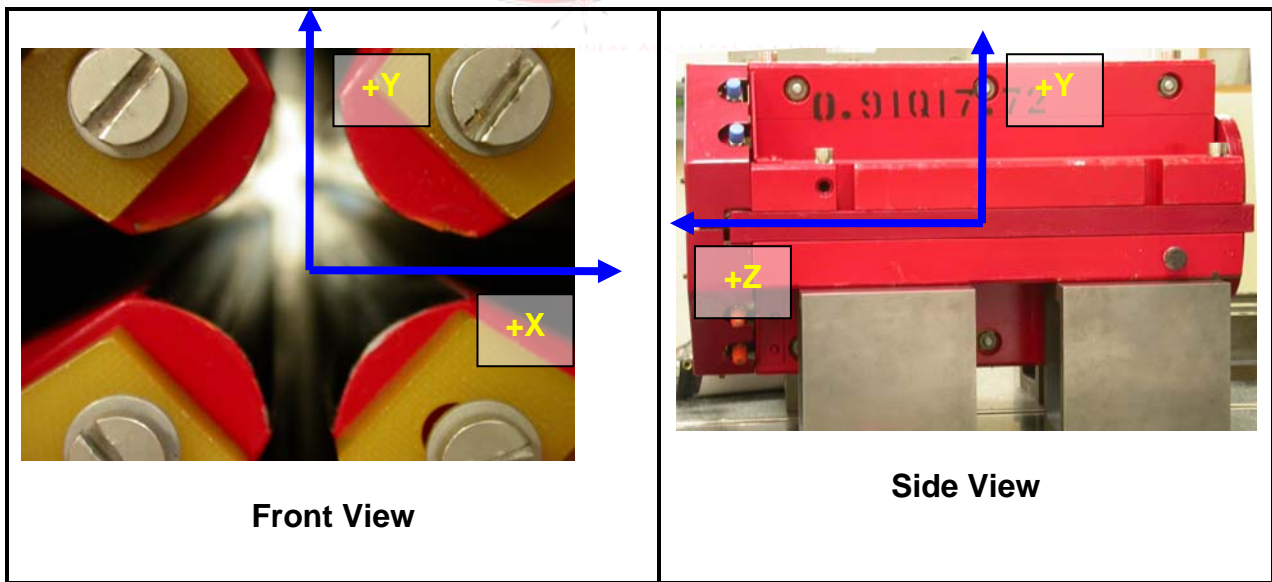
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

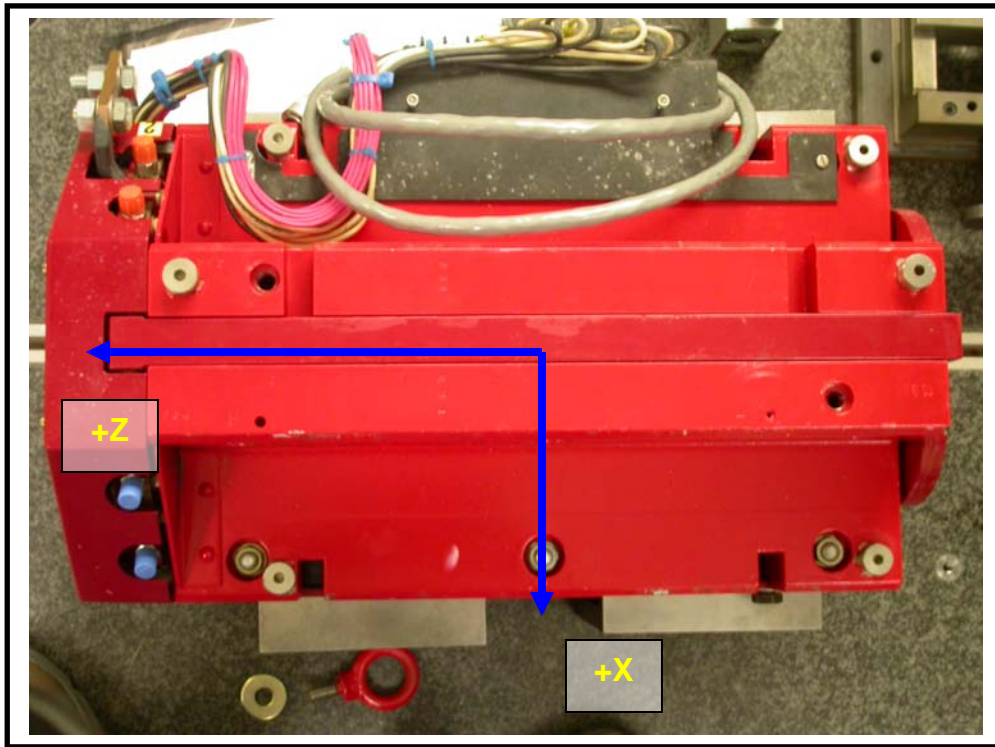


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00012	0.49933	5.00732	3.70317	-8.04452
TB B	0.00009	0.49917	-1.42857	7.31394	-8.01377
TB C	0.00018	0.49888	-5.03449	3.68246	-8.02983
TB D	0.00042	0.49923	-5.25073	3.68104	6.30315
TB E	0.00024	0.49945	-1.45980	7.31328	8.05913
TB F	0.00019	0.49930	5.25547	3.70312	6.29034

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90691	0.90682	0.00009
B-D	0.90652	0.90663	0.00011

