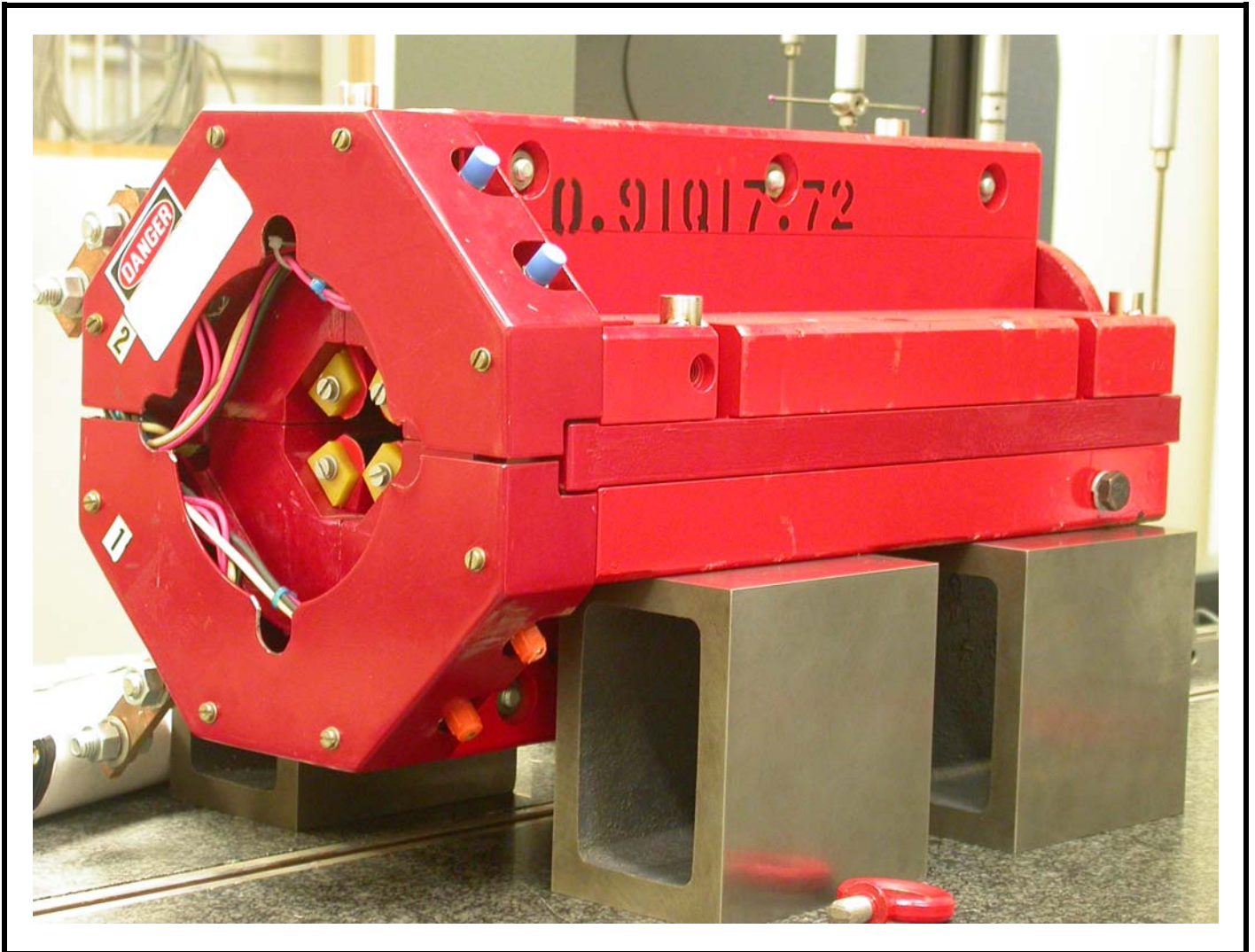


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, February 21, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000317
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000317.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

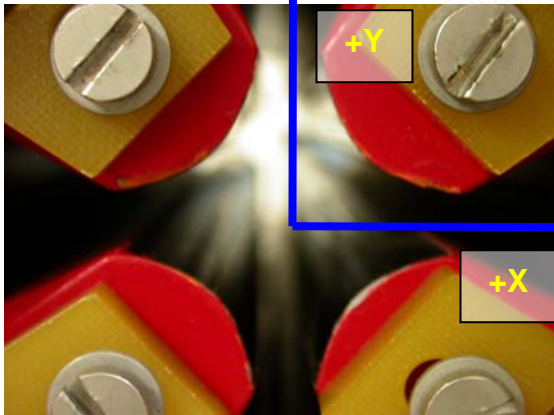
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

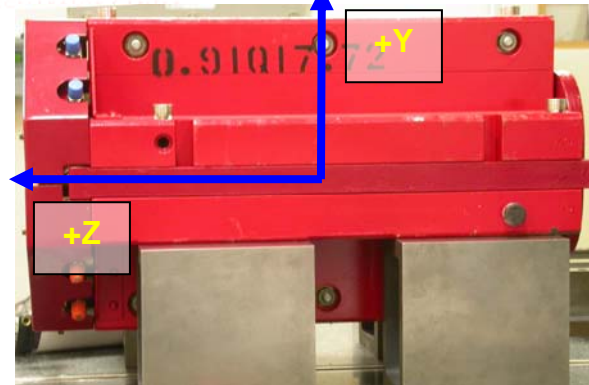
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



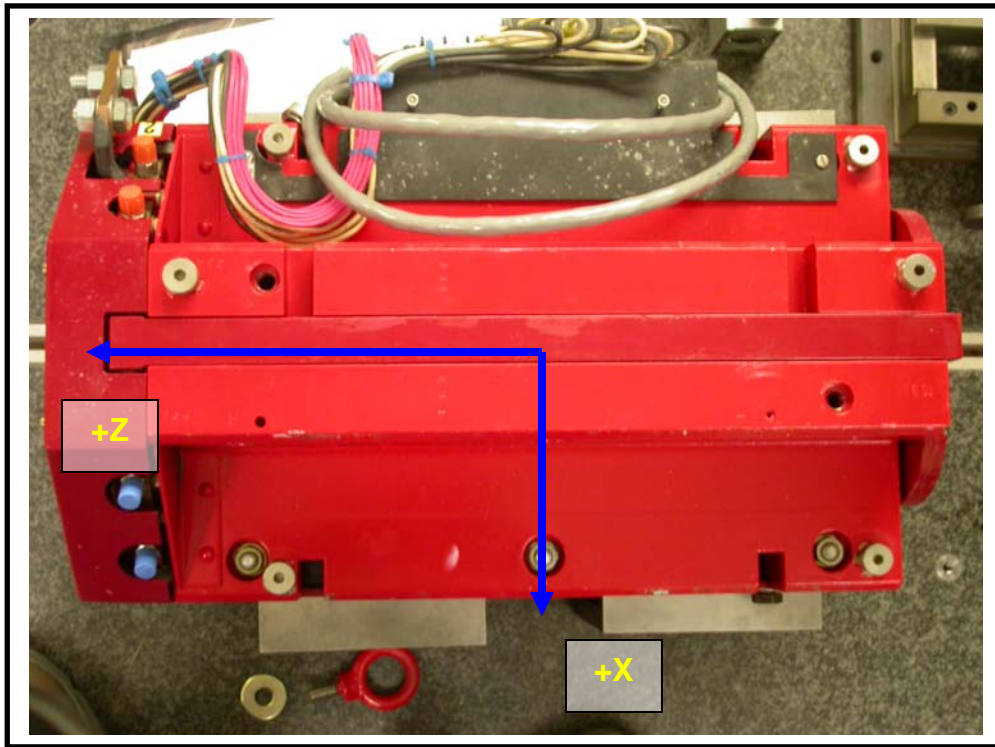
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00014	0.49725	5.02802	3.69313	-8.05779
TB B	0.00020	0.49683	-1.37014	7.30119	-8.05007
TB C	0.00039	0.49676	-4.97993	3.69161	-8.05734
TB D	0.00011	0.49725	-5.20112	3.69175	6.30079
TB E	0.00011	0.49613	-1.38315	7.29894	8.07283
TB F	0.00029	0.49678	5.26562	3.69430	6.29219

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90599	0.90636	0.00037
B-D	0.90597	0.90561	0.00036

