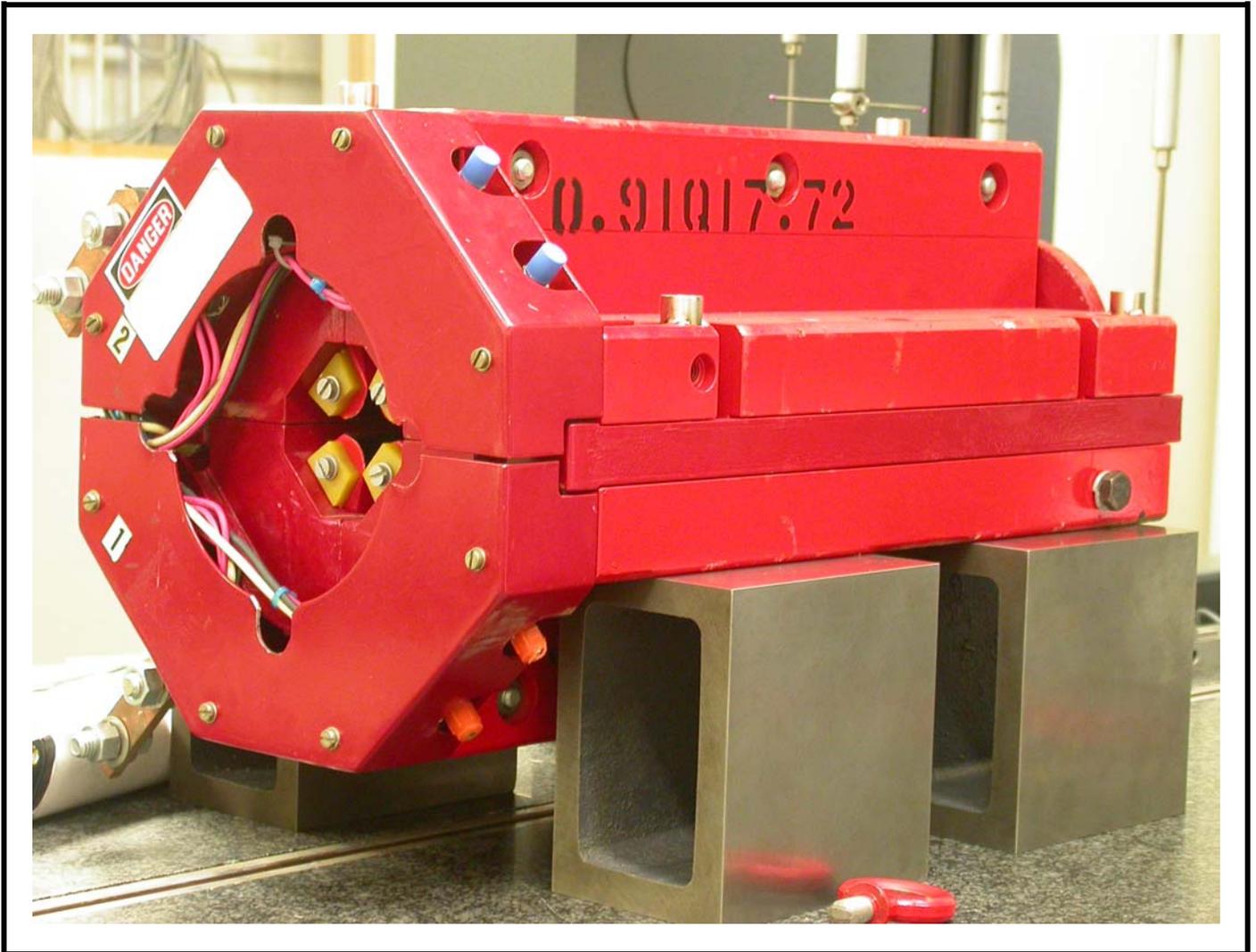


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, January 31, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000315
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000315.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

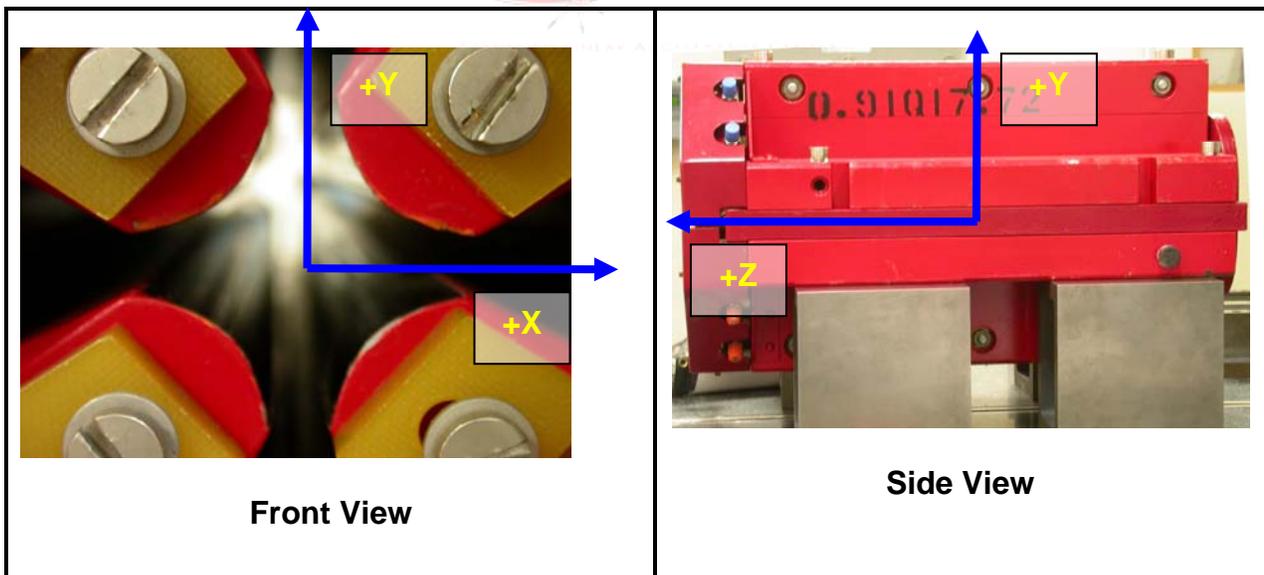
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

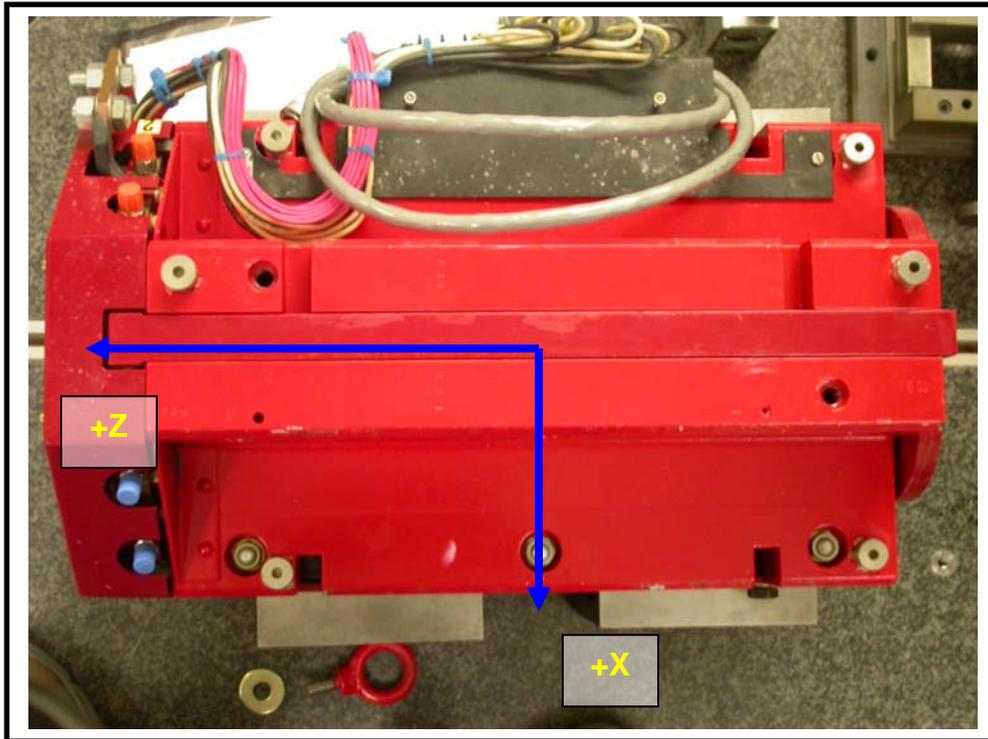
“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00037	0.49818	5.02407	3.70977	-8.07066
TB B	0.00017	0.49936	-1.46778	7.32040	-8.07584
TB C	0.00040	0.49815	-5.08665	3.68944	-8.07193
TB D	0.00049	0.49812	-5.25952	3.69051	6.30418
TB E	0.00056	0.49752	-1.45043	7.32286	8.06595
TB F	0.00042	0.49787	5.21811	3.71117	6.29140

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90669	0.90574	0.00095
B-D	0.90565	0.90639	0.00074

