

FACET II Magnet Fiducialization Report Injector Laser Heater Chicane 5D3.9 Dipole



Inspector : K. Caban
Engineer : C. Hast
Drawing No. : SA-380-331-12
Barcode # : 100885
Mfg. S/N : BCX10475 SN:2316-26124-03

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

Symmetry Plane between the side planes of (2X) Poles

Coordinate Origins

X Origin - Symmetry Plane between poles

Y Origin - Symmetry Plane between the side planes of (2X) Poles

Z Origin - Symmetry plane between Up Stream and Down Stream end surfaces

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Tooling Ball Locations



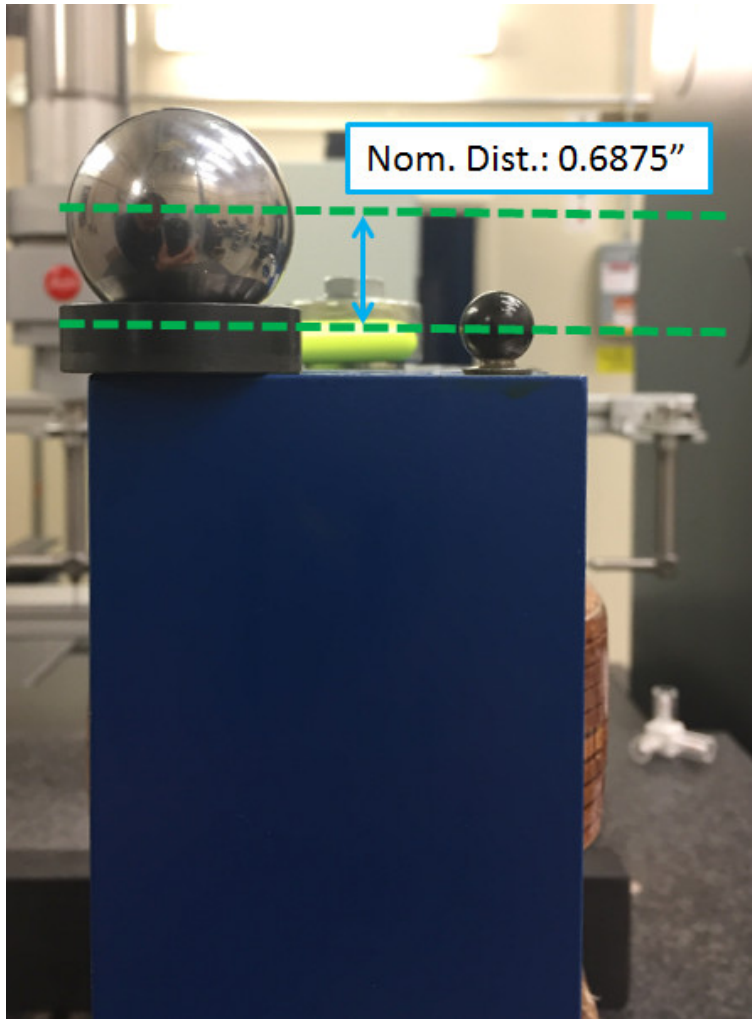
| Tooling Ball | X Coord. | Y Coord. | Z Coord. |
|--------------|----------|----------|----------|
| TB 1 | 5.1980 | 6.5133 | -1.0644 |
| TB 2 | 5.1971 | 6.5140 | 1.0615 |
| TB 3 | -5.1958 | 6.5144 | 1.0602 |
| TB 4 | -5.1943 | 6.5138 | -1.0651 |
| TB A | 5.1973 | 5.8262 | -1.0646 |
| TB B | 5.1970 | 5.8267 | 1.0616 |
| TB C | -5.1961 | 5.8273 | 1.0616 |
| TB D | -5.1949 | 5.8263 | -1.0649 |

Tooling Ball Locations (1-4) are 1 inch above Tooling Ball Plane
 Tooling Ball Locations (A-D) are 5/16 inch above Tooling Ball Plane
 Dimensions in Inch

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1" Tooling Ball to 5/16" Tooling Ball Difference



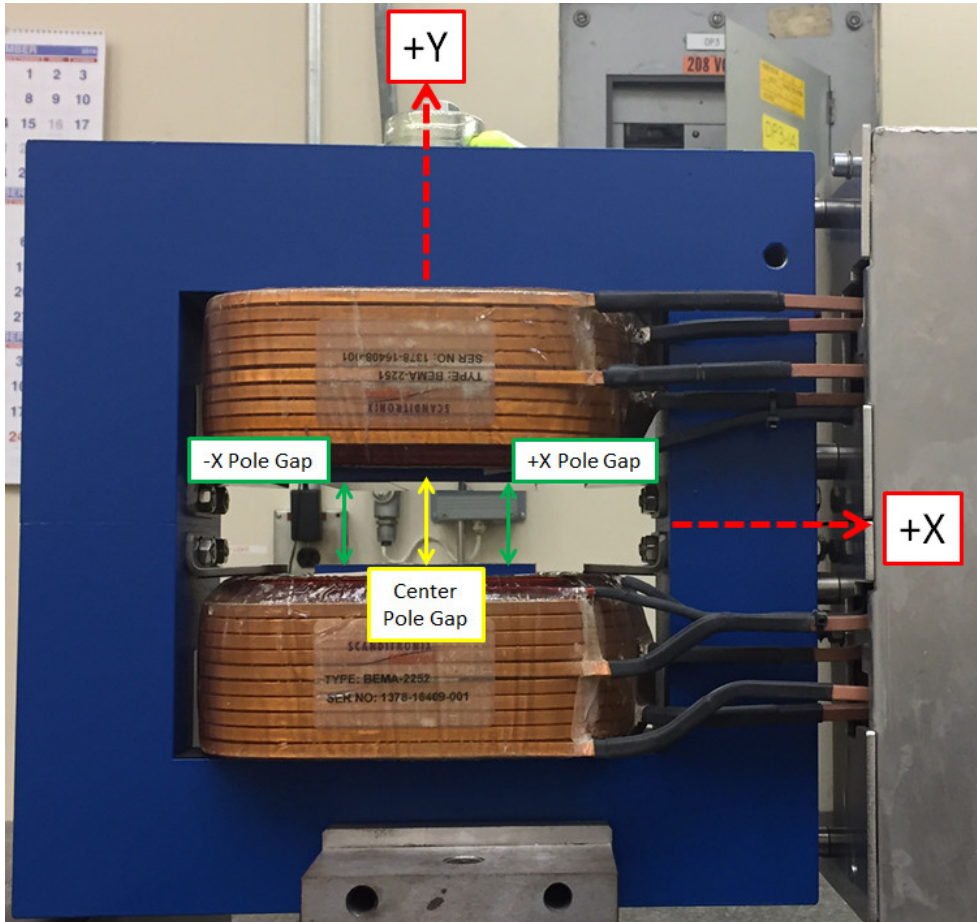
| Tooling Ball | Nom Dist. | Actual Dist. | ACT-NOM |
|--------------|----------------|--------------|---------|
| TB 1 | 0.6875 ± 0.001 | 0.6871 | -0.0004 |
| TB 2 | 0.6875 ± 0.001 | 0.6874 | -0.0001 |
| TB 3 | 0.6875 ± 0.001 | 0.6871 | -0.0004 |
| TB 4 | 0.6875 ± 0.001 | 0.6875 | 0.0000 |

Dimensions in Inch

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Pole Gap Measurements



| | U/S -X | U/S +X | D/S -X | D/S +X | U/S CENTER | D/S CENTER |
|-----------|---------|---------|---------|---------|------------|------------|
| GAP DIST. | 1.18066 | 1.18076 | 1.18079 | 1.18085 | 1.19626 | 1.19612 |

Dimensions in Inch

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