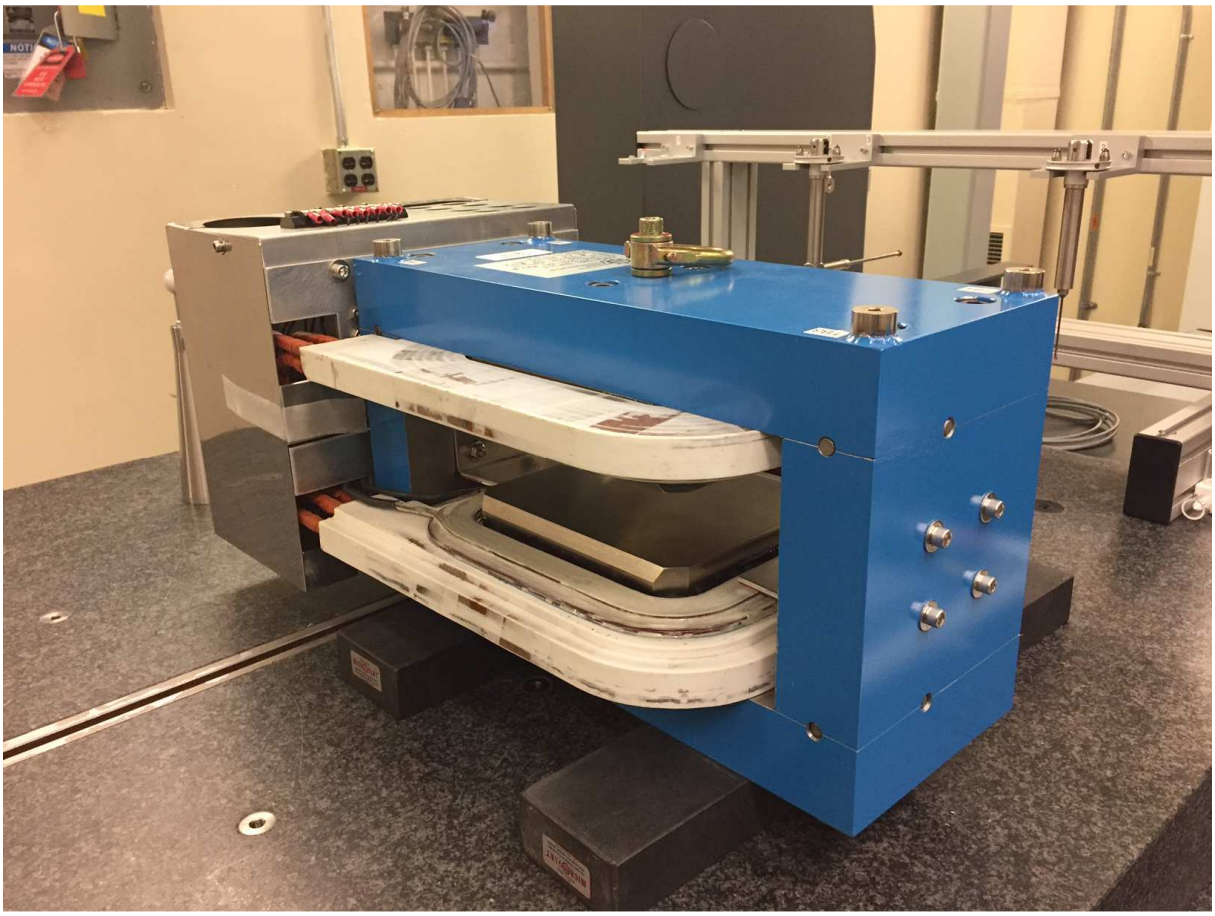
LCLS II Magnet Fiducialization Report

1.69D6.28T Dipole



Inspector : K. Caban

Engineer : J. Amann

Drawing No. : SA-388-320-05 R1

Barcode # : 4513

Mfg. S/N : 003

Coordinate System Setup

Spatial Alignment

Symmetry Plane between 2 Pole surfaces

Planar Alignment

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

Coordinate Origins

X Origin - Symmetry Plane between poles

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

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

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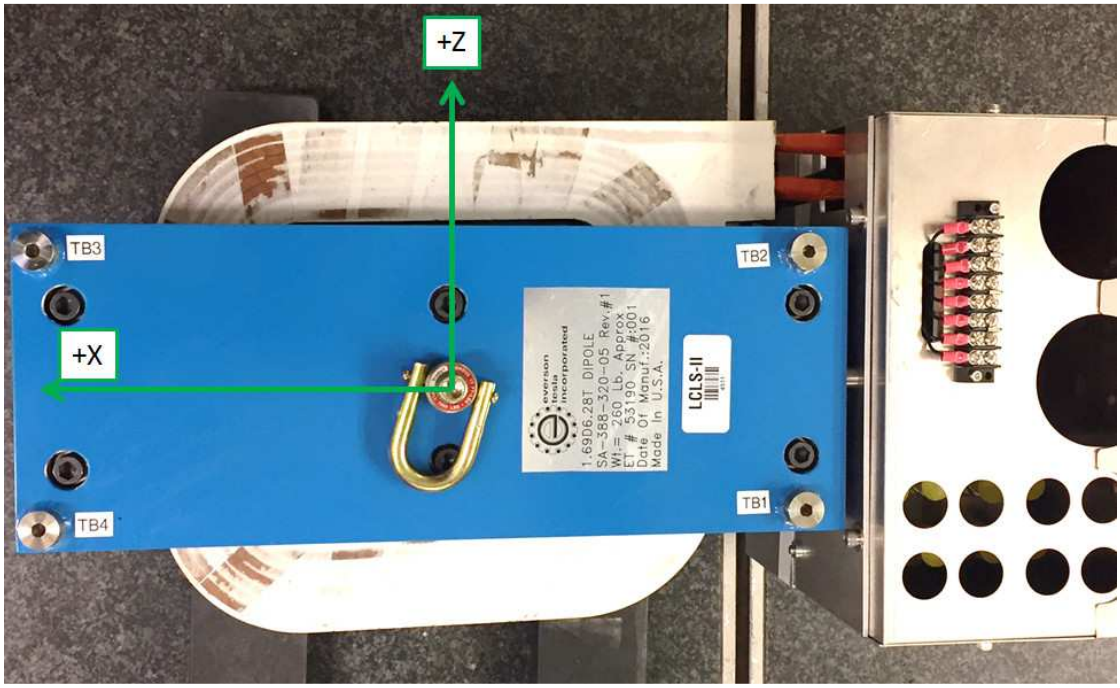
Tooling Ball Locations



Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	-7.25920	6.22561	-2.63008
TB 2	-7.23203	6.22501	2.63904
TB 3	7.74001	6.22563	2.62189
TB 4	7.72815	6.22601	-2.63245
TB A	-7.25961	5.53820	-2.63193
TB B	-7.23309	5.53786	2.63819
TB C	7.73833	5.53862	2.62437
TB D	7.72737	5.53890	-2.63151

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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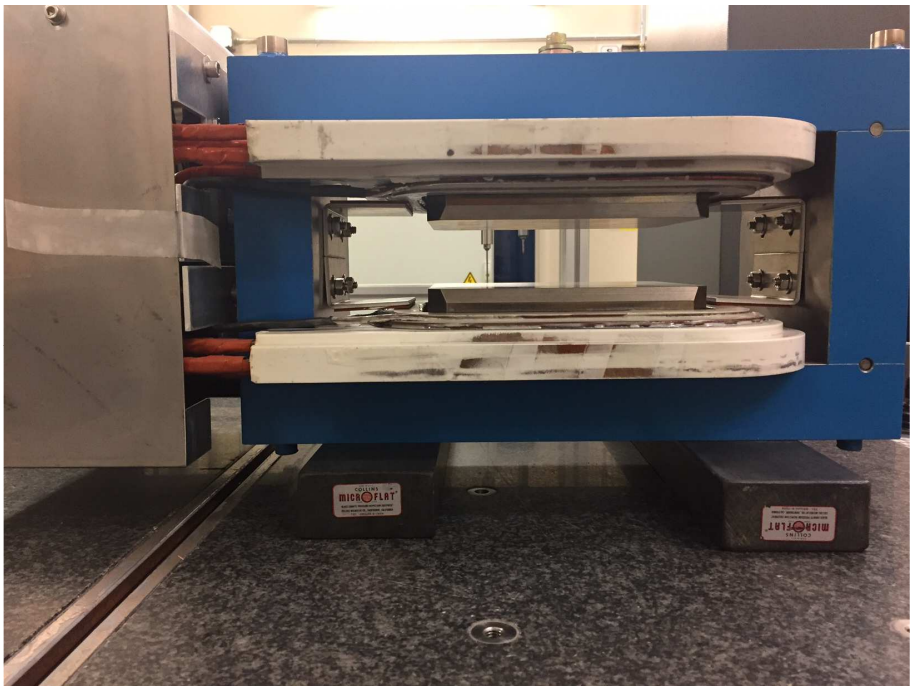
Pole Gap Measurements



	Nominal Gap	Average Gap	Minimum Gap	Pole Parallelism
Pole Gap	1.693 ± 0.002	1.69487	1.69488	0.00075

Dimensions in Inch

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