LCLS II Magnet Fiducialization Report

3D39 Dipole

Barcode # : 4500

MFG S/N:16079

Part Num: AD 253-623-30 R1

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

Symmetery Plane between Upper and Lower plates of magnet housing

Coordinate Origins

X Origin - Symmetry Plane between poles

Y Origin - Symmetry Plane between Top and Bottom housing plates

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

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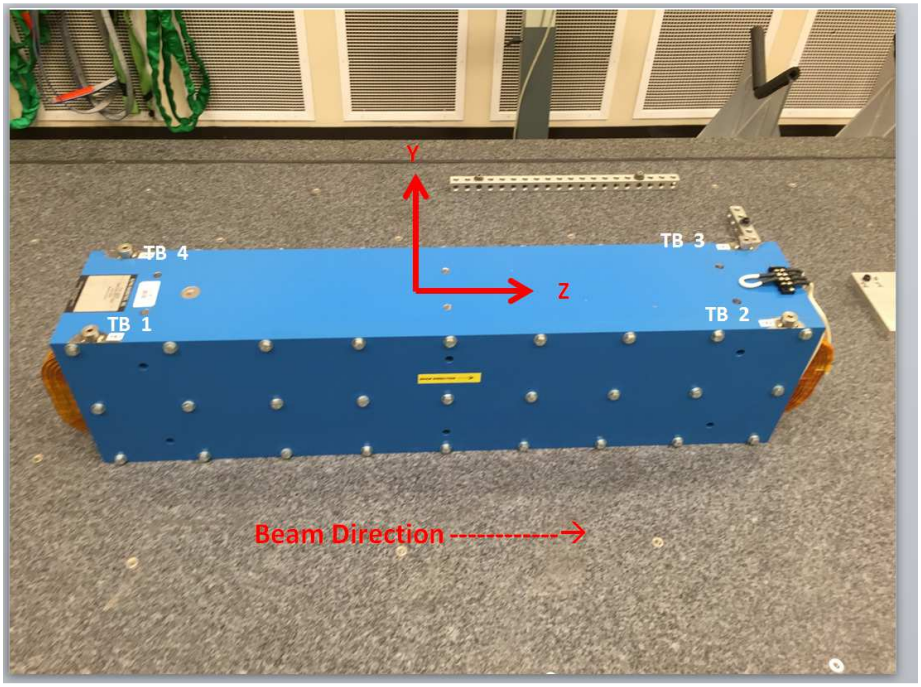
Tooling Ball Locations



Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	-3.30459	6.25624	-17.55019
TB 2	-3.31227	6.25364	17.54475
TB 3	3.28937	6.25735	17.48845
TB 4	3.29830	6.25330	-17.49305
TB A	-3.30404	5.56858	-17.55083
TB B	-3.31196	5.56621	17.54493
TB C	3.28955	5.56966	17.48958
TB D	3.29812	5.56575	-17.49316

Tooling Ball Locations (1-4) are 1 inch above top surface TB socket
Tooling Ball Locations (A-D) are 5/16 inch above top surface TB socket

Dimensions in Inch

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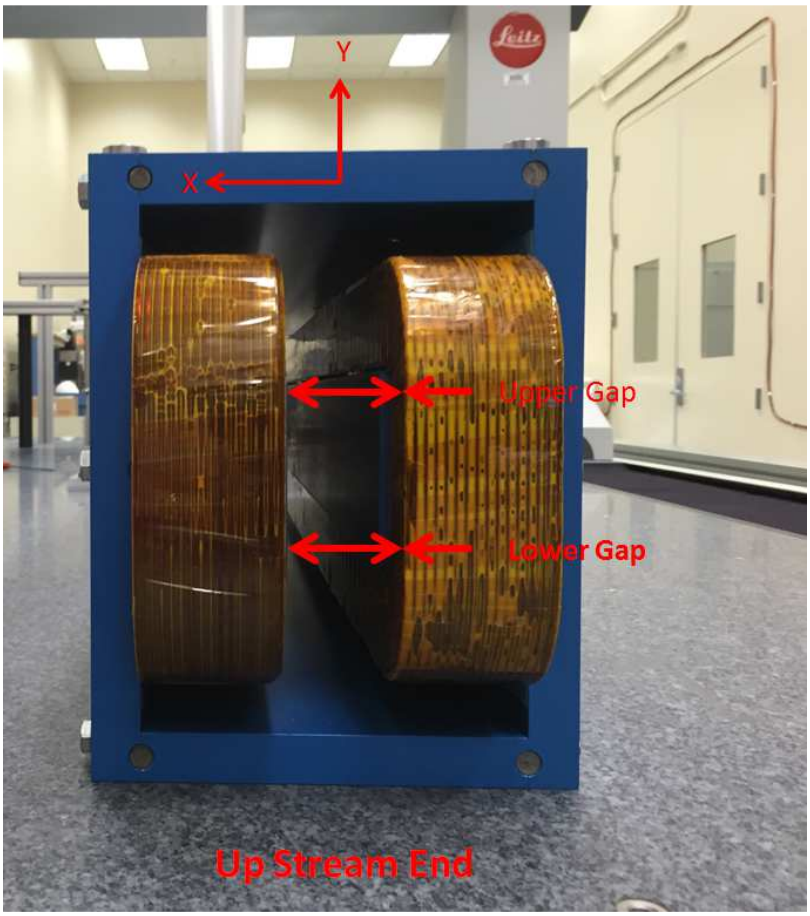
Pole Tip Gap Measurements



Pole Tips looking Down Stream

Location	Measured Gap
Upstream Lower	1.37634
Upstream Upper	1.37608
Downstream Lower	1.37937
Downstream Upper	1.37937

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