

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	2410107		
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

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		2410107	
To be carried out after assembly							
No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
5	Magnet array (Upper) Numbers Only note (xxx) See dwg. 7103050656						
	SXRHE-VS(xxx) N	N/A	90			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	01			OK	11/10/2024 bgr
	SXRHE-VL(xxx) S	N/A	81			OK	11/10/2024 bgr
	SXRHE-HL(xxx) ↓	N/A	18			OK	11/10/2024 bgr
	SXRHE-VL(xxx) N	N/A	122			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	63			OK	11/10/2024 bgr
	SXRHE-VS(xxx) S	N/A	87			OK	11/10/2024 bgr
6	Magnet array (Lower) Numbers Only note (xxx) See dwg. 7103050655						

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		2410107	
To be carried out after assembly							
No.	Description	Test equipment	Result	Criteria / Tolerance	Comments	Accepted	Sign/Date
	SXRHE-VS(xxx) N	N/A	111			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	107			OK	11/10/2024 bgr
	SXRHE-VL(xxx) S	N/A	126			OK	11/10/2024 bgr
	SXRHE-HL(xxx) ↓	N/A	23			OK	11/10/2024 bgr
	SXRHE-VL(xxx) N	N/A	89			OK	11/10/2024 bgr
	SXRHE-HS(xxx) ↑	N/A	48			OK	11/10/2024 bgr
	SXRHE-VS(xxx) S	N/A	66			OK	11/10/2024 bgr
7	Magnetic test See drawing 7103050653 for magnetic center						
8	Stretch wire measurement:						

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		2410107	
To be carried out after assembly							
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		OK	04/10/2024 PMHA
9	Hall probe measurements:						

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		2410107	
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

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		2410107	
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) •80,0 mm gap (x=-2) •80,0 mm gap (x=-1) •80,0 mm gap (x=1) •80,0 mm gap (x=2)	N/A	OK	Hall probe Horizontal measurement completed		OK	04/10/2024 PMHA

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		2410107	
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						

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		2410107	
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