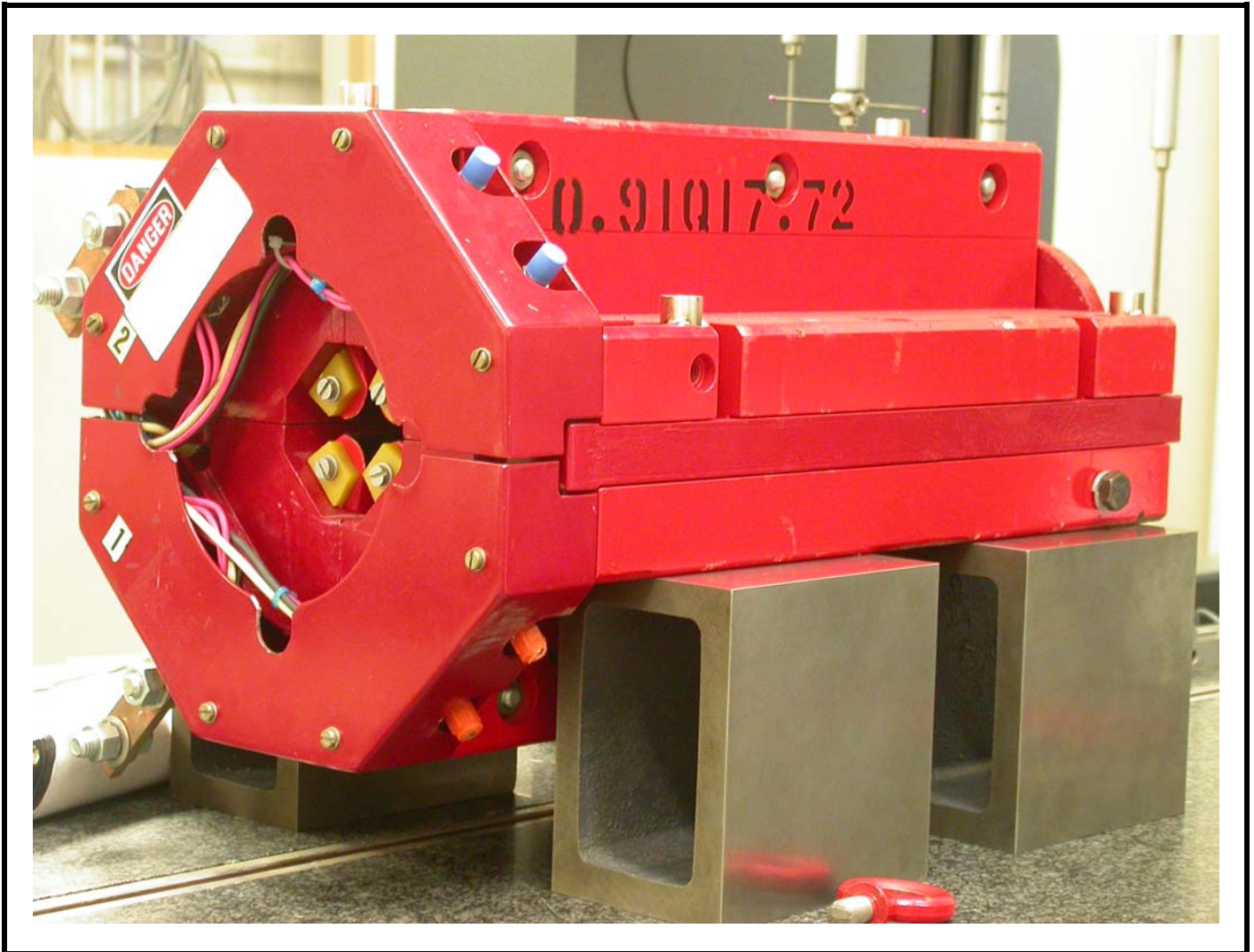


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, January 17, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000308
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000308.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

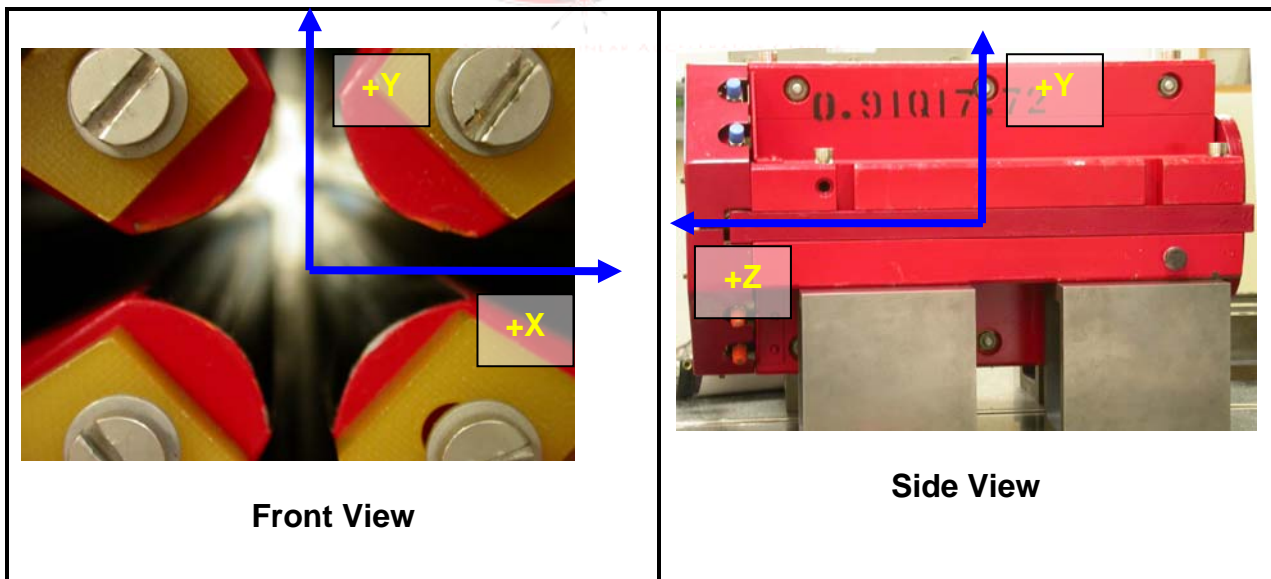
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

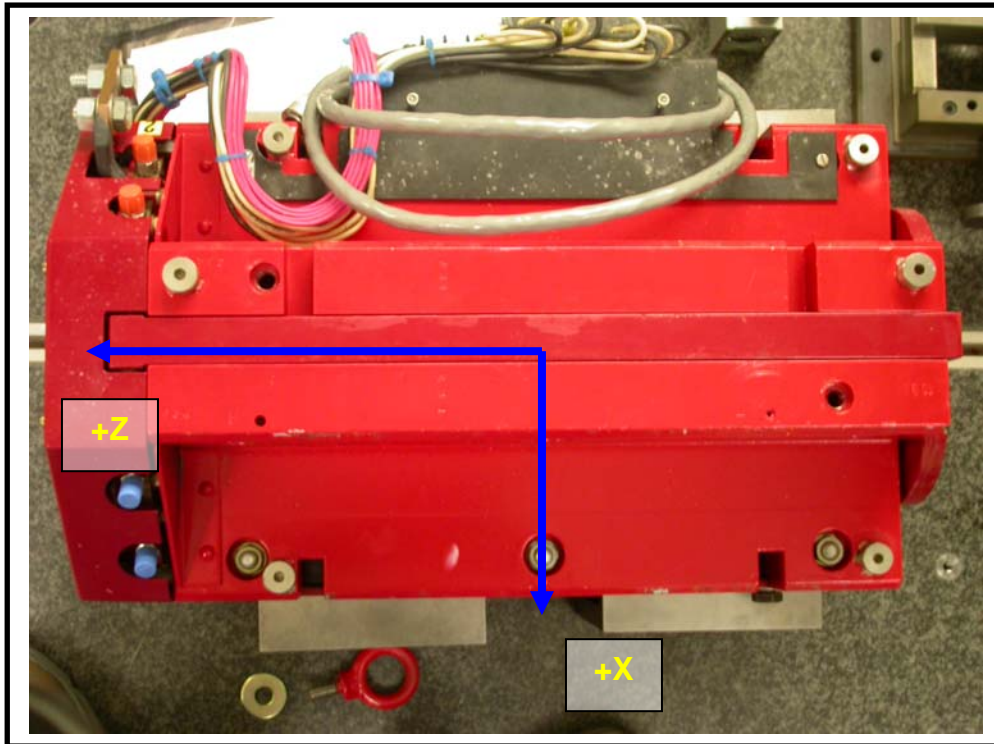
“X” & “Y” Zero

- 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	0.00035	0.49772	5.06479	3.69378	-8.06684
TB B	0.00036	0.49800	-1.40078	7.31585	-8.03895
TB C	0.00015	0.49937	-4.94032	3.70779	-7.98910
TB D	0.00037	0.49784	-5.24134	3.70807	6.27821
TB E	0.00041	0.49810	-1.39636	7.31511	8.05735
TB F	0.00035	0.49792	5.24986	3.69484	6.26869

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90697	0.90756	0.00059
B-D	0.90685	0.90618	0.00067

