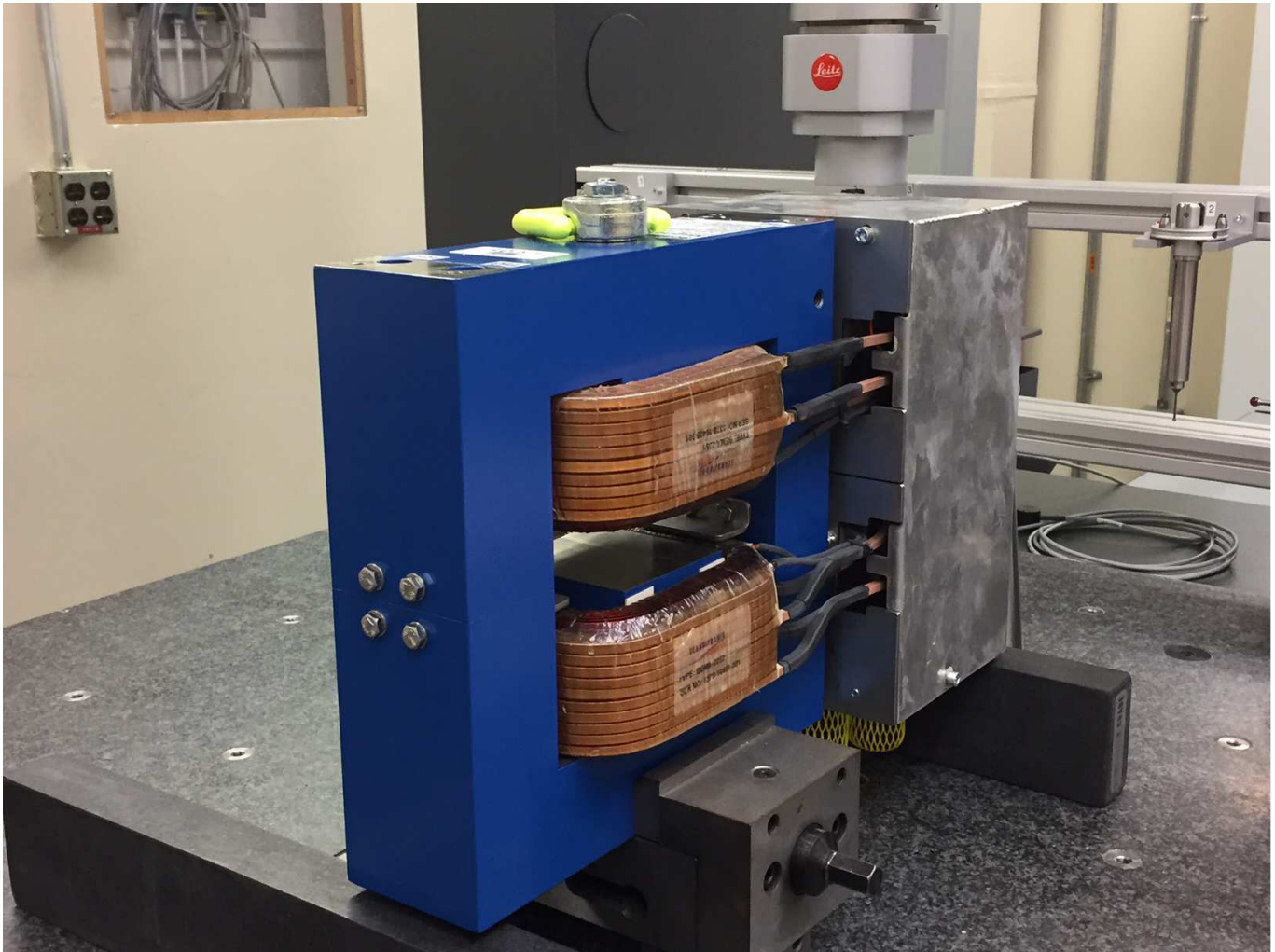


LCLS II Magnet Fiducialization Report Injector Laser Heater Chicane 5D3.9 Dipole



Inspector : K. Caban
Engineer : J. Amann
Drawing No. : SA-380-331-12
Barcode # : 4517
Mfg. S/N : 16082-3

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



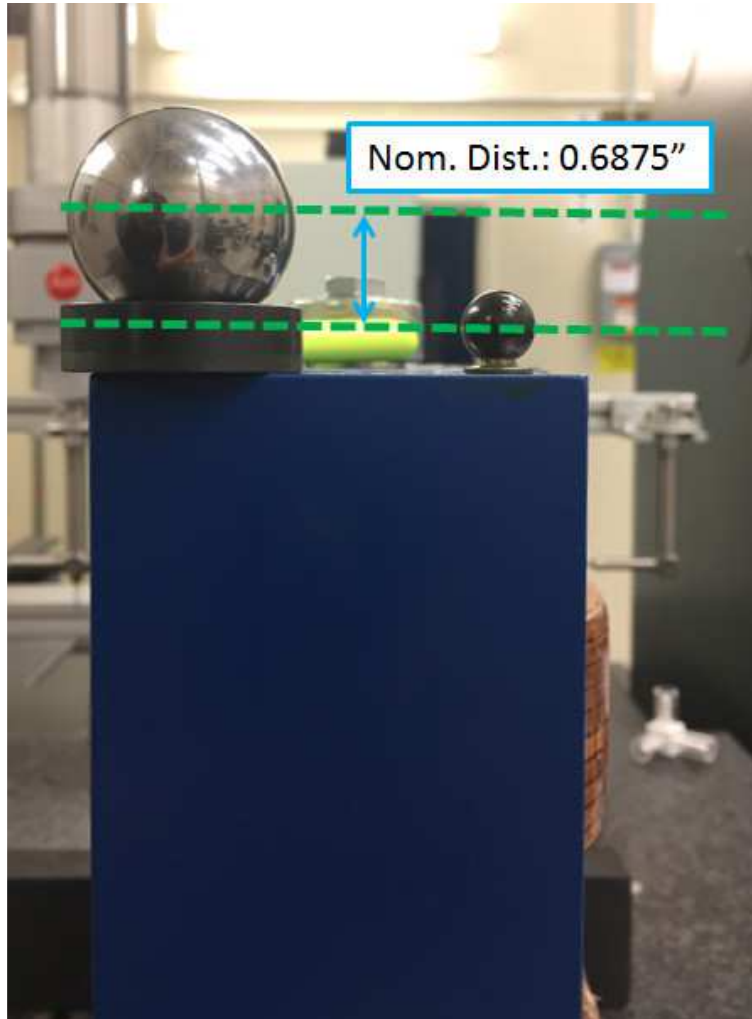
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	5.1973	6.5146	-1.0585
TB 2	5.1829	6.5247	1.0729
TB 3	-5.1979	6.5237	1.0618
TB 4	-5.1931	6.5221	-1.0604
TB A	5.1950	5.8306	-1.0561
TB B	5.1915	5.8304	1.0642
TB C	-5.1941	5.8307	1.0616
TB D	-5.1944	5.8281	-1.0638

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



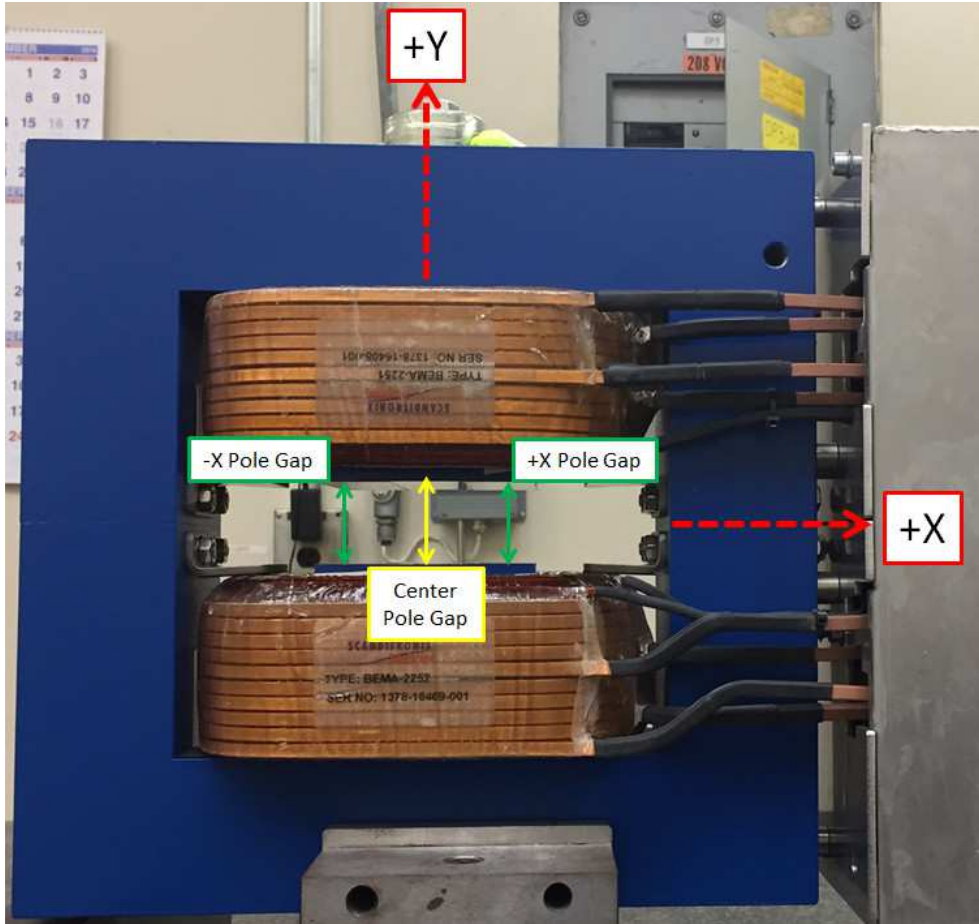
Tooling Ball	Nom Dist.	Actual Dist.	ACT-NOM
TB 1	0.6875 ± 0.001	0.684	-0.0035
TB 2	0.6875 ± 0.001	0.6944	0.0068
TB 3	0.6875 ± 0.001	0.693	0.0055
TB 4	0.6875 ± 0.001	0.6941	0.0066

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.	1.18105	1.18129	1.18144	1.18149	1.19618	1.19628

Dimensions in Inch

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