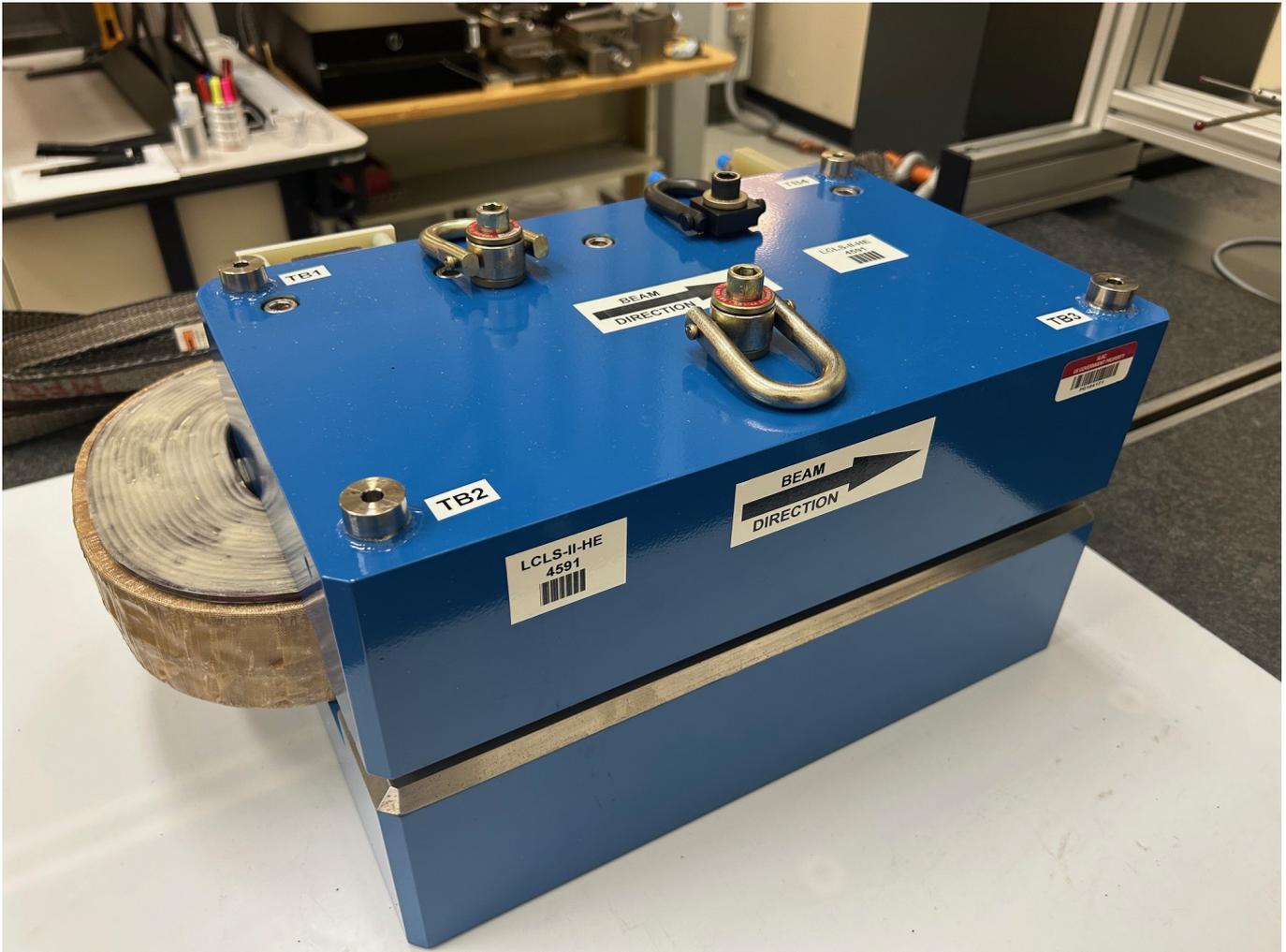


LCLS-II-HE DIPOLE Fiducialization Report 0.315D14.4-C DIPOLE ASSEMBLY - 8mm Gap



Inspector : K. Caban
Engineer : S. Anderson
Drawing No. : 53274 (Everson Tesla)
Barcode # : 4591
Mfg. S/N : PC104171

Coordinate System Setup

Spatial Alignment

Constructed using the Midplane of Upper (+Y) and Lower (-Y) Pole with the Midplane of the 2 Poles sets Y Zero and the Y+ Direction points towards the Tooling Balls Adapters.

Planar Alignment

Constructed using the Upstream (-Z) and Downstream (+Z) Ends of the poles. The Midplane from both ends sets Z Zero and +Z points towards TB 3/4 Side.

Coordinate Origins

X Origin - Symmetry Plane between side poles planes (planes parallel to the Coils)

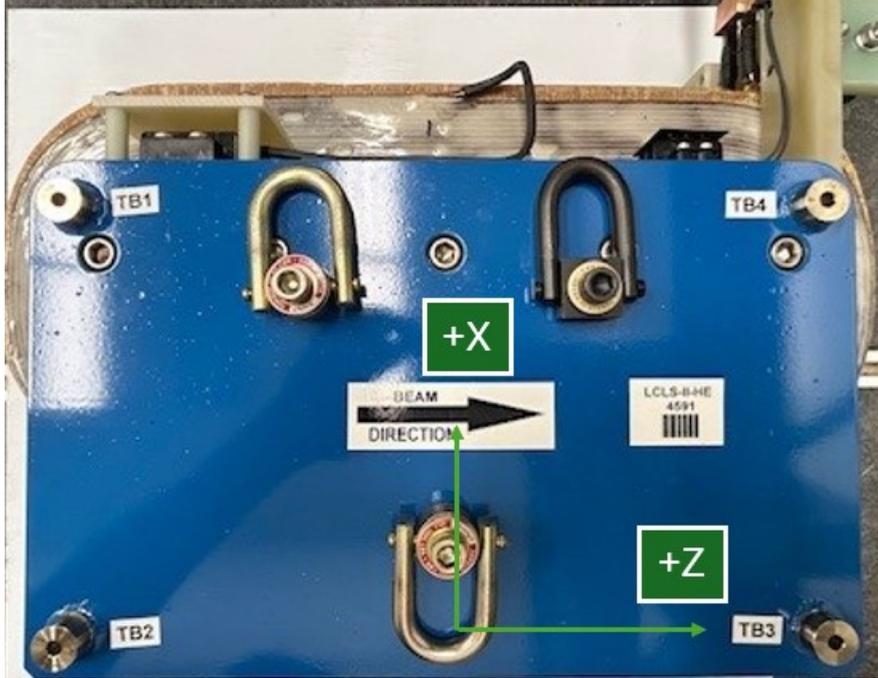
Y Origin - Symmetry Plane between the Poles (8mm/0.315" Gap Symmetry)

Z Origin - Symmetry plane between Up Stream and Down Stream end surfaces

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Tooling Ball Locations



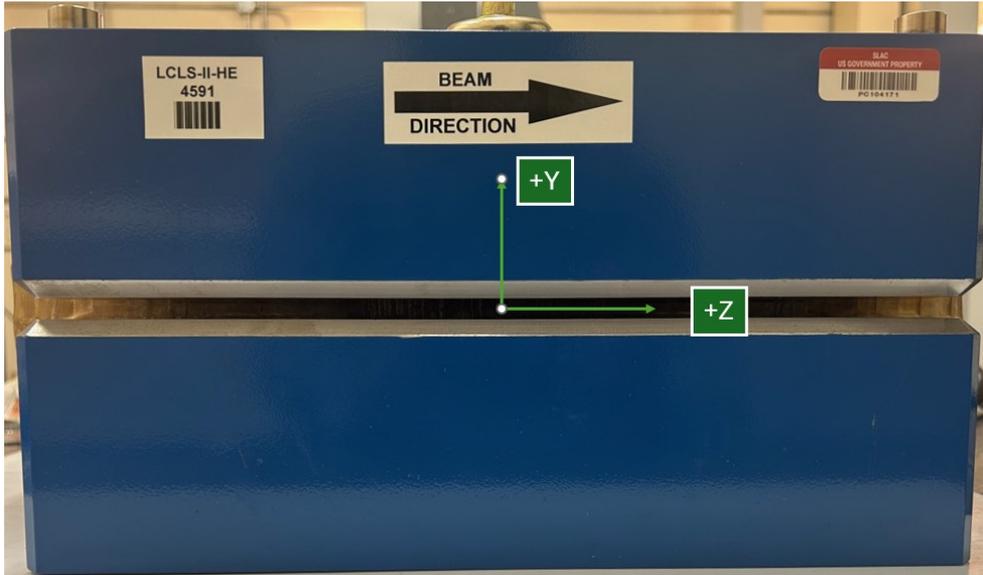
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	6.9422	5.4092	-6.3744
TB 2	-0.4238	5.4064	-6.3713
TB 3	-0.4191	5.4069	6.3683
TB 4	6.9410	5.4093	6.3719
TB A	6.9411	4.7217	-6.3735
TB B	-0.4231	4.7189	-6.3719
TB C	-0.4197	4.7194	6.3682
TB D	6.9400	4.7218	6.3702

Tooling Ball Locations (1-4) are 1 inch above Tooling Ball Plane
 Tooling Ball Locations (A-D) are 5/16 inch above Tooling Ball Plane
 Dimensions in Inch

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Pole Gap Measurements, Flatness & Parallelism



	-Y Pole Fltns	+Y Pole Fltns	Pole Parallel	Avg. Gap	Min. Gap	Max. Gap
POLE DATA	0.0002	0.0002	0.0002	0.3153	0.3151	0.3155

Dimensions in Inch

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