

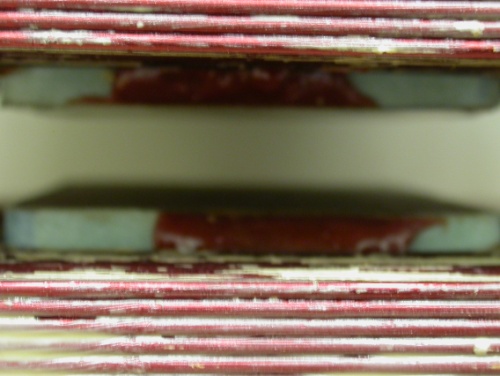
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| **BLUE DIPOLE - ECHO 7 EXP. (3D4 MAGNET)** |
| **FIDUCIALIZATION REPORT** |

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| **DSCN2185** |

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| Inspector: | Keith Caban |
| Customer: | Dieter Walz |
| Date: | Monday, July 20, 2009 |
| Work Order/Charge No.: | 09-3008 |
| Serial Number: | #4 |
| Stamped Drwg. #: | AD-234-309-91 |
| URL of Fiducial Report: | \\Web002\www-group\met\Quality\FIDUCIAL REPORTS\BLUE-DIPOLE FFTB STEERING MAGNET\AD-234-309-91 SN-4.pdf |

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| **Part Set-up – Coordinate System Set-up** |

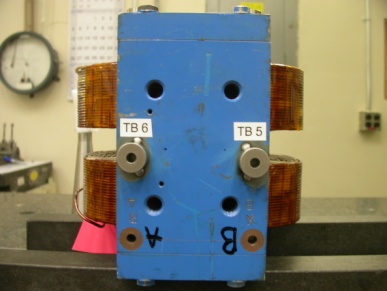
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| Planar Alignment |

* Plane along bottom pole plane.

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| Spatial Alignment |

* Plane of +Z face of magnet

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| “Z” Zero |



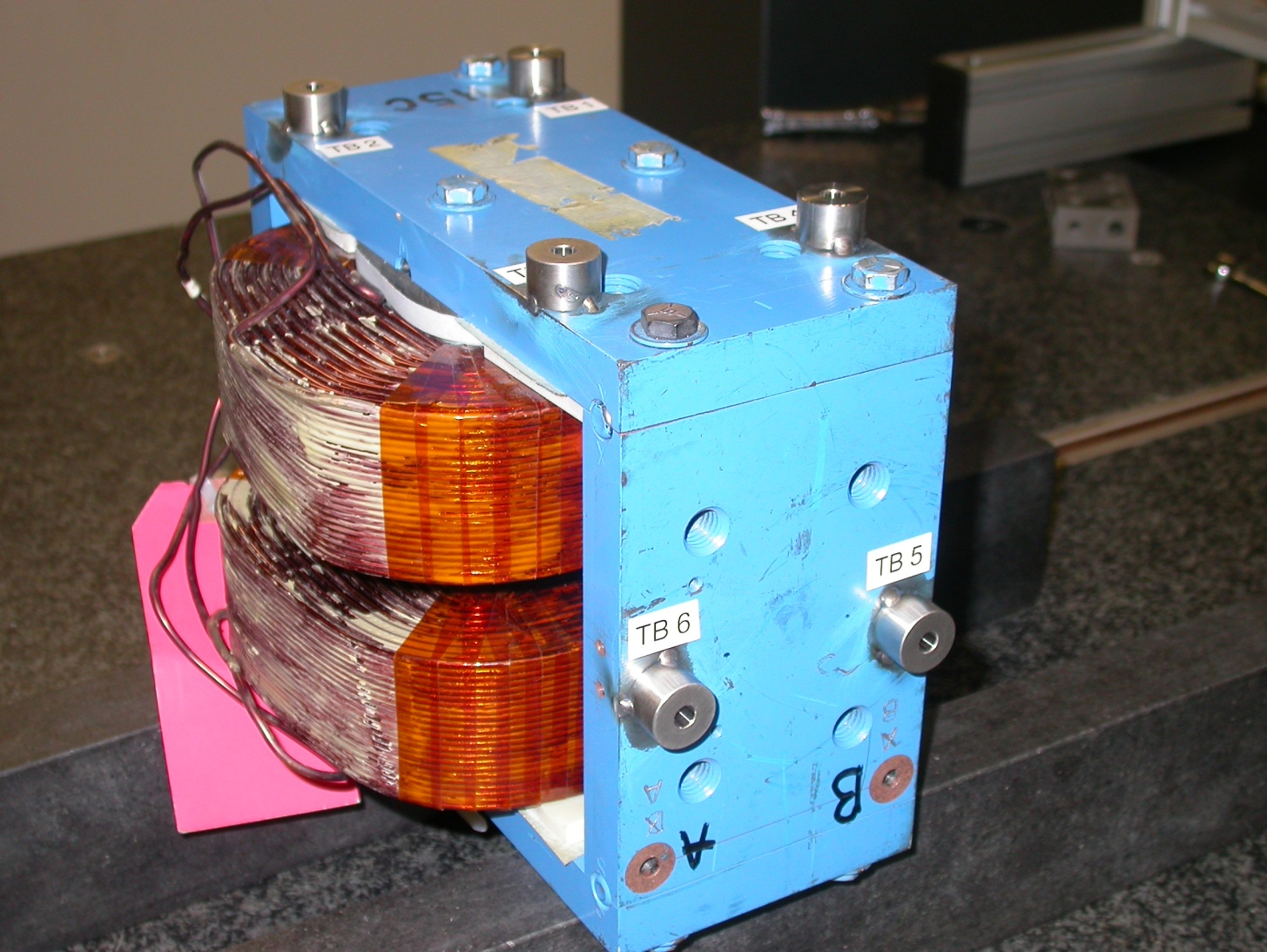
* Mid-Plane of the magnet. (see dashed planar alignment above)

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| “X” & “Y” Zero |

* X zero is created by the symmetry point of the outer ends of the magnet where TB 5 & 6 are and opposite where the terminal strip is located.
* Symmetry plane of the pole planes
  + This creates Y- zero

|  |  |
| --- | --- |
| DSCN2186  **+Y**  **+Z** | DSCN2194  **+X**  **+Y** |

|  |
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| **Tooling Ball Measurements/Locations** |



**-Z**

**+Y**

**-X**

Projected cylinder into 1” offset plane

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Tooling Ball** | **Form** | **n** | **X** | **Y** | **Z** | **b** |
| **TB 1** | 0.00040 | 0.25046 | 3.48652 | 5.02925 | 1.63371 | 0.00038 |
| **TB 2** | 0.00034 | 0.25044 | 3.47357 | 5.02923 | -1.60505 | 0.00037 |
| **TB 3** | 0.00023 | 0.25047 | -3.51175 | 5.02701 | -1.62813 | 0.00040 |
| **TB 4** | 0.00022 | 0.25057 | -3.50771 | 5.02701 | 1.65017 | 0.00015 |
| **TB 5** | 0.00026 | 0.25045 | -6.26583 | 0.00721 | 1.64715 | 0.00044 |
| **TB 6** | 0.00028 | 0.25044 | -6.26892 | 0.00109 | -1.61752 | 0.00034 |

**Pole Tip Distance/Gaps (at location X, Z)**

|  |  |  |  |
| --- | --- | --- | --- |
| **Station** | **Gap Distance** | **X** | **Z** |
| **1** | **0.60022** | **-1.125** | **-1.375** |
| **2** | **0.60044** | **1.125** | **-1.375** |
| **3** | **0.60041** | **0.000** | **0.000** |
| **4** | **0.60112** | **-1.125** | **1.375** |
| **5** | **0.60099** | **1.125** | **1.375** |
| **Avg. Gap** | **0.60064** | **-** | **-** |