

FIDUCIALIZATION INSTRUCTIONS FOR THE NEW LCLS-II GUN SOLENOID

From Cherrill Spencer, 10th July 2013

The solenoid magnet should be fiducialized by the Metrology Group using the CMM in building 25, using the same methodology as was used for the LCLS gun solenoids. This will require the installation of removable tooling balls, location of the geometric axis of the bore of the magnet, and location of tooling balls with respect to the X, Y and Z center of this geometric axis. Five tooling ball holes have been created in the upstream endplate of the solenoid magnets. The tooling ball holes in the flux return plates will not be used.

The following measurements should be made:

1. Precise location of the axis of the magnet, relative to the bores of the endplates (not to the inner bore of the magnet, which is only a carrier for the corrector coils).
2. Measurement of the perpendicularity of the endplates with respect to the axis.

CMM technician (initials):	KC
Date CMM performed (mmm-dd-yyyy):	07/19/2013

URL of on-line CMM fiducialization data (please modify or correct URL if necessary):

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