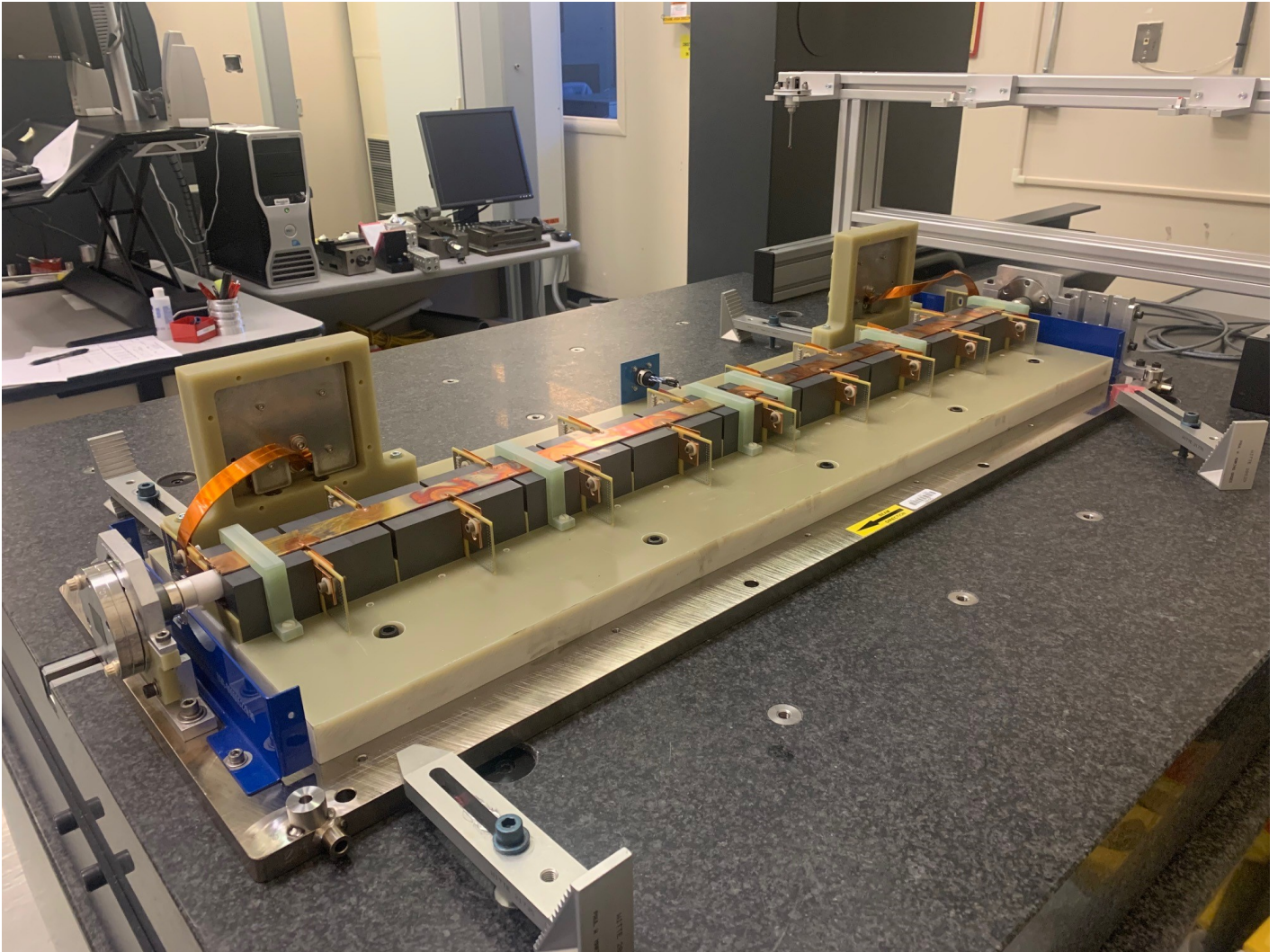


S30XL HIGH RATE KICKER MAG ASSY



Inspector : K. Caban
Engineer : T. Beukers
Drawing No. : SA-375-164-01 R1
Barcode # :4484

Coordinate System Setup

Spatial Alignment

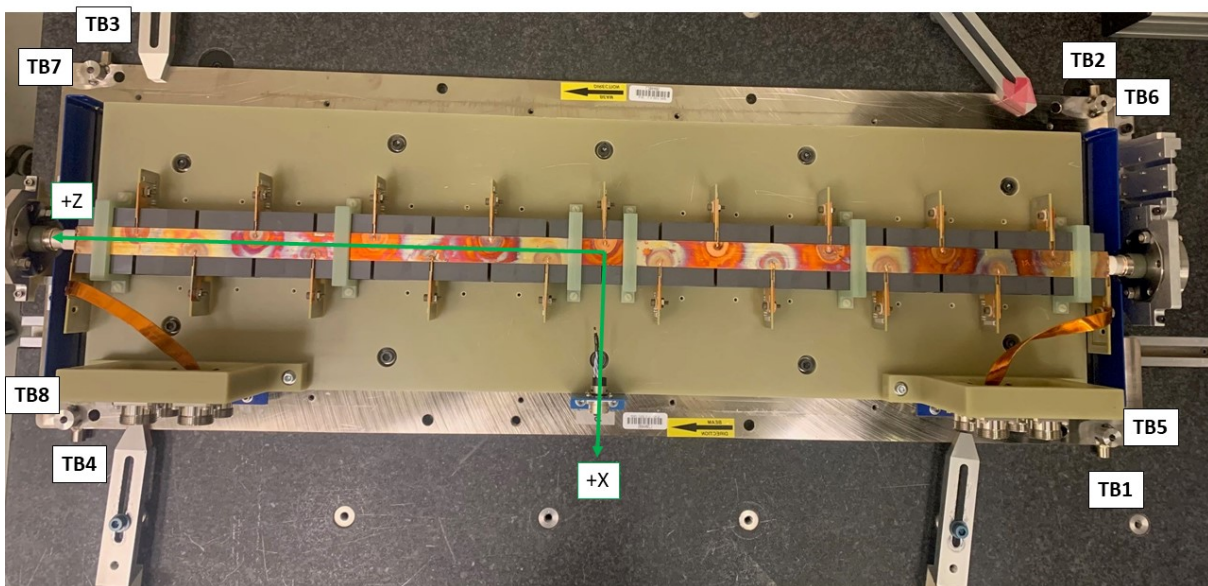
Symmetry Plane of the Outer Ferrite U-Core
Upstream End and Downstream End
Sets Zero in X and sets Pitch/Yaw

Planar Alignment

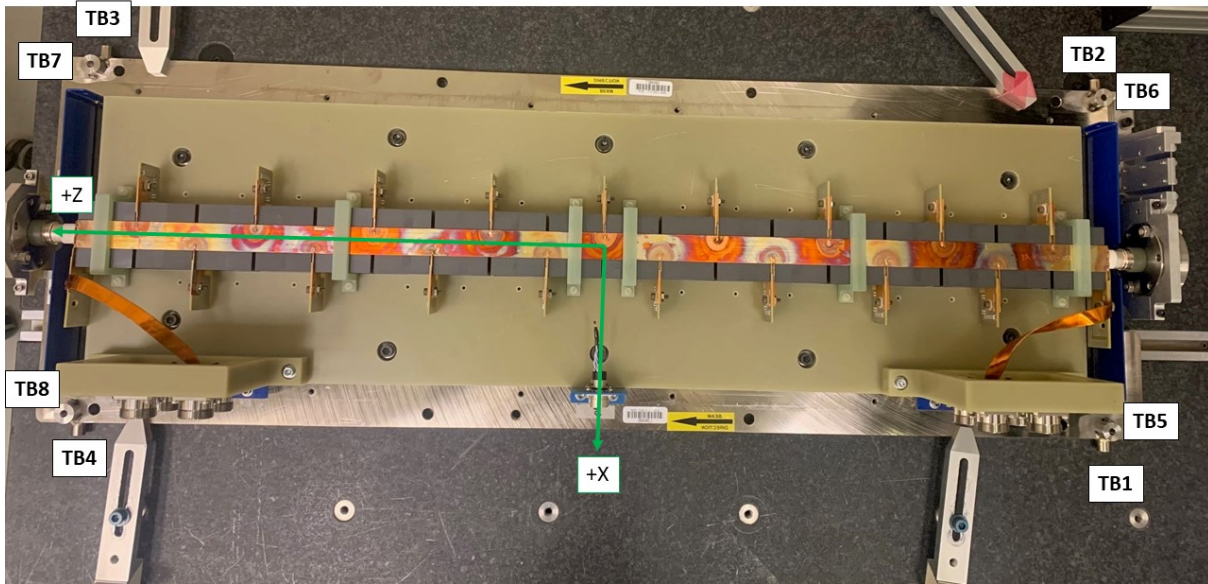
Top of Ferrite U-Core, shifted down -0.425"
Sets Roll and Zero in Y

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

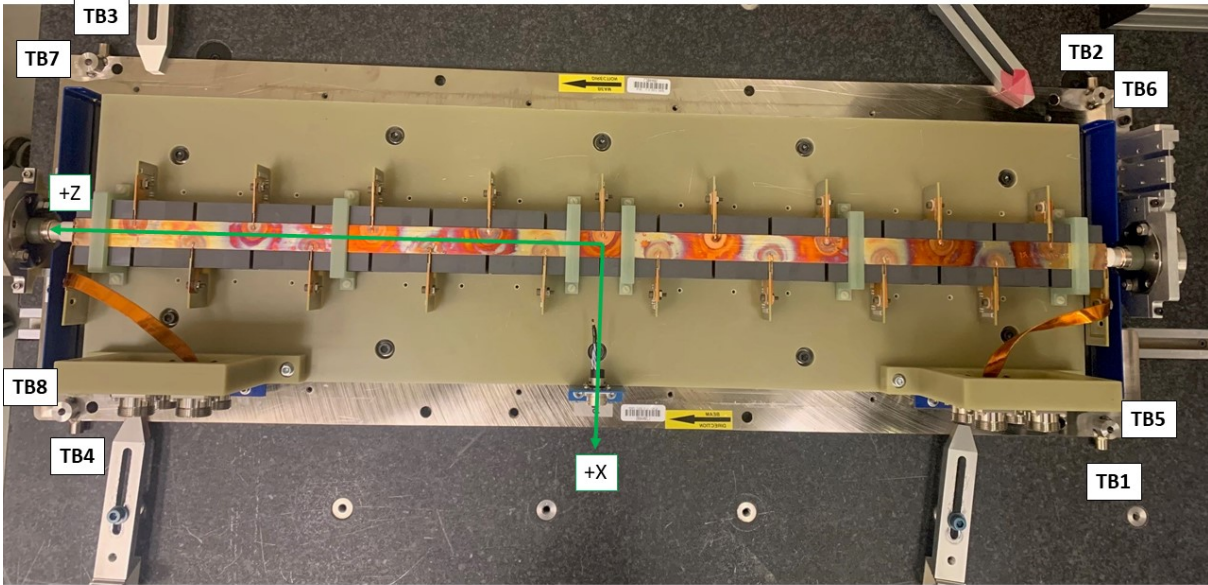


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	8.4939	-2.4125	-20.2757
TB 2	-8.5082	-2.3694	-20.2816
TB 3	-8.5142	-2.3763	19.5907
TB 4	8.4843	-2.4039	19.5972
TB 5	6.6308	-0.6234	-20.2426
TB 6	-6.6205	-0.6199	-20.3030
TB 7	-6.6425	-0.6154	19.8127
TB 8	6.5875	-0.6284	19.8272

Tooling Ball Locations are 1 inch above Tooling Ball Adapter Plane

Dimensions in Inch

Tooling Ball Locations Short Tooling Balls - 5/16 inch

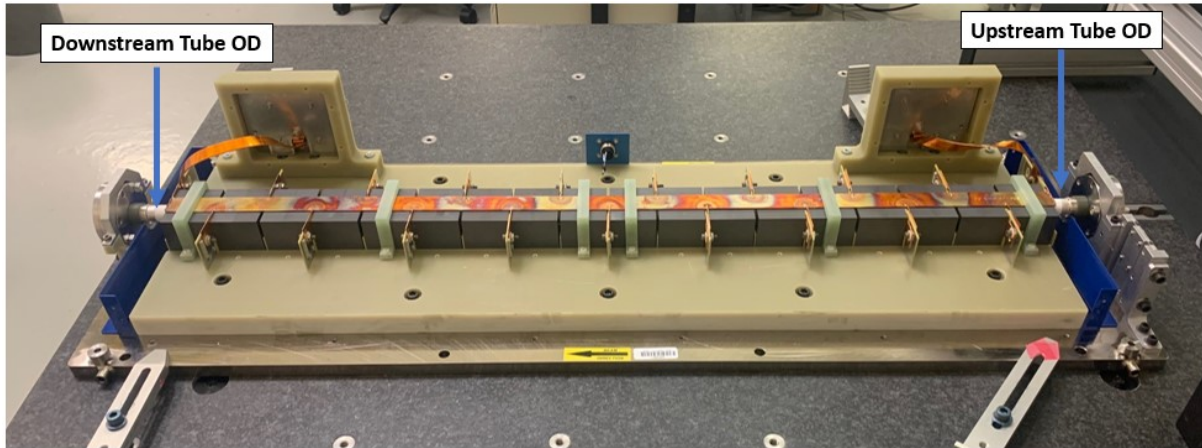


Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	7.8034	-2.3976	-20.2806
TB 2	-7.8205	-2.3691	-20.2851
TB 3	-7.8279	-2.3810	19.5862
TB 4	7.7937	-2.3951	19.5944
TB 5	6.6300	-1.3109	-20.2468
TB 6	-6.6238	-1.3074	-20.2990
TB 7	-6.6403	-1.3029	19.8127
TB 8	6.5881	-1.3159	19.8278

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	0.0052	0.0208	-18.8406
Downstream Tube OD	0.0049	0.0208	18.8414