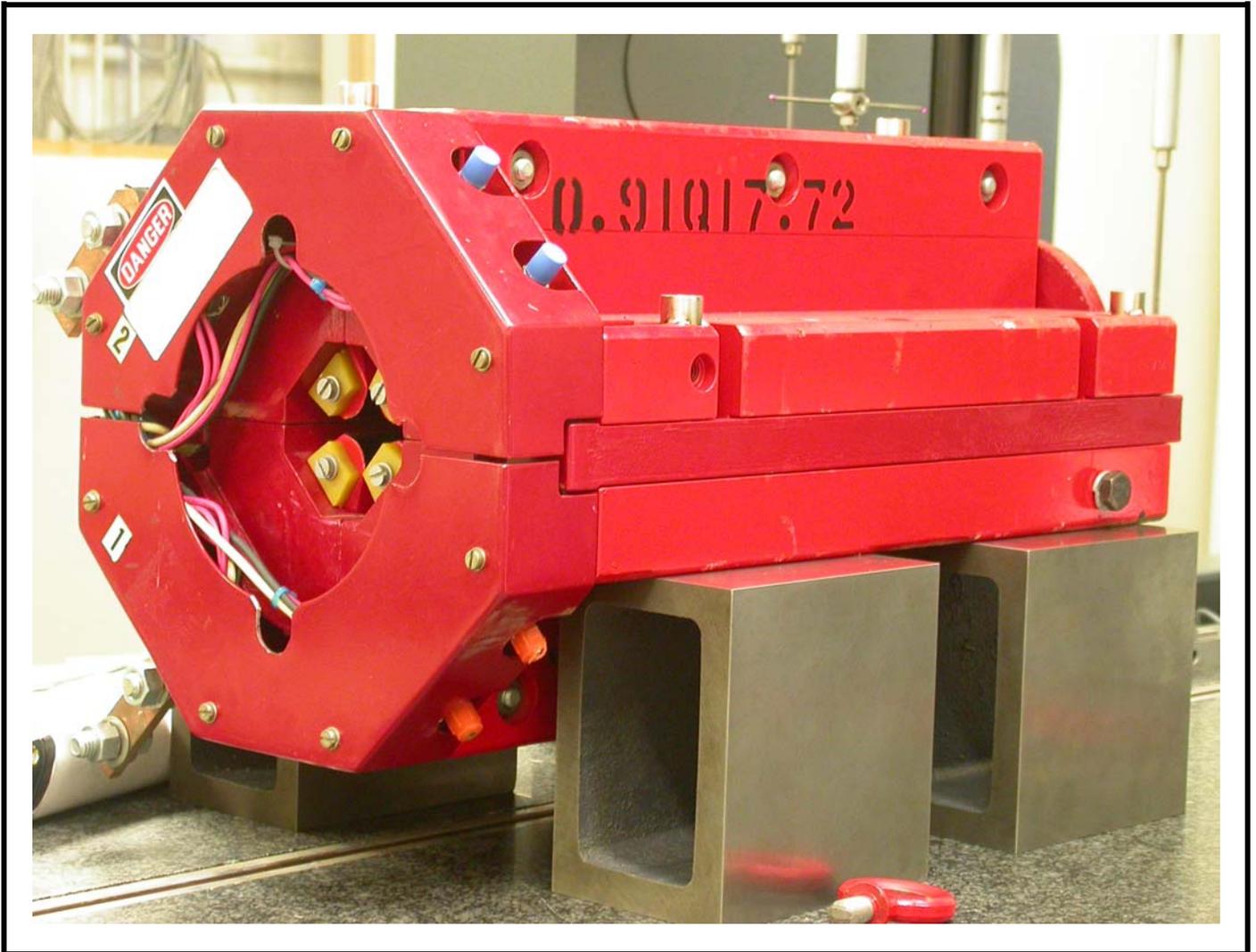


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Monday, March 26, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000311
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000311.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

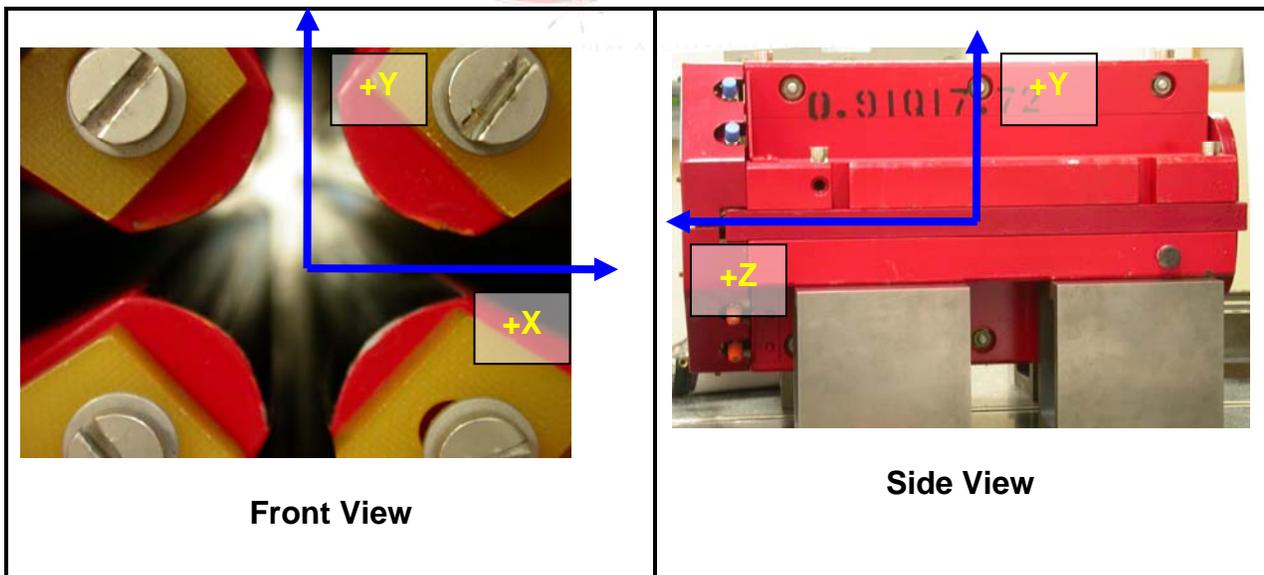
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

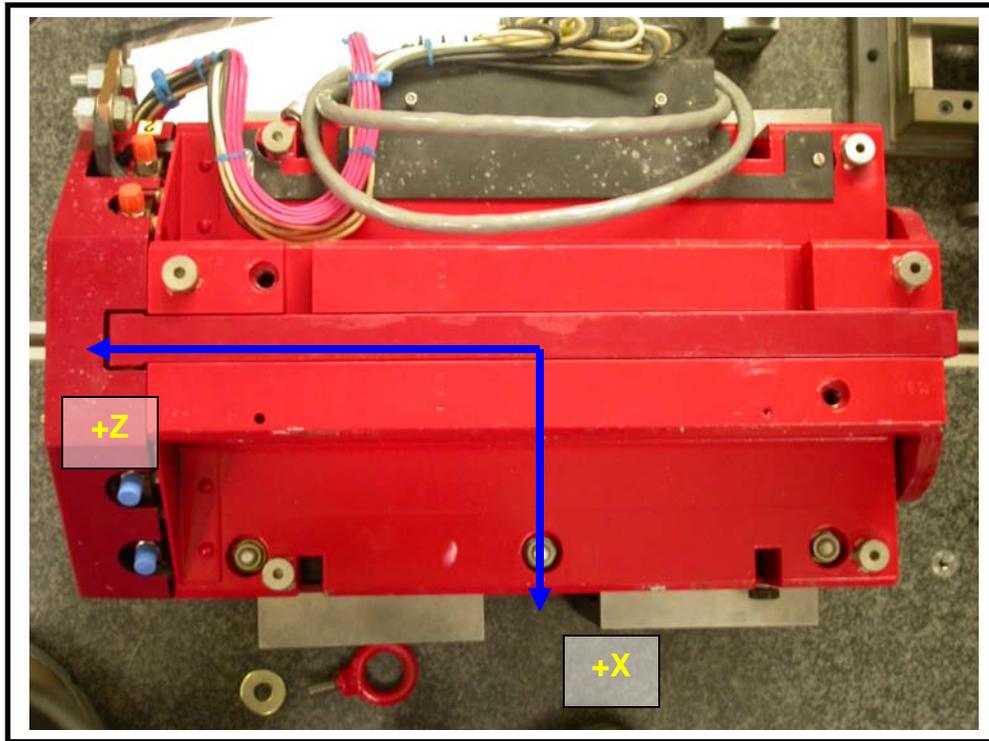


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00008	0.49945	5.02994	3.70497	-8.07217
TB B	0.00035	0.49766	-1.33017	7.32687	-7.97999
TB C	0.00014	0.49953	-5.02533	3.69999	-8.04243
TB D	0.00004	0.49943	-5.26053	3.70315	6.27197
TB E	0.00014	0.49935	-1.37415	7.32568	7.95803
TB F	0.00037	0.49833	5.25181	3.70714	6.30125

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90596	0.90630	0.00034
B-D	0.90586	0.90701	0.00115

