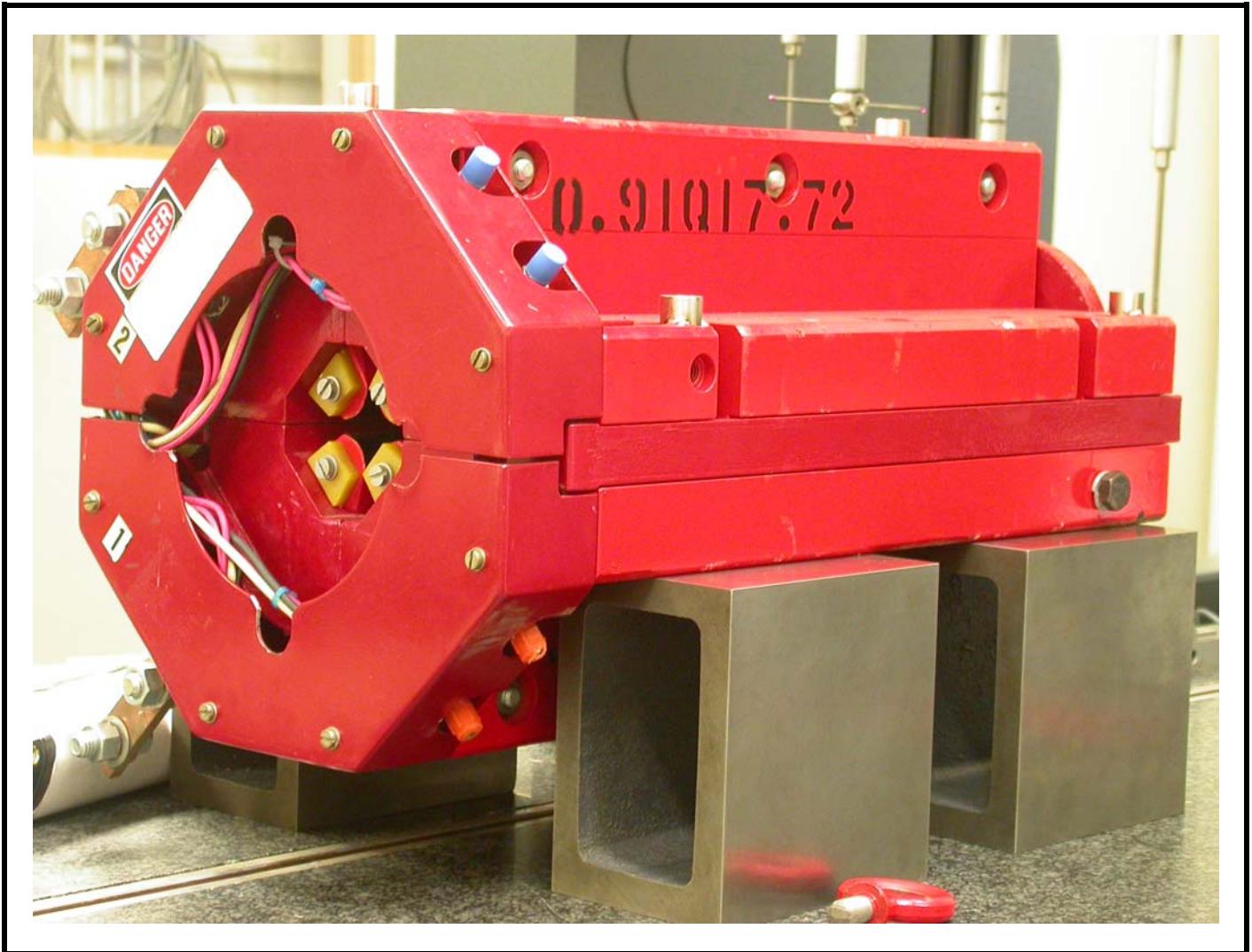


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Friday, January 19, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000233
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000233.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

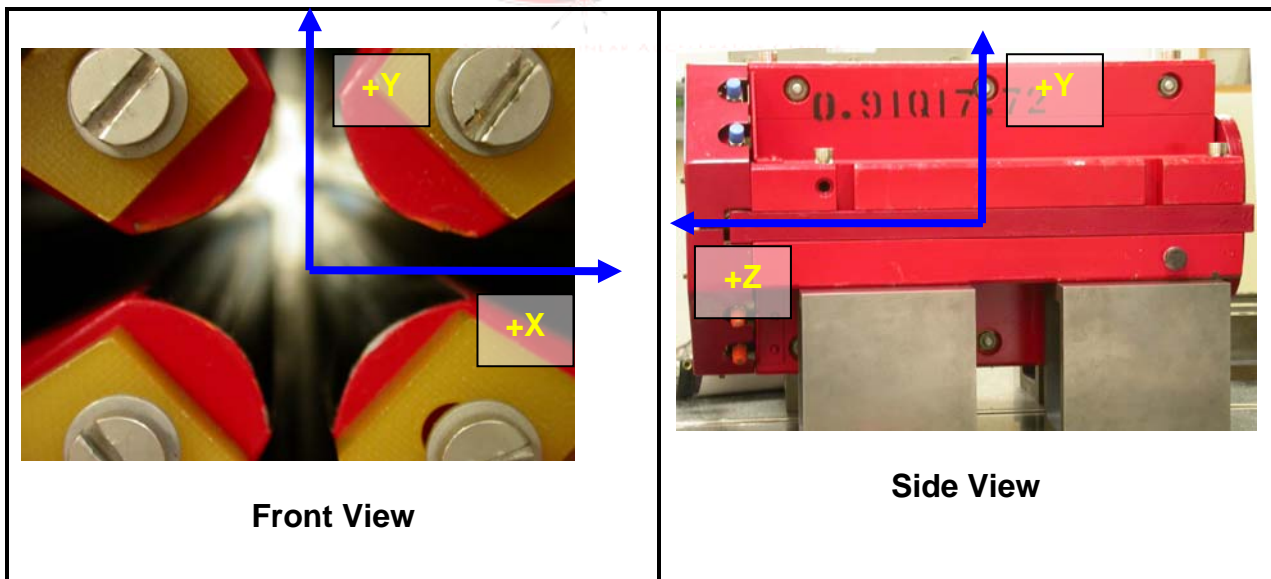
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

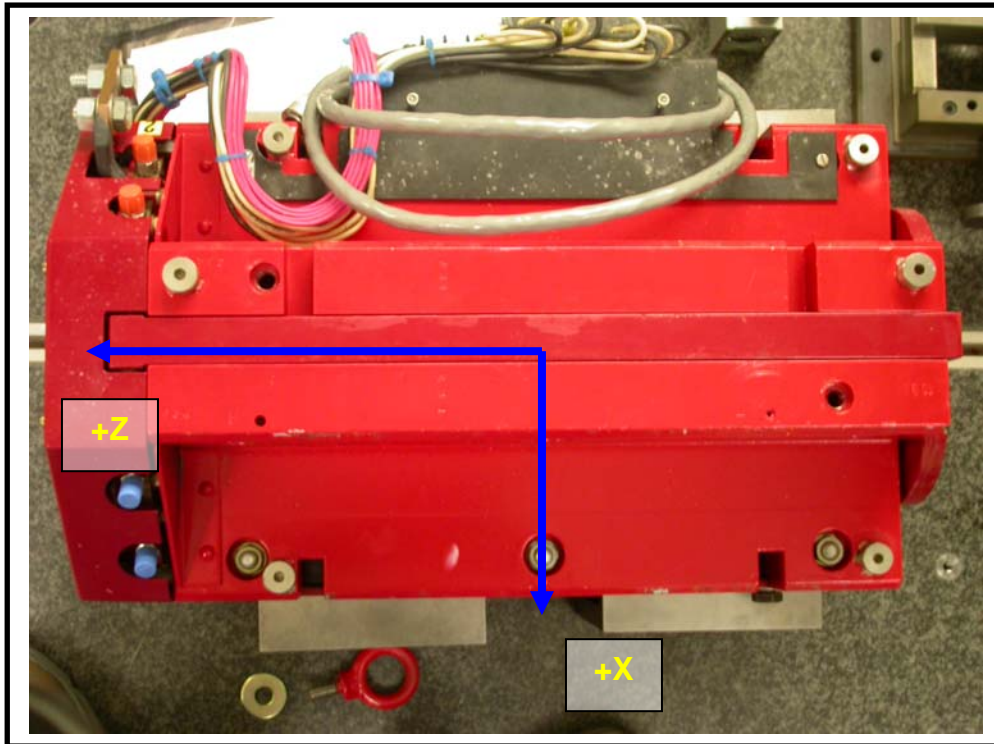
“X” & “Y” Zero

- 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	0.00019	0.49948	4.99769	3.70131	-8.01849
TB B	0.00016	0.49884	-1.35646	7.32459	-8.01089
TB C	0.00058	0.49785	-4.98605	3.70494	-8.00252
TB D	0.00084	0.49802	-5.27657	3.70659	6.27237
TB E	0.00033	0.49855	-1.36570	7.32235	7.98296
TB F	0.00006	0.50000	5.31613	3.70084	6.30118

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90753	0.90595	0.00158
B-D	0.90552	0.90745	0.00193

