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Description:		Product description	
Magnet Assemblies w. Permanent magnets		**SXR Phase Shifter - Permanent Magnet Assembly**	
Order No.:	Customer:	Part/Drawing No.:	Serial No.:
504313	**SLAC**	**7103050895**	**2410102**

To be carried out after assembly

No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
1	**Document information** **Template: Test_504313_MagnetAssembly.A**						
	Author:	N/A	OK			OK	06/03/2024 DANA
	Reviewer:	N/A	OK			OK	12/03/2024 EBCH
2	**Visual Inspection according to main drawing**						
3	**Magnet Arrays:**						
4	**Torque wrench check for magnet assembly** **According to drawing: 7103050655 & 7103050656**						
	Verify torque wrench setting at torque transducer	2361-D	5	5Nm ±0,3Nm	Torque Transducer.	OK	11/10/2024 bgr
	Tightening torque for 10 x M5 bolts	2361-D	OK	10 x M5 bolts fastened	Torque Transducer.	OK	11/10/2024 bgr

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5	**Magnet array (Upper) Numbers Only note (xxx) See dwg. 7103050656**						
	SXRHE-VS(xxx) N	N/A	34			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	125			OK	11/10/2024 bgr
	SXRHE-VL(xxx) S	N/A	11			OK	11/10/2024 bgr
	SXRHE-HL(xxx) ↓	N/A	52			OK	11/10/2024 bgr
	SXRHE-VL(xxx) N	N/A	10			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	16			OK	11/10/2024 bgr
	SXRHE-VS(xxx) S	N/A	101			OK	11/10/2024 bgr
6	**Magnet array (Lower) Numbers Only note (xxx) See dwg. 7103050655**						

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	SXRHE-VS(xxx) N	N/A	113			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	22			OK	11/10/2024 bgr
	SXRHE-VL(xxx) S	N/A	26			OK	11/10/2024 bgr
	SXRHE-HL(xxx) ↓	N/A	55			OK	11/10/2024 bgr
	SXRHE-VL(xxx) N	N/A	105			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	74			OK	11/10/2024 bgr
	SXRHE-VS(xxx) S	N/A	06			OK	11/10/2024 bgr
7	**Magnetic test See drawing 7103050653 for magnetic center**						
8	**Stretch wire measurement:**						

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No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	Stretch wire measurements at all gaps in x=-10 through x=10 in 2 mm steps. At all gaps shall both 1st and 2nd integral scans be performed Use seperate document for data logging, see "504313_ReferenceDoc" •10 mm gap •15 mm gap •20 mm gap •30 mm gap •100,0 mm gap	N/A	OK	Stretchwire measurement completed	Krav om maks 15 Gcm variation ikke overholdt	OK	04/10/2024 PMHA
9	**Hall probe measurements:**						

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To be carried out after assembly

No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	Hall probe measurements at intermediate gaps. Before and after each measurement series, reference magnetic field and magnet array temperature must be logged in order to perform temperature correction. 600 mm scans. Use seperate document for data logging, see "504313_ReferenceDoc" • 10 mm gap • 15 mm gap • 20 mm gap • 30 mm gap • 100,0 mm gap	N/A	OK	Hall probe gap measurement completed		OK	04/10/2024 PMHA

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To be carried out after assembly

No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	Hall probe Horizontal measurements. Before and after each measurement series, reference magnetic field and magnet array temperature must be logged in order to perform temperature correction. 600 mm scans. Use seperate document for data logging, see "504313_ReferenceDoc" •10 mm gap (x=-2) •10 mm gap (x=-1) •10 mm gap (x=1) •10 mm gap (x=2) •30,0 mm gap (x=-2) •30,0 mm gap (x=-1) •30,0 mm gap (x=1) •30,0 mm gap (x=2)	N/A	OK	Hall probe Horizontal measurement completed		OK	04/10/2024 PMHA

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To be carried out after assembly

No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	Hall probe Vertical measurements. Before and after each measurement series, reference magnetic field and magnet array temperature must be logged in order to perform temperature correction. 600 mm scans. Use seperate document for data logging, see "504313_ReferenceDoc" • 10 mm gap (y=-0,2) • 10 mm gap (y=-0,1) • 10 mm gap (y=0) • 10 mm gap (y=0,1) • 10 mm gap (y=0,2)	N/A	OK	Hall probe Vertical measurement completed		OK	04/10/2024 PMHA
10	**Visual inspection** **See drawing 7103050895**						
	Visual appearance	N/A	OK			OK	11/10/2024 bgr
11	**Production control**						

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To be carried out after assembly

No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	Approved by	N/A	OK			OK	11/10/2024 bgr
12	**Lead Engineer**						
	Approved by	N/A	OK			OK	14/10/2024 DANA

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