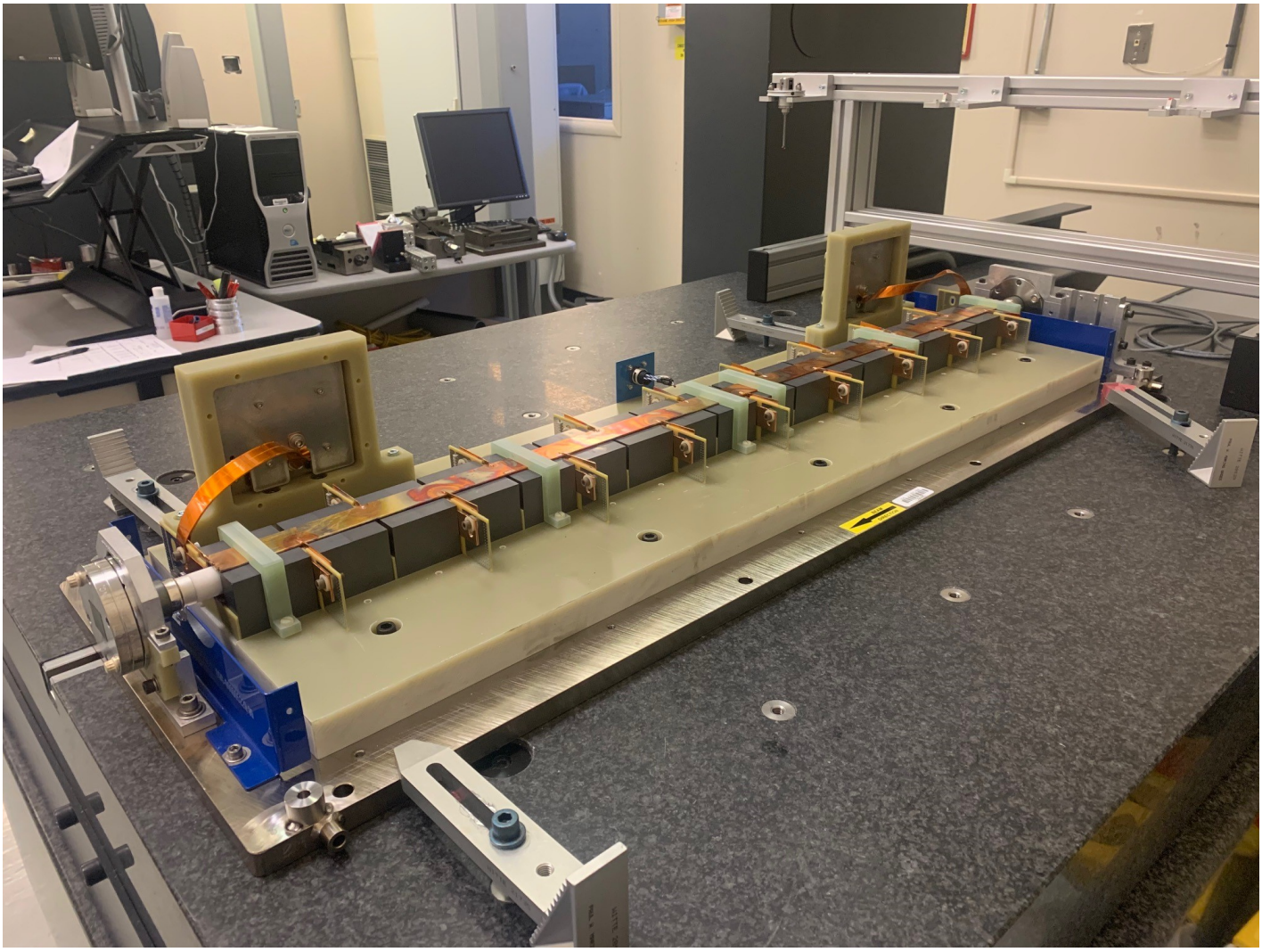
SLAC NATIONAL ACCELERATOR LABORATORY

LCLS-II

S30XL HIGH RATE KICKER MAG ASSY



Inspector : K. Caban

Engineer : T. Beukers

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

Barcode # :4483

Coordinate System Setup

Spatial Alignment

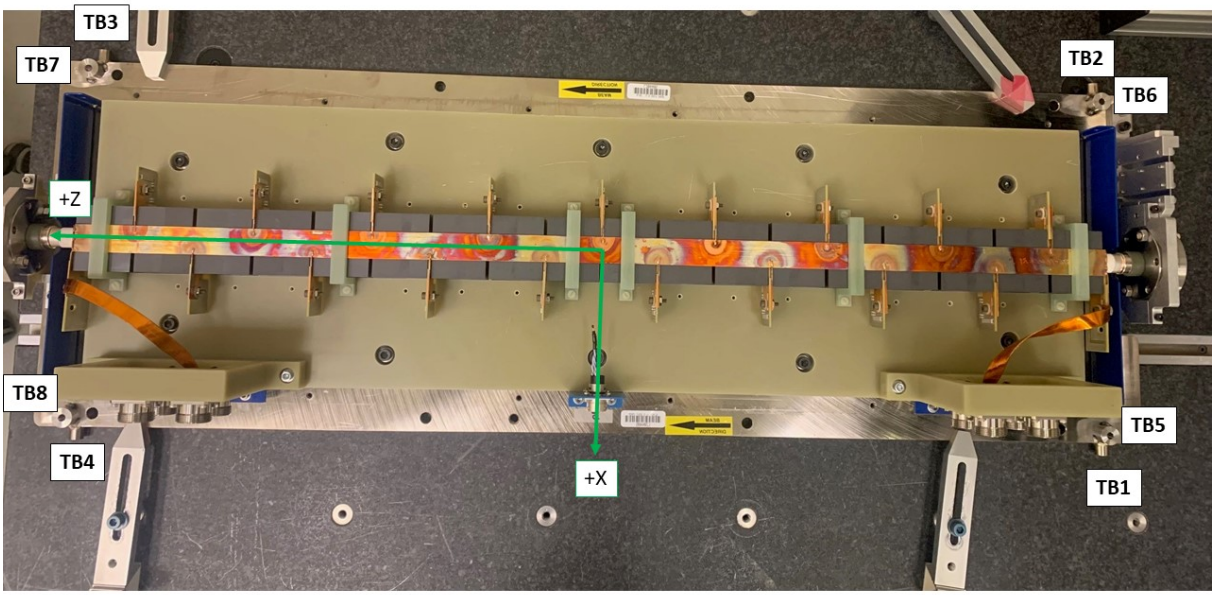
Symmetry Plane of the Outer Ferrite U-Core
Upstream End and Downstream End
Sets Zero in X and sets Pitch/Yaw

Planar Alignment

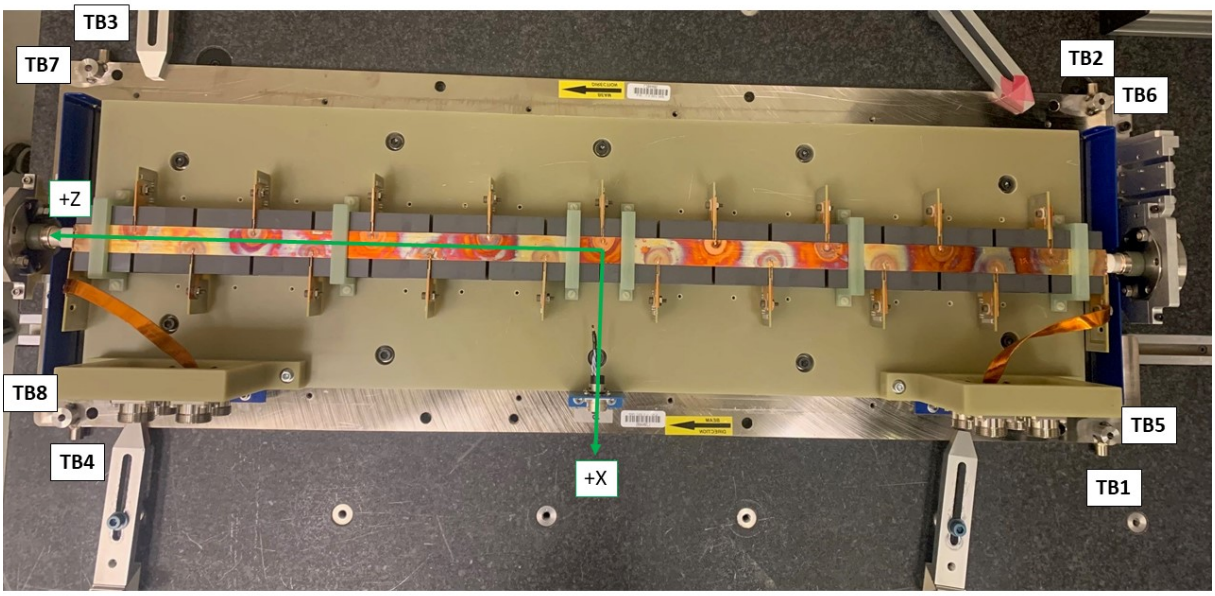
Top of Ferrite U-Core, shifted down -0.425"
Sets Roll and Zero in Y

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

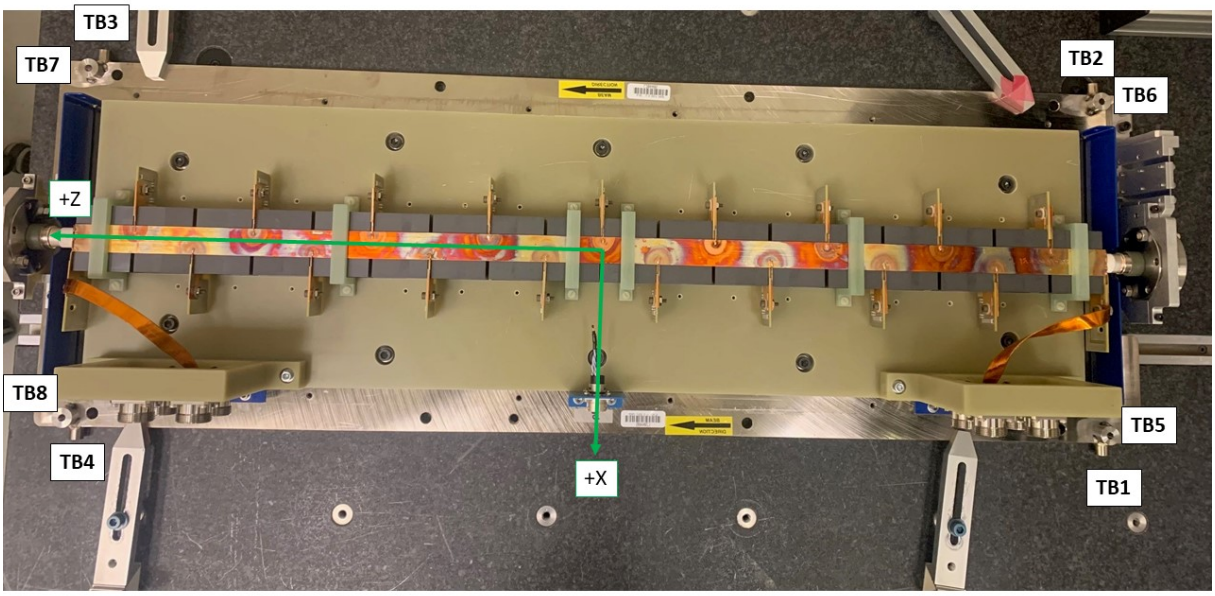


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	8.5049	-2.3648	-20.2635
TB 2	-8.4950	-2.3967	-20.2723
TB 3	-8.5087	-2.4272	19.6070
TB 4	8.4910	-2.3818	19.6105
TB 5	6.6123	-0.6154	-20.2429
TB 6	-6.6038	-0.6199	-20.2383
TB 7	-6.6077	-0.6348	19.8497
TB 8	6.5999	-0.6331	19.9395

Tooling Ball Locations are 1 inch above Tooling Ball Adapter Plane

Dimensions in Inch

Tooling Ball Locations
Short Tooling Balls - 5/16 inch

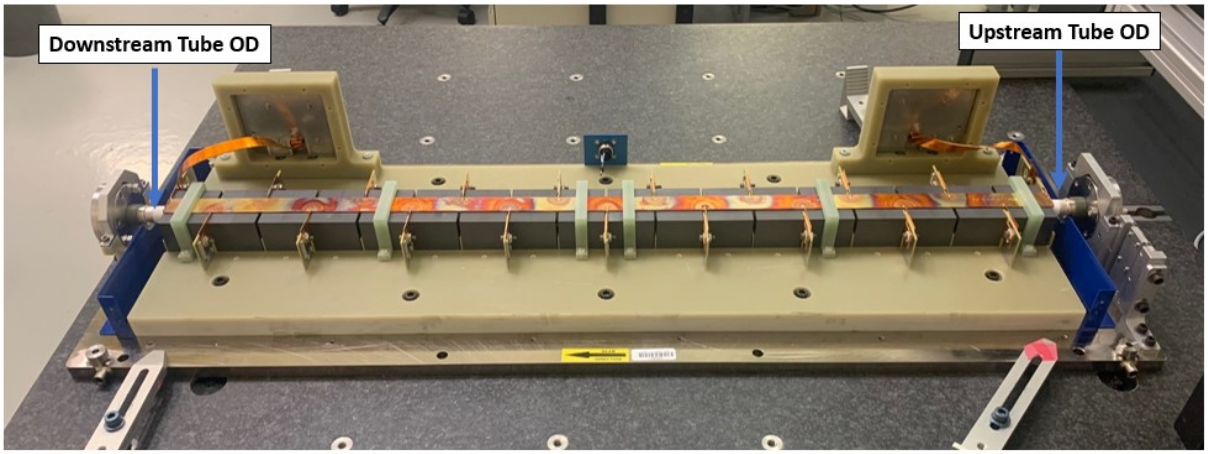


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	7.8169	-2.3687	-20.2594
TB 2	-7.8073	-2.3838	-20.2667
TB 3	-7.8213	-2.4105	19.6103
TB 4	7.8034	-2.3848	19.6138
TB 5	6.6114	-1.3029	-20.2456
TB 6	-6.6054	-1.3074	-20.2403
TB 7	-6.6106	-1.3223	19.8504
TB 8	6.6016	-1.3206	19.9386

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	-0.0024	0.0263	-18.8391
Downstream Tube OD	0.0031	0.0263	18.8440