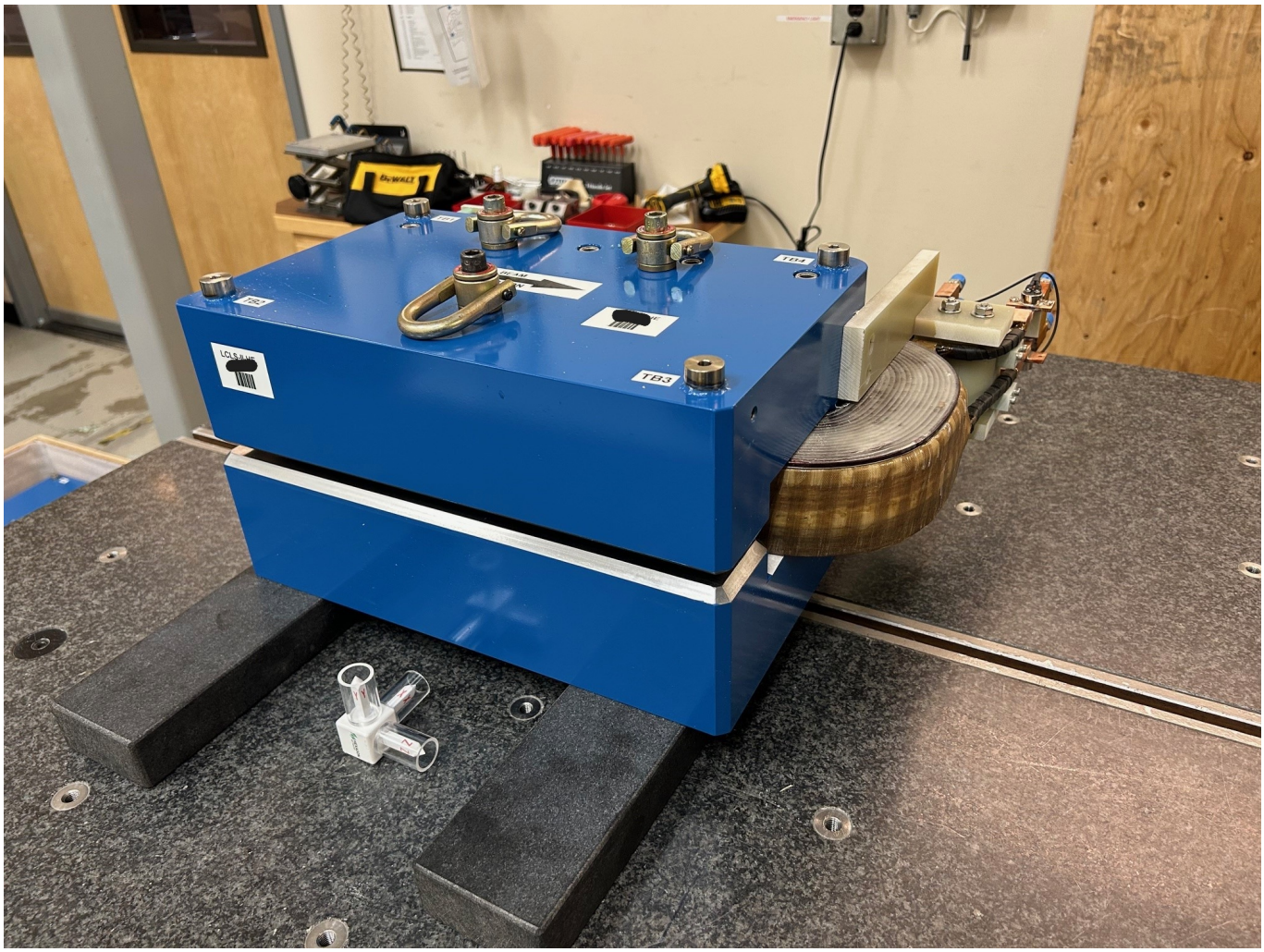
LCLS-II-HE Fiducialization Report
SXRSS C-MAGNET ASSY



Inspector : K. Caban
Engineer :S. Anderson
Drawing No. : DSG-000063372 R00
Barcode # : 4594
Mfg. S/N : SN 04

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

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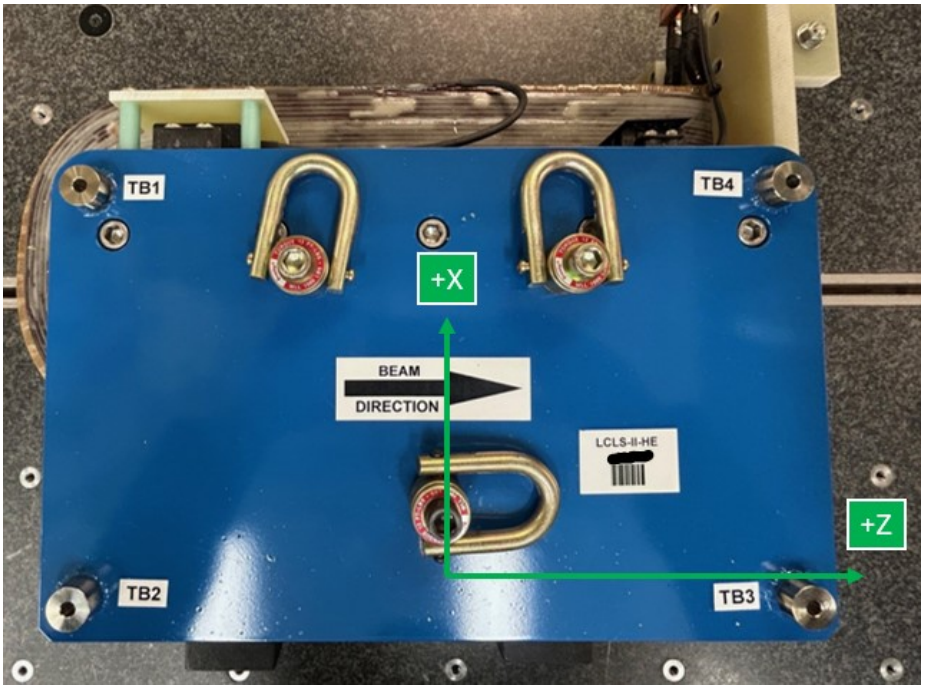
Tooling Ball Locations



Tooling Ball	X Coord.	Y Coord.	Z Coord.
TB 1	6.9429	5.4030	-6.3692
TB 2	-0.4204	5.4032	-6.3661
TB 3	-0.4232	5.4046	6.3756
TB 4	6.9432	5.4039	6.3731
TB A	6.9427	4.7155	-6.3690
TB B	-0.4207	4.7157	-6.3658
TB C	-0.4239	4.7171	6.3753
TB D	6.9430	4.7164	6.3738

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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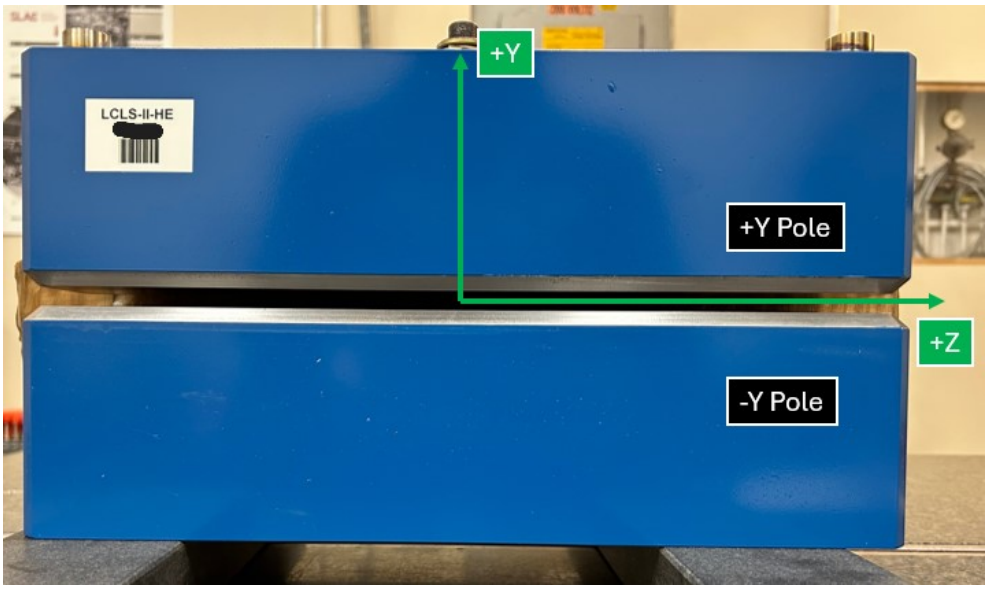
Pole Gap Measurements, Flatness & Parallelism



	-Y Pole Fltns	+Y Pole Fltns	Pole Parallel	Avg. Gap	Min. Gap	Max. Gap
POLE DATA	0.0002	0.0002	0.001	0.3156	0.3151	0.3162

Dimensions in Inch

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