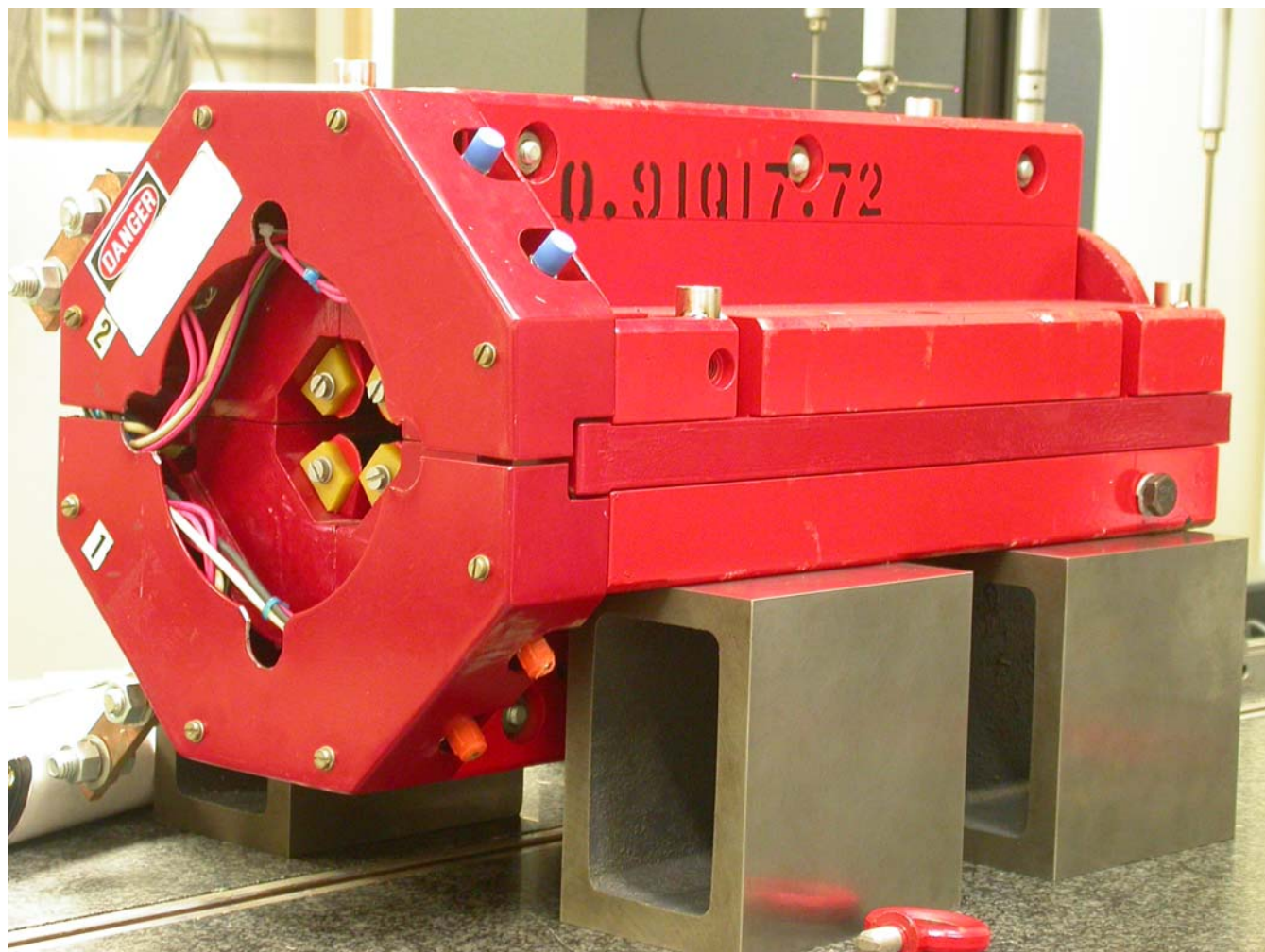


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector:	Keith Caban
Responsible Engineer:	Carl Rago
Date:	Monday, February 27, 2007
Work Order/Charge No.:	21699-1
Serial Number:	000318
URL of Fiducial Report:	\\Web002\\www-group\\met\\Quality\\FIDUCIAL REPORTS\\LCLS LTU QUAD\\000318.pdf

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

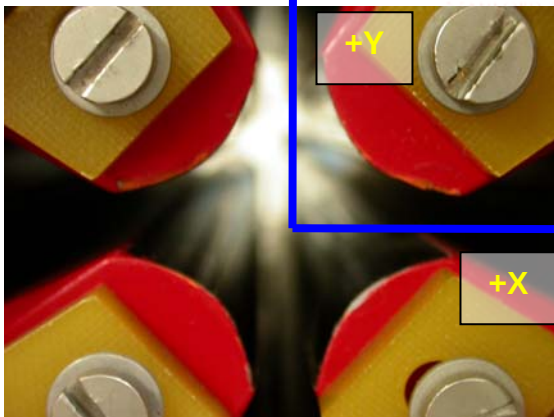
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

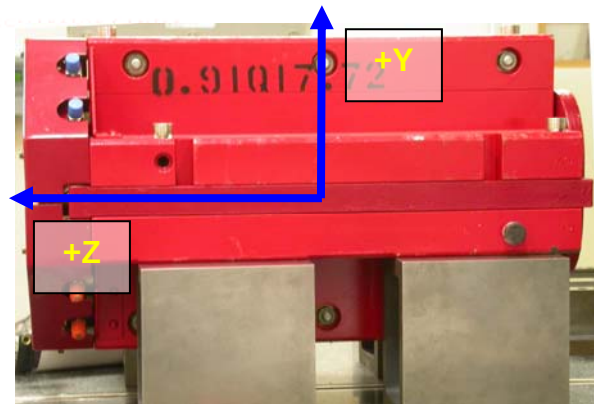
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



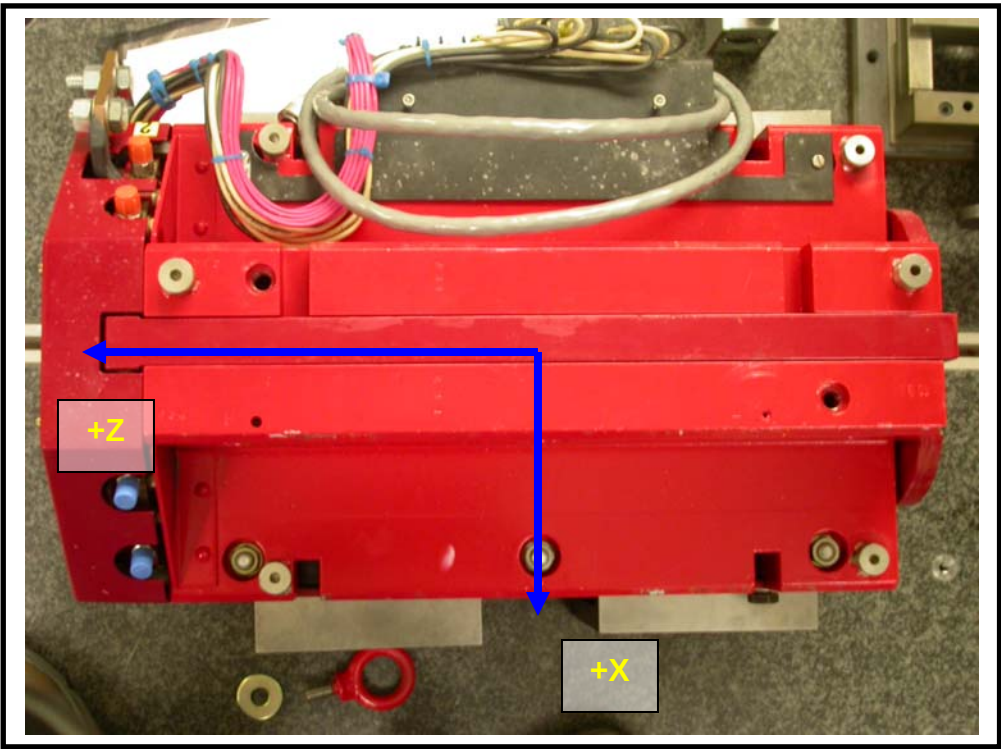
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00034	0.49786	4.99371	3.69060	-8.01623
TB B	0.00017	0.49760	-1.34646	7.32038	-7.98581
TB C	0.00031	0.49850	-4.96942	3.70076	-8.00862
TB D	0.00077	0.49792	-5.25868	3.70085	6.31759
TB E	0.00029	0.49640	-1.36398	7.32235	7.98023
TB F	0.00053	0.49694	5.26408	3.69014	6.29367

*** CORRECTED X & Y VALUES, MIS-TYPED COORDINATES 3/20/07.

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90709	0.90710	0.00001
B-D	0.90841	0.90662	0.00179

