



Notes:
 Attach and carefully align items 3, Pole Inserts to item 1, Core - (machined) and use items 5 and 6 to secure. Use 1/4 inch holes in items 3 to locate holes for item 4, 1/4 inch dia. x 1/2 inch long dowels. Match drill and insert dowels.

Assemble coil to core and use items 7 and 8.

REV	DESCRIPTION	DWN	CHKR	APV	DATE
1					

REQD	ITEM	PART NO.	DESCRIPTION
8	8	---	1 inch long 1/4-20 NC Skt. Head Capscrews
4	7	LCLS422A	Coil Holder Block
8	6	---	1/4 inch Washer
8	5	---	1.25 inch long 1/4-20 NC Hex Head Bolt
4	4	---	Stainless Dowel -- 0.25 dia. x 0.50 long
2	3	LCLS072A	POLE INSERT
1	2	LCLS2106A	LOWER COIL BRAZEMENT ASSEMBLY
1	1	LCL3086-2	Lower CORE - MACHINING DETAIL

REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS	
LOC	X ± .1	FRAC	± 1/64
DATE	XX ± .01	MAILED	± 1"
DEL	XX ± .001	TRNG	125

DATE	BY	DESCRIPTION	DATE	BY	DESCRIPTION
07-31-06	Jack Tansue	Microfilmed	09-09-99	999999	999999

REVISION	DATE	DESCRIPTION
1	05-02-00	USUALLY NO ONE

SCALE: NONE	DO NOT SCALE DRAWING	CAD FILE NAME: sa38031741-0.dft
STANFORD UNIVERSITY U.S. DEPARTMENT OF ENERGY LAWRENCE BERKELEY LABORATORY UNIVERSITY OF CALIFORNIA-BERKELEY LCLS Injector Project BXS Magnet Assembly Lower Half Magnet Subassembly		
DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH ASME Y14.5M-1994. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES: BREAK EDGES 000-015 INTERNAL CORNERS R.015 MAX FRACTIONS 2/16 DEC .XXX ± .XXXX ± ANGLE ± ALL SURF. ✓		LCLS MAGNET SYSTEMS BXS MAGNET ASSY LOWER HALF MAG SUBASSY LBL-LCLS416 A DRAWING NUMBER: SA-380-317-41 REVISION NUMBER: 0
NEXT ASSEMBLIES: INGR. C. PACO DWN. JACK TANSUE ENR. R. B. VINOW ENR. ERIC BONG ENR. DEN MARSH ENR. MIKE DITTMER		LCLS BXS MAG LWR HALF SUBASSY SLAC Release V:IMDCAD/DocumentControl/Images/Incoming/SLAC/isa38031741-0.dft.tif 9/6/2006 10:32:04 AM