

LCLS-II-HE Fiducialization Report SXRSS C-MAGNET ASSY



Inspector : K. Caban
Engineer :S. Anderson
Drawing No. : DSG-000063372 R00
Barcode # : 4592
Mfg. S/N : SN 02

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/Terminal Strip.

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 - Symetry Plane between side poles planes (planes parallel to the Coils)

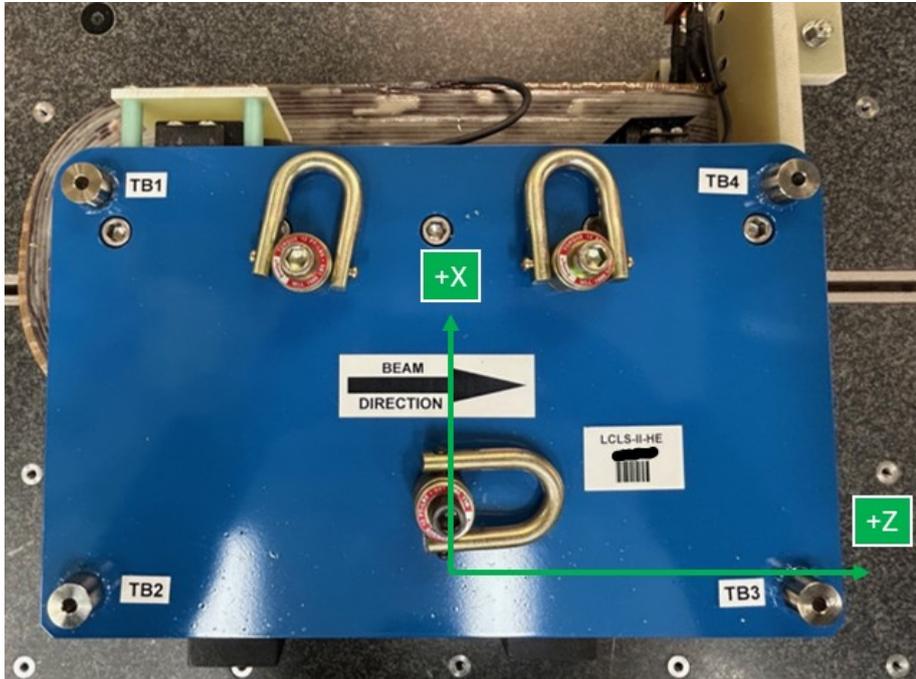
Y Origin - Symetry Plane between the Poles

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

Barcode # : 4592

MFG S/N: SN 02

Tooling Ball Locations



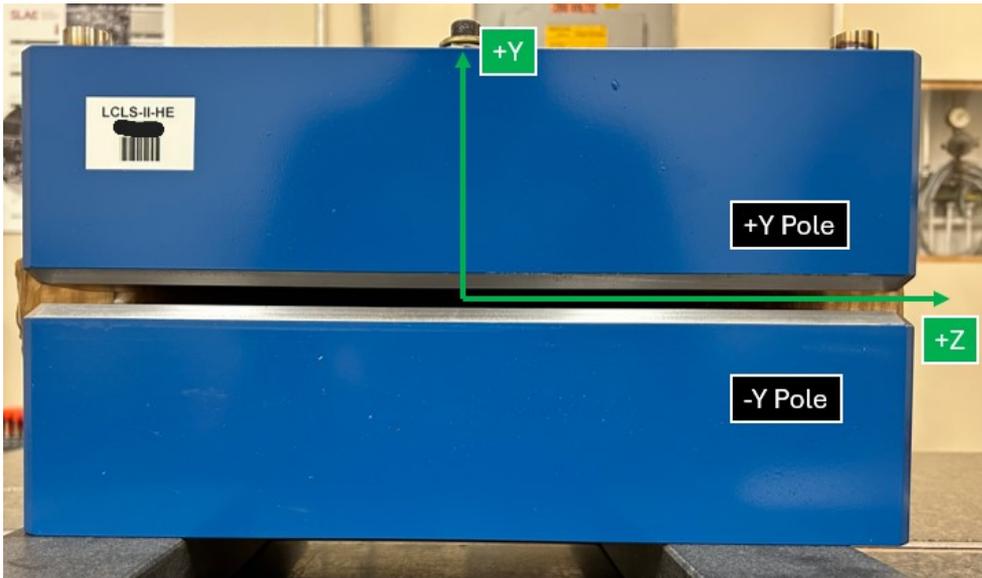
Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	6.9394	5.4061	-6.3713
TB 2	-0.4249	5.4042	-6.3681
TB 3	-0.4291	5.4035	6.3743
TB 4	6.9363	5.4053	6.3758
TB A	6.9392	4.7186	-6.3713
TB B	-0.4247	4.7167	-6.3678
TB C	-0.4279	4.7160	6.3741
TB D	6.9363	4.7178	6.3745

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

Barcode # : 4592

Mfg. S/N : SN 02

Pole Gap Measurements, Flatness & Parallelism



	-Y Pole Fltns	+Y Pole Fltns	Pole Parallel	Avg. Gap	Min. Gap	Max. Gap
POLE DATA	0.0003	0.0001	0.0014	0.3146	0.3138	0.3154

Dimensions in Inch

Barcode # : 4592
MFG S/N: SN 02