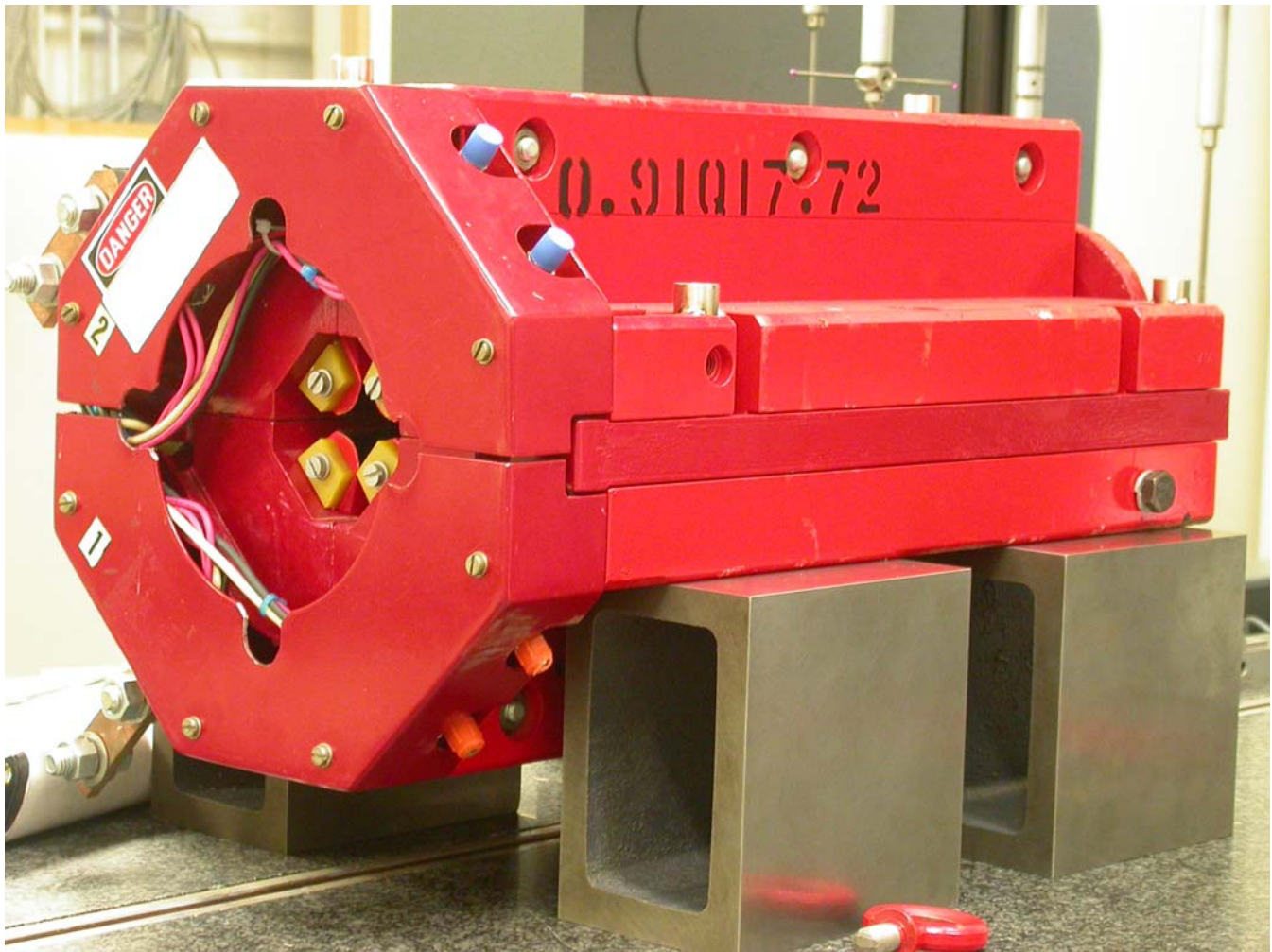


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector:	Keith Caban
Responsible Engineer:	Carl Rago
Date:	Wednesday, January 24, 2007
Work Order/Charge No.:	21699-1
Serial Number:	000239
URL of Fiducial Report:	\\Web002\\www-group\\met\\Quality\\FIDUCIAL REPORTS\\LCLS LTU QUAD\\000239.pdf

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

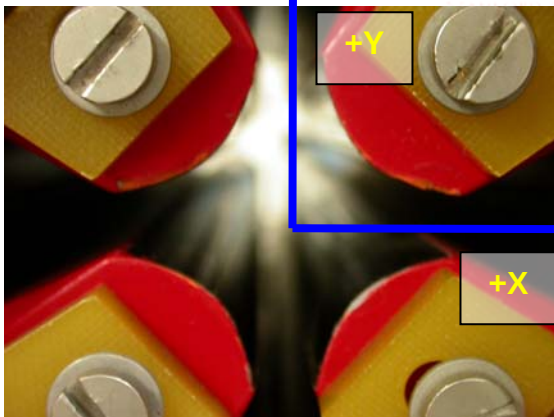
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

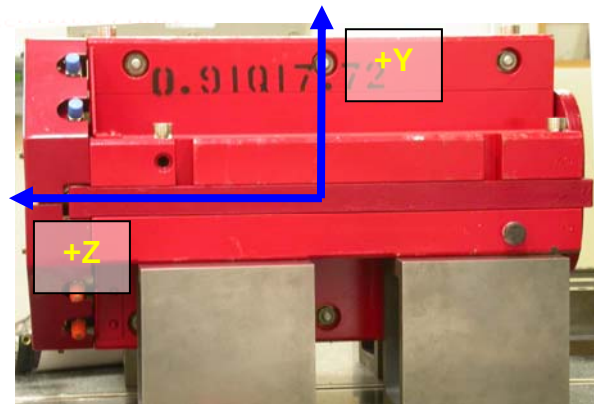
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



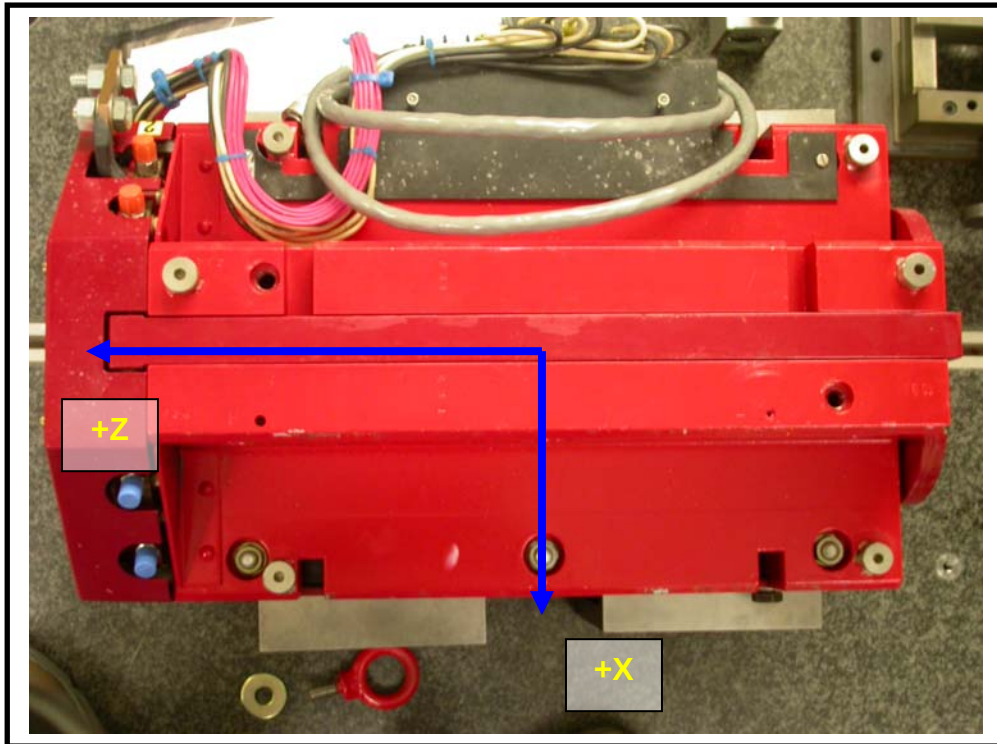
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00014	0.49983	5.03299	3.68947	-8.06378
TB B	0.00009	0.49940	-1.39973	7.31869	-8.05134
TB C	0.00015	0.49923	-5.02984	3.71186	-8.06359
TB D	0.00044	0.49820	-5.22381	3.71264	6.28695
TB E	0.00059	0.49801	-1.42123	7.31684	8.06905
TB F	0.00050	0.49859	5.26408	3.68945	6.30947

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90698	0.90665	0.00033
B-D	0.90543	0.90628	0.00085

