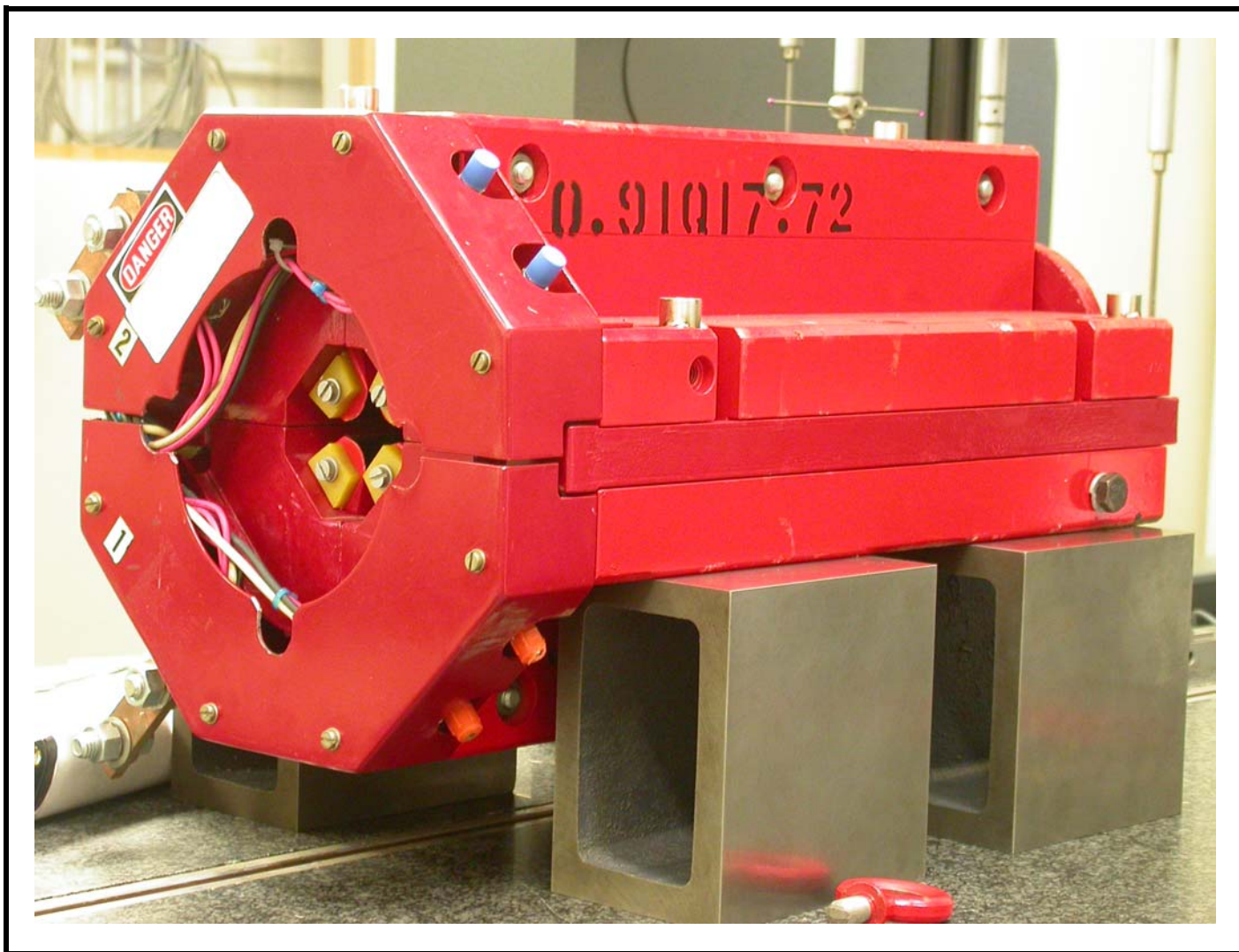


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Friday, March 23, 2007

Work Order/Charge No.: 21699-1

Serial Number: 000238

URL of Fiducial Report: <\\Web002\\www-group\\met\\Quality\\FIDUCIAL REPORTS\\LCLS LTU QUAD\\000238.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

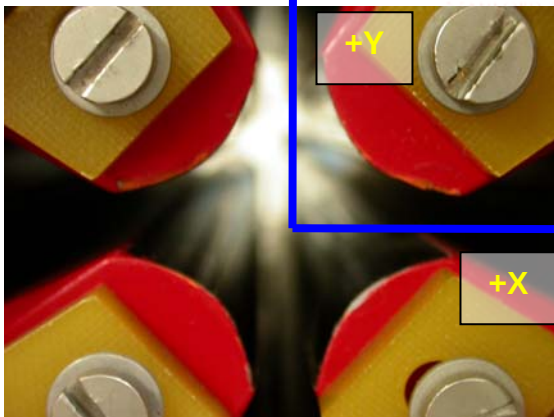
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

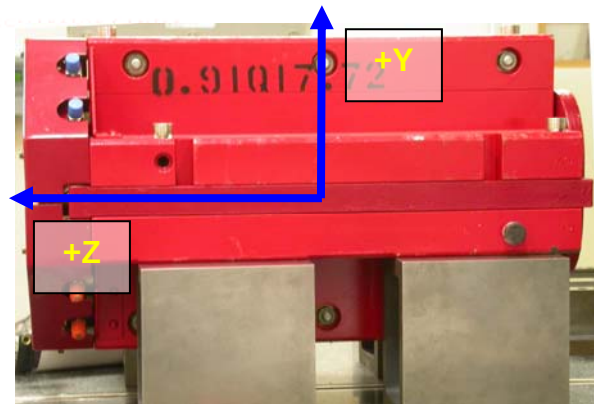
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



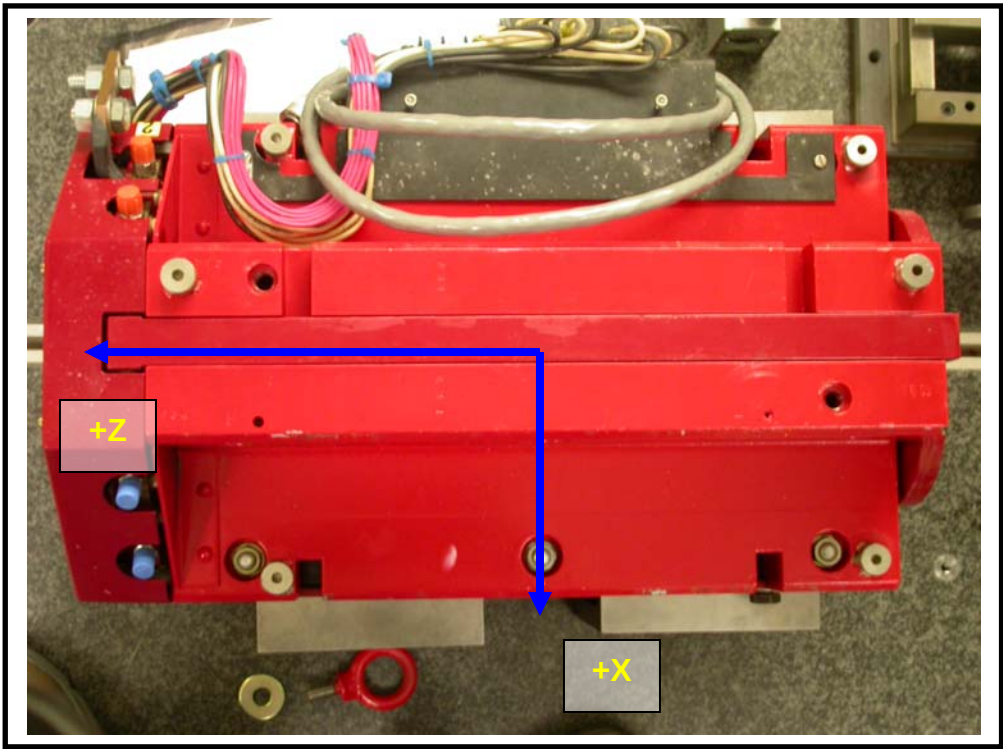
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00049	0.49742	5.02439	3.68602	-8.02600
TB B	0.00027	0.49917	-1.37446	7.31248	-8.04031
TB C	0.00029	0.49654	-5.00869	3.70381	-8.04784
TB D	0.00034	0.49719	-5.19244	3.70506	6.28542
TB E	0.00048	0.49641	-1.37494	7.31544	8.05437
TB F	0.00047	0.49737	5.28481	3.68511	6.31020

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90744	0.90775	0.00031
B-D	0.90545	0.90622	0.00077

