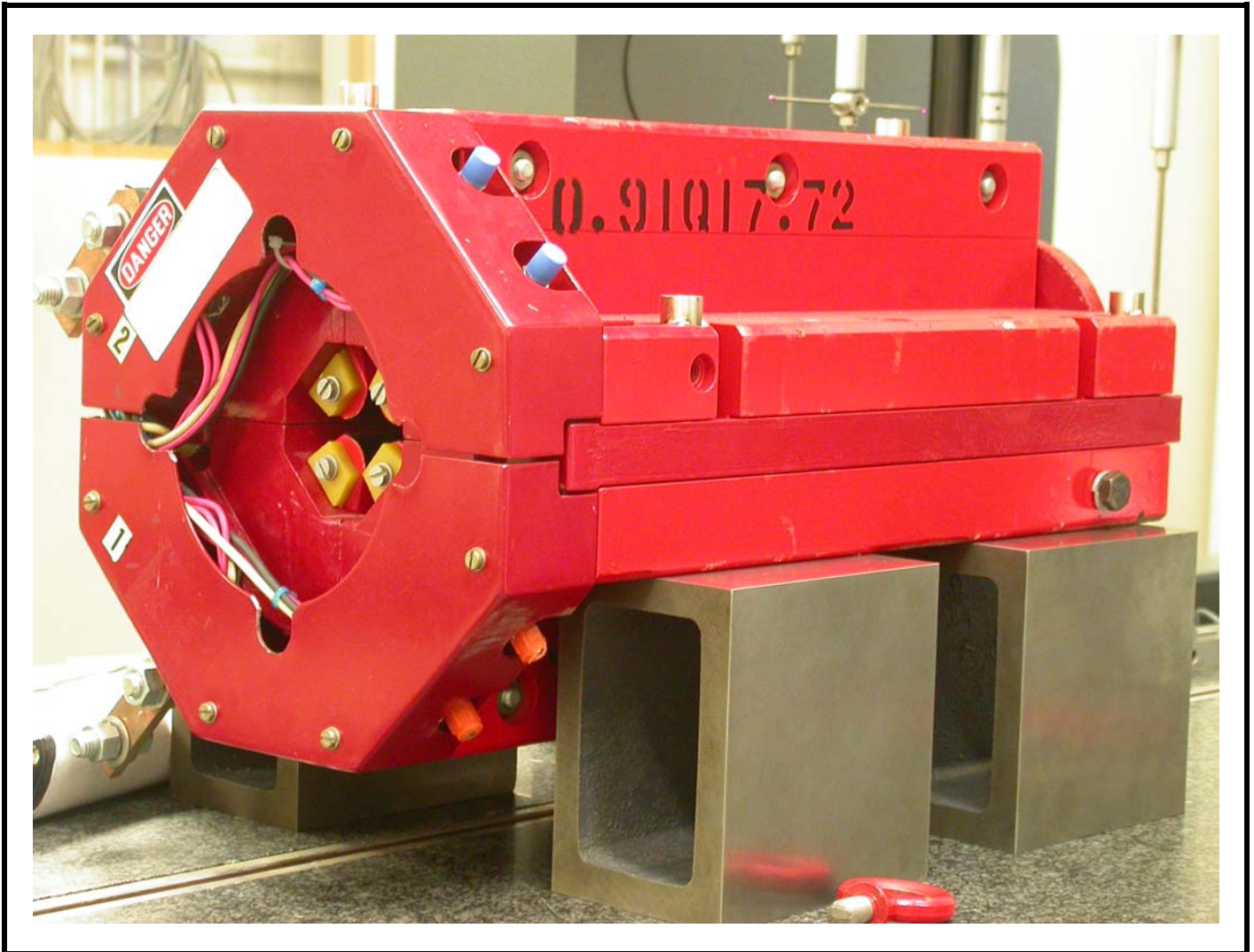


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Monday, March 26, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000223
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000223.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

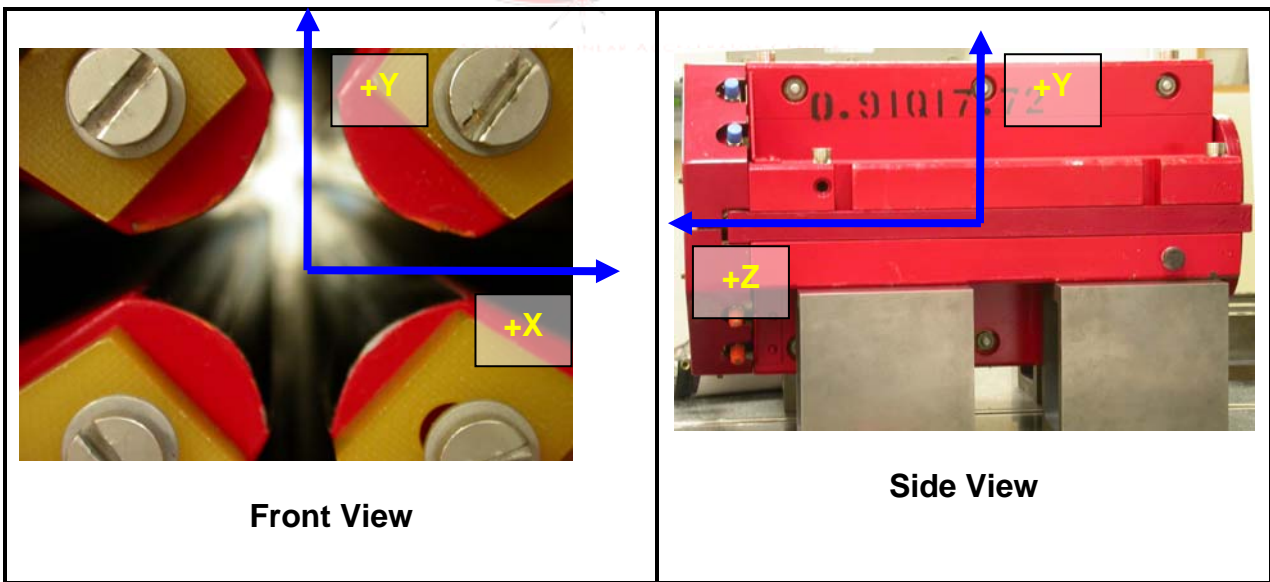
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

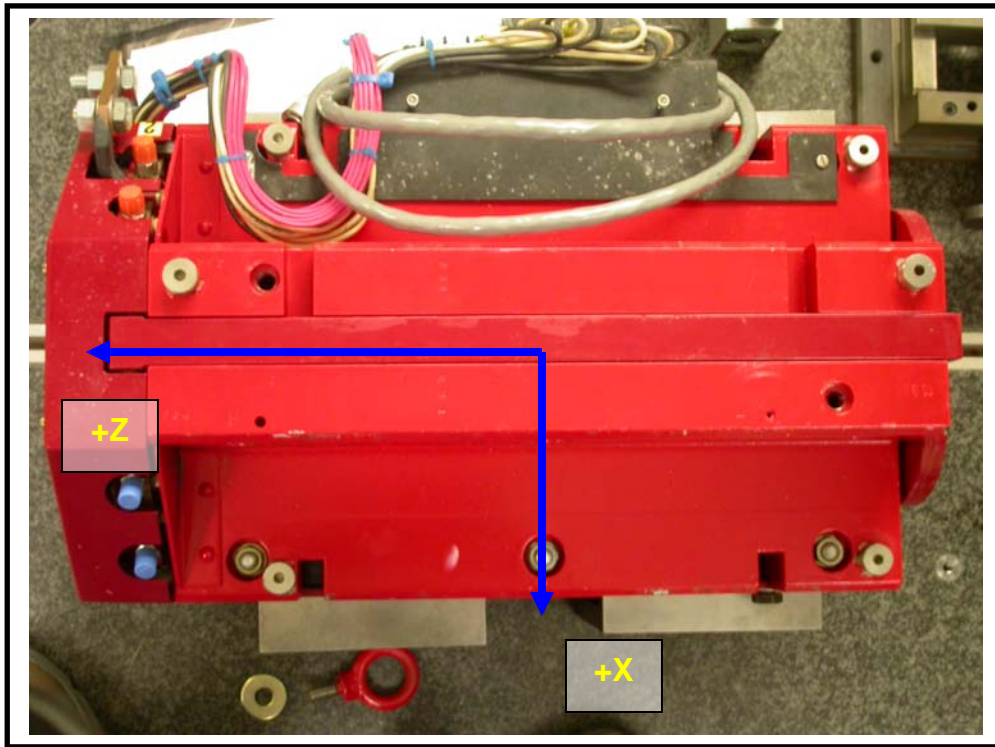


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00040	0.49670	5.03133	3.71623	-8.04045
TB B	0.00047	0.49870	-1.42063	7.31663	-8.06174
TB C	0.00019	0.49863	-5.04148	3.69048	-8.08133
TB D	0.00043	0.49867	-5.28980	3.69002	6.29343
TB E	0.00041	0.49727	-1.43417	7.31667	8.06180
TB F	0.00055	0.49771	5.26721	3.71589	6.29962

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90663	0.90697	0.00032
B-D	0.90610	0.90569	0.00041

