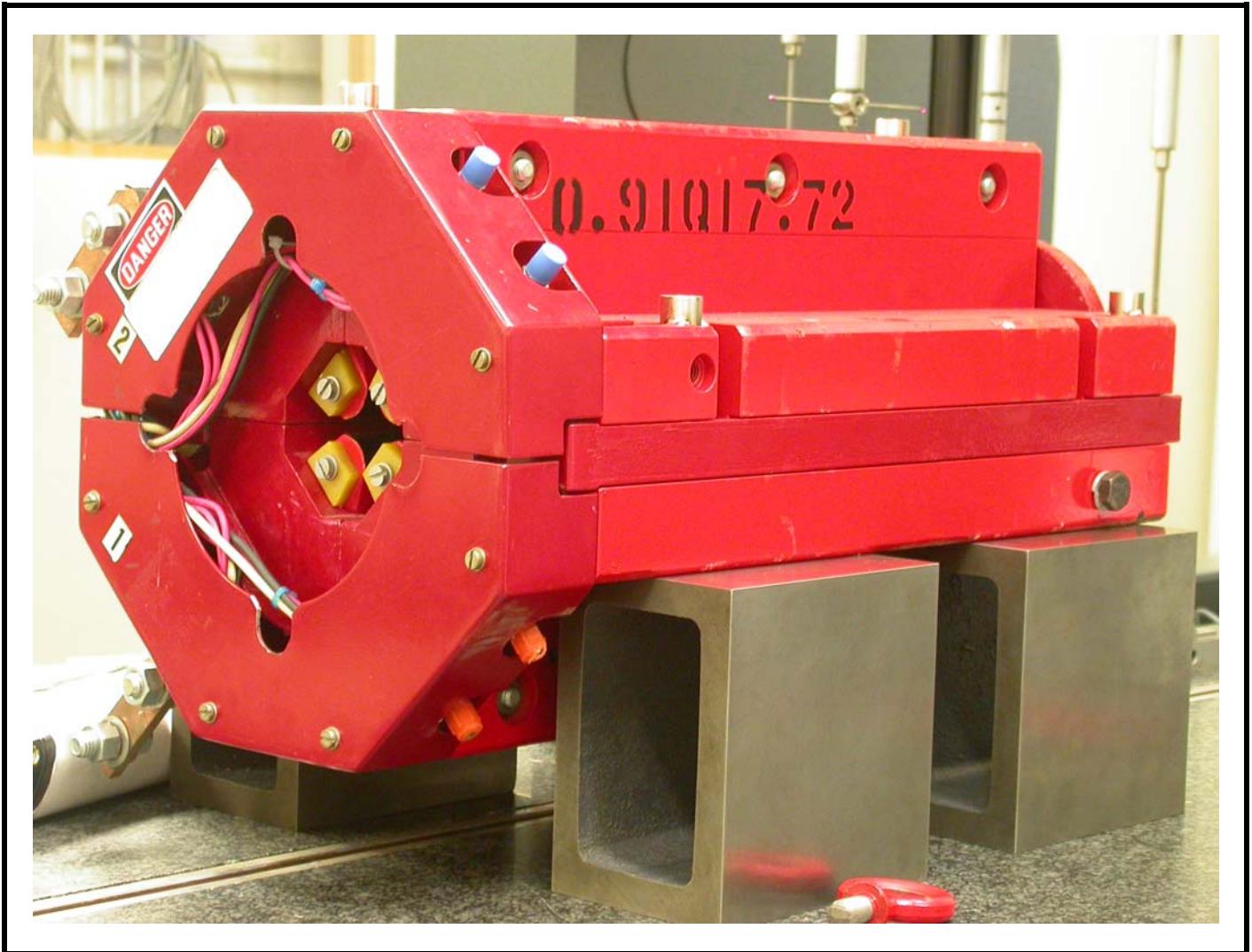


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, February 21, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000304
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000304.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

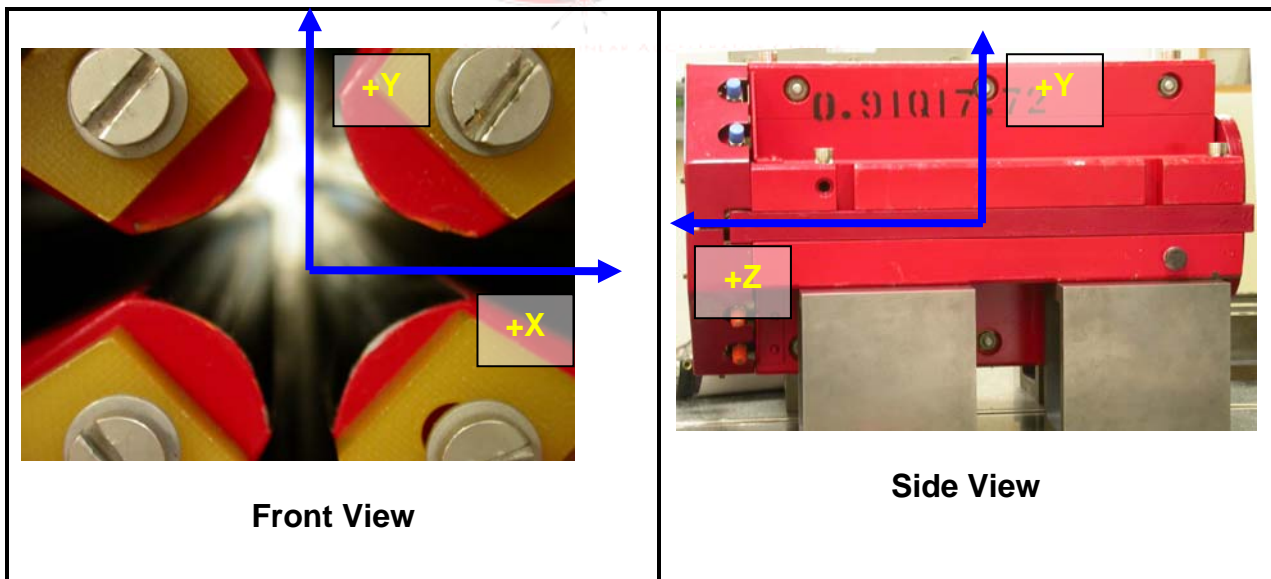
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

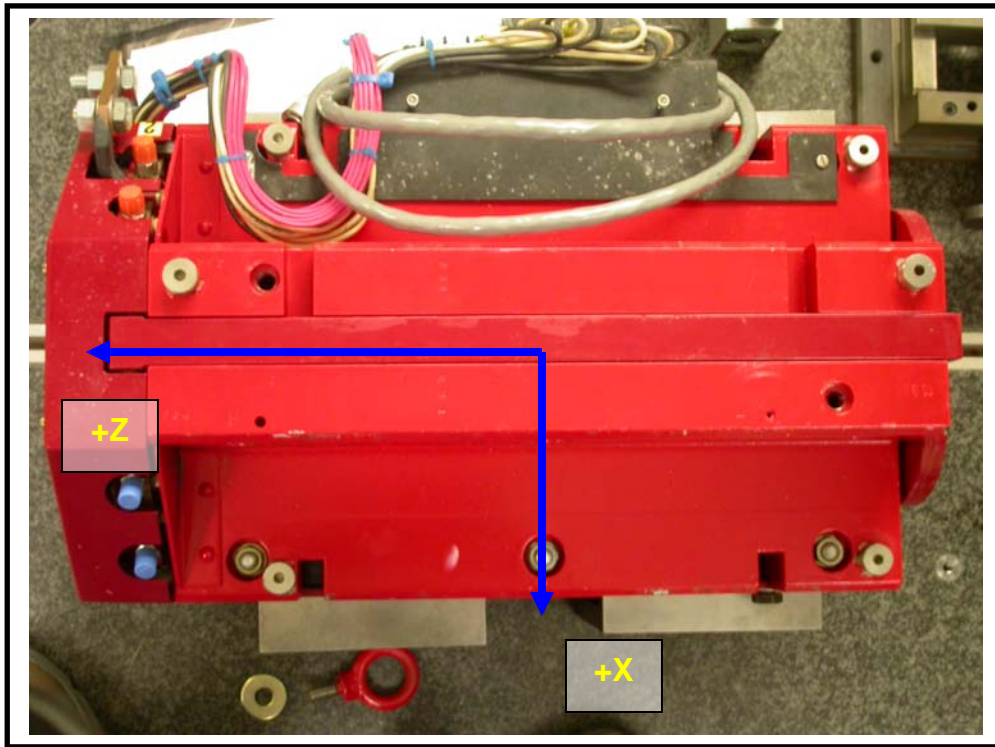


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00006	0.49913	5.00712	3.70673	-8.03280
TB B	0.00003	0.49967	-1.40711	7.32741	-8.02921
TB C	0.00012	0.49840	-4.95756	3.67656	-8.02702
TB D	0.00024	0.49740	-5.29555	3.67526	6.28779
TB E	0.00023	0.49766	-1.41054	7.32776	8.02866
TB F	0.00002	0.49982	5.21845	3.70606	6.27925

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90691	0.90712	0.00021
B-D	0.90654	0.90662	0.00008

