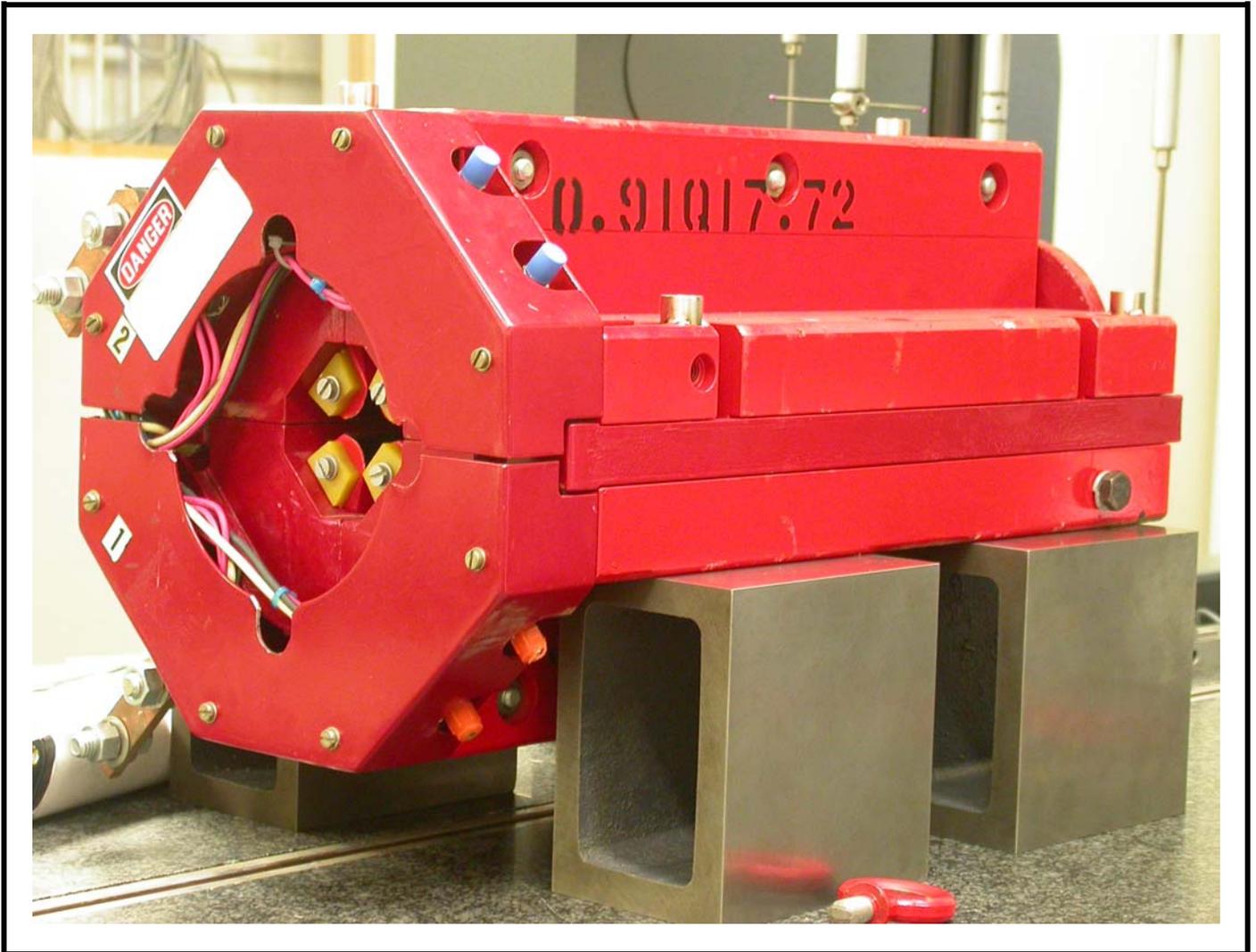


## LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban  
Responsible Engineer: Carl Rago  
Date: Monday, March 26, 2007  
Work Order/Charge No.: 21699-1  
Serial Number: 000305  
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000305.pdf>

## Part Set-up – Coordinate System Set-up

### Spatial Alignment

- Geometric axis of the poles of the magnet.

### Planar Alignment

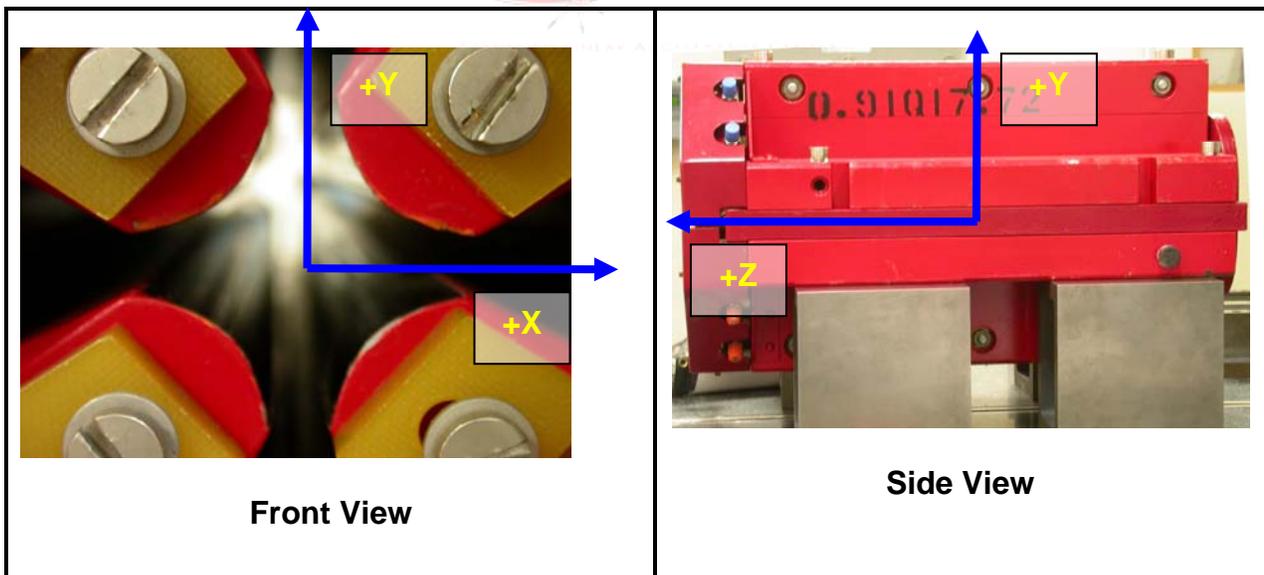
- Clocking plane where TB A,C, D, & E reside.

### “Z” Zero

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

### “X” & “Y” Zero

- Geometric axis of the poles of the magnet.

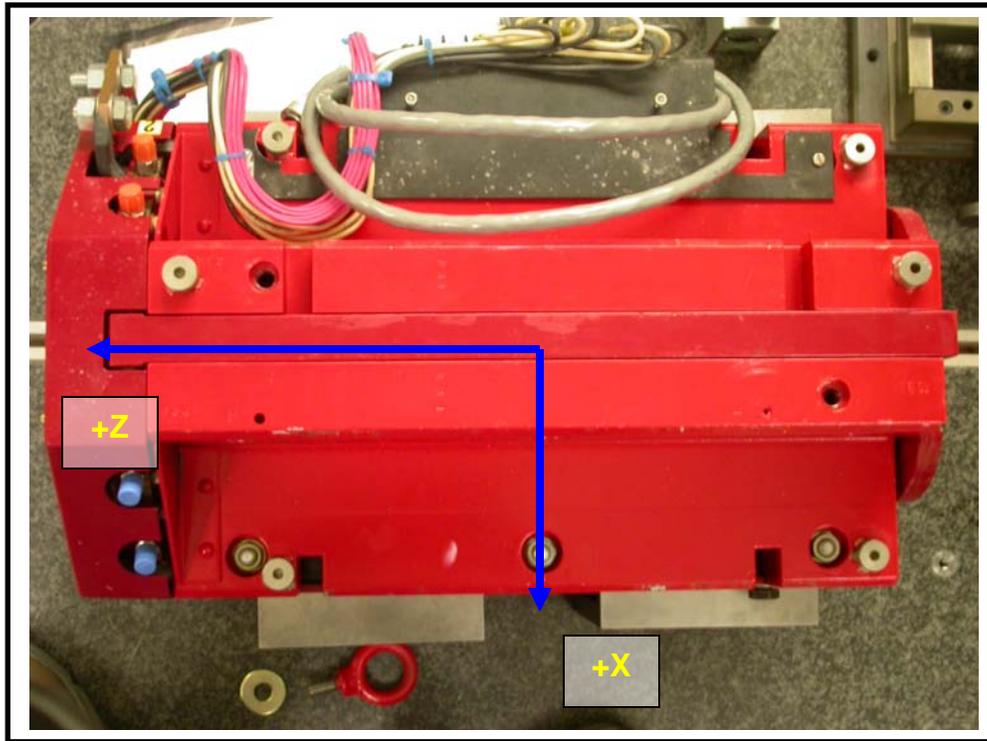


Front View

Side View

## Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00048	0.49660	5.04721	3.70047	-8.03672
TB B	0.00020	0.49770	-1.38658	7.31919	-8.02645
TB C	0.00057	0.49739	-5.01452	3.70411	-8.02948
TB D	0.00007	0.49669	-5.23398	3.70486	6.28162
TB E	0.00042	0.49688	-1.40919	7.32016	8.07233
TB F	0.00047	0.49614	5.26652	3.70107	6.29811

## Pole Distances

Pole	-Z side	+Z side	$\Delta$
A-C	0.90660	0.90419	0.00241
B-D	0.90643	0.90653	0.00010

