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| **LCLS SXR NRL MAIN BACK FLANGE** |
| **FIDUCIALIZATION REPORT** |

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| Inspector: | Keith Caban |
| Customer: | Michael Holmes |
| ate: | Thursday, July 14, 2011 |
| Work Order/Charge No.: | 27545-1 |
| Serial Number: | 001 |
| Drwg. #: | SK-MH070111 |
| URL of Fiducial Report: | \\Web002\www-group\met\Quality\FIDUCIAL REPORTS\SK-MH070111\SN 001.pdf |

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| **Part Set-up – Fiducial Coordinate System (per Michael Holmes)** |

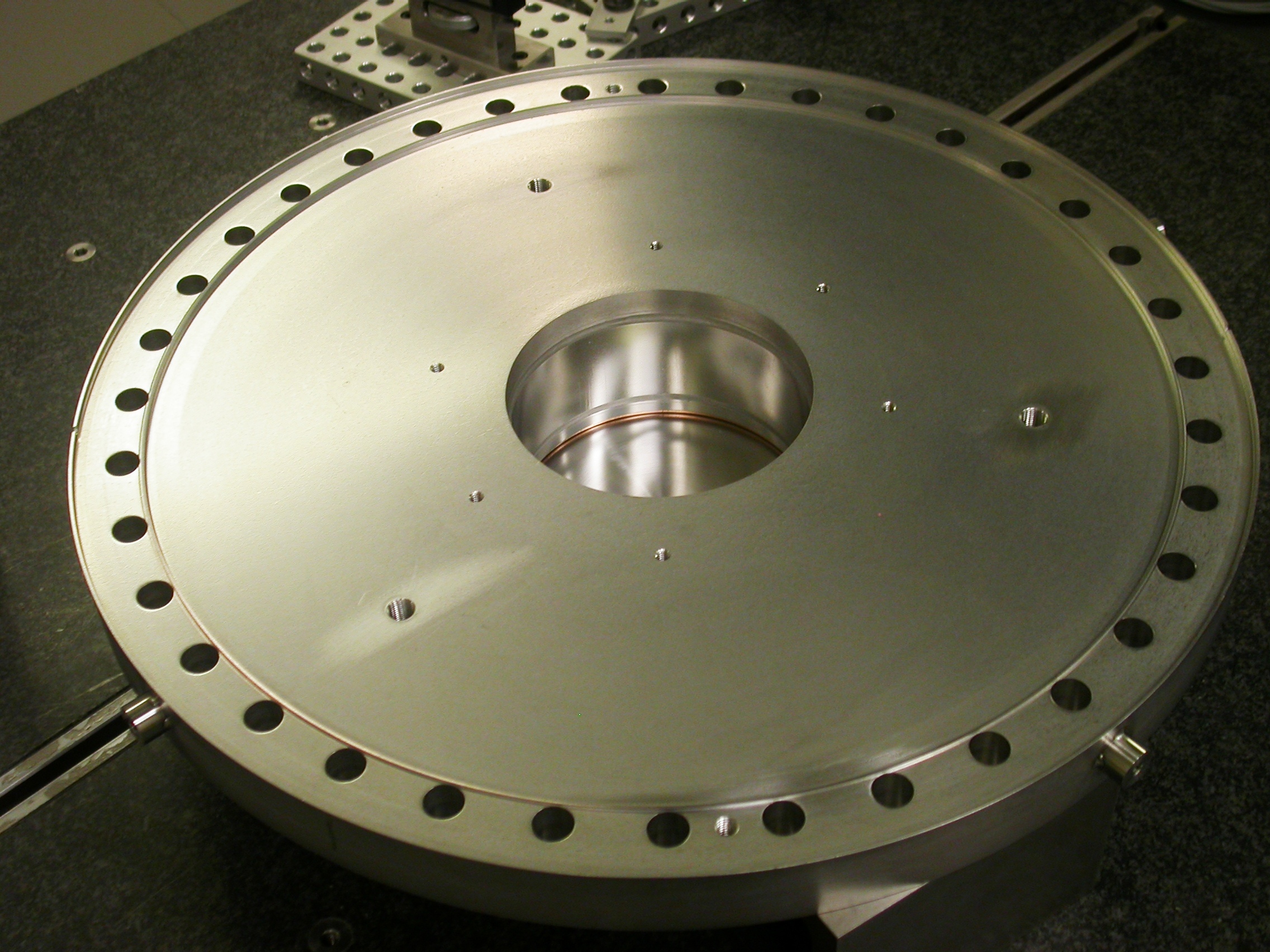
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| * Sealing Surface sets zero in ‘Z’ (Dashed Green Area, see picture below) * Thru ID simulates Beamline center that sets zero in ‘X’ & ‘Y’, and sets the planar alignment, where -Z moving away from the Sealing Surface. * Roll is eliminated by the axis of the center of the thru ID circle and the Center of Hole #0, which creates the –X axis. |

**-Z**

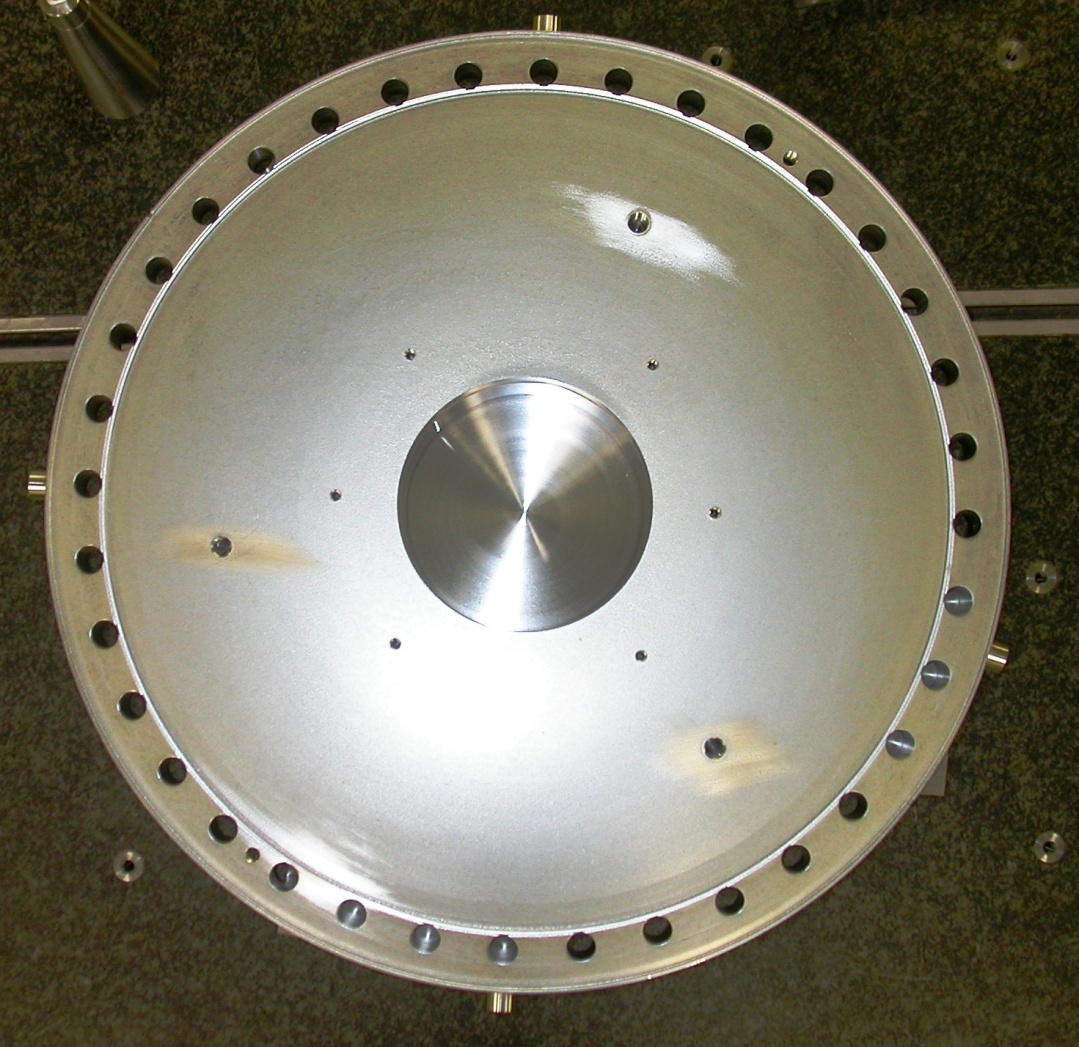
**+Y**

**-X**

**Hole #0**



**TB(4)**



**TB(3)**

**+Y**

**TB(2)**

**TB(1)**

**-X**

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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)

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| **Tooling Ball** | **Form** | **Diameter** | **X** | **Y** | **Z** |
| **TB 1** | 0.00028 | 0.49939 | -12.12697 | -3.25697 | 0.44075 |
| **TB 2** | 0.00018 | 0.49748 | -0.00739 | -12.55978 | 0.44180 |
| **TB 3** | 0.00012 | 0.49857 | 12.56029 | -0.02362 | 0.49608 |
| **TB 4** | 0.00066 | 0.49747 | -0.03335 | 12.55806 | 0.50175 |

**Location of OD Flange to ID (Beamline Center)**

X = 0.00241

Y= -0.00047

**LIP DISTANCE (Outer ring to OD) FROM SEALING SURFACE = 0.25205**