Issac + Emil's Hall probe results 6-12-06

Quality Tools and Abrasives, Inc.

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Cutting Tools • Carbide • Shop Supplies • Inventory Management
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Undulator #7

2					125 1.27	159 1.26	193 1.26
					126 1.26	160 1.27	194 1.26
					127 1.27	161 1.27	195 1.26
3 1.26	32 1.28	63 1.26	94 1.26		128 1.26	162 1.26	196 1.26
4 1.31	33 1.28	64 1.26	95 1.27		129 1.27	163 1.27	197 1.26
5. 1.29	34 1.27	65 1.27	96 1.26		130 1.27	164 1.26	198 1.26
6. 1.30	35 1.27	66 1.26	97 1.27		131 1.25	165 1.26	199 1.25
7. 1.29	36 1.26	67 1.25	98 1.26		132 1.26	166 1.26	200 1.26
8. 1.29	37 1.26	68 1.26	99 1.26		133 1.27	167 1.26	201 1.27
9 1.28	38 1.26	69 1.25	100 1.26		134 1.27	168 1.26	202 1.26
10. 1.29	39 1.26	70 1.26	101 1.26		135 1.27	169 1.27	203 1.26
11 1.29	40 1.26	71 1.25	102 1.26		136 1.27	170 1.26	204 1.26
12. 1.29	41 1.27	72 1.26	103 1.26		137 1.26	171 1.26	205 1.25
13 1.27	42 1.26	73 1.26	104 1.25		138 1.26	172 1.26	206 1.26
14. 1.26	43 1.25	74 1.27	105 1.25		139 1.26	173 1.26	207 1.26
15 1.26	44 1.25	75 1.27	106 1.25		140 1.26	174 1.25	208 1.26
16. 1.25	45 1.27	76 1.26	107 1.25		141 1.27	175 1.26	209 1.26
17 1.25	46 1.26	77 1.26	108 1.26		142 1.26	176 1.25	210 1.25
18 1.26	47 1.26	78 1.26	109 1.26		143 1.27	177 1.27	211 1.25
19. 1.27	48 1.27	79 1.26	110 1.26		144 1.26	178 1.25	212 1.25
20 1.27	49 1.26	80 1.26	111 1.26		145 1.26	179 1.26	213 1.26
21 1.26	50 1.26	81 1.25	112 1.26		146 1.26	180 1.26	214 1.26
22 1.25	51 1.27	82 1.26	113 1.26		147 1.26	181 1.26	215 1.25
23 1.26	52 1.27	83 1.25	114 1.25		148 1.25	182 1.26	216 1.26
24. 1.26	53 1.26	84 1.26	115 1.26		149 1.26	183 1.27	217 1.26
25 1.27	54 1.27	85 1.26	116 1.26		150 1.26	184 1.27	218 1.26
26 1.27	55 1.26	86 1.27	117 1.26		151 1.26	185 1.25	219 1.27
27. 1.27	56 1.25	87 1.25	118 1.26		152 1.25	186 1.26	220 1.27
28 1.27	57 1.26	88 1.25	119 1.26		153 1.25	187 1.26	221 1.27
29 1.26	58 1.26	89 1.26	120 1.26		154 1.25	188 1.26	222 1.26
30 1.26	59 1.27	90 1.26	121 1.26		155 1.26	189 1.26	223 1.28
31 1.26	60 1.26	91 1.26	122 1.26		156 1.25	190 1.25	224 1.22
	61 1.26	92 1.25	123 1.26		157 1.26	191 1.26	225
	62 1.26	93 1.27	124 1.26		158 1.25	192 1.26	

Lot 4

LOT4 magnets Serial # 1441-1920

Bottom Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	1565	Upstream	Right
2	1875	Downstream	Right
3	1471	Upstream	Right
4	1609	Downstream	Right
5	1559	Upstream	Left
6	1808	Downstream	Right
7	1588	Upstream	Left
8	1865	Downstream	Left
9	1551	Upstream	Left
10	1901	Downstream	Left
11	1447	Upstream	Left
12	1904	Downstream	Right
13	1500	Upstream	Right
14	1823	Downstream	Right
15	1521	Upstream	Left
16	1866	Downstream	Right
17	1473	Upstream	Right
18	1675	Downstream	Left
19	1443	Upstream	Left
20	1858	Downstream	Right
21	1709	Upstream	Right
22	1854	Downstream	Left
23	1549	Upstream	Right
24	1665	Downstream	Right
25	1568	Upstream	Left
26	1700	Downstream	Right
27	1667	Upstream	Left
28	1569	Downstream	Right
29	1721	Upstream	Right
30	1474	Downstream	Left
31	1464	Upstream	Left
32	1652	Downstream	Left
33	1716	Upstream	Left
34	1852	Downstream	Left
35	1441	Upstream	Left
36	1802	Downstream	Left
37	1678	Upstream	Left
38	1508	Downstream	Right
39	1786	Upstream	Left
40	1816	Downstream	Right
41	1584	Upstream	Left
42	1893	Downstream	Left
43	1749	Upstream	Right
44	1671	Downstream	Left
45	1774	Upstream	Left
46	1753	Downstream	Left
47	1572	Upstream	Right

Top Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	1887	Downstream	Right
2	1589	Upstream	Left
3	1909	Downstream	Left
4	1495	Upstream	Left
5	1744	Downstream	Left
6	1456	Upstream	Left
7	1888	Downstream	Left
8	1607	Upstream	Left
9	1688	Downstream	Left
10	1463	Upstream	Left
11	1761	Downstream	Left
12	1506	Upstream	Right
13	1598	Downstream	Left
14	1524	Upstream	Right
15	1653	Downstream	Left
16	1592	Upstream	Left
17	1509	Downstream	Right
18	1555	Upstream	Right
19	1594	Downstream	Left
20	1490	Upstream	Left
21	1627	Downstream	Left
22	1529	Upstream	Left
23	1811	Downstream	Left
24	1593	Upstream	Left
25	1657	Downstream	Left
26	1566	Upstream	Right
27	1687	Downstream	Right
28	1475	Upstream	Left
29	1880	Downstream	Right
30	1525	Upstream	Left
31	1641	Downstream	Left
32	1637	Upstream	Left
33	1836	Downstream	Left
34	1459	Upstream	Right
35	1818	Downstream	Right
36	1625	Upstream	Left
37	1663	Downstream	Left
38	1704	Upstream	Left
39	1743	Downstream	Left
40	1620	Upstream	Left
41	1862	Downstream	Right
42	1482	Upstream	Left
43	1762	Downstream	Left
44	1522	Upstream	Left
45	1809	Downstream	Left
46	1536	Upstream	Left
47	1758	Downstream	Right

48	1693	Downstream	Right
49	1692	Upstream	Left
50	1900	Downstream	Left
51	1722	Upstream	Left
52	1905	Downstream	Right
53	1661	Upstream	Left
54	1772	Downstream	Left
55	1668	Upstream	Right
56	1869	Downstream	Left
57	1807	Upstream	Right
58	1763	Downstream	Left
59	1738	Upstream	Left
60	1833	Downstream	Left
61	1733	Upstream	Left
62	1877	Downstream	Left
63	1824	Upstream	Right
64	1874	Downstream	Right
65	1540	Upstream	Right
66	1788	Downstream	Left
67	1737	Upstream	Right
68	1630	Downstream	Left
69	1847	Upstream	Left
70	1504	Downstream	Right
71	1530	Upstream	Left
72	1870	Downstream	Right
73	1785	Upstream	Left
74	1853	Downstream	Left
75	1680	Upstream	Left
76	1670	Downstream	Right
77	1685	Upstream	Right
78	1494	Downstream	Right
79	1691	Upstream	Right
80	1647	Downstream	Right
81	1450	Upstream	Left
82	1754	Downstream	Right
83	1539	Upstream	Left
84	1790	Downstream	Left
85	1486	Upstream	Right
86	1826	Downstream	Right
87	1576	Upstream	Left
88	1791	Downstream	Left
89	1797	Upstream	Right
90	1894	Downstream	Left
91	1726	Upstream	Left
92	1793	Downstream	Left
93	1844	Upstream	Right
94	1606	Downstream	Right
95	1477	Upstream	Left
96	1624	Downstream	Left
97	1712	Upstream	Right
98	1586	Downstream	Right
99	1751	Upstream	Left

48	1597	Upstream	Left
49	1827	Downstream	Right
50	1481	Upstream	Left
51	1846	Downstream	Right
52	1601	Upstream	Left
53	1736	Downstream	Left
54	1770	Upstream	Right
55	1507	Downstream	Right
56	1617	Upstream	Left
57	1640	Downstream	Left
58	1679	Upstream	Right
59	1635	Downstream	Left
60	1729	Upstream	Right
61	1634	Downstream	Left
62	1673	Upstream	Right
63	1898	Downstream	Right
64	1608	Upstream	Left
65	1604	Downstream	Left
66	1626	Upstream	Right
67	1686	Downstream	Left
68	1684	Upstream	Right
69	1654	Downstream	Right
70	1696	Upstream	Right
71	1882	Downstream	Left
72	1554	Upstream	Left
73	1639	Downstream	Right
74	1643	Upstream	Right
75	1756	Downstream	Left
76	1442	Upstream	Left
77	1855	Downstream	Right
78	1583	Upstream	Right
79	1483	Downstream	Right
80	1465	Upstream	Right
81	1780	Downstream	Right
82	1461	Upstream	Left
83	1857	Downstream	Right
84	1546	Upstream	Left
85	1902	Downstream	Right
86	1570	Upstream	Left
87	1713	Downstream	Right
88	1510	Upstream	Right
89	1699	Downstream	Right
90	1564	Upstream	Right
91	1746	Downstream	Right
92	1838	Upstream	Left
93	1879	Downstream	Right
94	1705	Upstream	Left
95	1541	Downstream	Right
96	1706	Upstream	Left
97	1783	Downstream	Right
98	1669	Upstream	Right
99	1725	Downstream	Left

100	1760	Downstream	Right
101	1532	Upstream	Right
102	1548	Downstream	Right
103	1444	Upstream	Left
104	1830	Downstream	Right
105	1720	Upstream	Right
106	1638	Downstream	Left
107	1777	Upstream	Left
108	1531	Downstream	Left
109	1519	Upstream	Left
110	1460	Downstream	Left
111	1645	Upstream	Right
112	1469	Downstream	Left
113	1871	Upstream	Left
114	1757	Downstream	Right
115	1732	Upstream	Right
116	1867	Downstream	Left
117	1815	Upstream	Left
118	1911	Downstream	Right
119	1885	Upstream	Right
120	1610	Downstream	Left
121	1892	Upstream	Left
122	1886	Downstream	Right
123	1741	Upstream	Right
124	1821	Downstream	Left
125	1910	Upstream	Left
126	1446	Downstream	Right
127	1915	Upstream	Right
128	1493	Downstream	Left
129	1899	Upstream	Right
130	1839	Downstream	Right
131	1488	Upstream	Left
132	1636	Downstream	Right
133	1707	Upstream	Left
134	1503	Downstream	Left
135	1778	Upstream	Left
136	1511	Downstream	Right
137	1512	Upstream	Right
138	1702	Downstream	Right
139	1863	Upstream	Right
140	1719	Downstream	Left
141	1660	Upstream	Left
142	1690	Downstream	Left
143	1553	Upstream	Right
144	1828	Downstream	Left
145	1920	Upstream	Left
146	1747	Downstream	Right
147	1466	Upstream	Right
148	1734	Downstream	Right
149	1787	Upstream	Left
150	1556	Downstream	Right
151	1498	Upstream	Left

100	1914	Upstream	Left
101	1698	Downstream	Right
102	1798	Upstream	Left
103	1773	Downstream	Left
104	1771	Upstream	Right
105	1718	Downstream	Right
106	1723	Upstream	Left
107	1478	Downstream	Left
108	1779	Upstream	Right
109	1642	Downstream	Left
110	1822	Upstream	Left
111	1711	Downstream	Right
112	1841	Upstream	Right
113	1916	Downstream	Left
114	1832	Upstream	Right
115	1496	Downstream	Left
116	1714	Upstream	Left
117	1884	Downstream	Left
118	1520	Upstream	Right
119	1800	Downstream	Right
120	1600	Upstream	Left
121	1501	Downstream	Left
122	1499	Upstream	Right
123	1814	Downstream	Left
124	1796	Upstream	Left
125	1514	Downstream	Right
126	1452	Upstream	Left
127	1730	Downstream	Right
128	1615	Upstream	Left
129	1913	Downstream	Left
130	1752	Upstream	Left
131	1445	Downstream	Left
132	1769	Upstream	Left
133	1768	Downstream	Right
134	1666	Upstream	Left
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136	1468	Upstream	Left
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139	1659	Downstream	Right
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142	1602	Upstream	Left
143	1789	Downstream	Left
144	1672	Upstream	Right
145	1891	Downstream	Left
146	1759	Upstream	Right
147	1766	Downstream	Right
148	1843	Upstream	Right
149	1835	Downstream	Left
150	1451	Upstream	Left
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157	1557	Upstream	Right
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164	1801	Downstream	Right
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166	1585	Downstream	Left
167	1748	Upstream	Left
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175	1581	Upstream	Right
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177	1784	Upstream	Right
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188	1810	Downstream	Right
189	1656	Upstream	Right
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191	1649	Upstream	Left
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193	1674	Upstream	Left
194	1834	Downstream	Left
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198	1873	Downstream	Left
199	1739	Upstream	Left
200	1677	Downstream	Right
201	1603	Upstream	Right
202	1681	Downstream	Left
203	1487	Upstream	Right

152	1448	Upstream	Right
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164	1457	Upstream	Left
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166	1491	Upstream	Right
167	1776	Downstream	Left
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171	1876	Downstream	Left
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173	1745	Downstream	Left
174	1516	Upstream	Left
175	1717	Downstream	Left
176	1502	Upstream	Left
177	1829	Downstream	Right
178	1889	Upstream	Left
179	1856	Downstream	Right
180	1472	Upstream	Left
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182	1775	Upstream	Right
183	1484	Downstream	Left
184	1708	Upstream	Left
185	1792	Downstream	Right
186	1455	Upstream	Right
187	1651	Downstream	Left
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190	1518	Upstream	Left
191	1812	Downstream	Left
192	1563	Upstream	Left
193	1781	Downstream	Right
194	1697	Upstream	Left
195	1580	Downstream	Right
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198	1715	Upstream	Right
199	1616	Downstream	Right
200	1595	Upstream	Right
201	1881	Downstream	Right
202	1562	Upstream	Right
203	1837	Downstream	Left

204	1804	Downstream	Left
205	1740	Upstream	Right
206	1628	Downstream	Left
207	1544	Upstream	Left
208	1917	Downstream	Right
209	1550	Upstream	Left
210	1912	Downstream	Right
211	1505	Upstream	Left
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213	1579	Upstream	Left
214	1919	Downstream	Right
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216	1695	Downstream	Right
217	1497	Upstream	Left
218	1896	Downstream	Left
219	1489	Upstream	Left
220	1612	Downstream	Right
221	1577	Upstream	Right
222	1676	Downstream	Right
223	1590	Upstream	Left
224	1850	Downstream	Left
225	1547	Upstream	Left

204	1631	Upstream	Left
205	1849	Downstream	Right
206	1538	Upstream	Right
207	1860	Downstream	Right
208	1485	Upstream	Right
209	1851	Downstream	Right
210	1611	Upstream	Right
211	1878	Downstream	Right
212	1571	Upstream	Left
213	1764	Downstream	Right
214	1587	Upstream	Left
215	1908	Downstream	Right
216	1614	Upstream	Left
217	1859	Downstream	Right
218	1528	Upstream	Right
219	1664	Downstream	Right
220	1535	Upstream	Right
221	1864	Downstream	Left
222	1515	Upstream	Right
223	1890	Downstream	Left
224	1613	Upstream	Left
225	1883	Downstream	Right

For "X-Axis Orientation" column
"Right" stands for right-numbered surface should face to the undulator axis.
"Left" stands for left-numbered surface should face to the undulator axis.
This "Right", "Left" procedure applies for both Top and Bottom Jaw

For "Main-Field Orientation" column **(see Assembly Procedure Document)**
"Downstream" side corresponts to the direction of lower-numbered slot.
Arrow should point toward the lower numbered slots.
"Upstream" side corresponds to the direction of higher-numbered slot.
Arrow should point toward the higher numbered slots.

Spare magnets

serial No.	Reduced Magnetization
1803	33%
1619	80%
1527	
1558	
1629	
1453	
1622	
1517	
1872	
1454	
1689	

Sample magnets

serial No.
1458
1545
1658
1727
1819

1825
1868
1492
1795
1573
1574
1462
1582
1596
1633
1543
1799
1682
1831

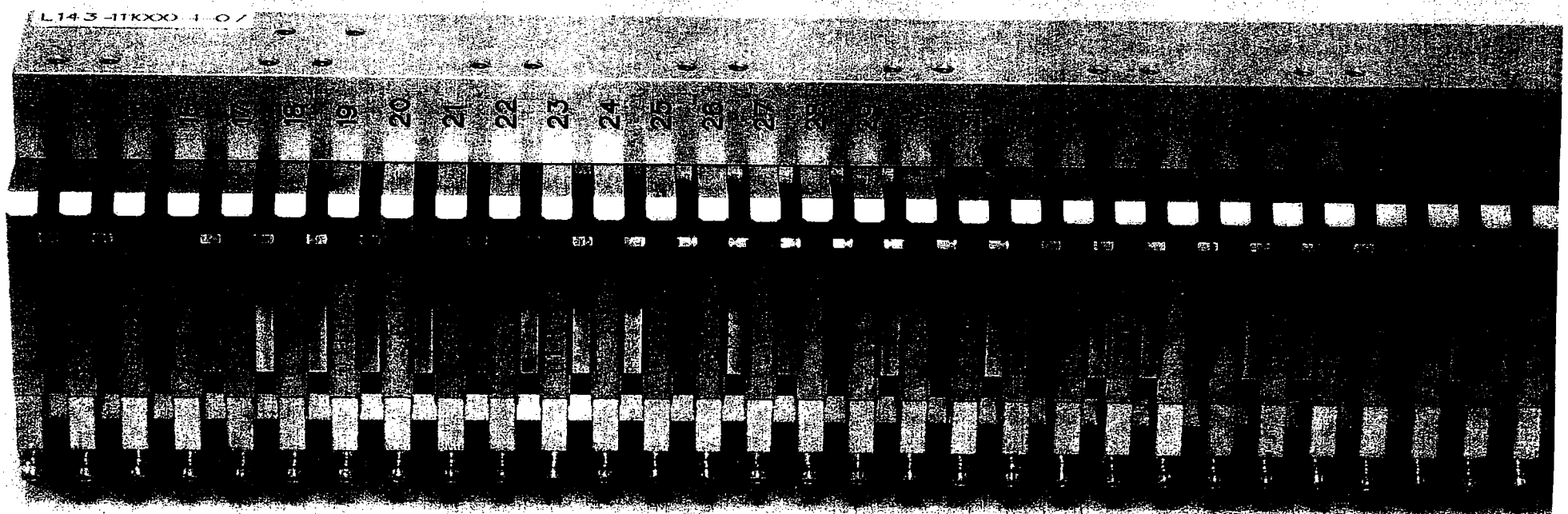
Red-numbered magnets were used for LOT2 assembly.

19 2:08PM

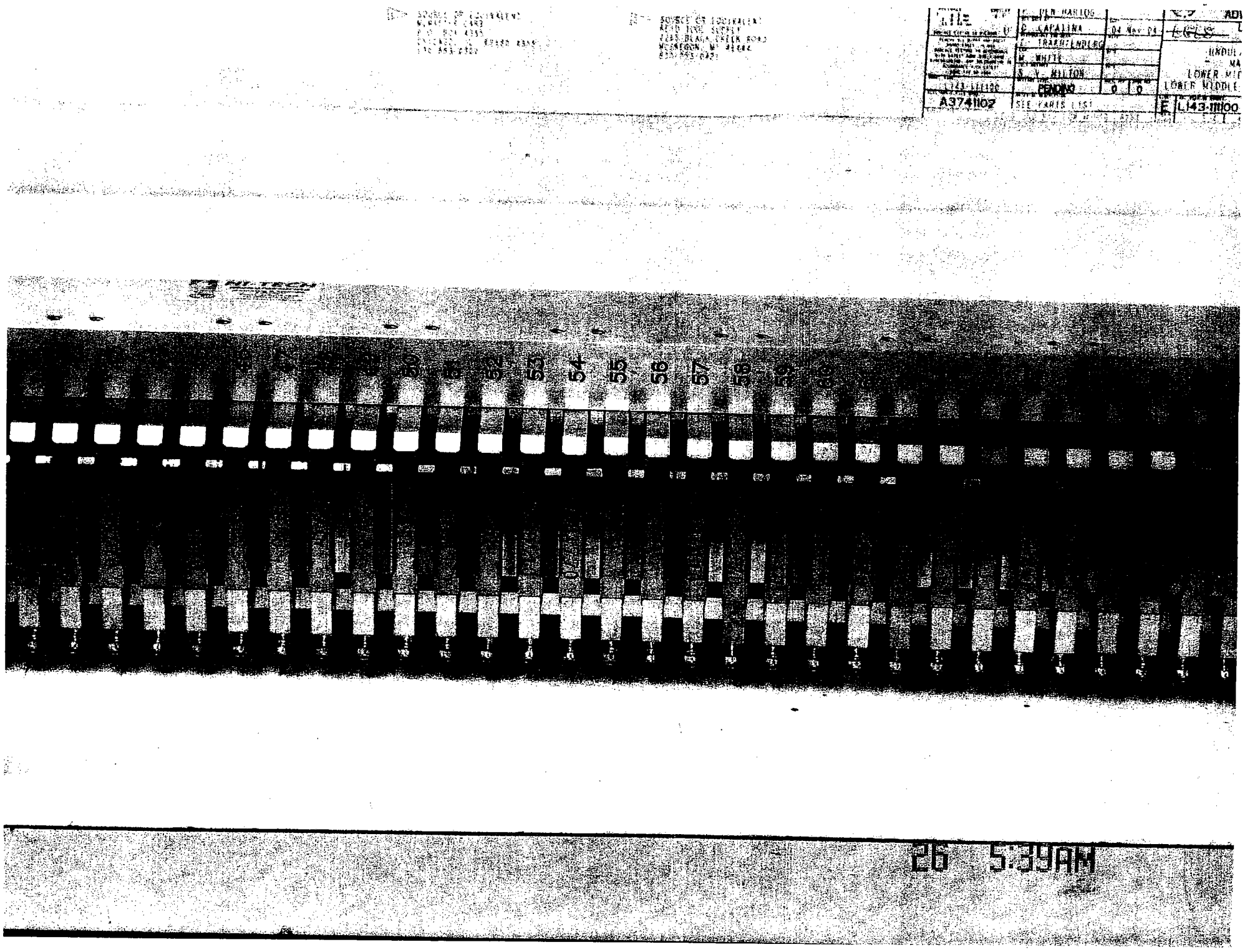
NOTES:

1. FOR ASSEMBLY PROCEDURE AND MAGNET INSTALLATION SEE DOCUMENT [illegible]
2. POSITION 4 SCREWS SHOULD BE TIGHTENED TO [illegible] INCH LBS. EACH SCREW SHOULD BE TIGHTENED TO [illegible] TORQUE AND THEN TO FULL TORQUE.
3. POSITION 7 SCREWS SHOULD BE TIGHTENED TO [illegible] INCH LBS.

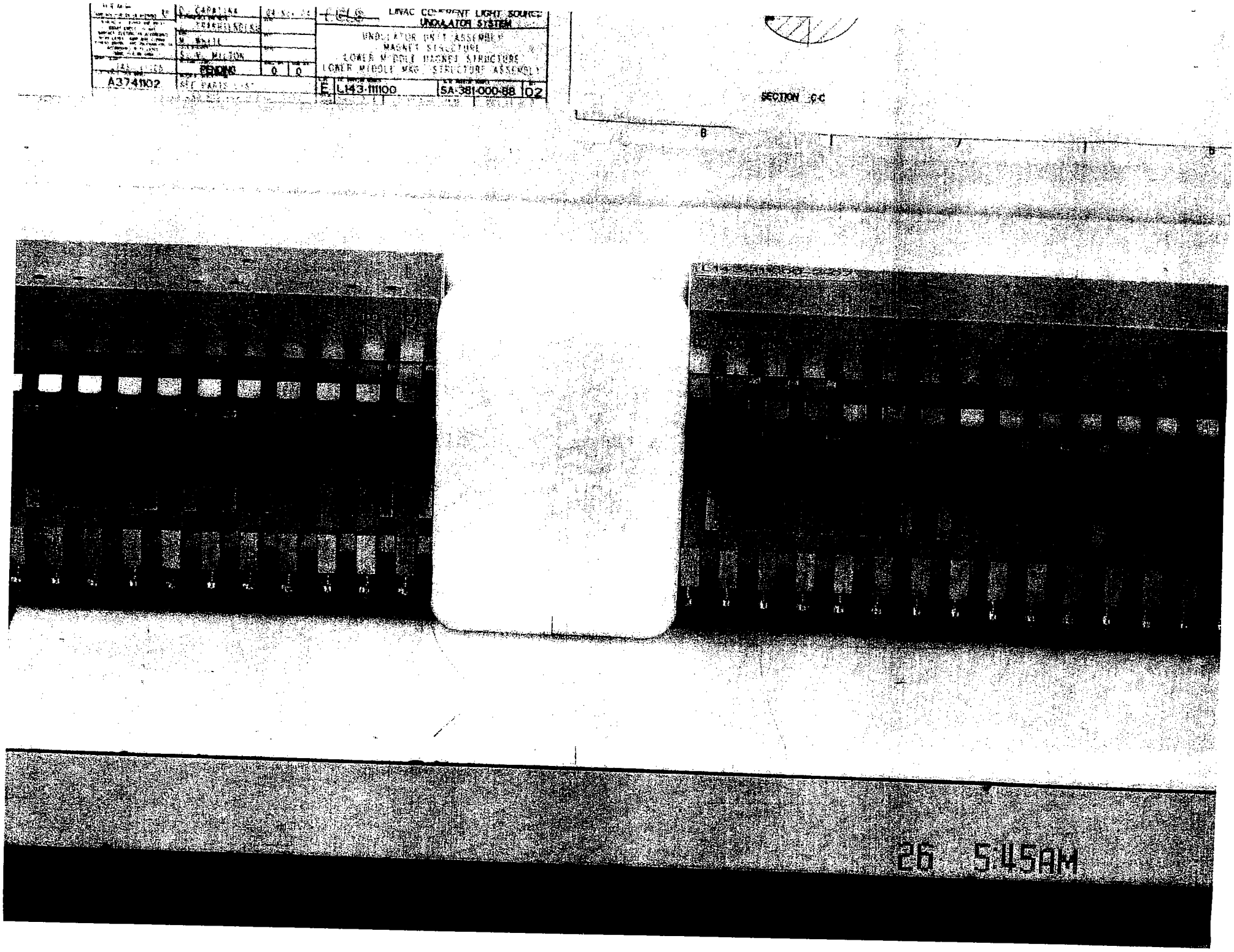
SOURCE OF
MINNESOTA
P.O. BOX
CHICAGO,
[illegible]

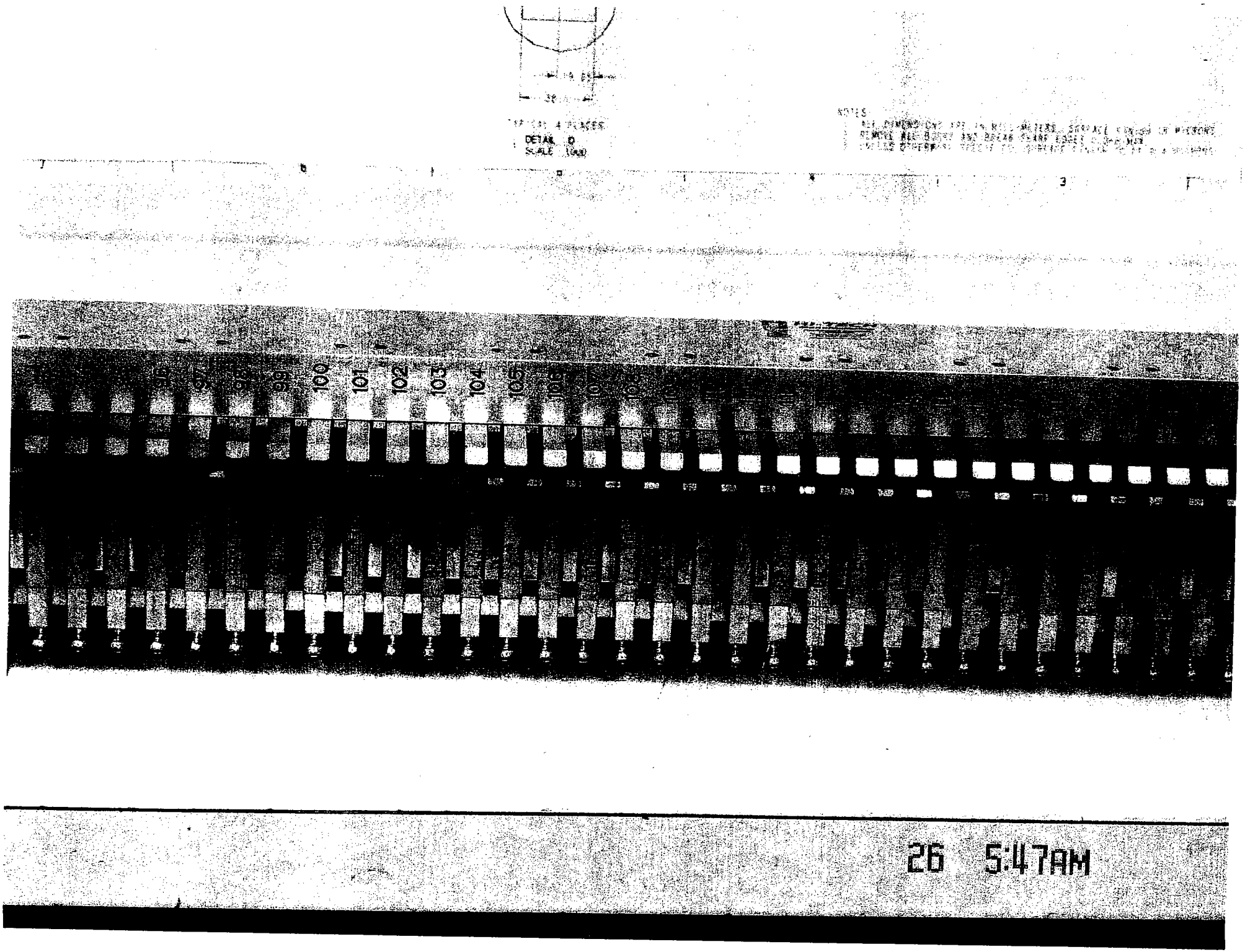


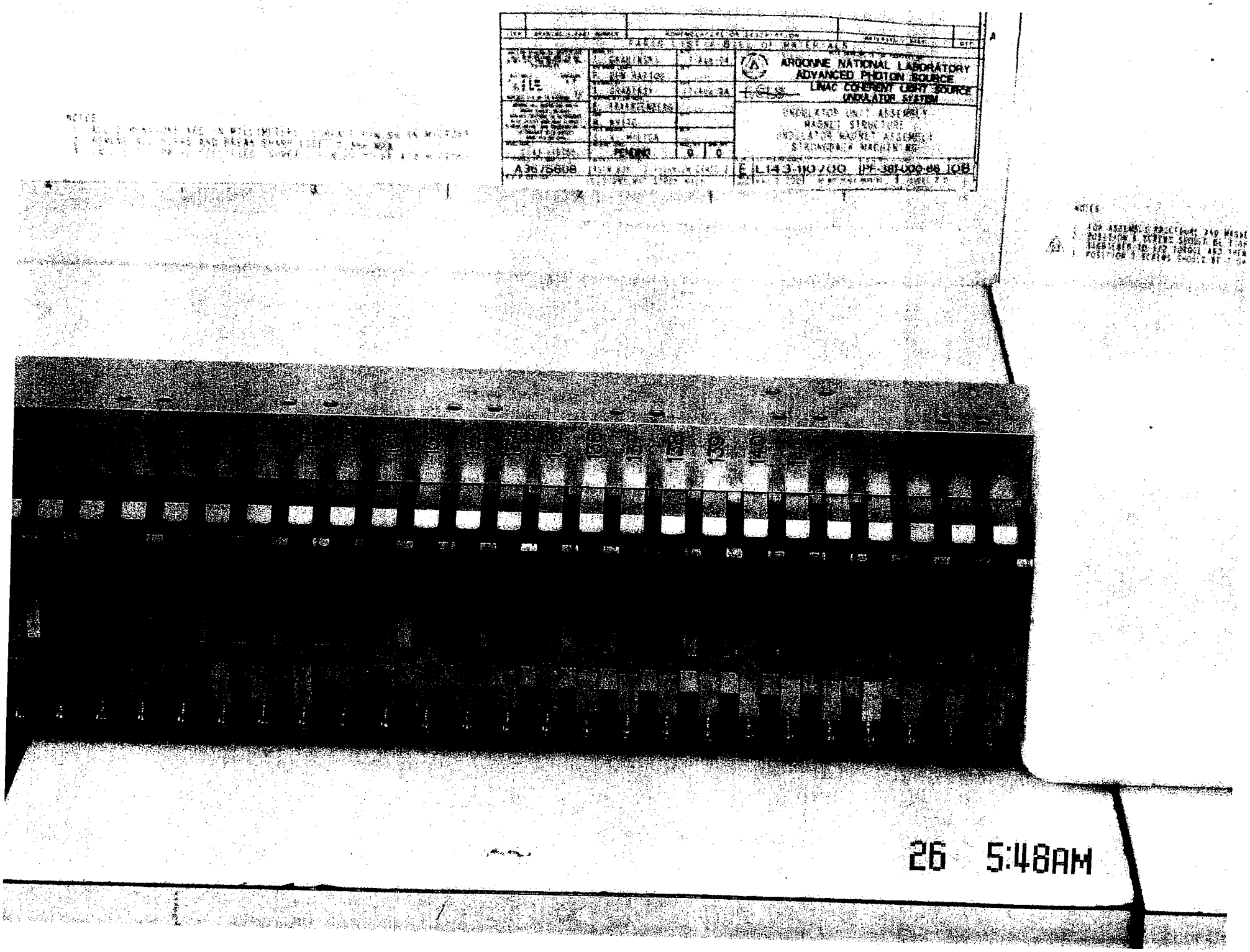
26 5:35AM

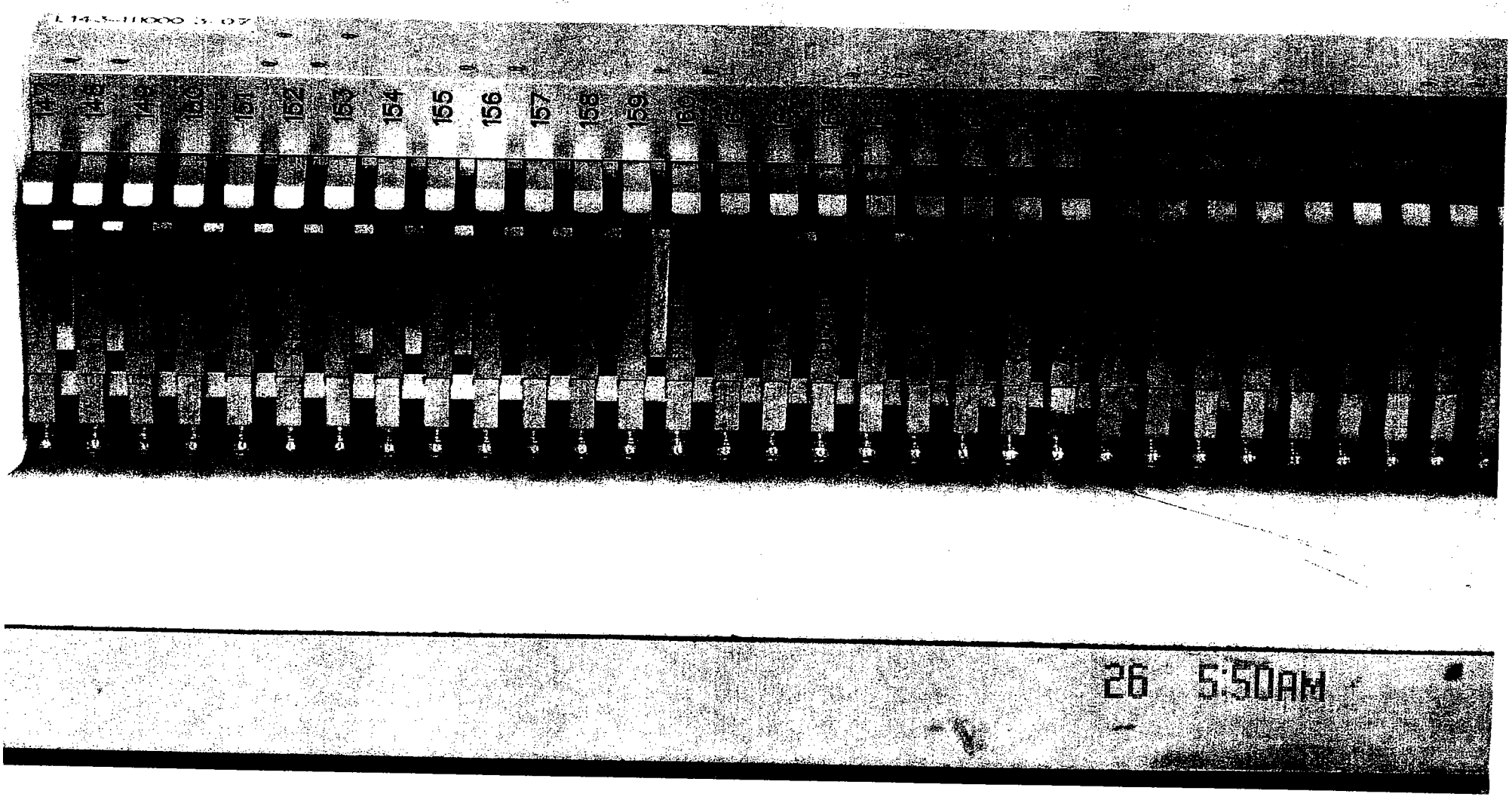


DEN HARTOG
C. CAPALINA
TRAKHTENBERG
M. WHITE
S. V. MILTON
PENDING
SEE PARTS LIST
A3741102
E
L143-111100
UNDUL
LOWER MI
LOWER MIDDLE
26 5:39AM


LINAC COHERENT LIGHT SOURCE
UNDULATOR SYSTEM
UNDULATOR UNIT ASSEMBLY
MAGNET STRUCTURE
LOWER MIDDLE MAGNET STRUCTURE
LOWER MIDDLE MAG. STRUCTURE ASSEMBLY
PENDING
0
0
A3741102
SEE PARTS LIST
E
L143-111100
SA-381-000-88
02
SECTION C-C
26 5:45AM


DETAIL D
SCALE 1000
NOTES
100
101
102
103
104
105
26 5:47AM


ARGONNE NATIONAL LABORATORY
ADVANCED PHOTON SOURCE
LINAC COHERENT LIGHT SOURCE
UNDULATOR SYSTEM
UNDULATOR UNIT ASSEMBLY
MAGNET STRUCTURE
UNDULATOR MAGNET ASSEMBLY
STRONGBACK MACHINING
PENDING
A3675608
E L143-110700
PF-381-000-88
OB
26 5:48AM


147
148
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152
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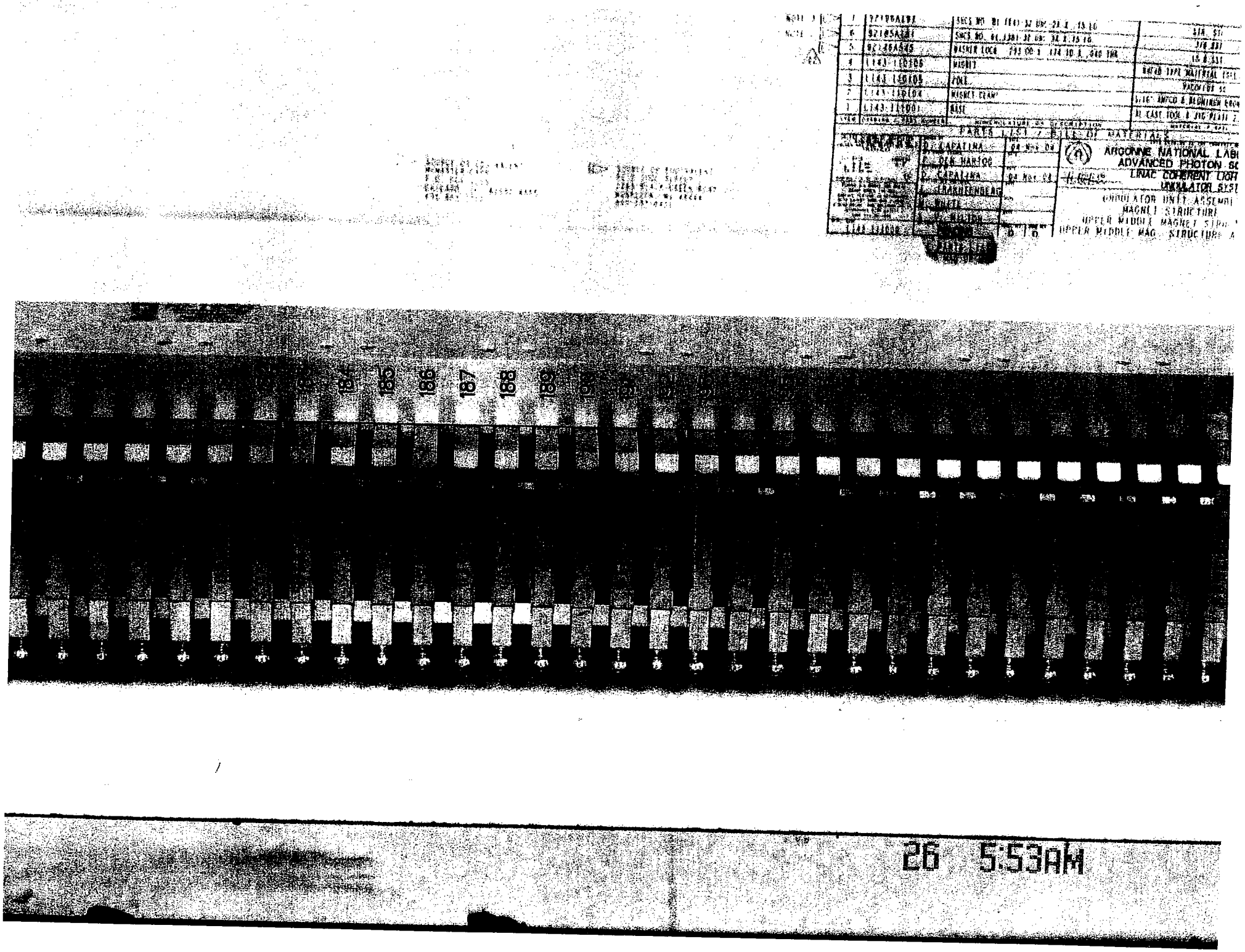
160
26 5:50AM



PARTS LIST / BILL OF MATERIALS
ARGONNE NATIONAL LAB
ADVANCED PHOTON SO
LINAC COHERENT LIGH
UNDULATOR SYST
UNDULATOR UNIT ASSEMBL
MAGNET STRUCTURE
UPPER MIDDLE MAGNET STRU
UPPER MIDDLE MAG. STRUCTURE A
184
185
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187
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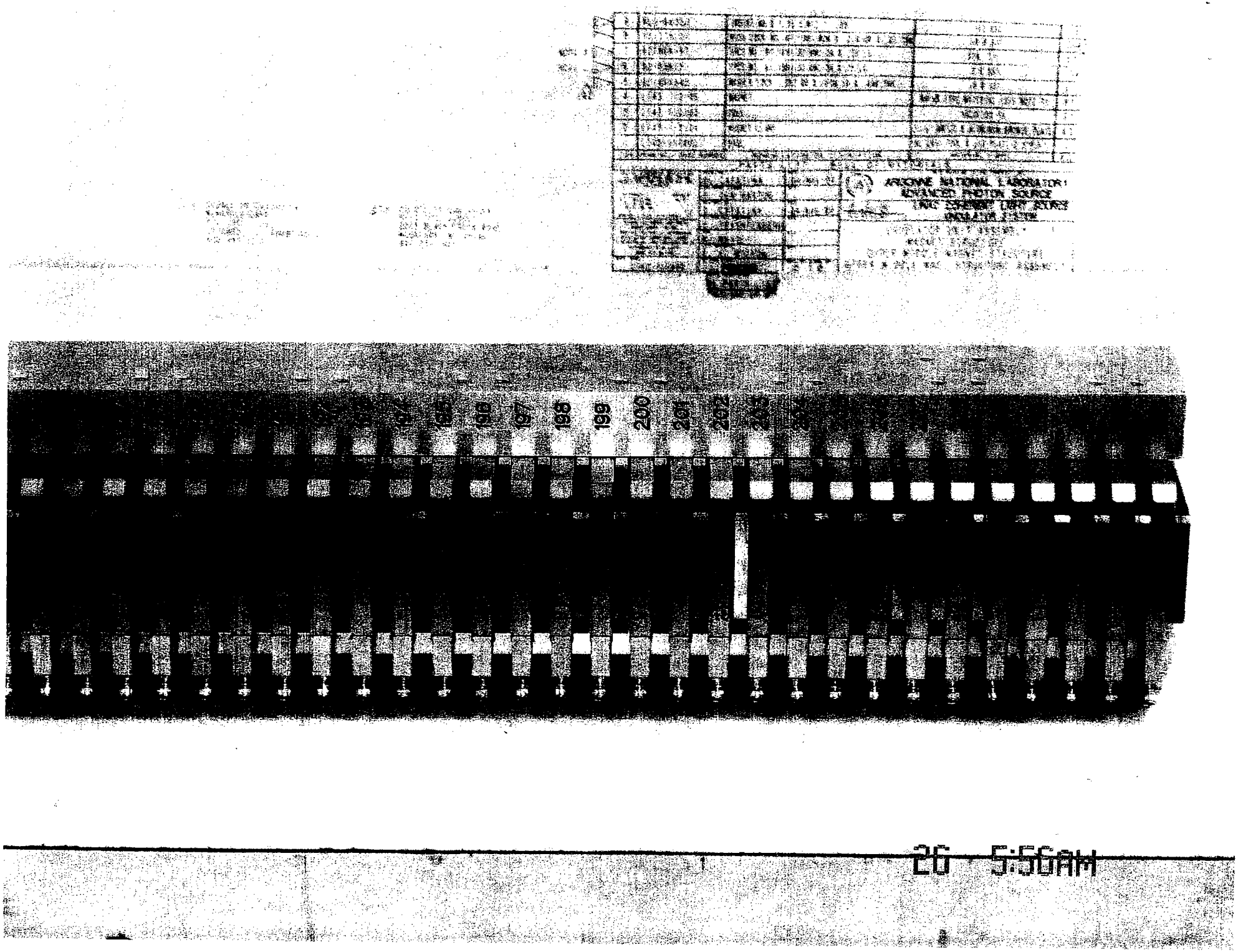
26 5:53AM


ARGONNE NATIONAL LABORATORY
ADVANCED PHOTON SOURCE
194
195
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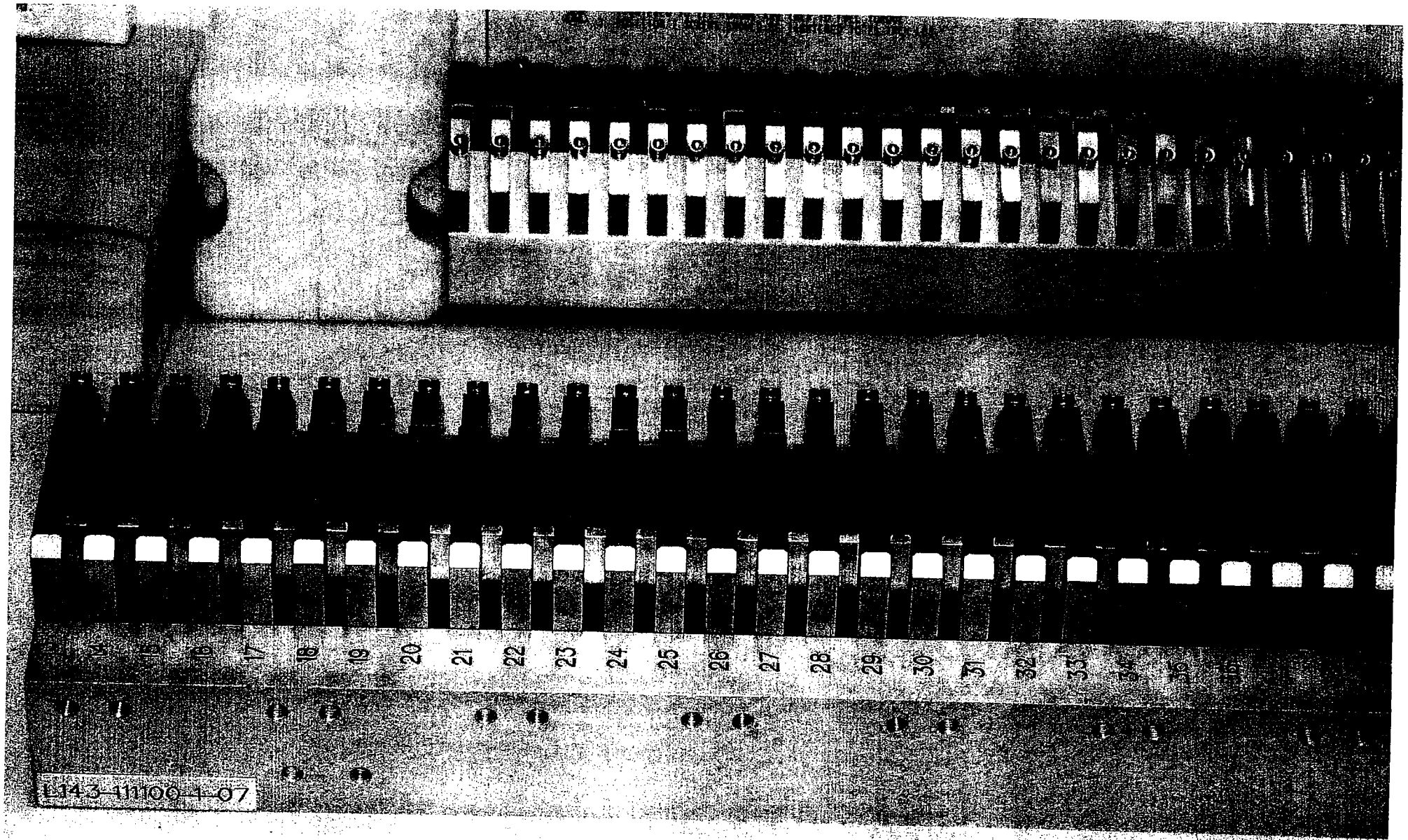

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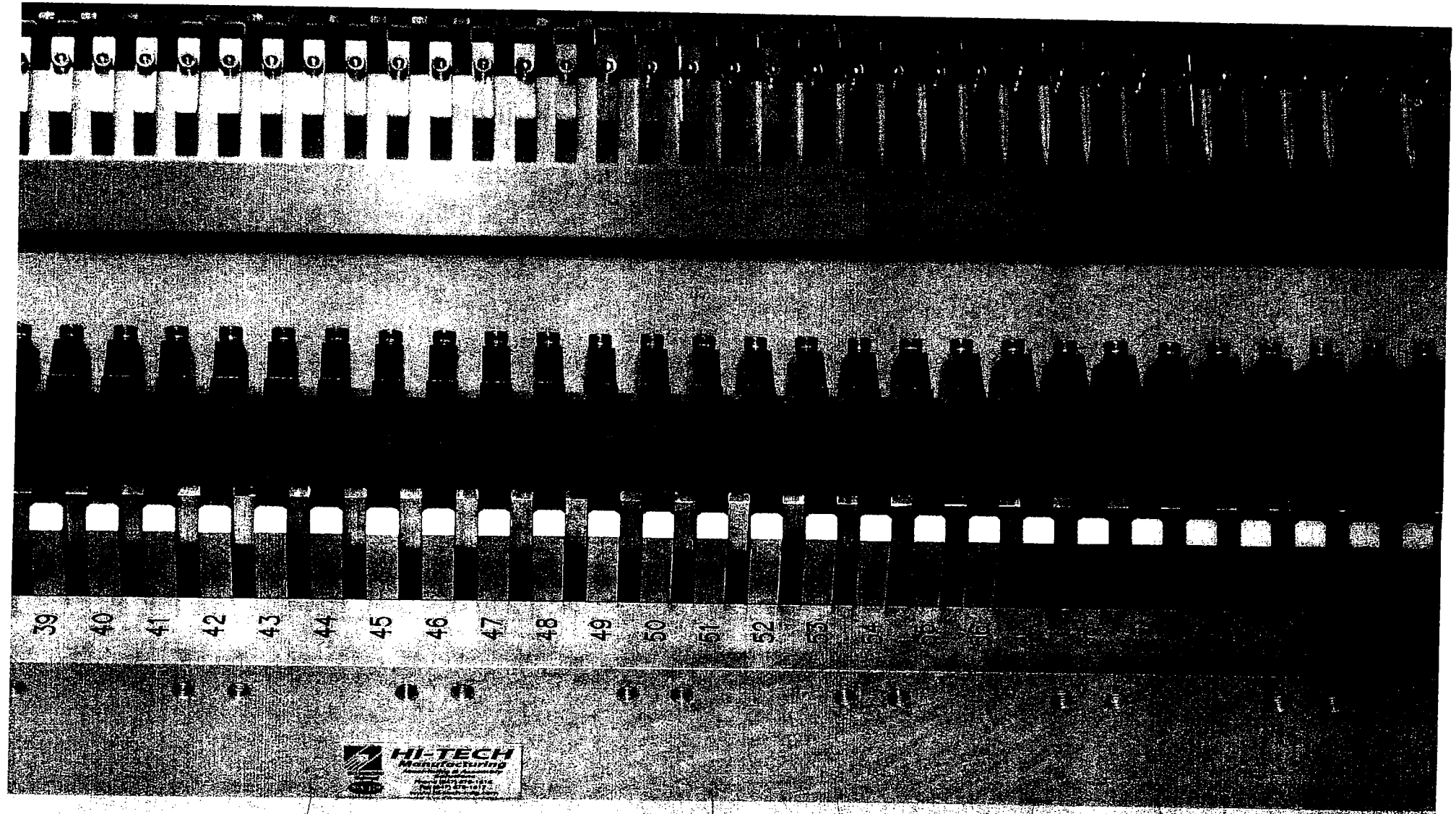

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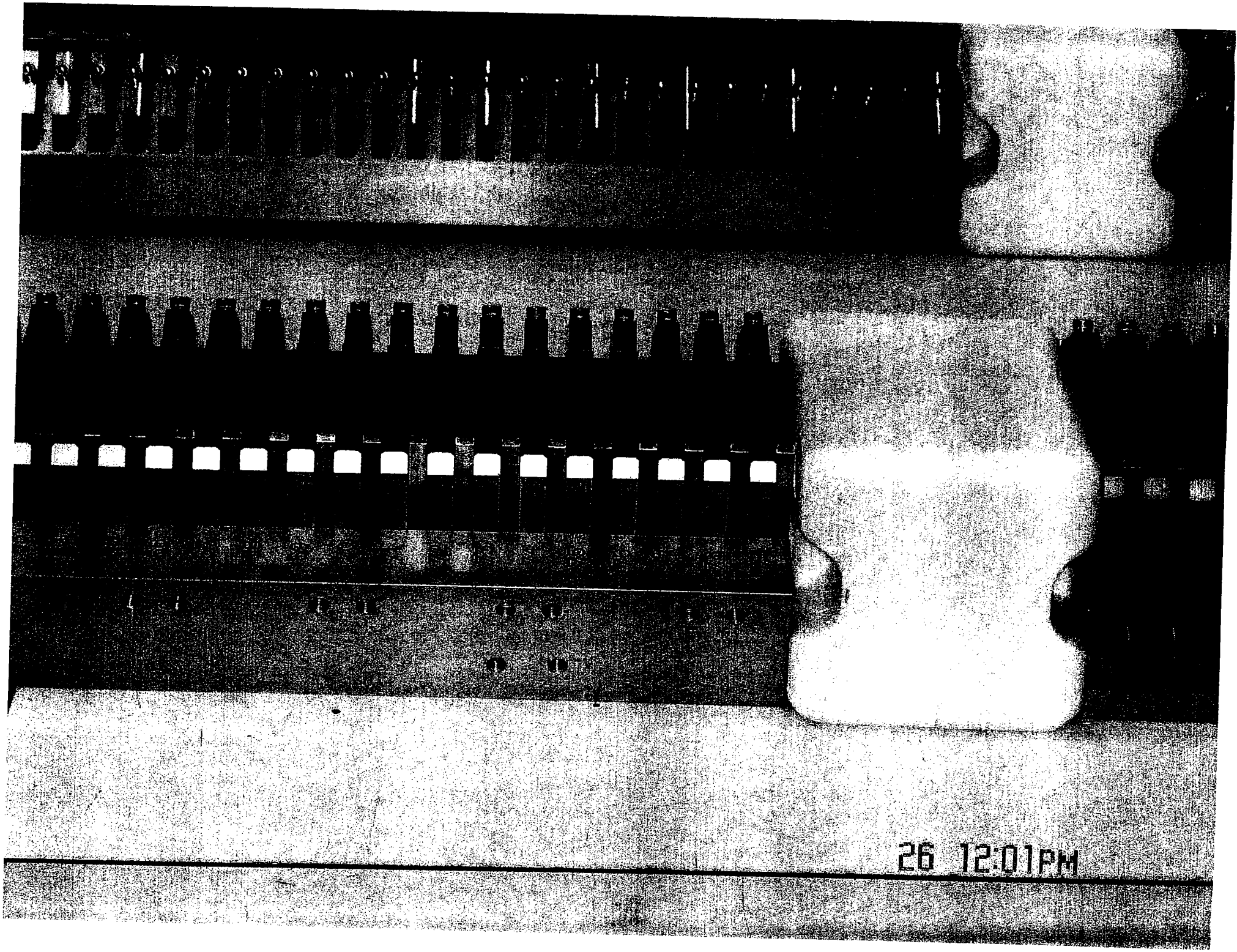
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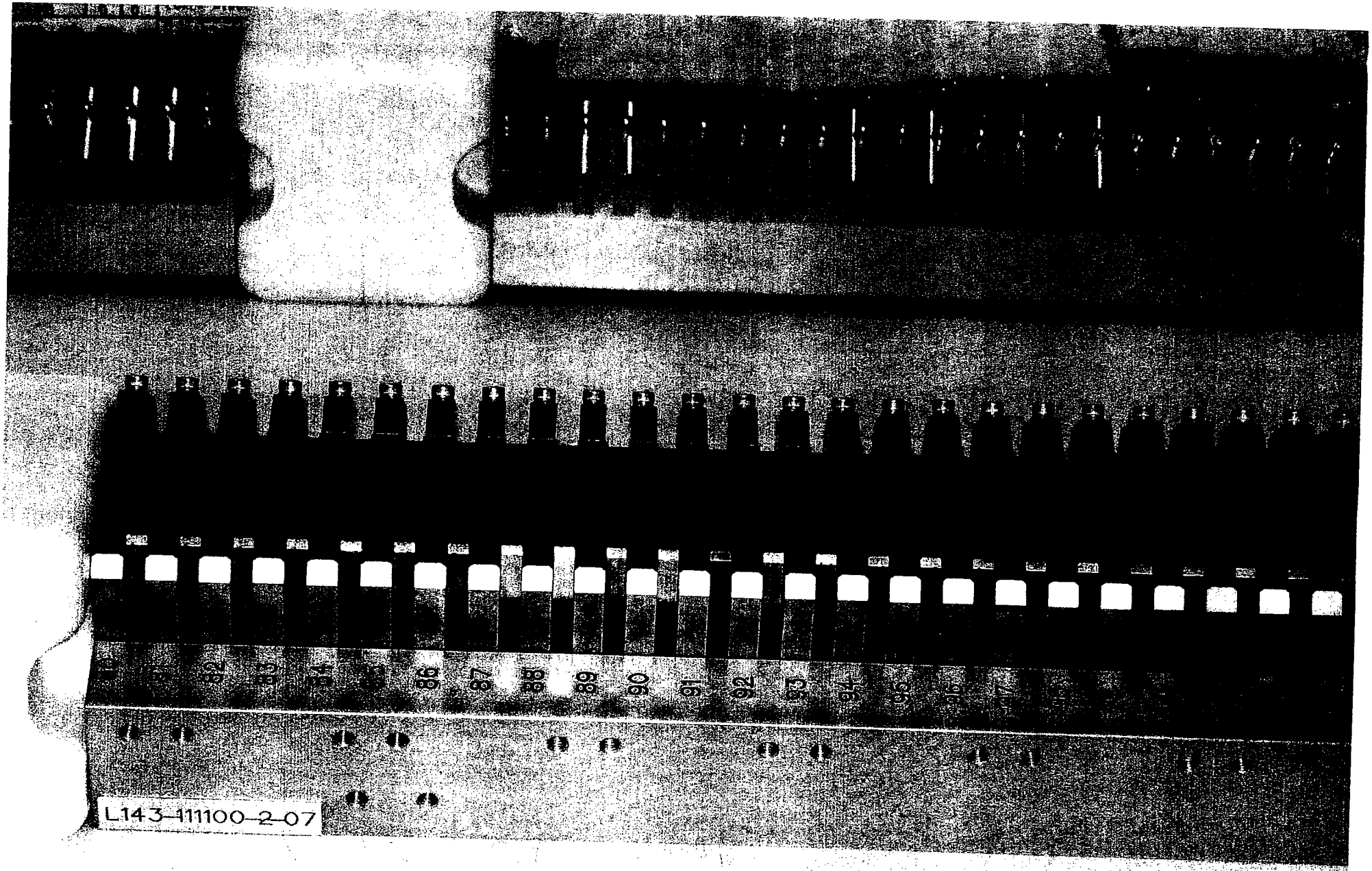

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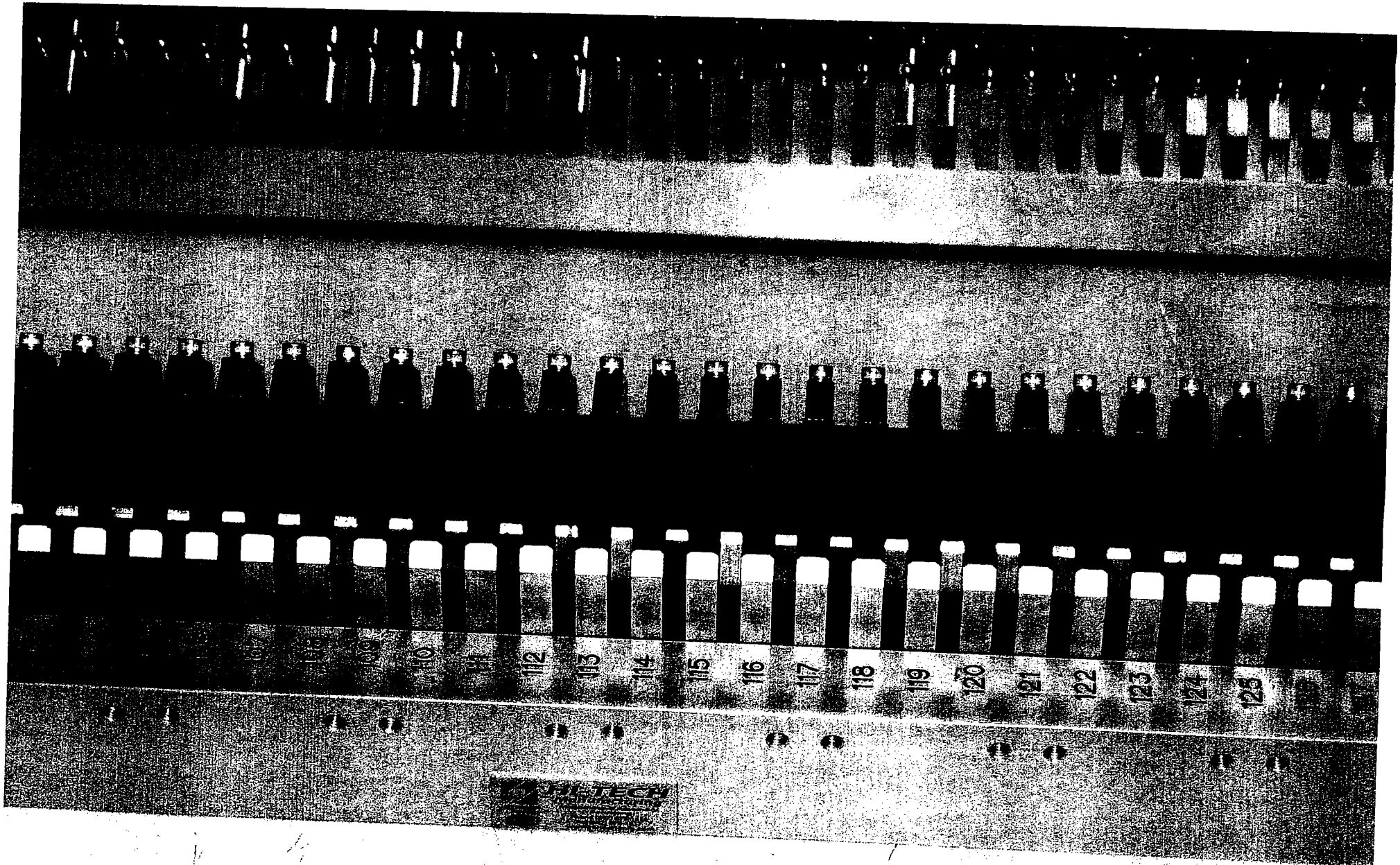
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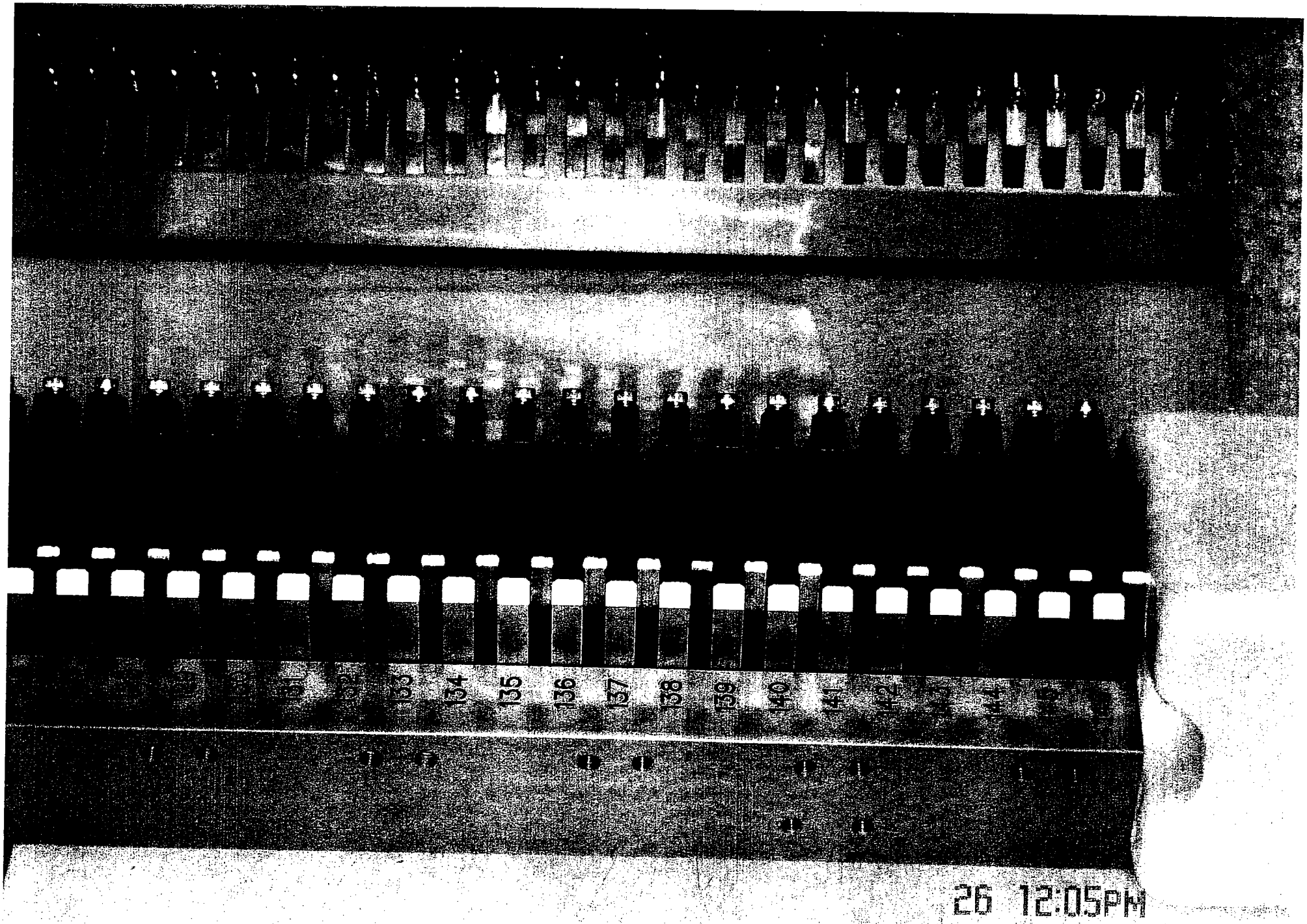
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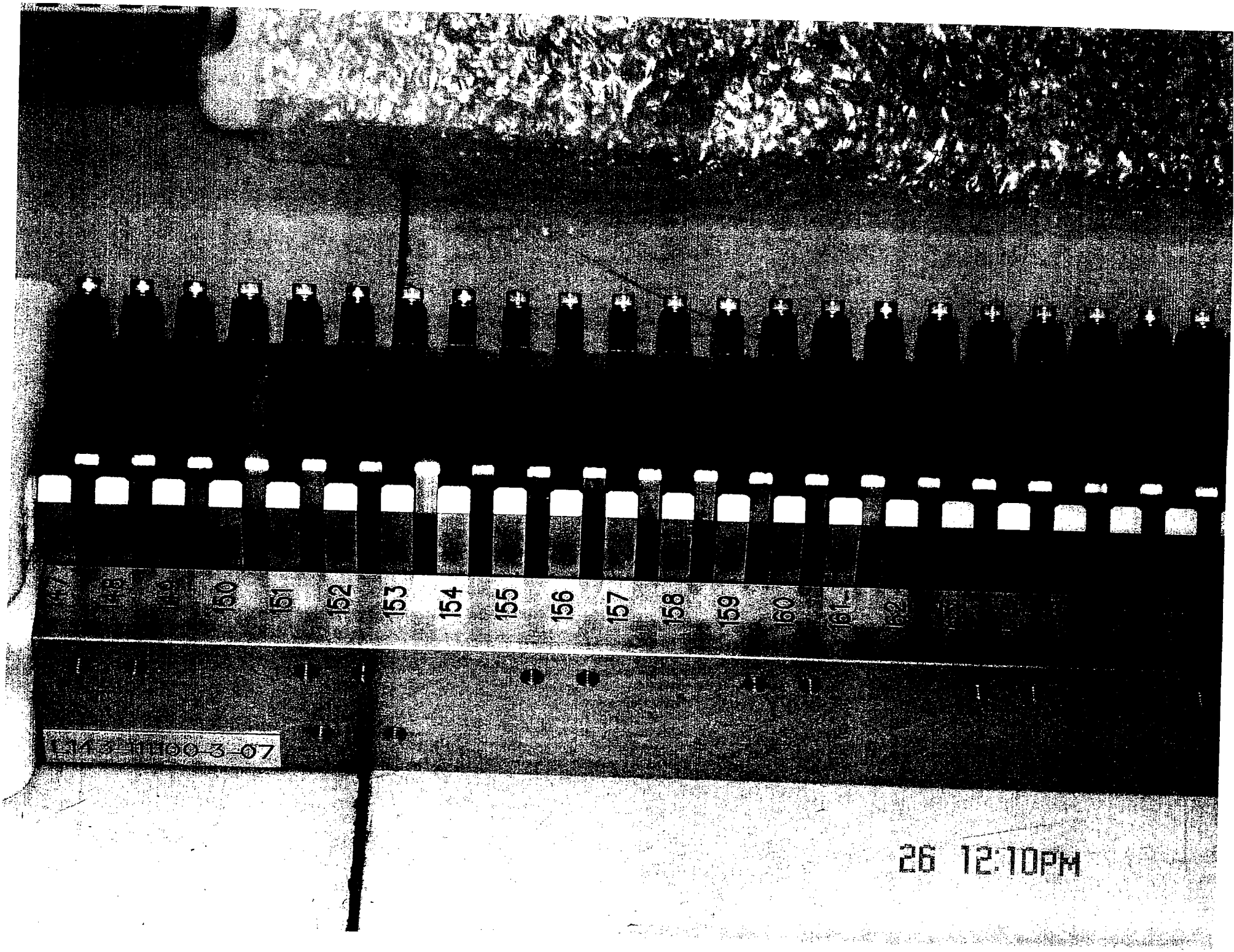
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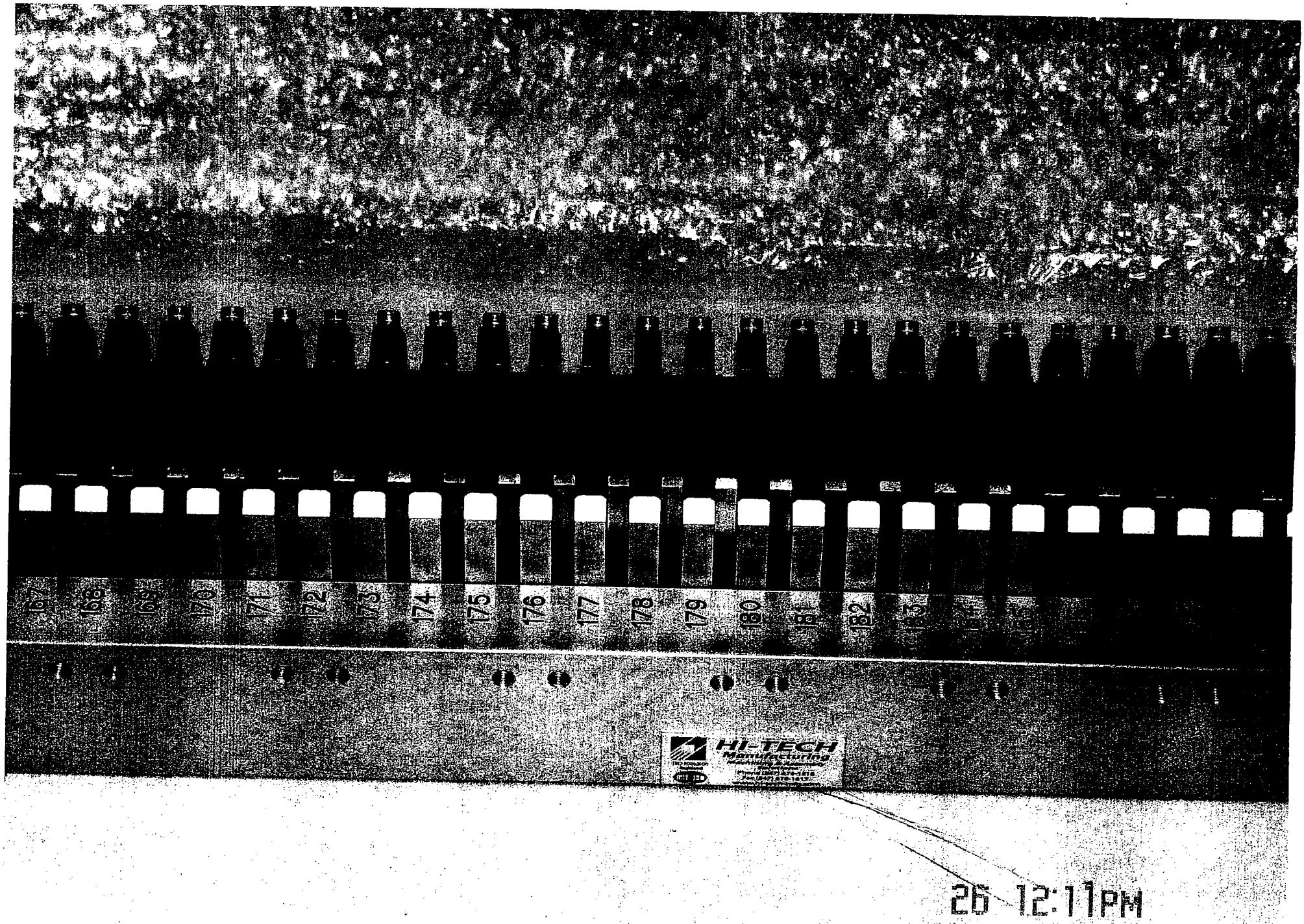
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HI-TECH
Manufacturing

26 12:11PM

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20 6:12AM

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Dial Machine, Inc.**

PART NAME: **LCLS Strongback**

DRAWING #: **L143-110700**

SERIAL #: 07

P.O.#: **5A-13624**

DATE: 05/05/06

#	Inspection/Test Requirement	Inspection Test Location	Accepted by or Nonconformance Report No.	Date
1	Visual inspection of part for shipping damage. A) Were critical surfaces protected per SOW L143-00030 Section 4.1.4? B) Is there any visible damage?	H.T.	SIMON	05/05/06
2	Check Strongback is marked with serial number & part no.'s (ANL & SLAC) per SOW Section 4.1.3?	H.T.	SIMON	05/05/06
3	Check all accompanying Certifications have correct part serial number	H.T.	SIMON	05/05/06
4	Check Material Certification for compliance with ASTM B381-03, Grade F2	H.T.	SIMON	05/05/06
5	Check Forging Annealing Certification for annealing conformance to AMS-H-81200A, Table V, commercial Pure, Bars & Forgings, including Note 8	H.T.	SIMON	05/05/06
6	Check Rough Machining Anneal Certification for annealing conformance to AMS-2801B section 3.2.9	H.T.	SIMON	5/05/06
7	Check the Strongback contractor's reported dimensional measurements against the part drawing	H.T.	SIMON	5/09/06
8	Verify the Strongback critical dimensions as listed in the SOW section 4.5.2 are in compliance with the print	H.T	SIMON	05/09/06

INSPECTOR: SIMON

QA Supervisor: Mulage

TEST EQUIPMENT USED: VISUAL

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: Dial Machine, Inc.

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 07

P.O.#: 5A-13624

DATE: 05-08-06

FEATURE: Gap Flatness

#	Distance (mm)	Measured A	Measured B	Comments
1	50	.0003	.0003	OK
2	350	.0004	.0002	OK
3	650	.0013	.0008	OK
4	950	.0013	.0007	OK
5	1250	.0005	.0010	OK
6	1550	.0005	.0009	OK
7	1850	.0009	.0009	OK
8	2150	.0006	.0007	OK
9	2450	.0007	.0008	OK
10	2750	.0014	.0010	OK
11	3050	.0000	.0003	OK
12	3350	.0000	.0001	OK

INSPECTOR: SIMON

QA Supervisor: Mulate

TEST EQUIPMENT USED: CUBIC PRECISION MODEL: 711010

COMMENTS: JIG TRANSIT SERIAL # 231067

DROP INDICATOR

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR:

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 07

P.O. #:

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Overall length	3400.00	+0 / -.04	3400.00	Accept/Reject
Gap height	167.00	+0.05 / -.0	167	Accept/Reject
Gap flatness (top and bottom)	<= .05	N/A	<= 1.03	Accept/Reject
Gap depth	130.00	+/- .08	130.07	Accept/Reject
Flatness of front face	<= .05	N/A	<= .03	Accept/Reject
Perpendicularity of front face to A	<= .1	N/A	<= .035	Accept/Reject
End face perpendicularity to A and B	<= .05	N/A	<= 1.03 <= 1.03	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mullaz

TEST EQUIPMENT USED: SIG TRANSIT MODEL: 711010

COMMENTS: DROP INDICATOR S/N - 231067

DIAL MACHINE, INC.
2902 Eastrock Drive • Eastrock Industrial Park • P.O. Box 5246
Rockford, Illinois 61125
Phone 815/397-6660 • Fax 815/397-0562
www.dialmachine.com

Packing Slip No. 23072

Bill To

ARGONNE NATIONAL LABORATORY
ATTN: ACCOUNTS PAYABLE BLDG 201
9700 SOUTH CASS AVENUE
ARGONNE IL 60439-4874

Ship To

ARGONNE NATIONAL LABORATORY
ATTN: ACCOUNTS PAYABLE BLDG 201
9700 SOUTH CASS AVENUE
ARGONNE IL 60439-4874

Ship Date	03/14/2006
Your Order	5A-04889
FOB	ROCKFORD
Ship Via	OUR TRUCK
Terms	NET 30
Our Order	21279

Order Qty	Ship Qty	Part ID/Description	Rev	U/M
1	1	SA-381-000-86 REV 03 TITANIUM STRONGBACK		EA

INSPECTION REPORTS ENCLOSED
IMACHINED COMPLETE PER PRINT
THIS PART REPRESENTS -07

Strongback -L143-110700
Inspection and Test Results

Serial Number	#7		Inspector	Floyd
Date		1/23/06		

CMM Critical Feature Results	Req	Tolr	Actual	
flatness - plane -A-		.050	.026	
side opposite -A- flatness		.050	.026	
surface finish -A-	1.6		.6	
surface finish side opposite -A-	1.6		.8	
-B- surface flatness		.050	.034	
-B- surface perp to -A-		.100	.025	
Pads				
RH Mounting Pad parallel to -A-		.050	.025	
LH Mounting Pad parallel to -A-		.050	.025	
Overall Length	3400.00	+.000/-.200	3399.996	
LH end to 1700mm holes right	1700.00	+.000/-.100	1699.992	
LH end to 1700mm holes left	1700.00	+.000/-.100	1700.004	
side opposite -A- 167.00 dim	167.00	+.050/-.000	167.034	plane to plane
Individual Gaps	167.00		167.00 - 167.03	direct gaps
side -A- to Centerline 83.5	83.50	+/- .080	83.517	
Other Dimensions		*Date*	*Reviewer*	
		1-23	skl	no deviations to print

Certifications		*Date*	*Reviewer*	
Material Certs		11-9	skl	batch review Serial #1
Heat Treat Certs		11-9	skl	batch review Serial #1

Approvals	

Temps	
	Start
	Finish

3/14/2006

Serial # 7

LCLS Strongback

Deviations on Features not on Critical Feature List

Feature		Nominal	Tolr	Actual	Deviation	Comment
	167.00mm Gap	.167.0	+.050/-.000	167.00-167.030		temp measured at 70.2 deg F
	measured with temperature probe					
	per discussion with E. Trakhtenberg					

CORROSION MATERIALS TEST REPORT

2262 Groom Rd.
Baker, LA 70714
(225) 775 - 3675 (Main Office)
(225) 778 - 6436 (Quality Control)
(225) 778 - 6489 (Fax)

Date: 11/9/2005

Customer: DIAL MACHINE
PO No: 102437
Alloy: Ti GR2 Heat No: 063-1 CMI No: C71263
Item Description: 12" DIA RD BAR X R/L Quantity:

Specifications DIN 50049 3.1B ASTM B348, ASTM B381
EN 10204 3.1B

Chemical Components

C	CO	CR	CU	FE	MN	MO	NI	P	S
0.01	—	—	—	0.05	—	—	—	—	—
SI	TI	V	W	CB+TA	SN	AL	ZN	PB	N
—	—	—	—	—	—	—	—	—	0.013

Mechanical Properties

Tensile Strength:
Yield Strength:
Hardness:
Elongation in 2":
Reduction in Area:

Remarks: O=0.04, H=0.002, Ti=BAL

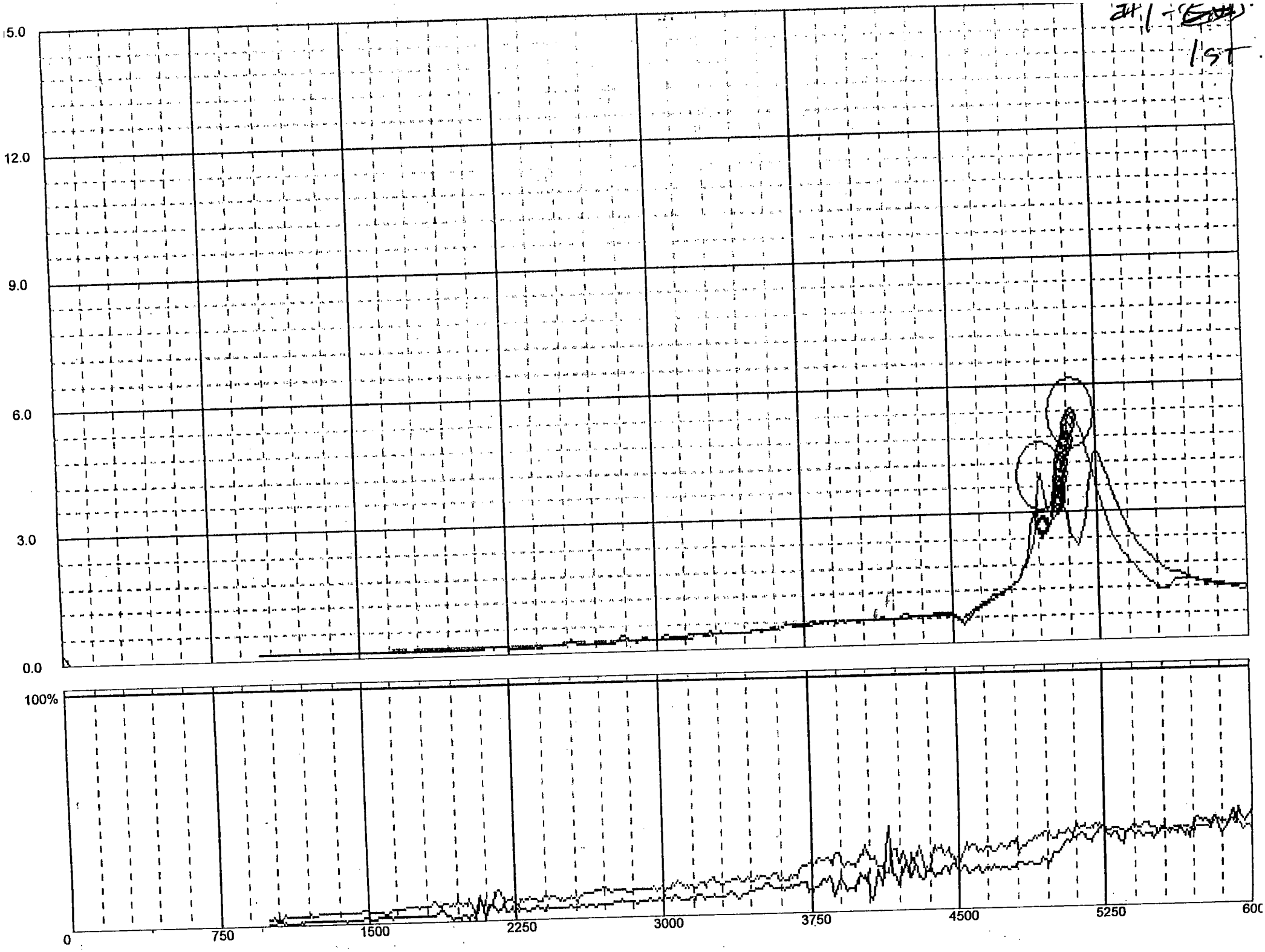
HEAT# PBA1063778 ANNEAI FCC 5 SOAK TIME 4HR SOAK TEMP 1250

The information stated in this document is true and accurate based upon information acquired by and maintained on file at Corrosion Materials.

Certified by: Tom Holstein

Title: Quality Control Coordinator

According to records provided by mill sources, all material has been manufactured free from mercury.
Corrosion Materials is an ISO 9001-2000 certified company, registered with RWTUV USA.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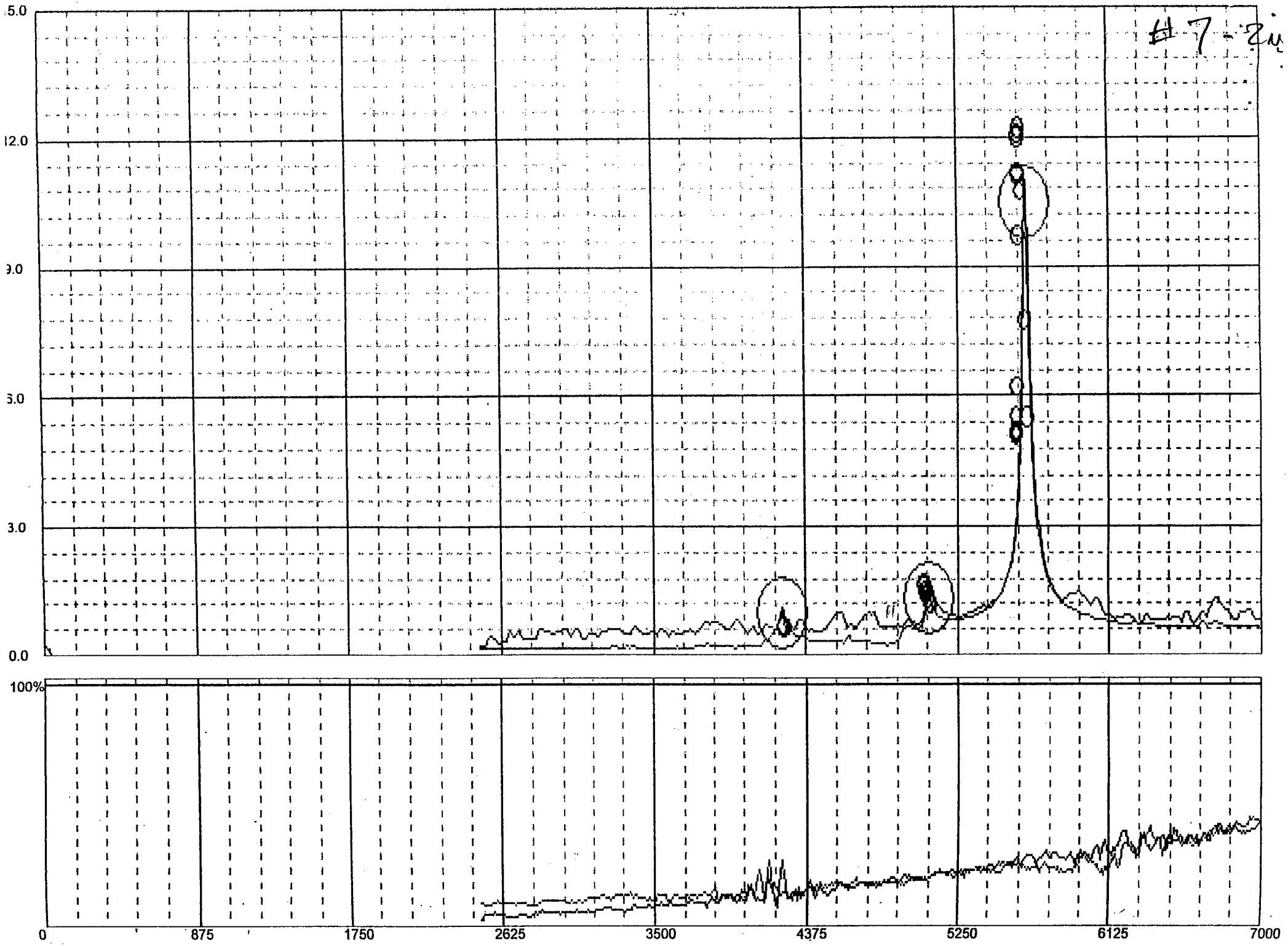
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INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111100-1-07

P.O. #: 5A13624 DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.988	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.97	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Nuelaze QA Supervisor: Nuelaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01

SERIAL #: L143-111100-2-07

P.O. #: 5A13624

DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.988	Accept/Reject
Bottom surface flatness	</= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.97	Accept/Reject
Overall width	128	+0 / -.1	127.99	Accept/Reject

INSPECTOR: Mulaze

QA Supervisor: Mulaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01

SERIAL #: L143-111100-3-07

P.O. #: 5A13624

DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.988	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.99	Accept/Reject
Overall width	128	+0 / -.1	128.00	Accept/Reject

INSPECTOR: Muelaza

QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01

SERIAL #: L143-111100-1-07

P.O. #:5A13624

DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.982	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.91	Accept/Reject
Overall width	128	+0 / -.1	127.92	Accept/Reject

INSPECTOR: Muñoz

QA Supervisor: Muñoz

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01 SERIAL #: L143-111100-2-07

P.O. #:5A13624 DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.982	Accept/Reject
Bottom surface flatness	</= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.972	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Mulaze QA Supervisor: Mulaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01

SERIAL #: L143-111100-3-07

P.O. #:5A13624

DATE: 05-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.0/29.982	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.95	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Mullaza

QA Supervisor: Mullaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Upper Left Magnet Structure Base

DRAWING #: L143-110801

SERIAL #: L143-110800-07

P.O. #: 5A13624

DATE: 05-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.998/29.987	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.012	Accept/Reject
Overall length	195	+0 / -.1	194.963	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Murtaza

QA Supervisor: Murtaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Lower Left Magnet Structure Base

DRAWING #: L143-110901

SERIAL #: L143-110900-07

P.O. #: 5A13624

DATE: 05-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.00/29.995	Accept/Reject
Bottom surface flatness	</= .04	N/A	.015	Accept/Reject
Overall length	195	+0 / -.1	194.95	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Muelage

QA Supervisor: Muelage

TEST EQUIPMENT USED: CMM & Micrometer .

COMMENTS: .

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc.

PART NAME: Lower Right Magnet Structure Base

DRAWING #: L143-111301

SERIAL #: L143-111300-07

P.O. #: 5A13624

DATE: 05-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 30.00/29.998	Accept/Reject
Bottom surface flatness	<= .04	N/A	0.015	Accept/Reject
Overall length	189	+0 / -.1	188.99	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Mulaze

QA Supervisor: Mulaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Right Magnet Structure Base

DRAWING #: L143-111201 SERIAL #: L143-111200-07

P.O. #: 5A13624 DATE: 05-14-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.997/29.999	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.02	Accept/Reject
Overall length	189	+0 / -.1	188.97	Accept/Reject
Overall width	128	+0 / -.1	127.96	Accept/Reject

INSPECTOR: Muklaza QA Supervisor: Muklaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01864

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01878

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: [illegible]

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01881

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01812

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01591

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Murleze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01876

P.O. #: SA 13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10		Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulay

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01694

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulaze

TEST EQUIPMENT USED: DROP INDICATOR

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01523

P.O. #: SA 13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mustafa

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01842

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulaja

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01445

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muler

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN - ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01501

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.03	Accept/Reject
Magnet Width	66.00	+/- .25	66.07	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullen

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106 – 04

SERIAL #: 01711

P.O. #: SA 13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Marlaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01698

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murtaza

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: Q1746

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muñoz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01780

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01882

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muñoz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01634

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01846

P.O. #: SA 13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murtaza

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN - ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106 - 04

SERIAL #: Q1862

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mustaza

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01641

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.94	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muelaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01627

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01761

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01887

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaze

TEST EQUIPMENT USED: DROP - INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01577

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01505

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Murlaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106 - 04

SERIAL #: 01603

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01649

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulleza

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106 – 04

SERIAL #: 01750

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01449

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.99	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullenga

TEST EQUIPMENT USED: DROP INDICATORS.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01534

P.O. #: SA13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simod

QA Supervisor: Mulaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01498

P.O. #: 5A 13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.03	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muellage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN - ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01660

P.O. #: SA13624

DATE: 5-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: [illegible]

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106

SERIAL #: 01488

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.99	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01892

P.O. #: SA-13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.99	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01645

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muelaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01532

P.O. #: 5A13624

DATE: 05-10-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mullaze

TEST EQUIPMENT USED: DROP GAGE. INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01726

P.O. #: 5A13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SMIN - ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01450

P.O. #: SA13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01530

P.O. #: 5A13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulaza

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01733

P.O. #: 5A13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01722

P.O. #: SA13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mullaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01584

P.O. #: SA13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.03	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muelaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01464

P.O. #: SA 13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.05	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Huelage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 0709

P.O. #: 5A13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.009	Accept/Reject
Magnet Width	66.00	+/- .25	66.04	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mulage

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106-04

SERIAL #: 01447

P.O. #: SA13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.965	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaz

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: SHIN-ETSU

PART NAME: LCLS Magnet

DRAWING #: L143-110106 — 04

SERIAL #: 01565

P.O. #: 5A13624

DATE: 05-09-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.06	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaze

TEST EQUIPMENT USED: DROP INDICATORS

COMMENTS: