

SLAC Traveler for LCLS undulator re-tuning. Undulator S/N # 32 Dataset0003

This traveler is intended to cover magnetic measurements and mechanical fiducialization of the undulator segments at MMF.

Preparation:

Move the undulator inside the temperature controlled room and keep it in the crate for 7 days to get the room temperature.

Placing undulator on the measurement bench:

Earthquake T-bolts attached		✓
Thermistor blocks attached		✓
X-trajectory shims modified		
Y-trajectory shims replaced	N/A	
Check interference with probes		✓
Check end plates		✓
Technician (initials):		Y
Date (mm-dd-yyyy):		01/21/09

Tuning.

Follow the fine tuning test plan to align the undulator to the bench, measure x , y field and calculate the trajectories, phases and field integrals, and fiducialize the undulator (LCLS-TN-06-17, LCLS-TN-07-2). X and Y to be set to 10 μ m; roll to 0.1mrad; pitch to 0.005mrad, and yaw to 0.010mrad.

Mechanical alignment done		✓
Magnetic alignment done		✓
Probe roll angle checked		✓

The following information is to be noted by an engineer upon finishing alignment to the granite:

Engineer (initials):	Y
Date (mm-dd-yyyy):	01/21/09
Average X (m):	0.029145
Average Y (m):	0.000344
Final Roll (rad):	+2.10 ⁻⁶
Final Pitch (rad):	+0.3.10 ⁻⁶
Final Yaw (rad):	-0.2.10 ⁻⁶

$$T = 19.97 \text{ } ^\circ\text{C}$$

The following information is to be noted by an engineer upon final tuning:

Engineer (Initials):	Y
Date (mm/dd/yyyy)	01/22/09
Reference magnet measurement (T):	-0.369150
First integral Y at center (Tm):	$-18 \cdot 10^{-6}$
Second integral Y at center (Tm ²):	$-2 \cdot 10^{-6}$
First integral X at center (Tm):	$+18 \cdot 10^{-6}$
Second integral X at center (Tm ²):	$-11 \cdot 10^{-6}$
Magnetic axis position X (m):	0.029260
Magnetic axis position Y (m):	0.000358
Final Phase error rms (°):	4.2
Final max X trajectory error (μm):	-0.5
Final max Y trajectory error (μm):	±0.3
Measured K-value:	3.486727
X-field correction (T):	$-0.23 \cdot 10^{-4}$
Y-field correction (T):	$-0.03 \cdot 10^{-4}$
Final Phase error entrance (°):	-1.1
Final Phase error cell (°):	+2.2
Final Phase error exit (°):	-0.2
Slot number	30

URL of on-line Final tuning data:

www-group.slac.stanford.edu/met/MagMeas/MAGDATA/LCLS/Undulator/L143-112000-32/DATASET003/Fine%20Tuning/

Fiducialization on Kugler bench:

Upon completion of the tuning the undulator should be fiducialized; optical measurements to be done the same day as magnetic measurements.

Attach pointed magnets to the both ends of the undulator. Measure position of the PM centers w.r.t. the undulator center line.

The following information is to be noted by an engineer:

Engineer (Initials):	YL
Upstream PM X offset (m):	0.029152
Upstream PM Y offset (m):	0.000302
Downstream PM X offset (m):	0.029059
Downstream PM Y offset (m):	0.000216
Reference upstream PM X offset (m):	0.076826
Reference upstream PM Y offset (m):	0.000320
Reference downstream PM X offset (m):	0.076916
Reference downstream PM Y offset (m):	0.000491
Keyence probe (m):	+0.011074
Keyence block (m):	-0.011367

Have an alignment crew to measure offsets between PM tooling balls, the undulator tooling balls, reference PM tooling balls to an alignment reference line, Hall probe in X and gage block in Y. Attach alignment data sheet to the traveler.

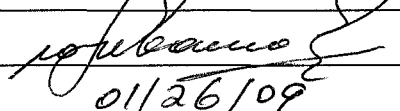
Surveyor (initials):	LG
Date (mm/dd/yyyy):	01/22/09

Move the undulator to CMM to finalize the fiducialization.

Attach CMM data sheet to the traveler.

URL of on-line fiducialization data:

www-group.slac.stanford.edu/met/MagMeas/MAGDATA/LCLS/Undulator/L143-112000-32/DATASET003/

Undulator tuning completed (signed):	
Date (mm/dd/yy)	01/26/09