

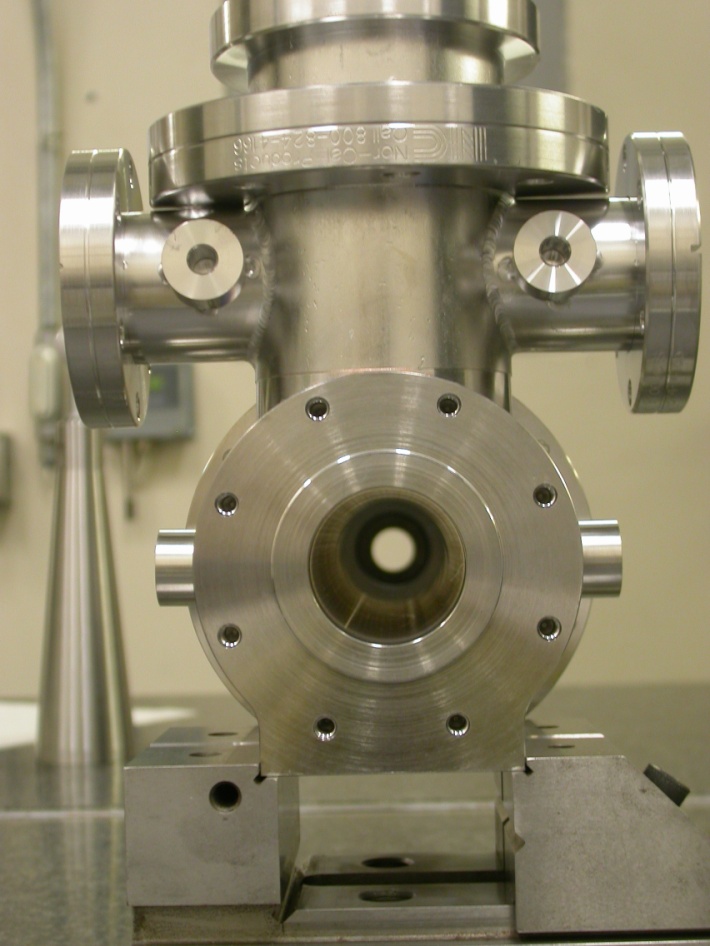
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| **LUSI CXI ROUGH TO UHV TUBE ASSY** |
| **FIDUCIALIZATION REPORT** |

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| DSCN2509 |

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| Inspector: | Keith Caban |
| Customer: | Don Schafer |
| ate: | Monday, July 11, 2011 |
| Work Order/Charge No.: | 27272-1 |
| Serial Number: | 001 |
| Drwg. #: | SA-391-530-09 R0 |
| URL of Fiducial Report: | \\Web002\www-group\met\Quality\FIDUCIAL REPORTS\SA-391-530-09\SN 001.pdf |

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| **Part Set-up – Coordinate System Set-up (Per Phone Conversation with D. Schafer 07/11/11)** |

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| * Based CSY off of the Drawing (SA-391-530-09). * Datum ‘A’ is a plane measurement and is the spatial alignment, zero in Z. * Datum ‘B’ is a cylinder measurement, sets zero in X & Y. * Bottom Flat on Turbo Stage is the planar alignment (roll). |



**TB(1)**

**TB(4)**

**+X**

**TB(2)**

**+Y**

**TB(3)**

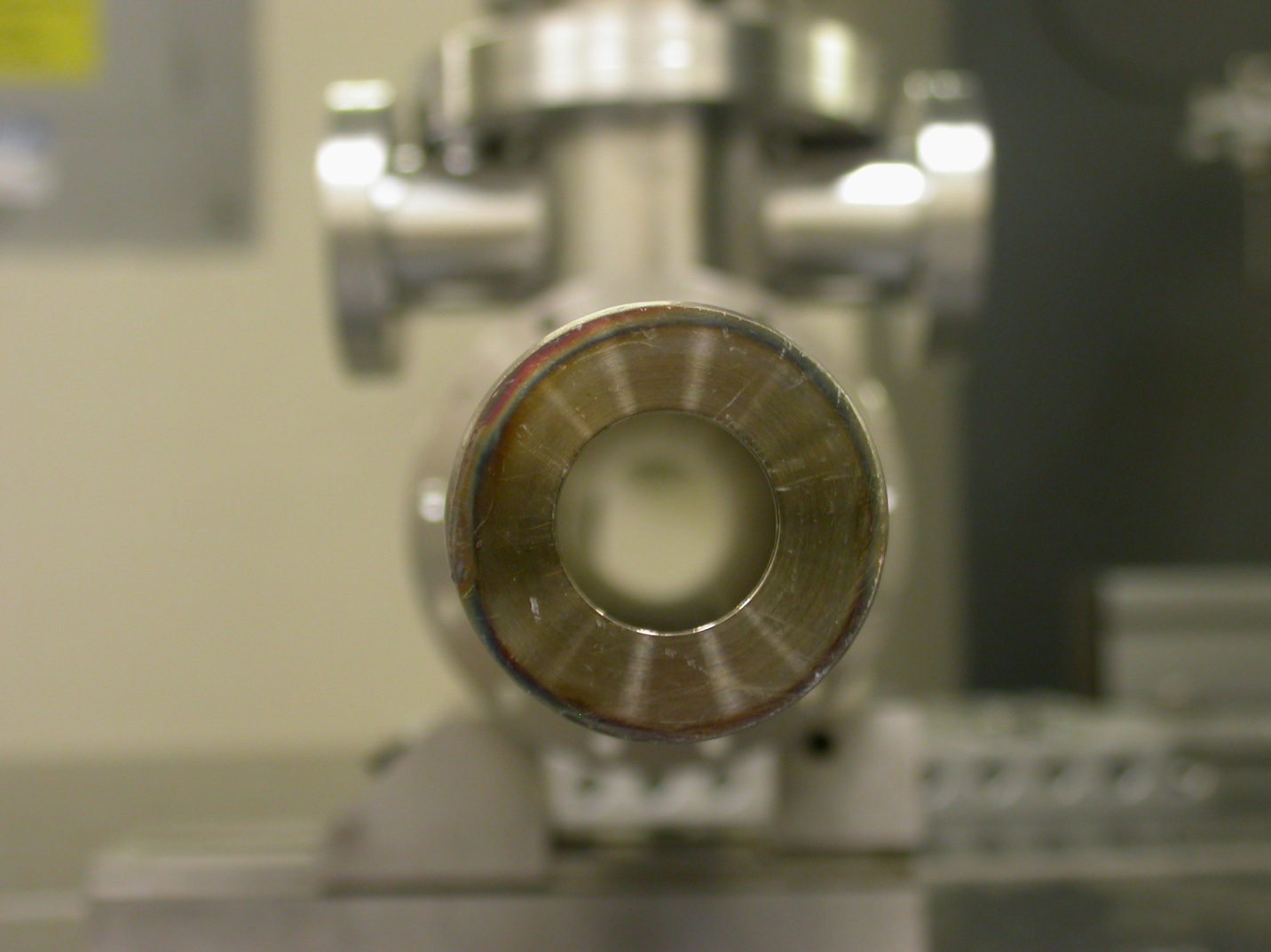
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| **Tooling Ball Measurements/Locations** |

Using ½” Diameter Tooling Balls with 1” extension

TB’s are scribed on Part located near TB Holes and/or TB Adapters (welded)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Tooling Ball** | **Form** | **Diameter** | **X** | **Y** | **Z** |
| **TB 1** | 0.00037 | 0.49981 | 3.19710 | 0.02839 | -1.95768 |
| **TB 2** | 0.00008 | 0.49996 | -3.19763 | -0.01576 | -1.92715 |
| **TB 3** | 0.00006 | 0.49994 | 1.56405 | 2.85671 | -4.04093 |
| **TB 4** | 0.00054 | 0.49966 | -1.55741 | 2.82253 | -4.04877 |

**Location of .752 diameter on opposite end**

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**Actual center position =**

**X= -0.0246**

**Y= -0.0207**

**+X**

**+Y**