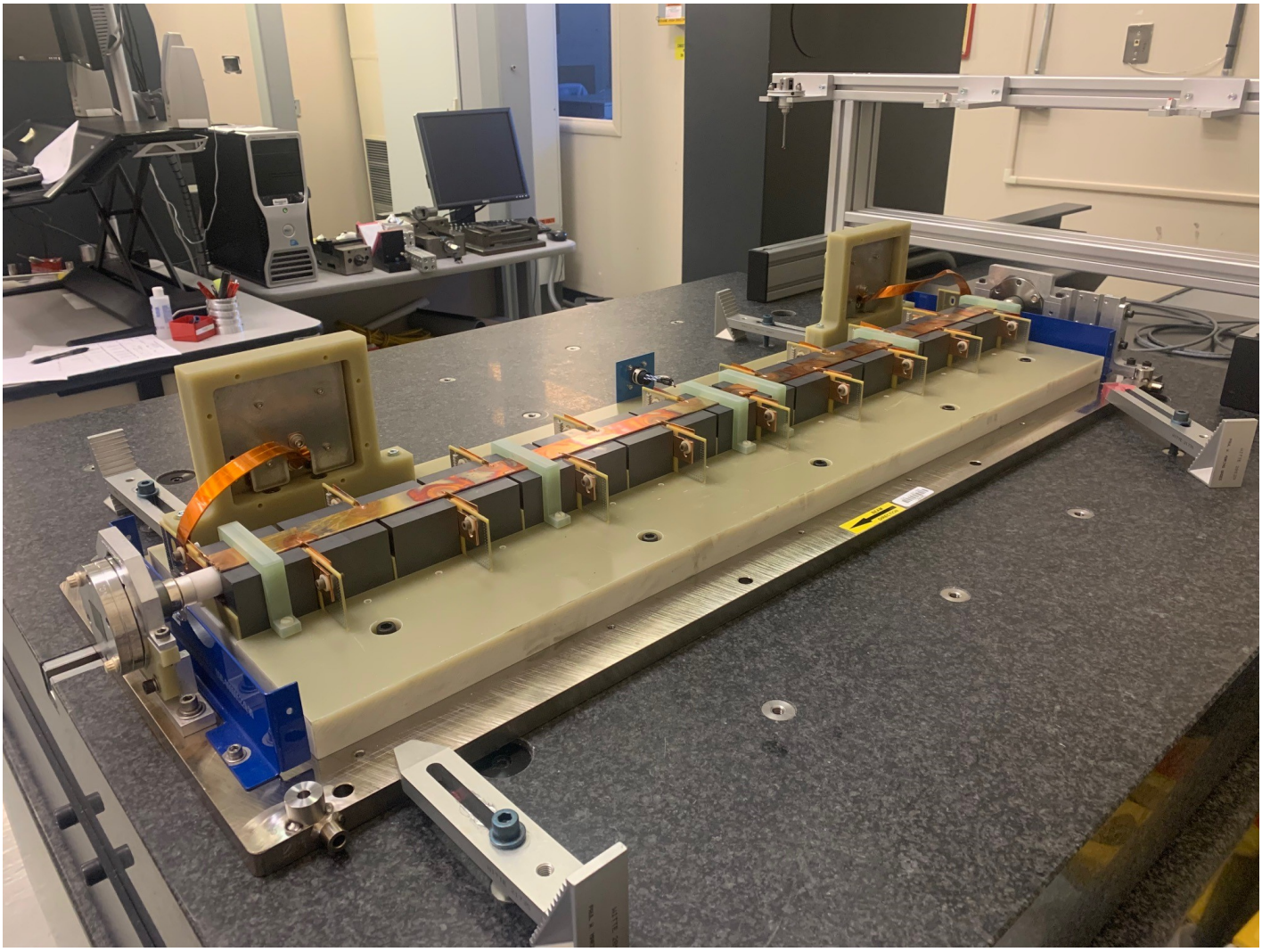
SLAC NATIONAL ACCELERATOR LABORATORY

LCLS-II

S30XL HIGH RATE KICKER MAG ASSY



Inspector : K. Caban

Engineer : T. Beukers

Drawing No. : SA-375-164-01 R1

Barcode # :4482

Coordinate System Setup

Spatial Alignment

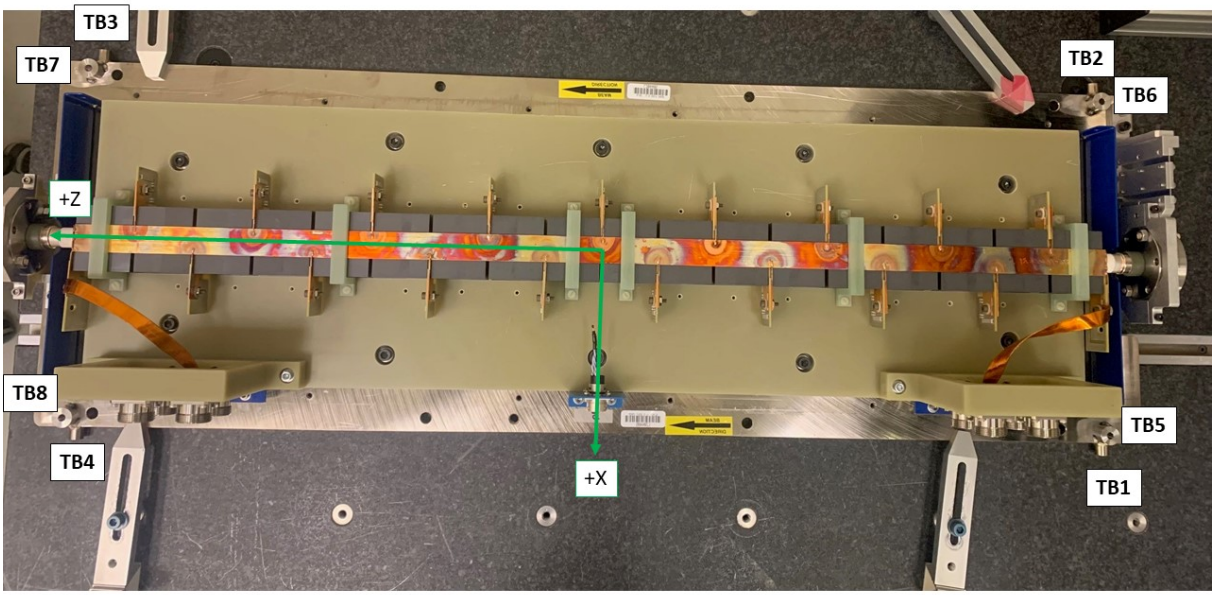
Symmetry Plane of the Outer Ferrite U-Core
Upstream End and Downstream End
Sets Zero in X and sets Pitch/Yaw

Planar Alignment

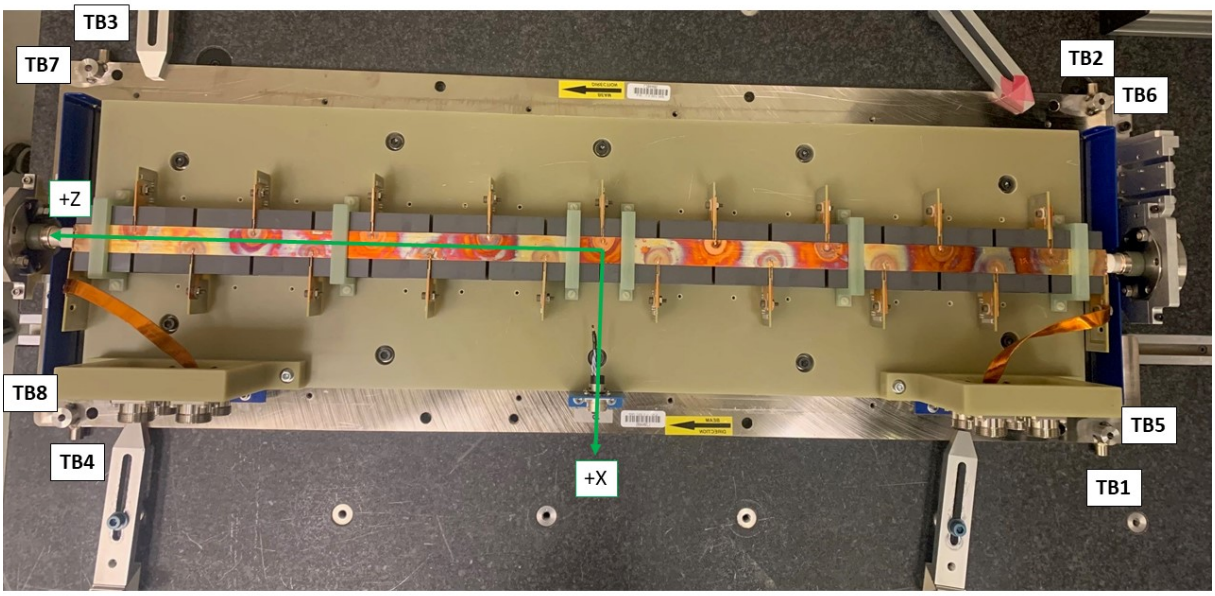
Top of Ferrite U-Core, shifted down -0.425"
Sets Roll and Zero in Y

Coordinate Origins

Origin in Z is the symmetry Plane of the end of the Upstream end of U-Core Ferrite
(side with flexure holder sticking down from plate) and Downstream end of U-Core Ferrite.



Standard 1 inch offset Tooling Balls

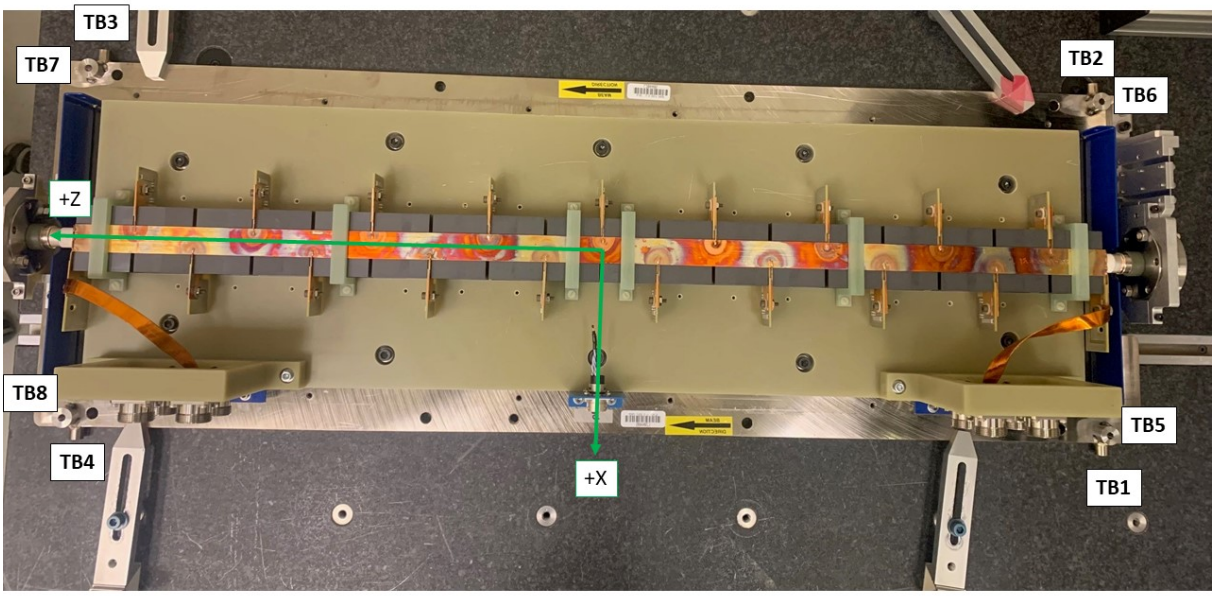


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	8.4689	-2.3919	-20.2361
TB 2	-8.5348	-2.3703	-20.2122
TB 3	-8.4700	-2.3731	19.6579
TB 4	8.5281	-2.3807	19.6364
TB 5	6.6115	-0.6273	-20.2664
TB 6	-6.6373	-0.6248	-20.2451
TB 7	-6.5885	-0.6221	19.8605
TB 8	6.6437	-0.6222	19.8530

Tooling Ball Locations are 1 inch above Tooling Ball Adapter Plane

Dimensions in Inch

Tooling Ball Locations
Short Tooling Balls - 5/16 inch

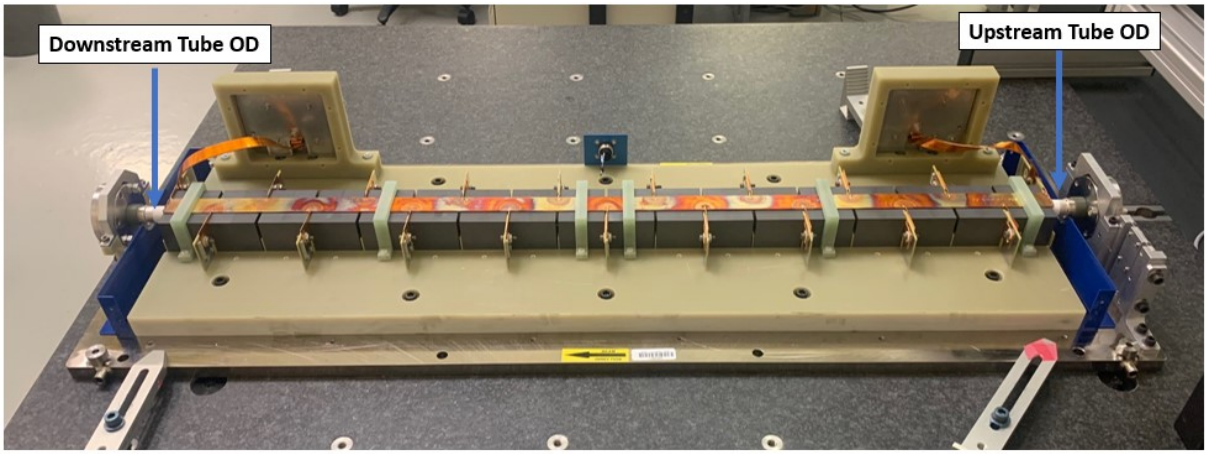


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	7.7799	-2.3858	-20.2399
TB 2	-7.8450	-2.3724	-20.2198
TB 3	-7.7813	-2.3709	19.6499
TB 4	7.8402	-2.3800	19.6300
TB 5	6.6089	-1.3148	-20.2619
TB 6	-6.6412	-1.3123	-20.2442
TB 7	-6.5871	-1.3096	19.8620
TB 8	6.6439	-1.3097	19.8535

Tooling Ball Locations are 5/16 (.3125) inch above Tooling Ball Adapter Plane

Dimensions in Inch

OD Tube Measurements U/S-D/S



OD Tube Loc	X-Coord.	Y-Coord.	Z-Coord.
Upstream Tube OD	0.0013	0.0277	-18.8437
Downstream Tube OD	0.0143	0.0277	18.8485