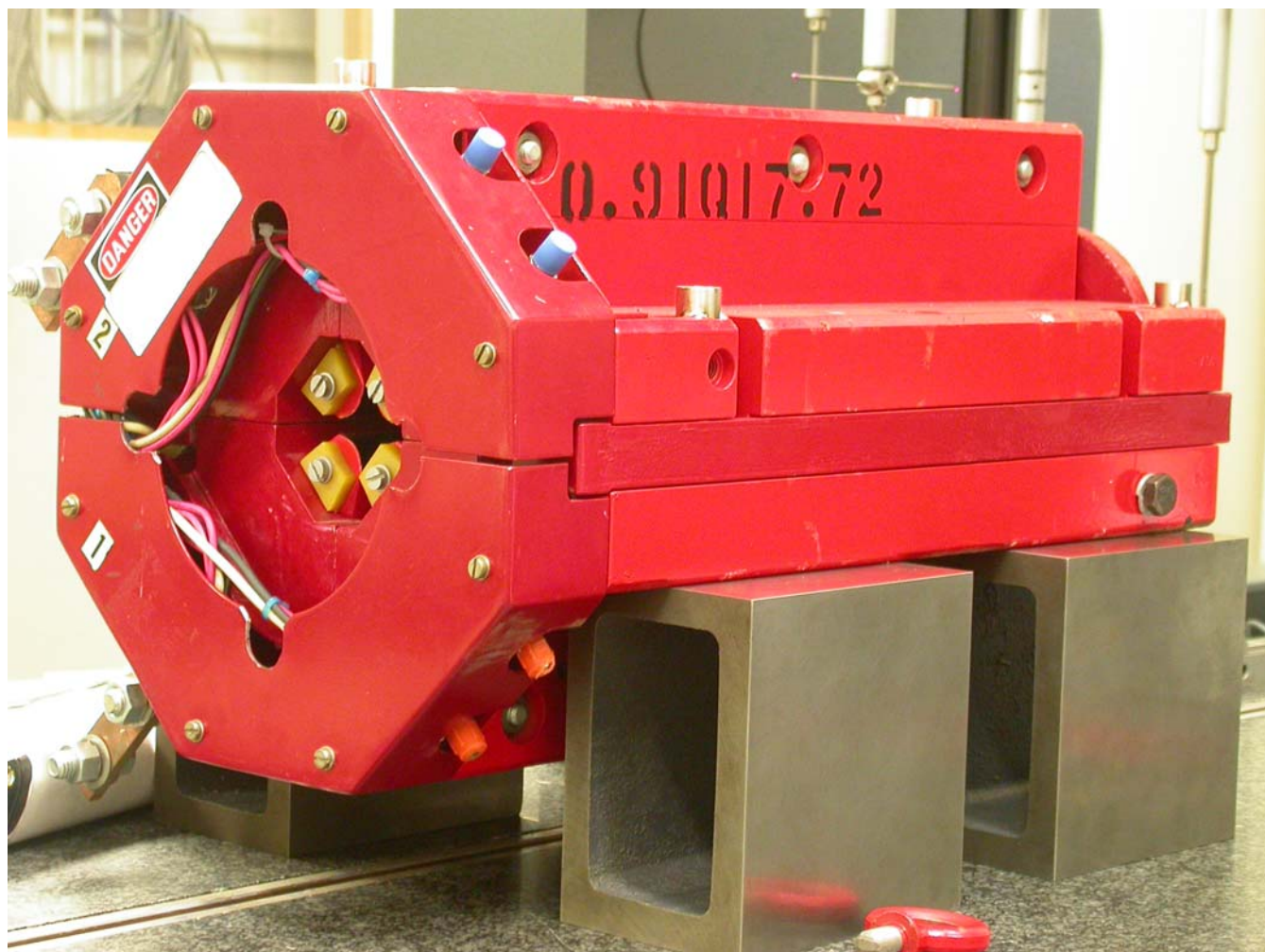


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector:	Keith Caban
Responsible Engineer:	Carl Rago
Date:	Monday, January 22, 2007
Work Order/Charge No.:	21699-1
Serial Number:	000227
URL of Fiducial Report:	\\Web002\\www-group\\met\\Quality\\FIDUCIAL REPORTS\\LCLS LTU QUAD\\000227.pdf

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

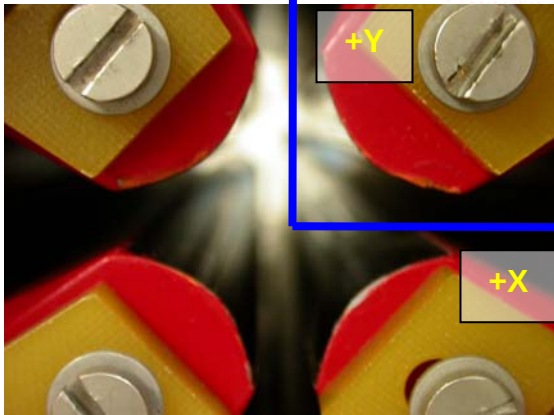
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

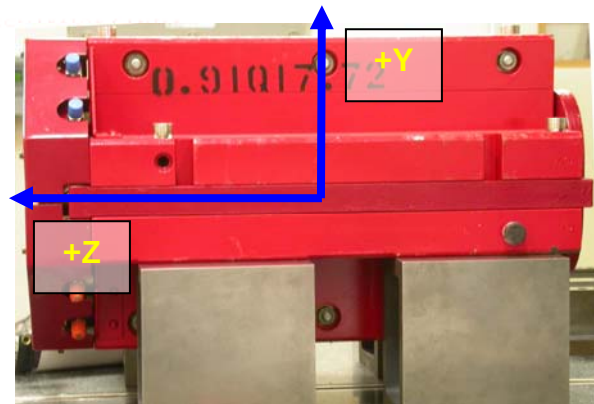
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



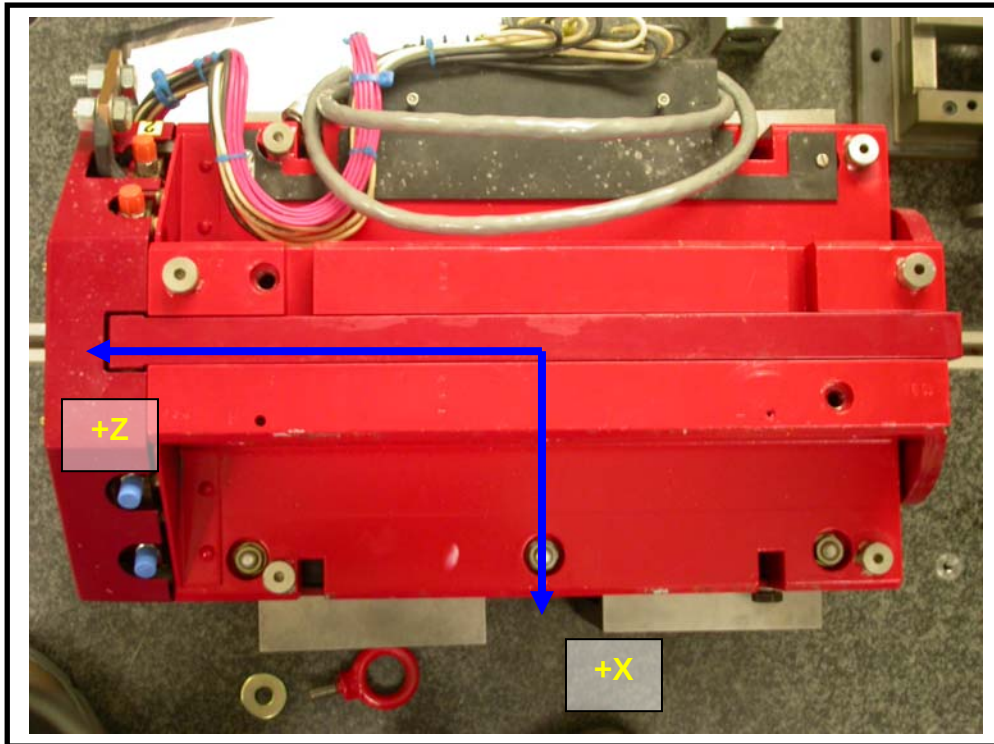
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00027	0.49903	5.04224	3.70393	-8.06503
TB B	0.00045	0.49725	-1.40342	7.32776	-8.04272
TB C	0.00015	0.49938	-5.03450	3.70449	-8.04832
TB D	0.00025	0.49881	-5.26028	3.70488	6.28659
TB E	0.00038	0.49789	-1.40037	7.32659	8.06366
TB F	0.00035	0.49930	5.27750	3.70303	6.29297

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90568	0.90648	0.00080
B-D	0.90649	0.90527	0.00122

