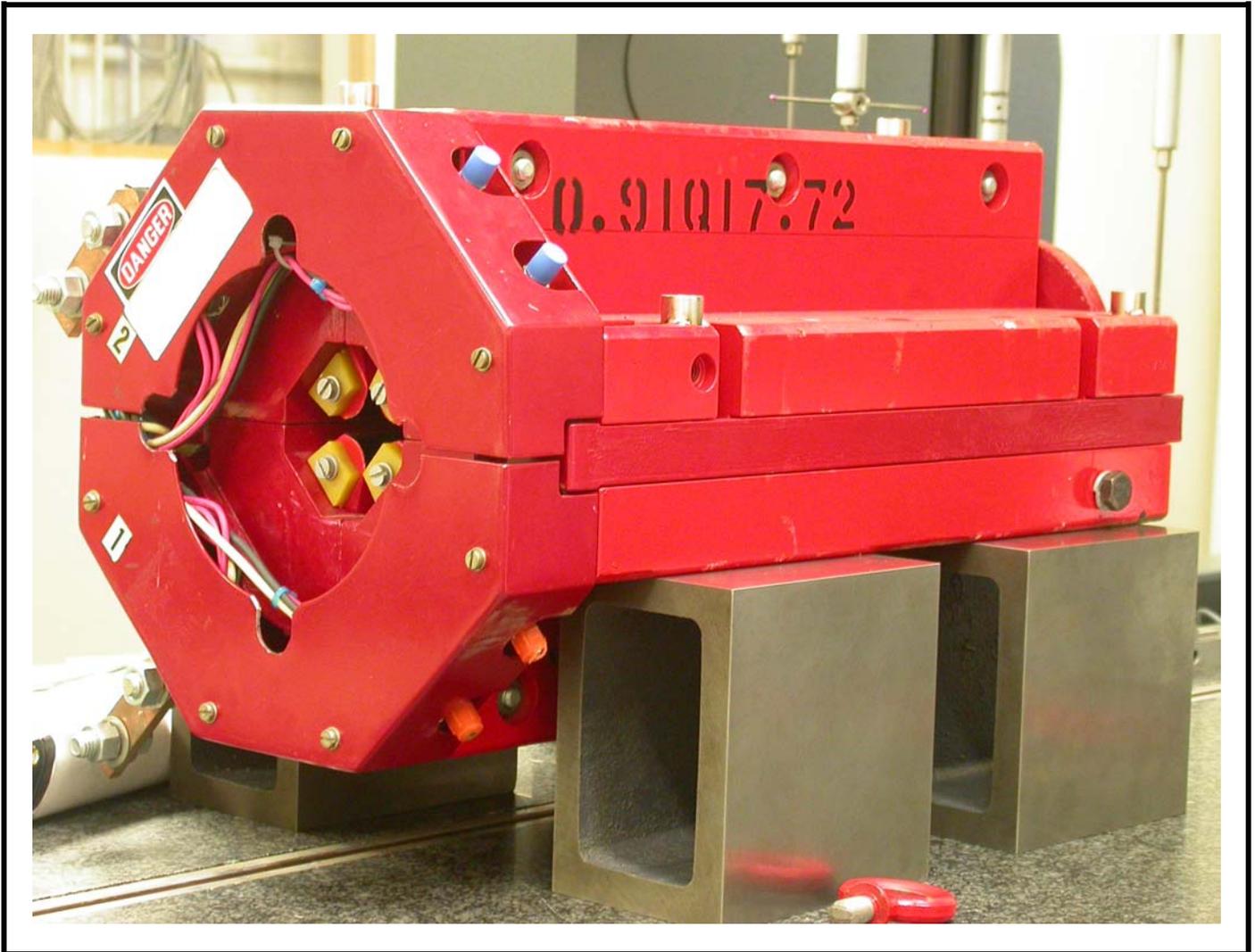


LCLS '0.91Q17.72' LTU Quadrupole Magnet FIDUCIALIZATION REPORT



Inspector: Keith Caban
Responsible Engineer: Carl Rago
Date: Wednesday, February 28, 2007
Work Order/Charge No.: 21699-1
Serial Number: 000462
URL of Fiducial Report: <\\Web002\www-group\met\Quality\FIDUCIAL REPORTS\LCLS LTU QUAD\000462.pdf>

Part Set-up – Coordinate System Set-up

Spatial Alignment

- Geometric axis of the poles of the magnet.

Planar Alignment

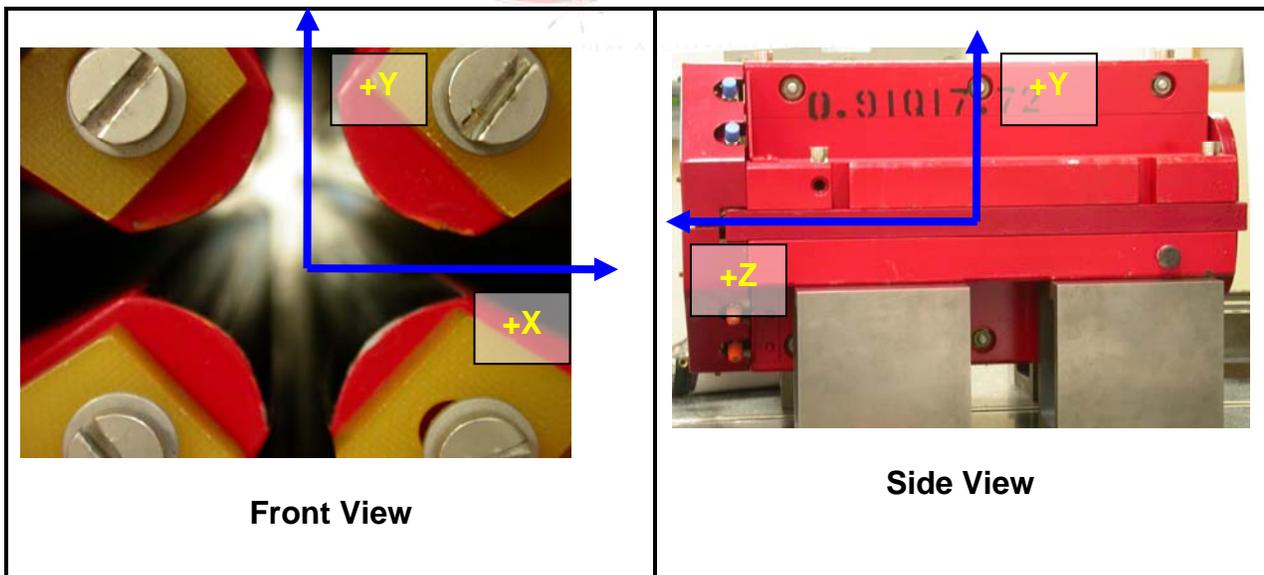
- Clocking plane where TB A,C, D, & E reside.

“Z” Zero

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

“X” & “Y” Zero

- Geometric axis of the poles of the magnet.

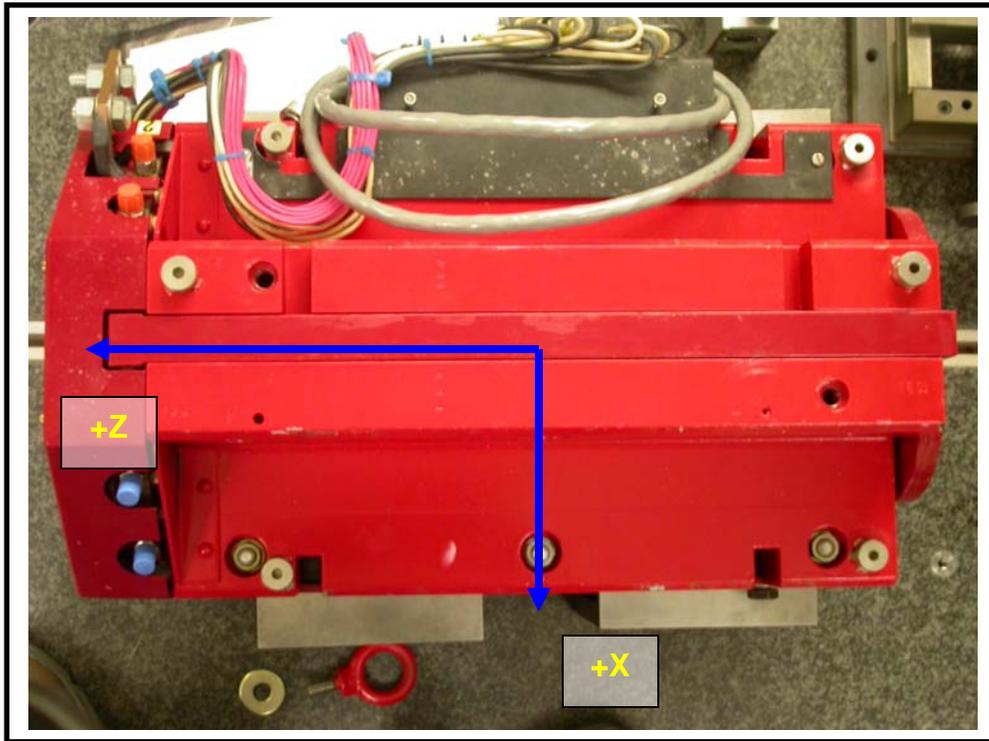


Front View

Side View

Tooling Ball Measurements/Locations

Top of magnet; view from "+Y"



Tooling Ball	FORM	DIAMETER	X	Y	Z
TB A	0.00016	0.49800	5.00833	3.72194	-8.05438
TB B	0.00018	0.49916	-1.37340	7.30538	-8.00001
TB C	0.00023	0.49730	-5.01854	3.67519	-8.08101
TB D	0.00064	0.49636	-5.32069	3.67425	6.32448
TB E	0.00001	0.49995	-1.39906	7.30575	8.01331
TB F	0.00026	0.49823	5.24275	3.72333	6.30076

Pole Distances

Pole	-Z side	+Z side	Δ
A-C	0.90582	0.90712	0.00130
B-D	0.90640	0.90598	0.00042

