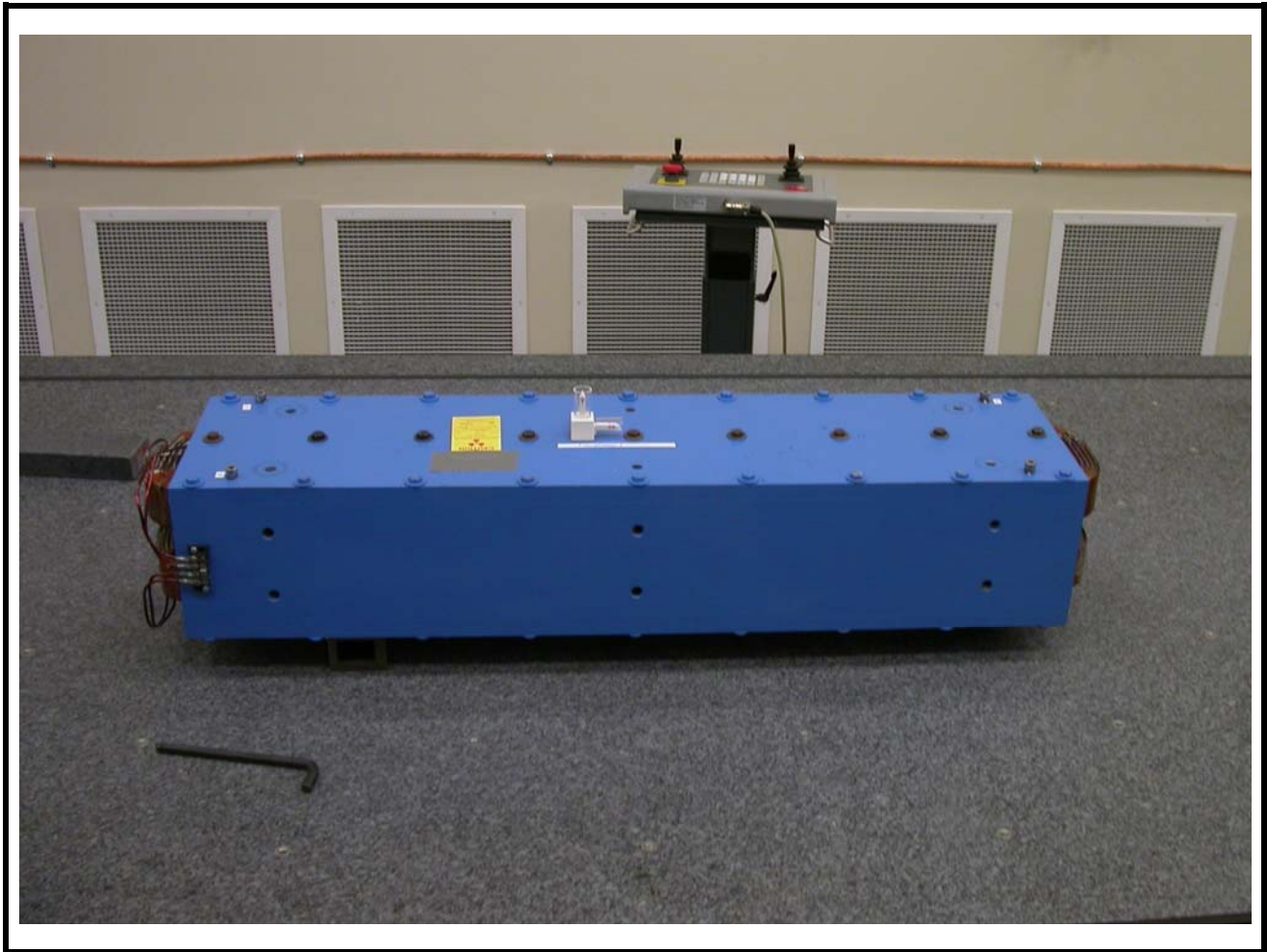


LCLS Dipole Magnet FIDUCIALIZATION REPORT



Inspector: Ed Reese
Responsible Engineer: Carl Rago
Date: Monday, February 12, 2007
Work Order/Charge No.: 21697-1
Serial Number 000353
URL of Fiducial Report: \\Web002\www-group\met\Quality\FIDUCIAL_REPORTS\LCLS_DIPOLE\000353.PDF

Part Set-up – Coordinate System Set-up

Planar Alignment

- Symmetry Axis between inner side plates of housing

Spatial Alignment

- Symmetry Plane between upper and lower poles

“Z” Zero

- Symmetry Point between faces perpendicular to beam

“X” Zero

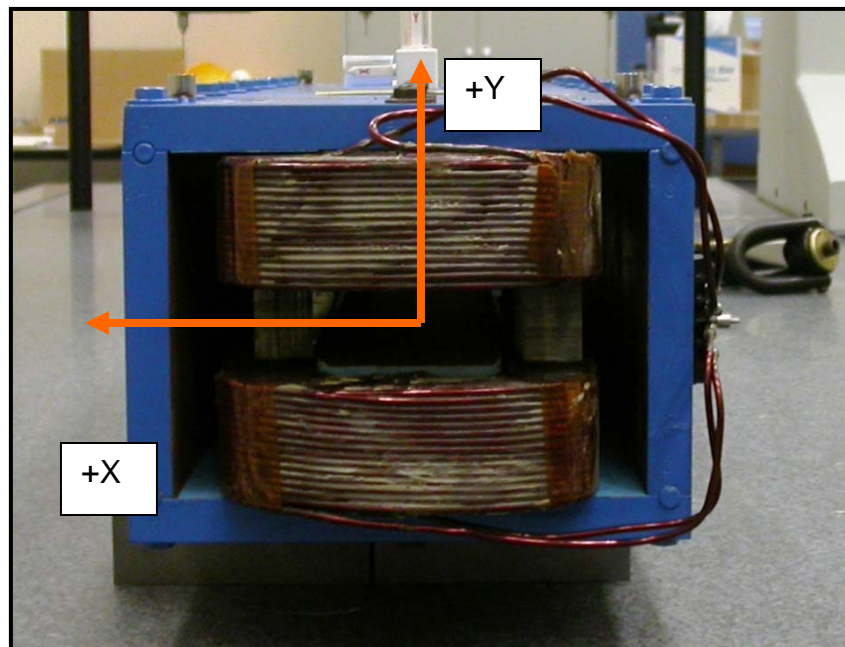
- Symmetry Axis between Inner side plate of housing

“Y” Zero

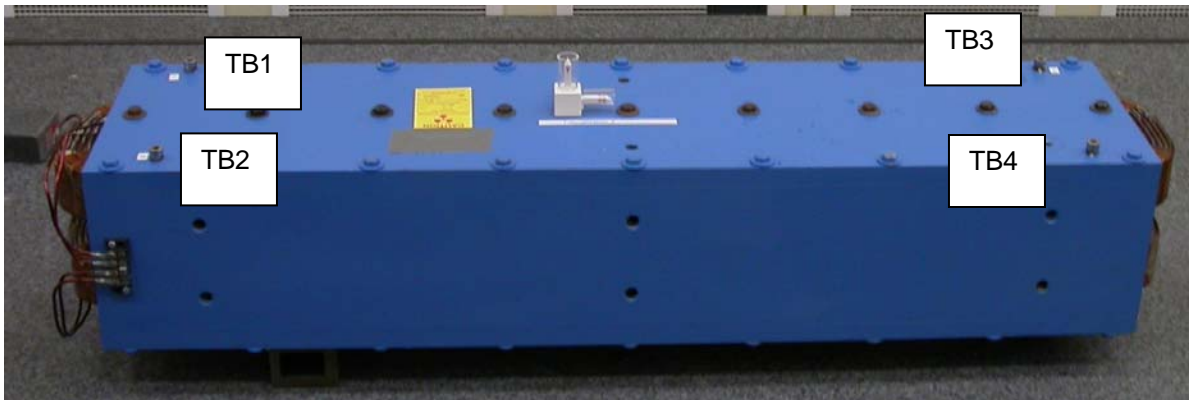
- Symmetry Plane between upper and lower poles



-Z End View



Tooling Ball Measurements/Locations



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB 1	0.00108	0.49657	4.01339	5.16433	-17.01042
TB 2	0.00017	0.49917	-3.86069	5.16223	-16.95661
TB 3	0.00004	0.49972	3.88023	5.16239	17.02284
TB 4	0.00000	0.49809	-3.88433	5.16311	17.03344

Additional Requested Measurements

LOCATION	POLE DISTANCE
-X/-Z	1.37802
+X/-Z	1.37754
-X/+Z	1.37886
+X/+Z	1.37817