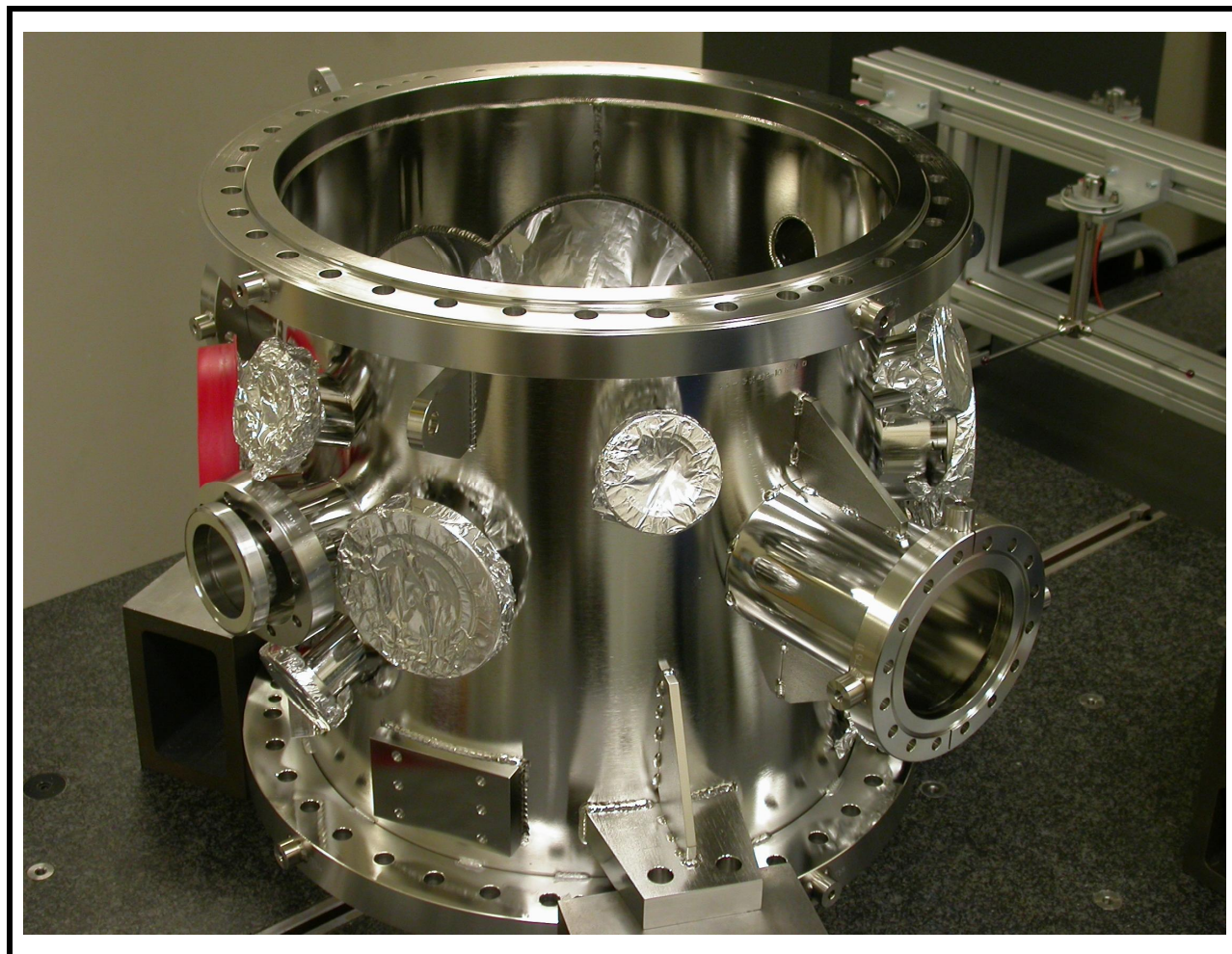




LUSI AMO VACUUM CHAMBER FIDUCIALIZATION REPORT



Inspector: Keith Caban
Customer: Jean Charles Castagna
Date: Wednesday, June 09, 2010
Work Order/Charge No.: 25783-1
Serial Number: 001
Drwg. #: SC-391-212-10 Rev 0
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\SC-391-212-10\SN 001.pdf>

Part Set-up – Coordinate System Set-up

- Axis of Port 1 flange to Port 10 flange is the Z axis in which “positive Z” is pointing towards Port 10.

Spatial Alignment

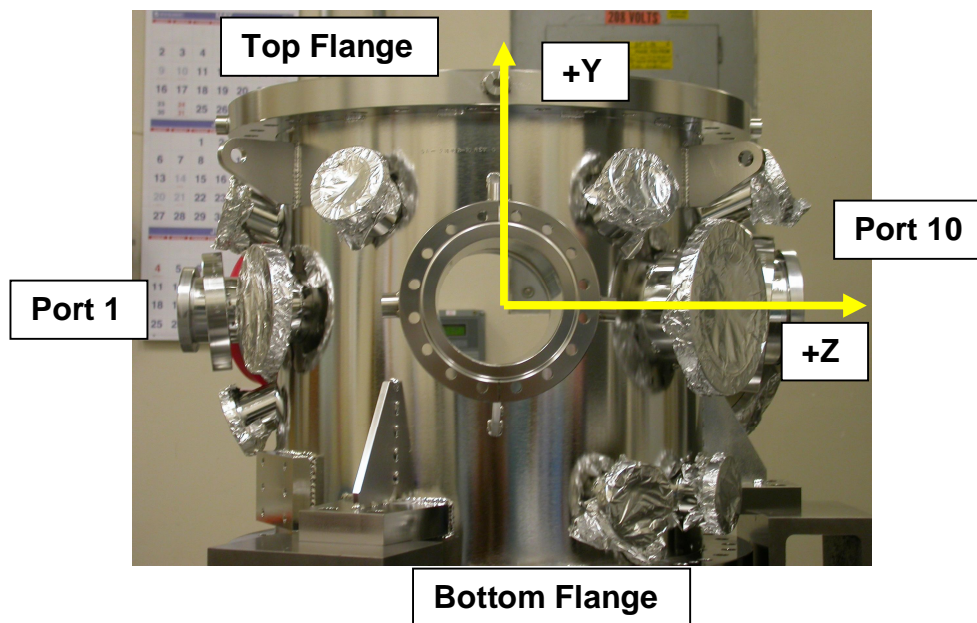
- Plane of top flange that points and sets the direction in “positive Y”.

“Z” Zero

- The axis of the Bottom and Top Flanges. (2 Circles)

“X” & “Y” Zero

- X, Y zero is the axis created by Port 1 & 10 flanges (see planar alignment)



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)

*- Used ½" Diameter Tooling ball with ½" extension due to space. (only on TB 4)

Tooling Ball	Form	Diameter	X	Y	Z
TB 1	0.00001	0.50007	0.00573	6.95821	-11.29097
TB 2	0.00090	0.49914	-11.26586	6.96669	0.00058
TB 3	0.00002	0.50007	0.00087	6.93617	11.26680
TB 4* Used ½" ext.	0.00023	0.49930	10.79466	6.94029	-0.00201
TB 5	0.00071	0.49823	-11.27902	-9.29891	-0.04736
TB 6	0.00031	0.49960	0.13681	-9.30938	-11.26757
TB 7	0.00006	0.50003	11.27132	-9.30935	0.05665
TB 8	0.00031	0.49820	12.92856	5.48613	-0.02823
TB 9	0.00022	0.49906	12.96545	-0.17782	-5.48037
TB 10	0.00018	0.49951	-12.92524	4.49787	0.03091
TB 11	0.00012	0.49894	-12.89611	-0.17273	-4.47891
TB 12	0.00042	0.49915	-12.91245	-0.30550	4.46723