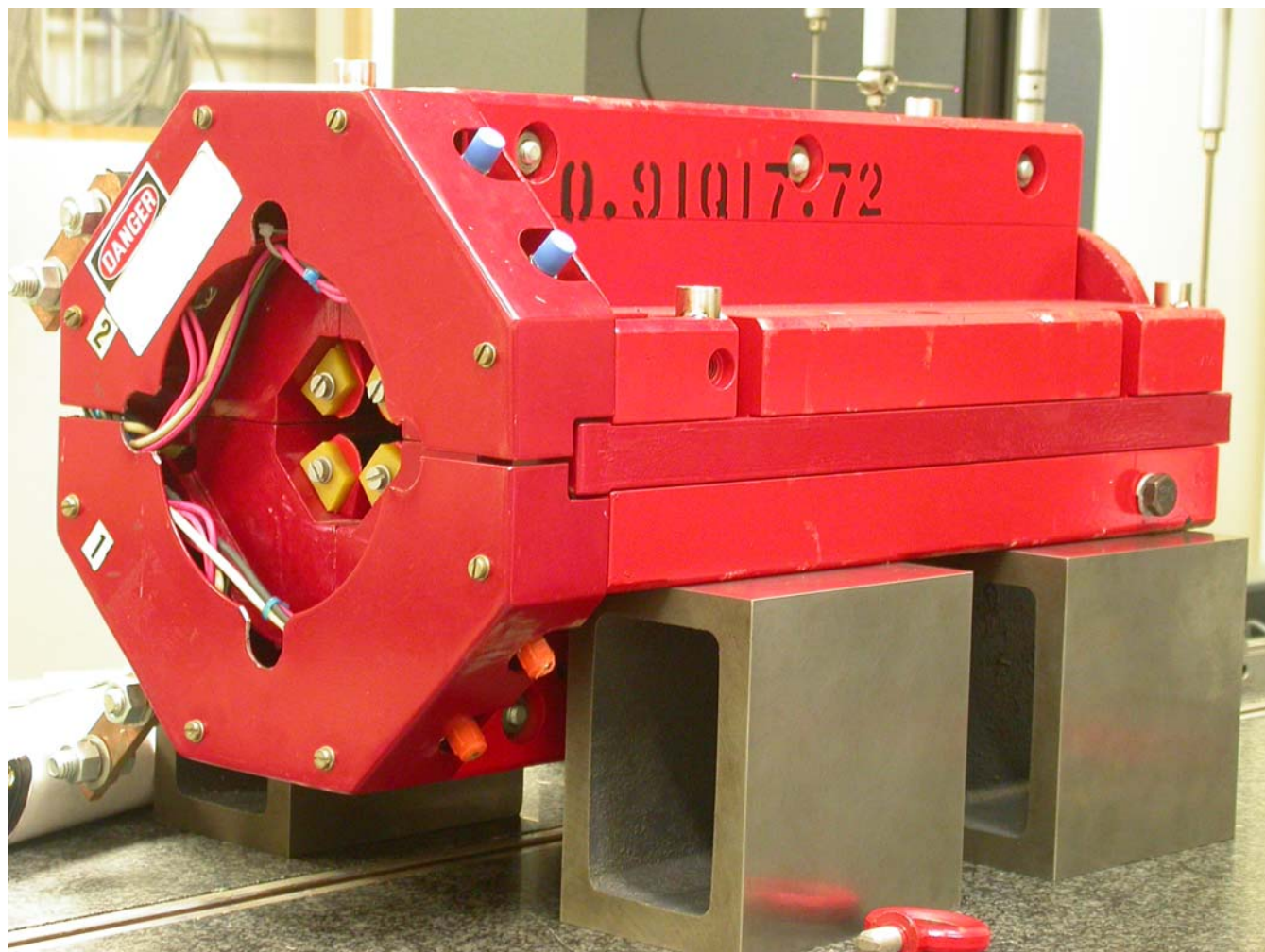


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector:	Keith Caban
Responsible Engineer:	Carl Rago
Date:	Monday, January 22, 2007
Work Order/Charge No.:	21699-1
Serial Number:	000320
URL of Fiducial Report:	\\Web002\\www-group\\met\\Quality\\FIDUCIAL REPORTS\\LCLS LTU QUAD\\000320.pdf

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

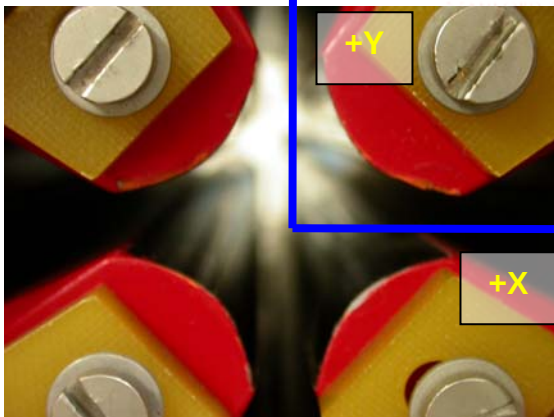
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

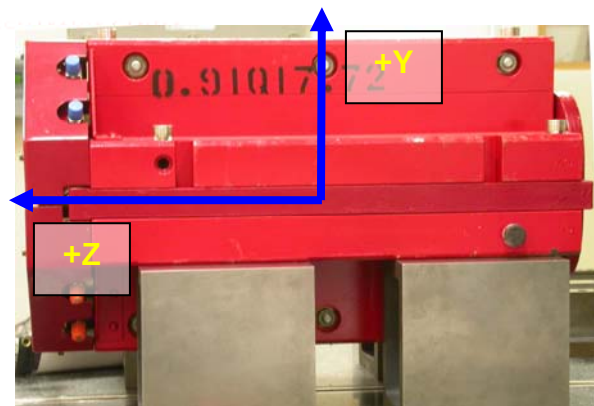
- Mid-plane of the magnet (pole planes on each end).

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.



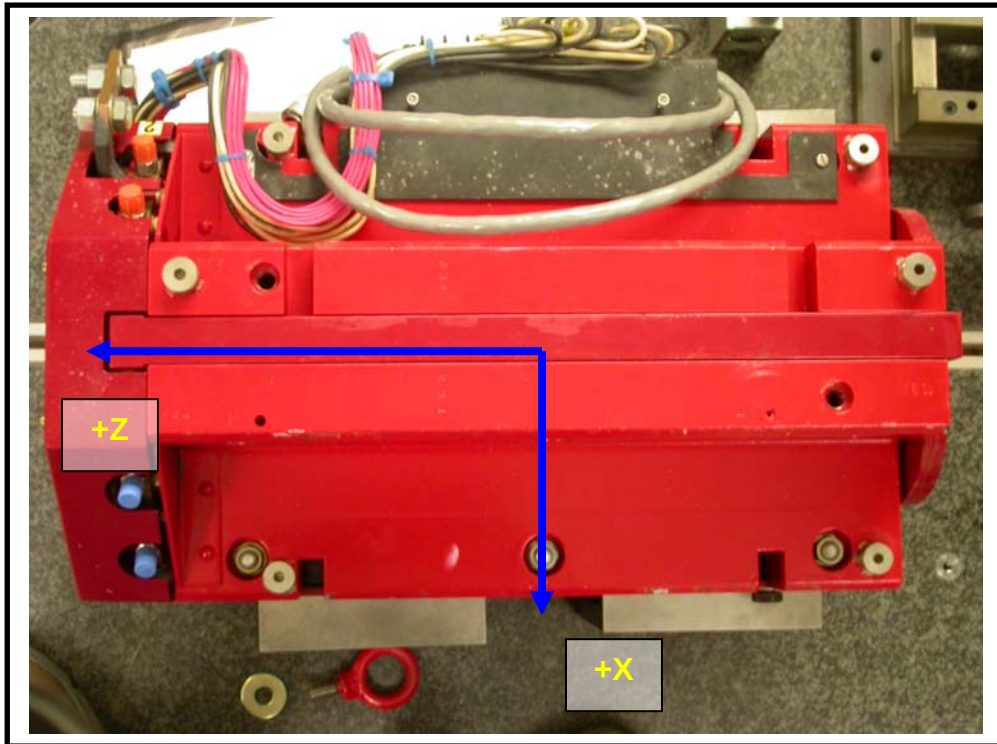
Front View



Side View

Tooling Ball Measurements/Locations

Top of magnet; view from “+Y”



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00046	0.49751	5.00743	3.70959*	-8.04255
TB B	0.00024	0.49797	-1.38670	7.32264	-8.04184
TB C	0.00025	0.49953	-5.01686	3.69631	-8.01610
TB D	0.00015	0.49949	-5.31589	3.69821	6.28880
TB E	0.00049	0.49760	-1.38417	7.32461	7.99910
TB F	0.00012	0.49983	5.29916	3.70885	6.30051

* Denotes input error, data set is now correct.

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90753	0.90811	0.00058
B-D	0.90641	0.90864	0.00223

