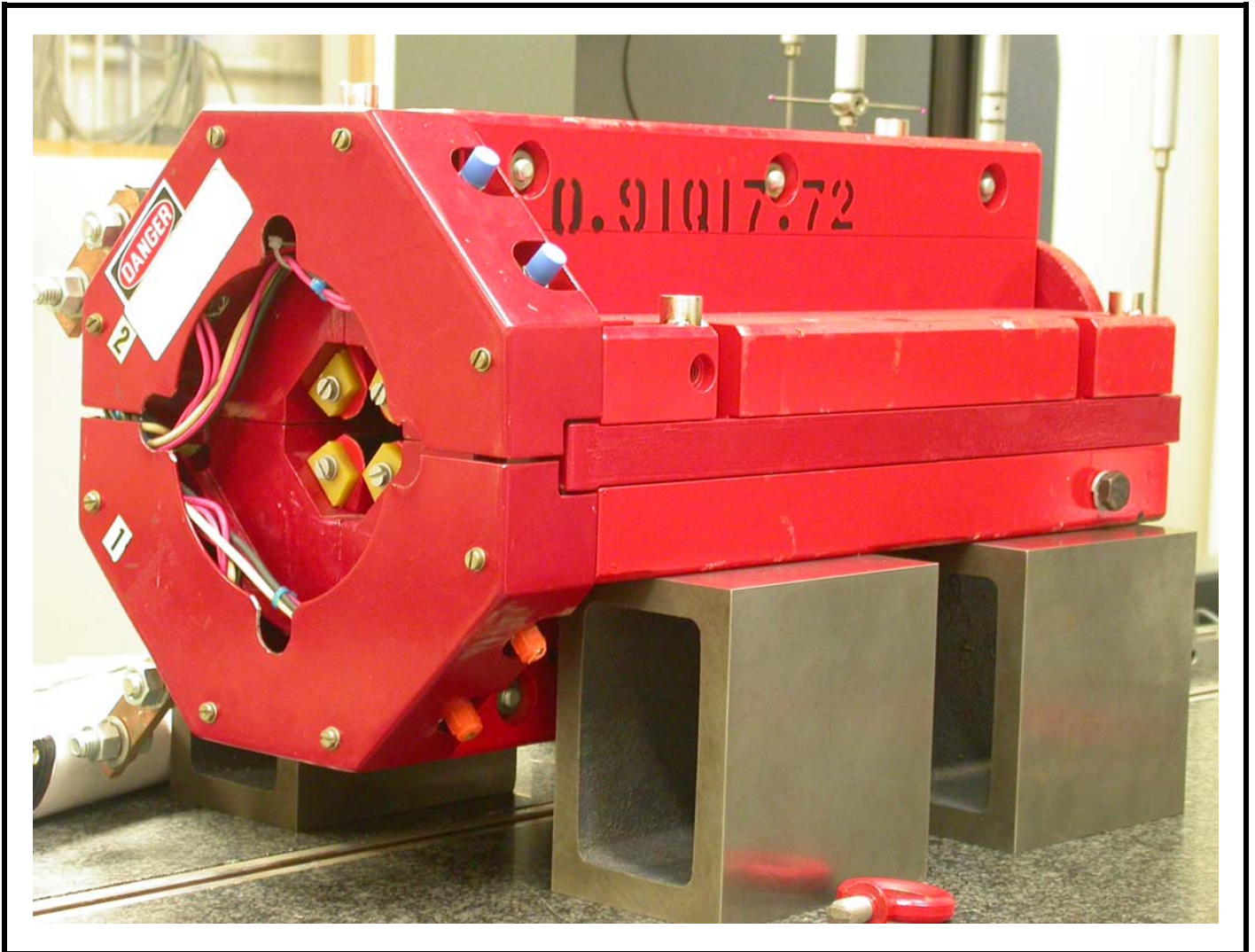


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, January 17, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000231
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000231.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

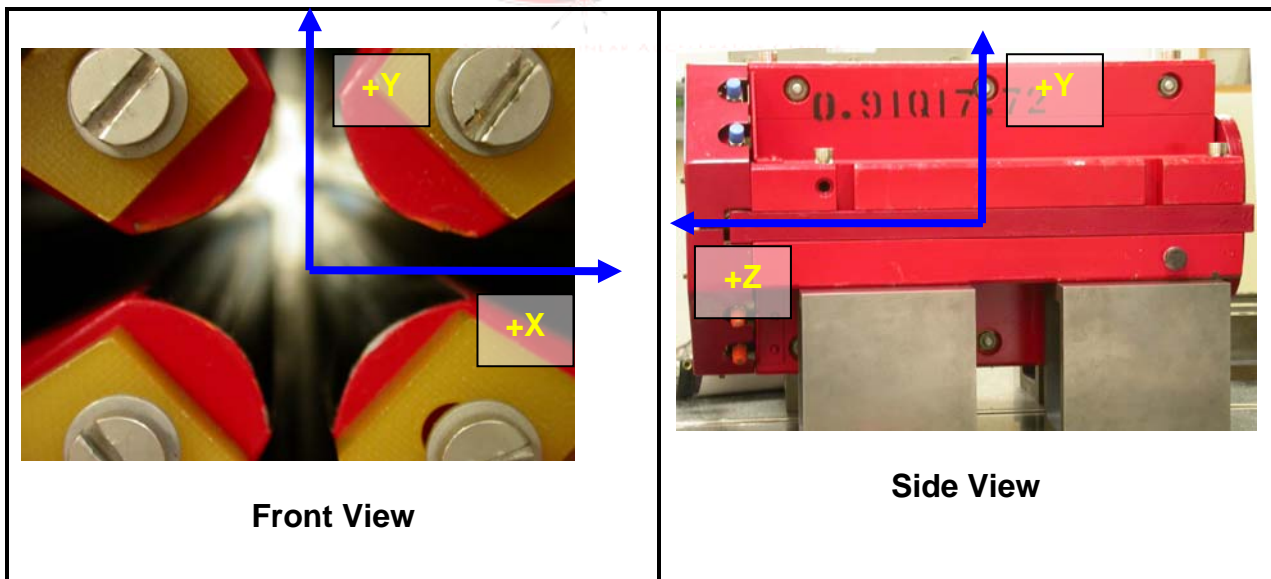
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

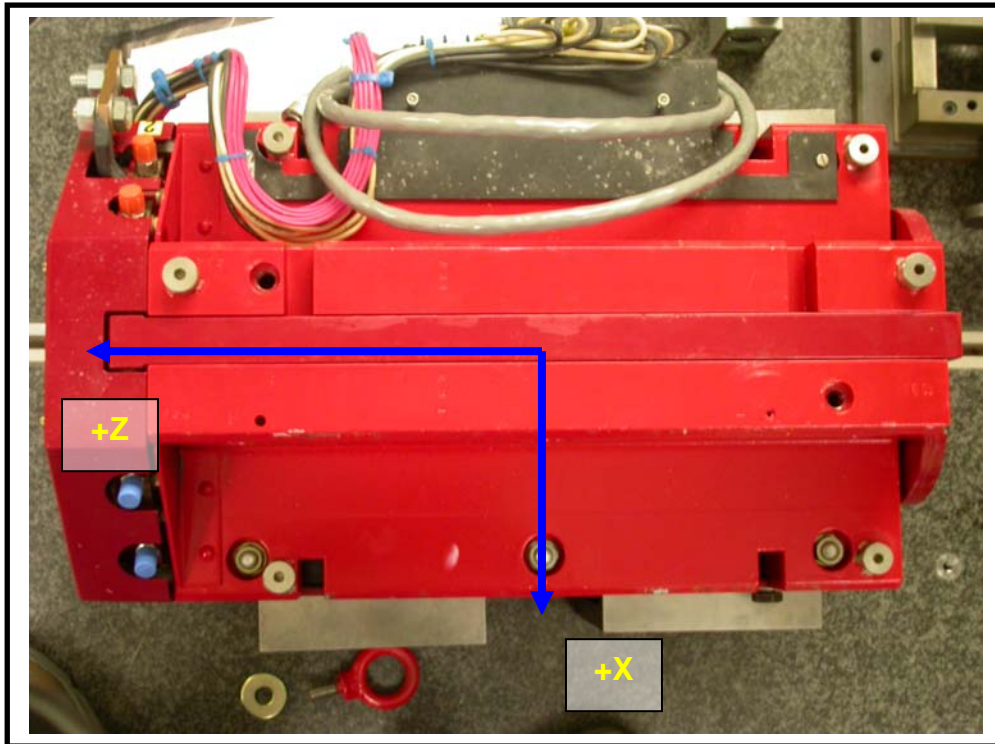
“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00037	0.49822	5.04606	3.69103	-8.07890
TB B	0.00030	0.49798	-1.42474	7.32040	-8.05678
TB C	0.00012	0.49970	-5.03234	3.70747	-8.09385
TB D	0.00003	0.49987	-5.24470	3.70747	6.27577
TB E	0.00003	0.49986	-1.39944	7.31910	8.08000
TB F	0.00003	0.49990	5.29455	3.69047	6.28348

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90430	0.90527	0.00097
B-D	0.90547	0.90646	0.00099

