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

Quality Assurance Traveler

ATTACH THIS FORM TO LCLS SYSTEMS AND COMPONENTS TO CONTROL THE SEQUENCE OF QUALITY ASSURANCE TASKS. RETURN THE COMPLETED TRAVELER TO THE LCLS QUALITY ASSURANCE COORDINATOR UPON COMPLETION.

System or Component Name: *LCLS Undulator Main Assembly*		
Part/Drawing Number: *L143-112000*	Revision: ____	Serial Number: 17
Manufacturer: Hi-Tech MFG		Purchase Order Number: 5A-13624

Special Instructions:

This form is to be completed prior to the acceptance of LCLS Undulator Main Assemblies

Quality Assurance Tasks (attach continuation sheets if additional steps are required)

Seq No.	Task Description *Inform the LCLS Technical Lead if a task cannot be competed or a requirement met	Completed by/Date*	Requirement Met	Requirement Not Met*
1	*Perform visual inspection of the completed assembly for workmanship and correctness.*	not req'd	☑	☐
2	*Perform visual inspection of the completed assembly for correct the following markings on the Strongback:* L143-11200-05 SA-381-001-35 Serial number same as the Strongback	not req'd	☑	☐
3	*Perform visual inspection of the completed assembly for correct the following markings on the Magnet Structure Assemblies:* • Upper Left Magnet Structure Assemblies: L-143-110800-assembly no. • Upper Right Magnet Structure Assemblies: L143-111200-assembly no. • Upper Middle Magnet Structure Assemblies: L143-111000-1,2,3-assembly no. • Lower Left Magnet Structure Assemblies: 143-110900-assembly serial no. • Lower Right Magnet Structure Assemblies: L143-111300-assembly serial no. • Lower Middle Magnet Structure Assemblies: L143-111100-1,2-3-assembly no.	not req'd	☑	☐
4	*Verify correct gap size along the entire undulator length using contactor's go/no-go gages.*	E T 3/4/06	☐	☐
5	*Verify correct gap size along the entire undulator length using calibrated gage blocks.*	ET 3/4/06	☑	☐
6	*Check the peak field at each magnet location using a portable Hall probe.*	ET 3/4/06	☑	☐
7	*Verify that the following quality assurance documentation has been completed by the contractor:* • ANL Acceptance Criteria Listings E5-026046, E5-020020, E5-069069 • LCLS Inspection/Acceptance Report for LCLS Magnets • LCLS Inspection/Acceptance Report for Supplier Inspection form for LCLS Magnet Assemblies • Magnet Sort List • Photographs showing correct magnet serial numbers and orientation • ANL Supplier Disposition Reports documenting any noncomformance to specifications drawings or other contract requirements	not req'd	☑	☐
8	*Verify that the magnet photographs of the magnet sub assemblies are in agreement with the magnet sort list.*	not req'd	☑	☐
9	*Review shipping container and that the contractor has Shockwatch monitoring devices available*	not req'd	☑	☐
10	*Forward completed traveler form to LCLS QA Coordinator Tom Barsz. B401, C4243.*		☐	☐

LCLS Task Leader Pre-Approval: _____ **Date:** _____

LCLS QA Coordinator Pre-Approval: _____ **Date:** _____

Optional Approver Comments:

Distribute completed traveler to: **Responsible Engineer, Task Leader, LCLS Quality Assurance Coordinator, Chief Engineer**

Other: _____

Enter Quality Improvements Lessons-Learned resulting from this activity below.

ARGONNE NATIONAL LABORATORY

ACCEPTANCE CRITERIA LISTING

1. DISTRIBUTION:

INSPECTION REQUIRED: ☑

4. ORIGINATOR'S NAME & DIVISION: Glen Lawrence/XFD 5. PHONE: 2-9298 6. DATE: 06/13/2005

9. FOR INSPECTION, DELIVER TO BLDG. NO.: DIVISION: XFD ATTN.: G. Lawrence

10. AFTER INSPECTION, DELIVER TO BLDG. NO.: SLAC DIVISION: LCLS ATTN.:

11. REFERENCES AND/OR REMARKS:

Item may be inspected by LCLS QA at Contractor site prior to shipment with follow-up inspection at receiving site. First Articles from each of the two contractors are to be shipped to ANL/APS to be magnetically shimmed and characterized in the APS Magnet Measurement room. The 38 remaining units shall be shipped directly to SLAC to be magnetically shimmed and characterized in the LCLS Magnet Measurement room.

15. ORIGINATOR OF PLAN: Glen Lawrence DATE: 06/13/2005

16. PLAN REVIEWED/APPROVED BY: DATE: 00/00/0000

17. QAR CONCURRENCE WITH PLAN: DATE: 00/00/0000

3. ACL NO.: E5-164018 LINE NBR: 1

7. PART NO. & NAME: L143-112000 LCLS Undulator Main Assy. 8. QUANTITY: 2

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
1	Inspect shipping container for evidence of damage or rough handling	eceiving / Inspectic	SLAC	
2	Inspect shipping sensors for record of temperature variations and shock/g loads in x,y and z during shipping	eceiving / Inspectic	SLAC	
3	Review all required certifications for compliance and completeness	actor Fac. or Rec.	TM	11/6/06
4	Visual inspection of Undulator Assy for shipping damage	eceiving / Inspectic	SLAC	
5	Visual inspection of Undulator Assy for completeness to print, including all loose parts	actor Fac. or Rec.	SLAC	

ARGONNE NATIONAL LABORATORY

ACCEPTANCE CRITERIA LISTING

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
6	Verify Undulator gap using Go-NoGo gauge	Contractor Facility		8/4/06

Not Required Fields

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ACCEPTANCE CRITERIA LISTING

1. DISTRIBUTION:

INSPECTION REQUIRED: ☑

4. ORIGINATOR'S NAME & DIVISION: Glen Lawrence/XFD 5. PHONE: 2-9298 6. DATE: 01/25/2005

9. FOR INSPECTION, DELIVER TO BLDG. NO.: N/A DIVISION: ATTN.:

10. AFTER INSPECTION, DELIVER TO BLDG. NO.: NA DIVISION: ATTN.:

11. REFERENCES AND/OR REMARKS:

The Magnet Poles are to be delivered to the Undulator Assembly Contractors by the Machining Contractor. Undulator Assembly Contractor shall inspect the Magnet Poles prior to acceptance. ANL shall review all Certifications and Machining Contractor's reported measurements & optionally perform on-site inspections.

15. ORIGINATOR OF PLAN: Glen Lawrence DATE: 01/27/2005

16. PLAN REVIEWED/APPROVED BY: DATE: 00/00/0000

17. QAR CONCURRENCE WITH PLAN: DATE: 00/00/0000

3. ACL NO.: E5-026046 LINE NBR: 1

7. PART NO. & NAME: L143-110105 Upper Magnet Structure Pole 8. QUANTITY: 192

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
1	Visual inspection of parts for shipping damage	ulator Assy Contra	H. Tech	8/4/05
2	Check that parts were "bagged and tagged" with serial no.'s and part no.'s (ANL & SLAC) per SOW L143-00031, Section 4.1.3	ulator Assy Contra		
3	Check that parts were marked with serial numbers per SOW section 4.1.3.	ulator Assy Contra		
4	Check that accompanying certifications have correct part serial numbers	ulator Assy Contra		
5	Check the material certification for compliance with ASTM A801, Type 1	tor Assy Contracto		

ARGONNE NATIONAL LABORATORY

ACCEPTANCE CRITERIA LISTING

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
6	Check the anneal certification for compliance with AMS-A801, or a specified material supplier's annealing schedule.	tor Assy Contracto	H. Tay	8/4/6
7	Check that the machining Contractor's certified dimensional measurements are in compliance with the drawing	ANL	T M	11/6/06
8	Verify the critical dimensions as listed in the SOW, Section 4.5.2 are in compliance with the drawing	ulator Assy Contra	H. Tay	8/4/06

Not Required Fields

ARGONNE NATIONAL LABORATORY

ACCEPTANCE CRITERIA LISTING

1. DISTRIBUTION:

INSPECTION REQUIRED: ☑

4. ORIGINATOR'S NAME & DIVISION: Glen Lawrence/XFD 5. PHONE: 2-9298 6. DATE: 03/10/2005

9. FOR INSPECTION, DELIVER TO BLDG. NO.: 401 DIVISION: XFD ATTN.: Glen Lawrence

10. AFTER INSPECTION, DELIVER TO BLDG. NO.: 401 DIVISION: XFD ATTN.: Glen Lawrence

11. REFERENCES AND/OR REMARKS:

Most of the magnets will be drop shipped directly to the Undulator Assembly Contractor, who will only perform limited physical inspection of the parts as they are highly magnetized. A sampling from each lot will be sent to ANL for verification of the magnetic field properties.

15. ORIGINATOR OF PLAN: Glen Lawrence DATE: 02/07/2005

16. PLAN REVIEWED/APPROVED BY: DATE: 00/00/0000

17. QAR CONCURRENCE WITH PLAN: DATE: 00/00/0000

3. ACL NO.: E5-069069 LINE NBR: 1

7. PART NO. & NAME: L143-110106 Upper Left Magnet Structure 8. QUANTITY: 192

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
1	Visual inspection of parts for shipping damage	ulator Ass'y Contra	H. Tah	8/4/04
2	Visual inspection of parts for surface chips and pits	ulator Ass'y Contra	↓	↓
3	Dimensional check of part for conformance to the drawing	ulator Ass'y Contra	↓	↓
4	Review vendor certified test data agrees with SOW requirements	APS Bldg 401	TMz	11/6/04
5	Review Vendor sort list for agreement with sort procedure.	APS Bldg 401	TMz	11/6/04

Not Required Fields

ARGONNE NATIONAL LABORATORY

ACCEPTANCE CRITERIA LISTING

12. STEP NO.	13. INSPECTION/TEST REQUIREMENT	14. INSPECTION TEST LOCATION	18. ACCEPTED BY OR NONCONFORMANCE REPORT NO.	19. DATE
6	On random sampling, inspect magnetic field with magnetic visualization film for magnetic defects.	APS Magnet Group	SS [signature]	11/6/06
7	On random sampling, confirm Magnetic Moment magnitude and vector components agree with vendor reports	APS Magnet Group	SS S.S	
8	On radom sampling, verify the magnet s demagnetization and thermal stability.	APS Magnet Group	SS S.S	

#17

LOT11 magnets					
Slot No	12.	Slot No		Slot Number	
1	–	51	65	100	70
2	–	52	71	101	73
3	97	53	73	102	71
4	– 66	54	73	103	77
5	75	55	72	104	61
6	– 76	56	77	105	60
7	69	57	74	106	73
8	– 71	58	75	107	69
9	72	59	74	108	83
10	– 79	60	77	109	79
11	. ~~72~~	61	69	110	75
12	– 78	62	71	111	74
13	68	63	75	112	75
14	– 74	64	75	113	74
15	73	65	73	114	77
16	81	66	69	115	75
17	88	67	76	116	61
18	83	68	77	117	74
19	68	69	67	118	80
20	70	70	68	119	74
21	86	71	75	120	73
22	72	72	73	121	75
23	74	73	73	122	75
24	79	74	76	123	75
25	77	75	75	124	78
26	76	76	76	125	71
27	75	77	~~69~~	126	62
28	70	78	64	127	67
29	71	79	70	128	70
30	71	80	73	129	72
31	74	81	77	130	78
32	72	82	74	131	77
33	69	83	66	132	67
34	75	84	~~61~~ 74	133	76
35	75	85	82	134	83
36	76	86	73	135	70
37	73	87	78	136	72
38	62	88	76	137	63
39	75	89	78	138	76
40	74	90	75	139	74
41	78	91	65	140	75
42	81	92	78	141	75
43	72	93	82	142	68
44	68	94	83	143	72
45	63	95	74	144	72
46	65	96	77	145	63
47	74	97	76	146	66
48	~~69~~	98	79	147	61
49	79	99	78	148	67
50	77			149	66

Slot Number		Slot Number	
150	72	200	71
151	73	201	60
152	75	202	72
153	71	203	71
154	76	204	65
155	68	205	73
156	72	206	70
157	75	207	74
158	75	208	74
159	78	209	60
160	80	210	69
161	64	211	69
162	73	212	63
163	71	213	66
164	69	214	73
165	78	215	68
166	72	216	68
167	81	217	76
168	72	218	74
169	68	219	66
170	75	220	72
171	70	221	63
172	72	222	74
173	61	223	15
174	69	224	
175	75	225	
176	76		
177	74		
178	72		
179	75		
180	60		
181	71		
182	73		
183	76		
184	82		
185	77		
186	77		
187	73		
188	72		
189	66		
190	73		
191	63		
192	70		
193	76		
194	71		
195	71		
196	69		
197	69		
198	63		
199	61		

Device #17, Lot#1.

Accepted 08/04/06

Nash

Shigeki Sasaki

#17

LOT11 magnets Serial # 4801-5280

Bottom Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	5047	Upstream	Right
2	4858	Downstream	Right
3	5117	Upstream	Left
4	4962	Downstream	Right
5	4974	Upstream	Left
6	4926	Downstream	Left
7	5254	Upstream	Right
8	5226	Downstream	Right
9	4969	Upstream	Left
10	5125	Downstream	Left
11	5130	Upstream	Right
12	5129	Downstream	Right
13	4994	Upstream	Right
14	4984	Downstream	Right
15	5095	Upstream	Right
16	5265	Downstream	Left
17	5155	Upstream	Left
18	5206	Downstream	Left
19	5065	Upstream	Left
20	5084	Downstream	Right
21	4932	Upstream	Right
22	4886	Downstream	Left
23	5216	Upstream	Left
24	4905	Downstream	Right
25	5131	Upstream	Right
26	5193	Downstream	Left
27	5205	Upstream	Left
28	5183	Downstream	Right
29	5145	Upstream	Right
30	4924	Downstream	Left
31	5114	Upstream	Right
32	4920	Downstream	Left
33	5012	Upstream	Left
34	4829	Downstream	Left
35	5000	Upstream	Right
36	5204	Downstream	Right
37	5243	Upstream	Right
38	4911	Downstream	Right
39	5249	Upstream	Left
40	5196	Downstream	Left
41	5032	Upstream	Left
42	5262	Downstream	Left
43	5049	Upstream	Left
44	4803	Downstream	Left
45	5082	Upstream	Left
46	5218	Downstream	Right
47	5108	Upstream	Right

Top Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	4903	Downstream	Left
2	4806	Upstream	Right
3	4859	Downstream	Left
4	5091	Upstream	Left
5	4856	Downstream	Right
6	4951	Upstream	Left
7	5199	Downstream	Right
8	5089	Upstream	Right
9	4853	Downstream	Right
10	5016	Upstream	Right
11	4918	Downstream	Right
12	5170	Upstream	Left
13	5208	Downstream	Right
14	4928	Upstream	Right
15	4997	Downstream	Left
16	5037	Upstream	Right
17	4913	Downstream	Left
18	5132	Upstream	Right
19	4844	Downstream	Left
20	5189	Upstream	Right
21	4892	Downstream	Left
22	5017	Upstream	Left
23	5275	Downstream	Left
24	5071	Upstream	Right
25	5027	Downstream	Right
26	5035	Upstream	Right
27	4834	Downstream	Left
28	5173	Upstream	Left
29	4925	Downstream	Left
30	4802	Upstream	Right
31	4906	Downstream	Left
32	4809	Upstream	Left
33	4959	Downstream	Right
34	4838	Upstream	Right
35	5174	Downstream	Right
36	5043	Upstream	Right
37	4930	Downstream	Left
38	5076	Upstream	Right
39	5264	Downstream	Left
40	4956	Upstream	Left
41	4845	Downstream	Right
42	4831	Upstream	Right
43	4960	Downstream	Right
44	5002	Upstream	Right
45	4887	Downstream	Right
46	4961	Upstream	Right
47	5237	Downstream	Right

48	4882	Downstream	Right
49	4937	Upstream	Right
50	5270	Downstream	Right
51	5185	Upstream	Right
52	4908	Downstream	Right
53	4867	Upstream	Right
54	5267	Downstream	Right
55	5163	Upstream	Right
56	5138	Downstream	Left
57	4978	Upstream	Right
58	4895	Downstream	Left
59	5134	Upstream	Left
60	5088	Downstream	Left
61	5113	Upstream	Right
62	4927	Downstream	Right
63	5022	Upstream	Right
64	5194	Downstream	Right
65	5233	Upstream	Left
66	4910	Downstream	Right
67	5179	Upstream	Left
68	4832	Downstream	Left
69	5074	Upstream	Right
70	4817	Downstream	Right
71	5245	Upstream	Right
72	5097	Downstream	Right
73	5119	Upstream	Right
74	5230	Downstream	Right
75	5202	Upstream	Right
76	5115	Downstream	Left
77	5228	Upstream	Left
78	4967	Downstream	Right
79	5142	Upstream	Right
80	4945	Downstream	Left
81	4837	Upstream	Left
82	5176	Downstream	Left
83	4848	Upstream	Right
84	5160	Downstream	Left
85	4998	Upstream	Right
86	4825	Downstream	Right
87	5221	Upstream	Left
88	5217	Downstream	Left
89	5203	Upstream	Right
90	5045	Downstream	Left
91	5111	Upstream	Right
92	5161	Downstream	Right
93	5039	Upstream	Left
94	5128	Downstream	Left
95	4816	Upstream	Left
96	4891	Downstream	Left
97	5190	Upstream	Right
98	5028	Downstream	Right
99	4855	Upstream	Left

48	4942	Upstream	Right
49	4914	Downstream	Right
50	5241	Upstream	Left
51	5240	Downstream	Left
52	5003	Upstream	Left
53	4902	Downstream	Left
54	4996	Upstream	Right
55	5014	Downstream	Left
56	5162	Upstream	Right
57	5231	Downstream	Left
58	5126	Upstream	Right
59	4821	Downstream	Right
60	5059	Upstream	Left
61	5232	Downstream	Right
62	4991	Upstream	Left
63	5122	Downstream	Right
64	5144	Upstream	Right
65	4995	Downstream	Left
66	5146	Upstream	Right
67	4850	Downstream	Right
68	5152	Upstream	Right
69	4986	Downstream	Right
70	5046	Upstream	Right
71	4981	Downstream	Left
72	5070	Upstream	Left
73	5200	Downstream	Left
74	5123	Upstream	Right
75	4948	Downstream	Right
76	4815	Upstream	Left
77	4949	Downstream	Left
78	5148	Upstream	Right
79	4953	Downstream	Left
80	5169	Upstream	Right
81	5038	Downstream	Right
82	5149	Upstream	Left
83	5244	Downstream	Right
84	5177	Upstream	Right
85	4964	Downstream	Left
86	5172	Upstream	Left
87	5075	Downstream	Right
88	4929	Upstream	Left
89	4950	Downstream	Right
90	5120	Upstream	Right
91	4896	Downstream	Left
92	4810	Upstream	Left
93	4885	Downstream	Right
94	5062	Upstream	Right
95	5008	Downstream	Right
96	4933	Upstream	Right
97	4963	Downstream	Right
98	5239	Upstream	Right
99	5072	Downstream	Left

100	5112	Downstream	Right
101	4992	Upstream	Right
102	4833	Downstream	Left
103	5052	Upstream	Left
104	4872	Downstream	Left
105	4938	Upstream	Left
106	5150	Downstream	Right
107	4811	Upstream	Left
108	5257	Downstream	Right
109	4846	Upstream	Right
110	5073	Downstream	Right
111	4954	Upstream	Left
112	5238	Downstream	Left
113	5223	Upstream	Right
114	5227	Downstream	Left
115	4955	Upstream	Left
116	4808	Downstream	Left
117	4805	Upstream	Right
118	4965	Downstream	Left
119	5277	Upstream	Right
120	5271	Downstream	Left
121	5266	Upstream	Left
122	5135	Downstream	Right
123	4944	Upstream	Left
124	4861	Downstream	Left
125	4988	Upstream	Left
126	5029	Downstream	Right
127	5020	Upstream	Right
128	5124	Downstream	Left
129	5192	Upstream	Right
130	5214	Downstream	Left
131	5165	Upstream	Left
132	5178	Downstream	Left
133	5274	Upstream	Right
134	4813	Downstream	Right
135	5031	Upstream	Right
136	4934	Downstream	Left
137	5099	Upstream	Right
138	5258	Downstream	Left
139	4946	Upstream	Left
140	4971	Downstream	Left
141	5066	Upstream	Right
142	4957	Downstream	Left
143	5010	Upstream	Left
144	5063	Downstream	Left
145	5133	Upstream	Left
146	4818	Downstream	Left
147	5247	Upstream	Right
148	4921	Downstream	Left
149	5116	Upstream	Left
150	4881	Downstream	Left
151	5100	Upstream	Right

100	5251	Upstream	Right
101	5181	Downstream	Right
102	5253	Upstream	Right
103	4897	Downstream	Right
104	5279	Upstream	Left
105	5006	Downstream	Left
106	5085	Upstream	Left
107	5013	Downstream	Right
108	5153	Upstream	Right
109	4871	Downstream	Left
110	5040	Upstream	Left
111	5087	Downstream	Right
112	4912	Upstream	Left
113	4879	Downstream	Right
114	5033	Upstream	Left
115	4824	Downstream	Left
116	5269	Upstream	Right
117	4989	Downstream	Left
118	4842	Upstream	Left
119	5159	Downstream	Right
120	4907	Upstream	Right
121	5186	Downstream	Left
122	5141	Upstream	Right
123	4968	Downstream	Left
124	5220	Upstream	Left
125	5212	Downstream	Right
126	5098	Upstream	Right
127	4939	Downstream	Left
128	5167	Upstream	Right
129	5081	Downstream	Right
130	5077	Upstream	Left
131	4917	Downstream	Left
132	5042	Upstream	Right
133	5263	Downstream	Right
134	5015	Upstream	Right
135	4875	Downstream	Right
136	4828	Upstream	Right
137	5224	Downstream	Right
138	5018	Upstream	Right
139	5219	Downstream	Right
140	4863	Upstream	Left
141	4854	Downstream	Left
142	5184	Upstream	Left
143	5246	Downstream	Right
144	5105	Upstream	Right
145	5195	Downstream	Right
146	5079	Upstream	Right
147	5068	Downstream	Left
148	5158	Upstream	Right
149	5121	Downstream	Right
150	4999	Upstream	Left
151	5104	Downstream	Left

152	4823	Downstream	Right
153	4987	Upstream	Left
154	5154	Downstream	Left
155	5136	Upstream	Left
156	4990	Downstream	Right
157	4980	Upstream	Right
158	4826	Downstream	Right
159	4812	Upstream	Left
160	5093	Downstream	Right
161	5280	Upstream	Right
162	4873	Downstream	Right
163	5234	Upstream	Left
164	4947	Downstream	Right
165	5092	Upstream	Right
166	5252	Downstream	Left
167	5021	Upstream	Right
168	4827	Downstream	Right
169	5137	Upstream	Right
170	5229	Downstream	Right
171	5025	Upstream	Right
172	5127	Downstream	Left
173	4976	Upstream	Right
174	4884	Downstream	Right
175	4868	Upstream	Right
176	4915	Downstream	Right
177	5055	Upstream	Left
178	5259	Downstream	Left
179	5140	Upstream	Right
180	4841	Downstream	Left
181	5060	Upstream	Left
182	4888	Downstream	Left
183	5050	Upstream	Right
184	5211	Downstream	Right
185	5235	Upstream	Right
186	5191	Downstream	Left
187	5250	Upstream	Right
188	4909	Downstream	Left
189	4840	Upstream	Right
190	5213	Downstream	Left
191	4862	Upstream	Right
192	4890	Downstream	Left
193	5005	Upstream	Right
194	4877	Downstream	Right
195	5225	Upstream	Left
196	5067	Downstream	Left
197	4952	Upstream	Left
198	4874	Downstream	Left
199	5007	Upstream	Left
200	5209	Downstream	Right
201	5102	Upstream	Left
202	4864	Downstream	Right
203	5086	Upstream	Left

152	4931	Upstream	Right
153	5180	Downstream	Left
154	4866	Upstream	Left
155	4982	Downstream	Right
156	5248	Upstream	Right
157	4983	Downstream	Right
158	5168	Upstream	Left
159	4876	Downstream	Right
160	5242	Upstream	Right
161	4820	Downstream	Right
162	5048	Upstream	Left
163	4919	Downstream	Right
164	4972	Upstream	Right
165	4899	Downstream	Right
166	5215	Upstream	Right
167	5151	Downstream	Left
168	4977	Upstream	Left
169	4898	Downstream	Right
170	5107	Upstream	Right
171	5182	Downstream	Right
172	5083	Upstream	Right
173	5273	Downstream	Left
174	4839	Upstream	Right
175	4865	Downstream	Right
176	4804	Upstream	Left
177	4819	Downstream	Left
178	5156	Upstream	Right
179	4894	Downstream	Left
180	5166	Upstream	Right
181	5175	Downstream	Left
182	5096	Upstream	Right
183	4835	Downstream	Right
184	4940	Upstream	Right
185	4893	Downstream	Left
186	5026	Upstream	Right
187	5188	Downstream	Right
188	4979	Upstream	Right
189	5222	Downstream	Right
190	5164	Upstream	Left
191	5201	Downstream	Right
192	5272	Upstream	Right
193	5256	Downstream	Right
194	4870	Upstream	Right
195	4869	Downstream	Left
196	4966	Upstream	Right
197	4900	Downstream	Left
198	5110	Upstream	Right
199	5207	Downstream	Right
200	5041	Upstream	Left
201	5261	Downstream	Right
202	4973	Upstream	Left
203	4958	Downstream	Right

204	4889	Downstream	Right
205	5078	Upstream	Left
206	4843	Downstream	Right
207	5058	Upstream	Right
208	5019	Downstream	Right
209	5011	Upstream	Left
210	4943	Downstream	Left
211	5036	Upstream	Left
212	4880	Downstream	Right
213	5057	Upstream	Right
214	4878	Downstream	Left
215	5106	Upstream	Right
216	4847	Downstream	Right
217	5236	Upstream	Left
218	5198	Downstream	Right
219	5069	Upstream	Right
220	5210	Downstream	Right
221	5143	Upstream	Right
222	4904	Downstream	Left
223	5109	Upstream	Right
224	4923	Downstream	Left
225	4935	Upstream	Right

204	5030	Upstream	Right
205	5276	Downstream	Left
206	5001	Upstream	Left
207	4836	Downstream	Right
208	5023	Upstream	Right
209	5139	Downstream	Right
210	5147	Upstream	Left
211	5268	Downstream	Right
212	5094	Upstream	Right
213	4857	Downstream	Right
214	4814	Upstream	Left
215	4916	Downstream	Left
216	5054	Upstream	Right
217	4985	Downstream	Left
218	5064	Upstream	Right
219	4822	Downstream	Left
220	5024	Upstream	Right
221	4901	Downstream	Right
222	4975	Upstream	Left
223	5260	Downstream	Left
224	4993	Upstream	Right
225	4860	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 Right and Left 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.

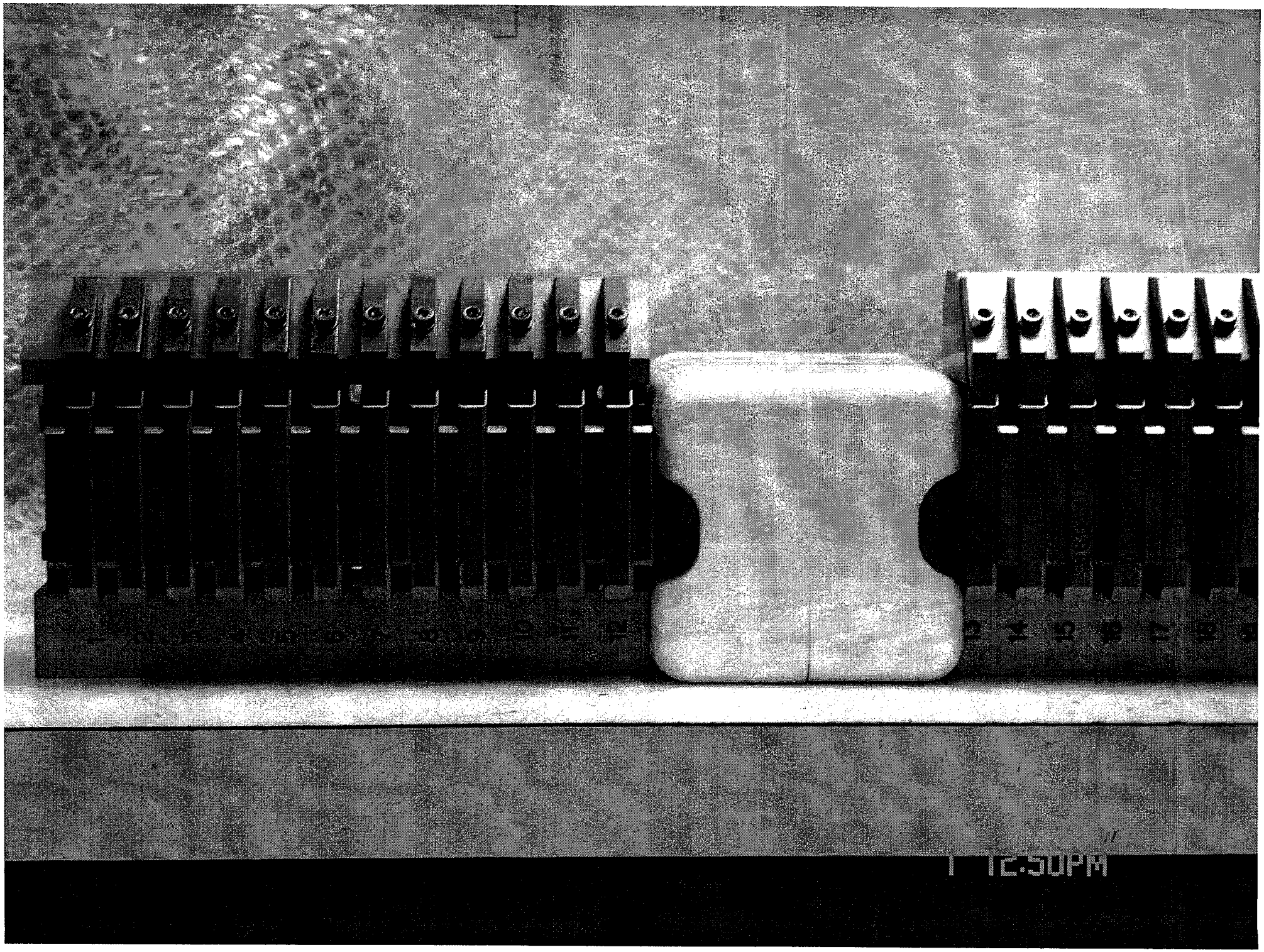
Spare magnets

serial No.	Reduced Magnetization
4922	33%
5056	80%
5004	
5118	
5051	
4807	
4883	
5044	
5197	
5034	
5187	
5053	

Sample magnets

serial No.	
4830	
4936	
5080	
5171	
5255	broken-unusable

4851
5101
4970
5090
4801
5157
4852
4849
5061
5009
4941
5278
5103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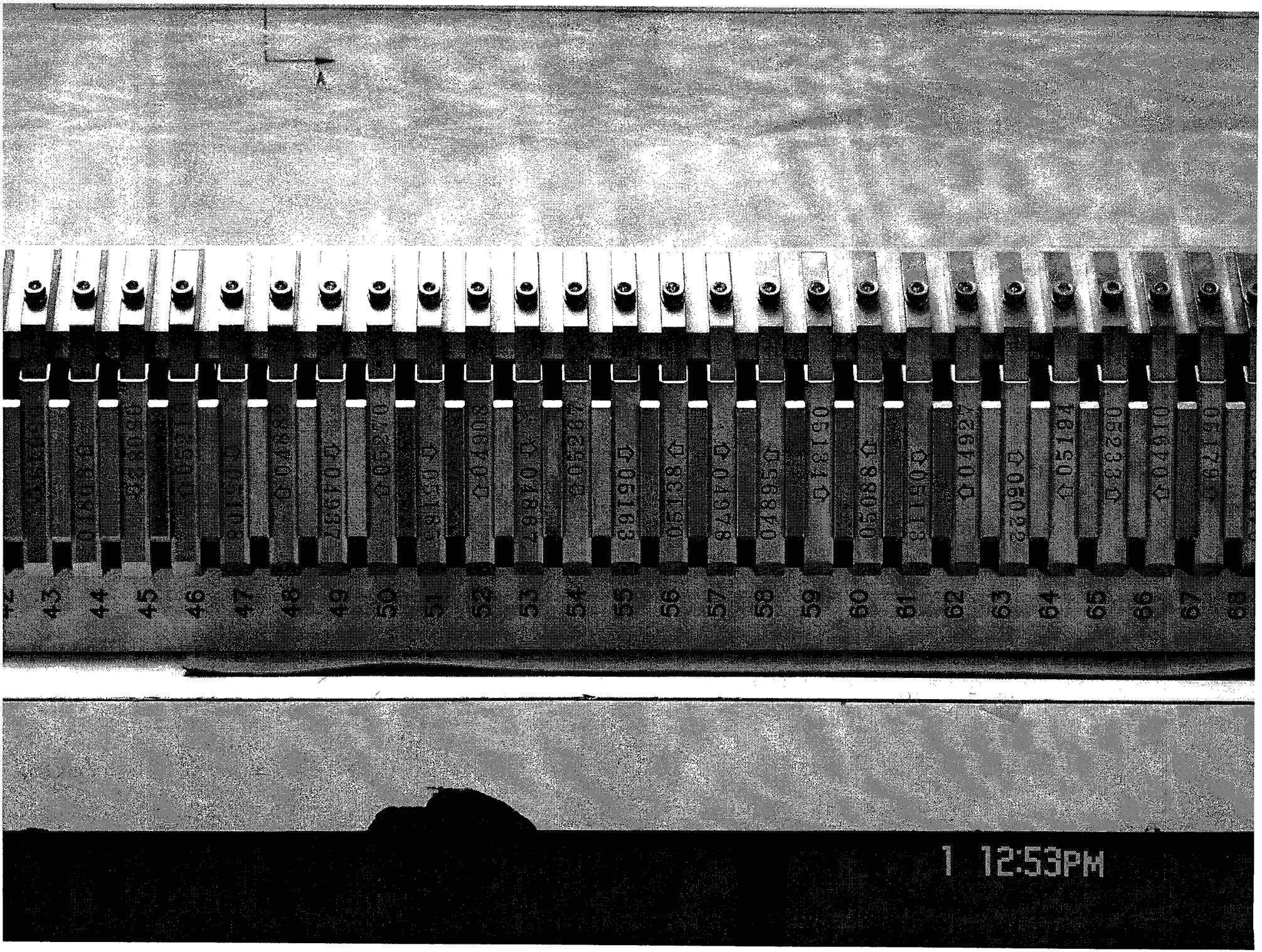
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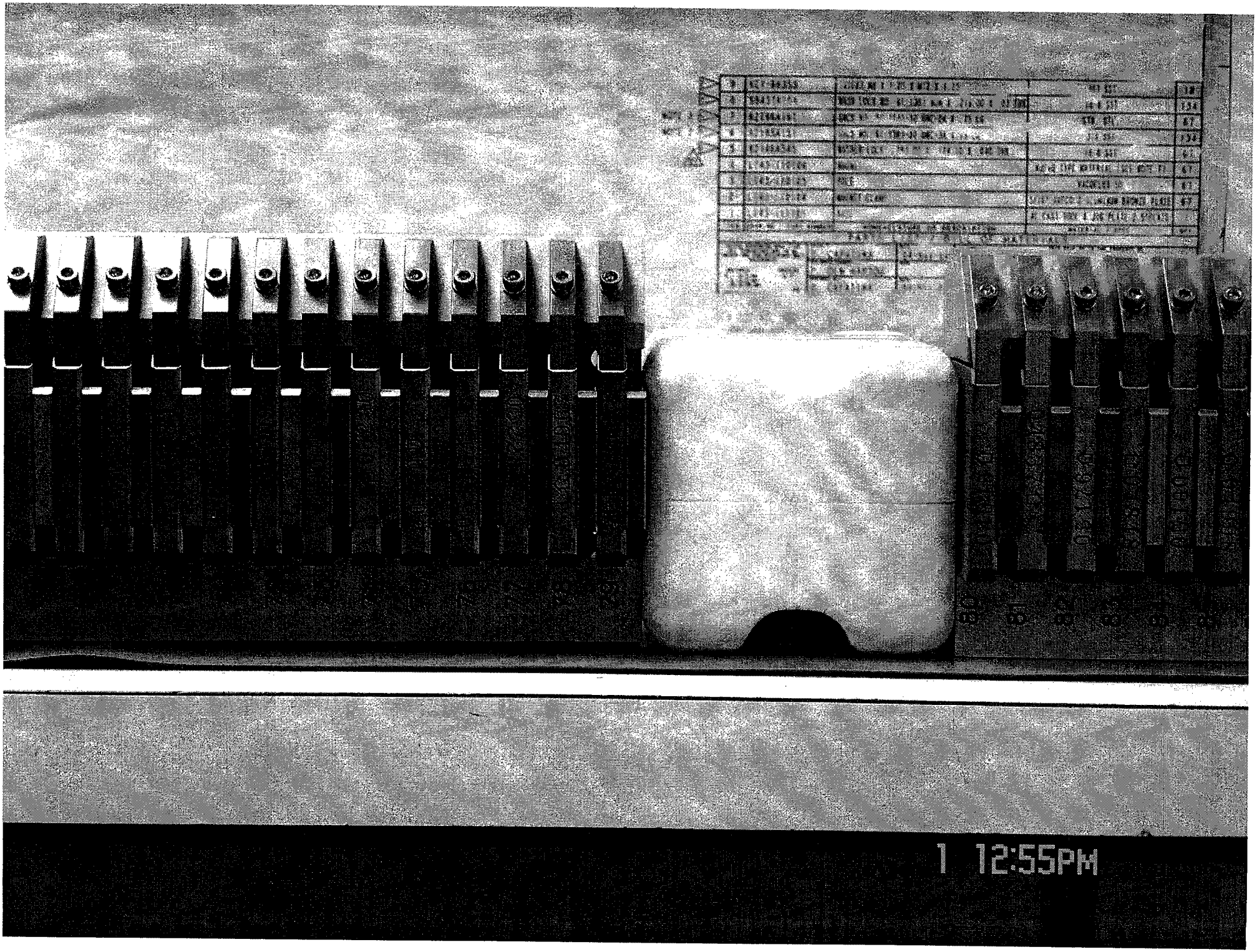
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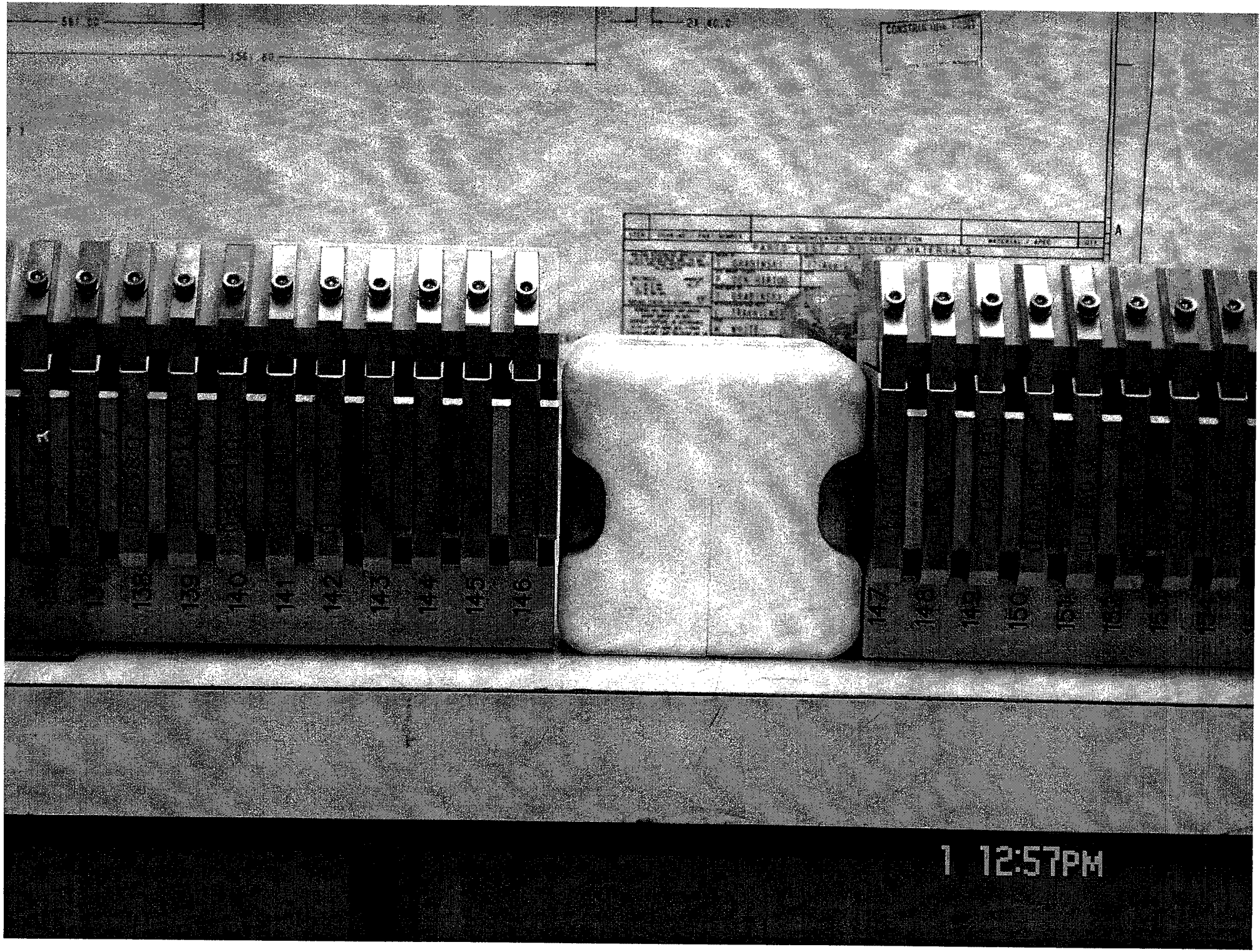
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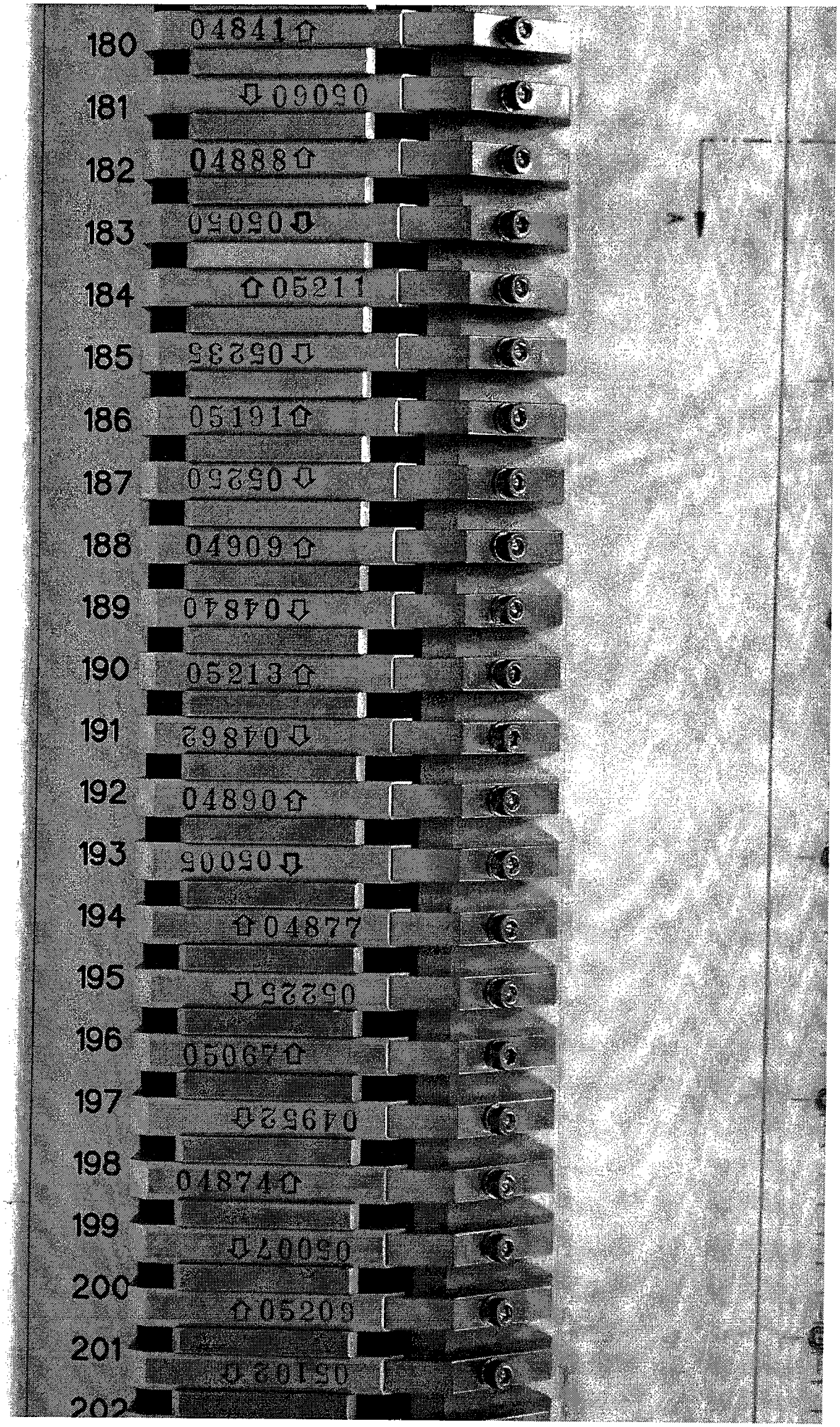
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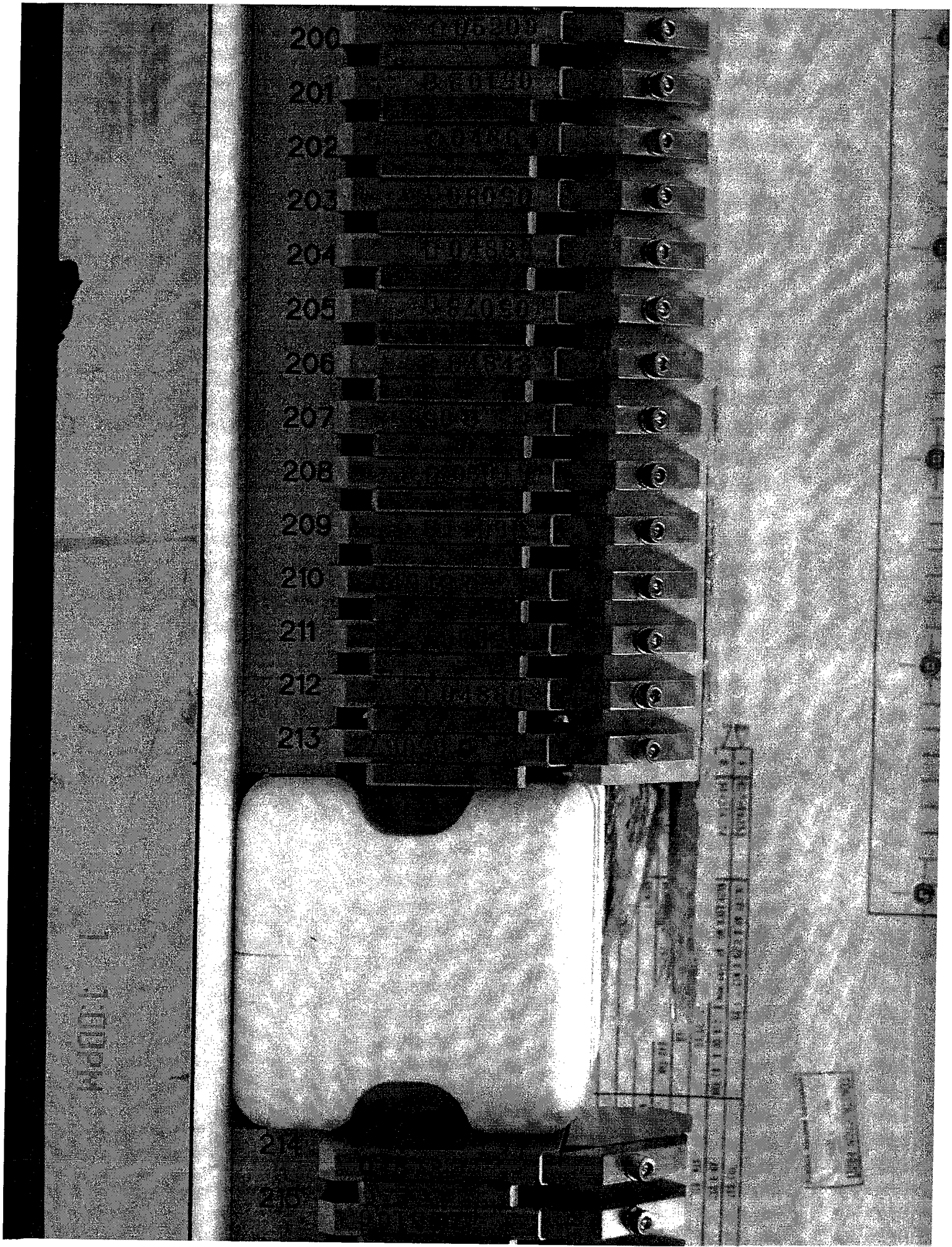
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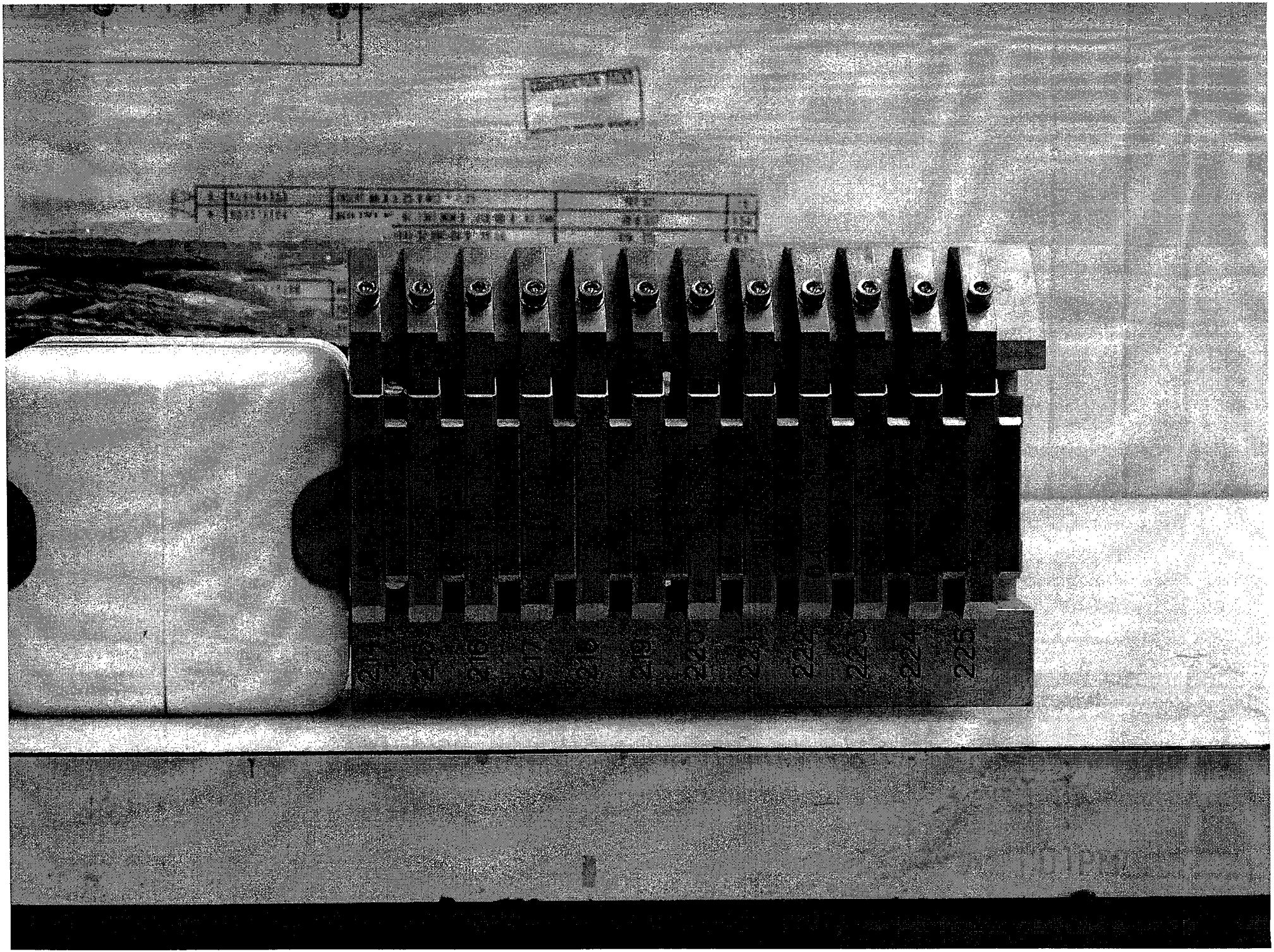
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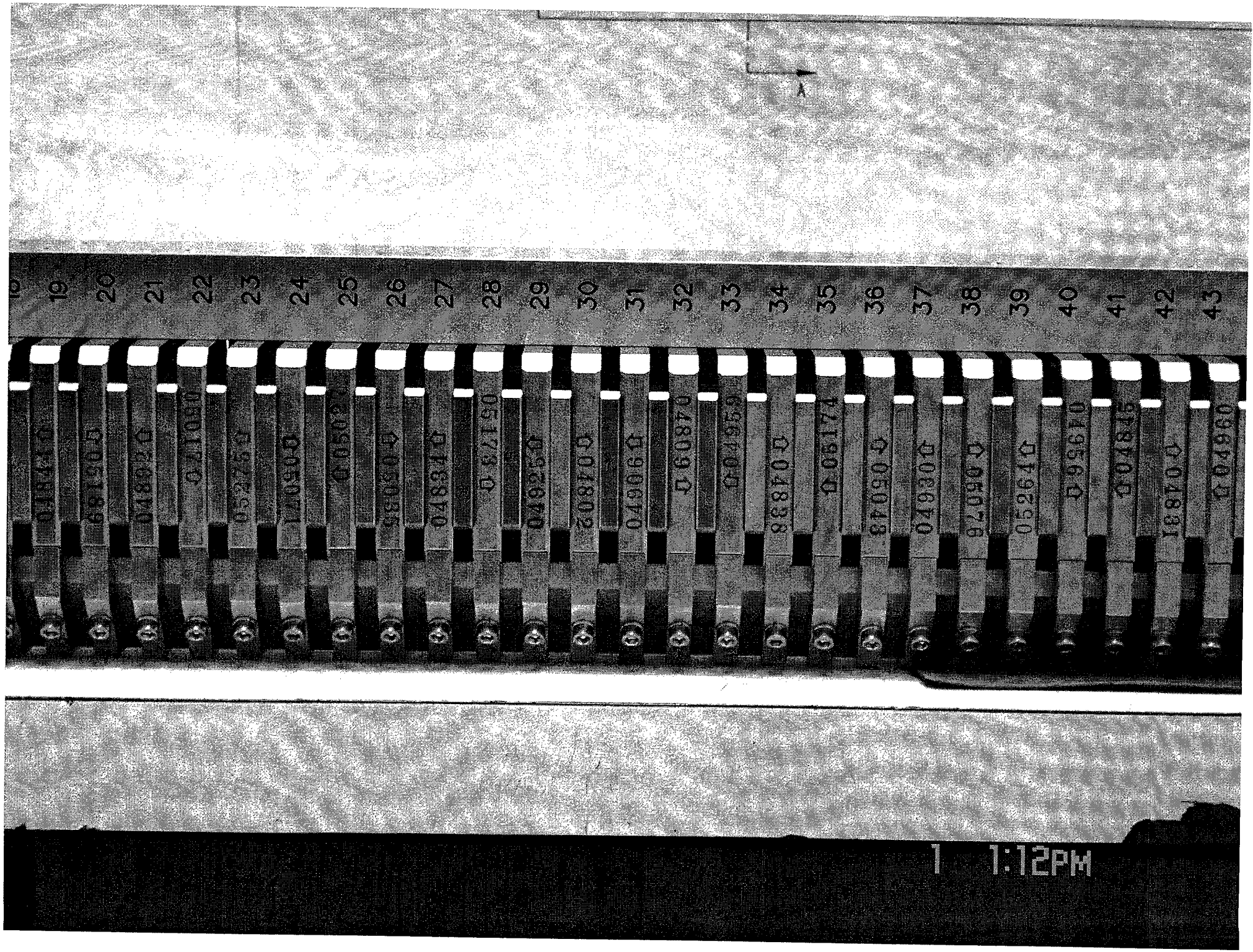
up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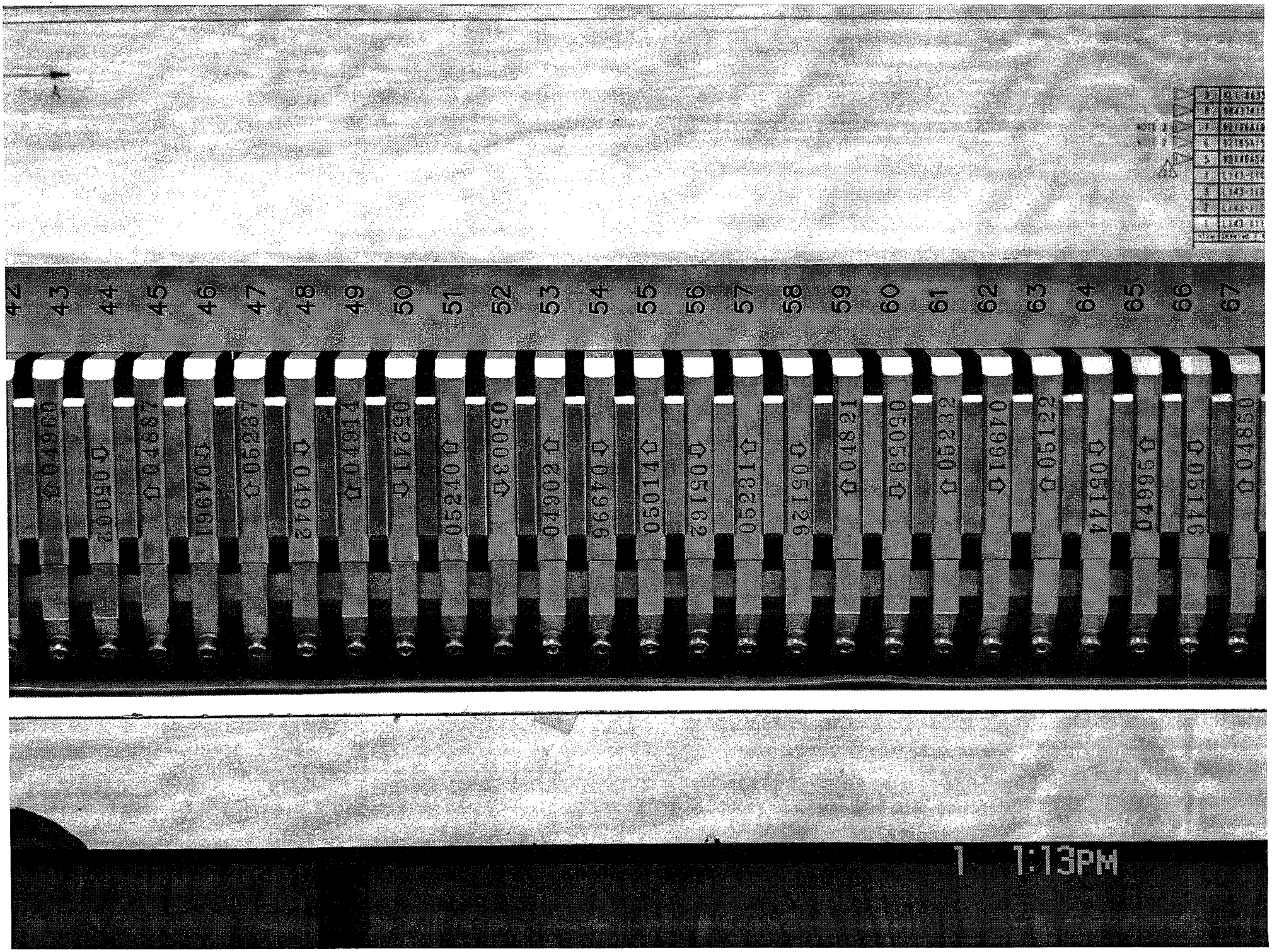
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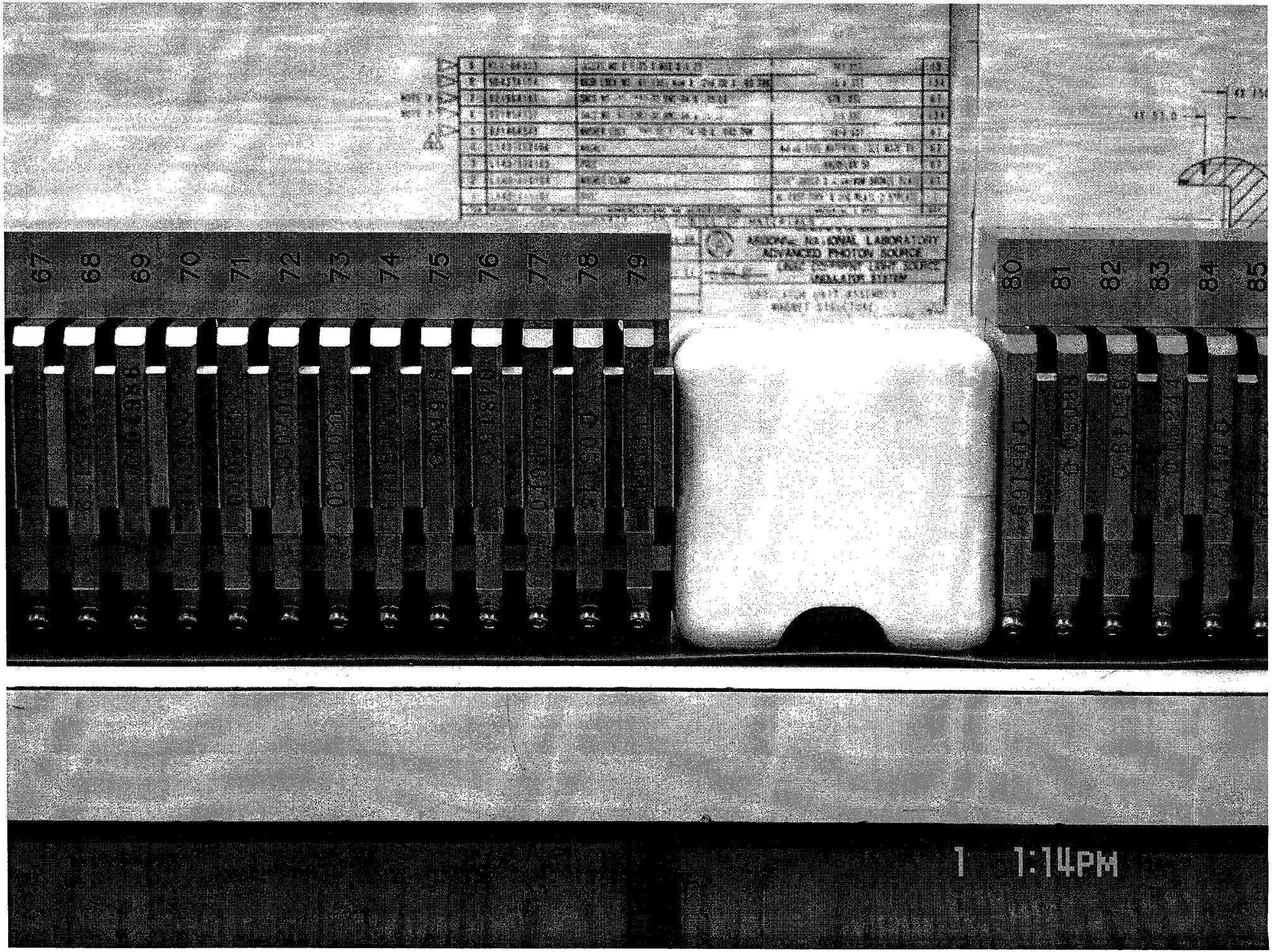
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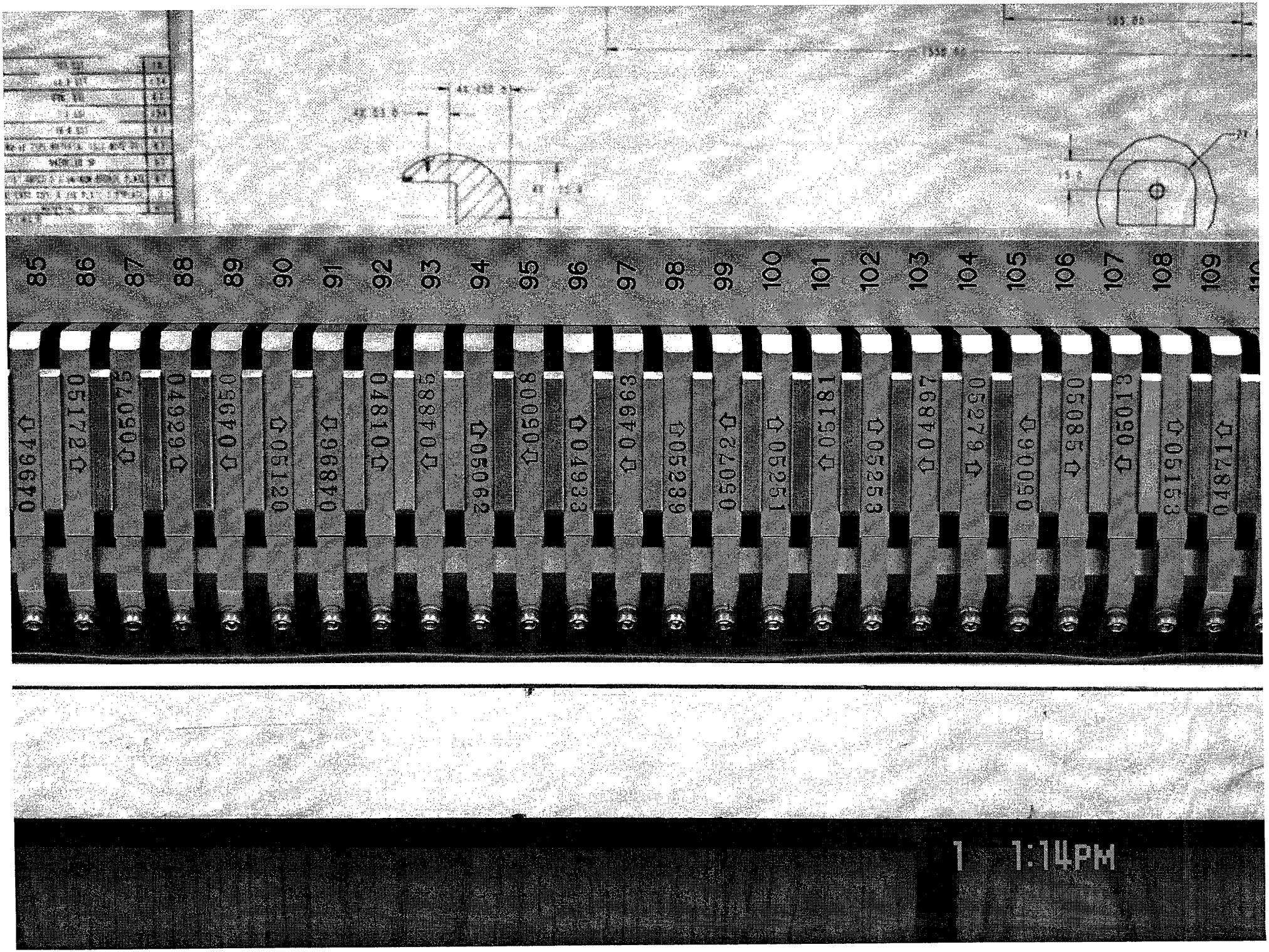
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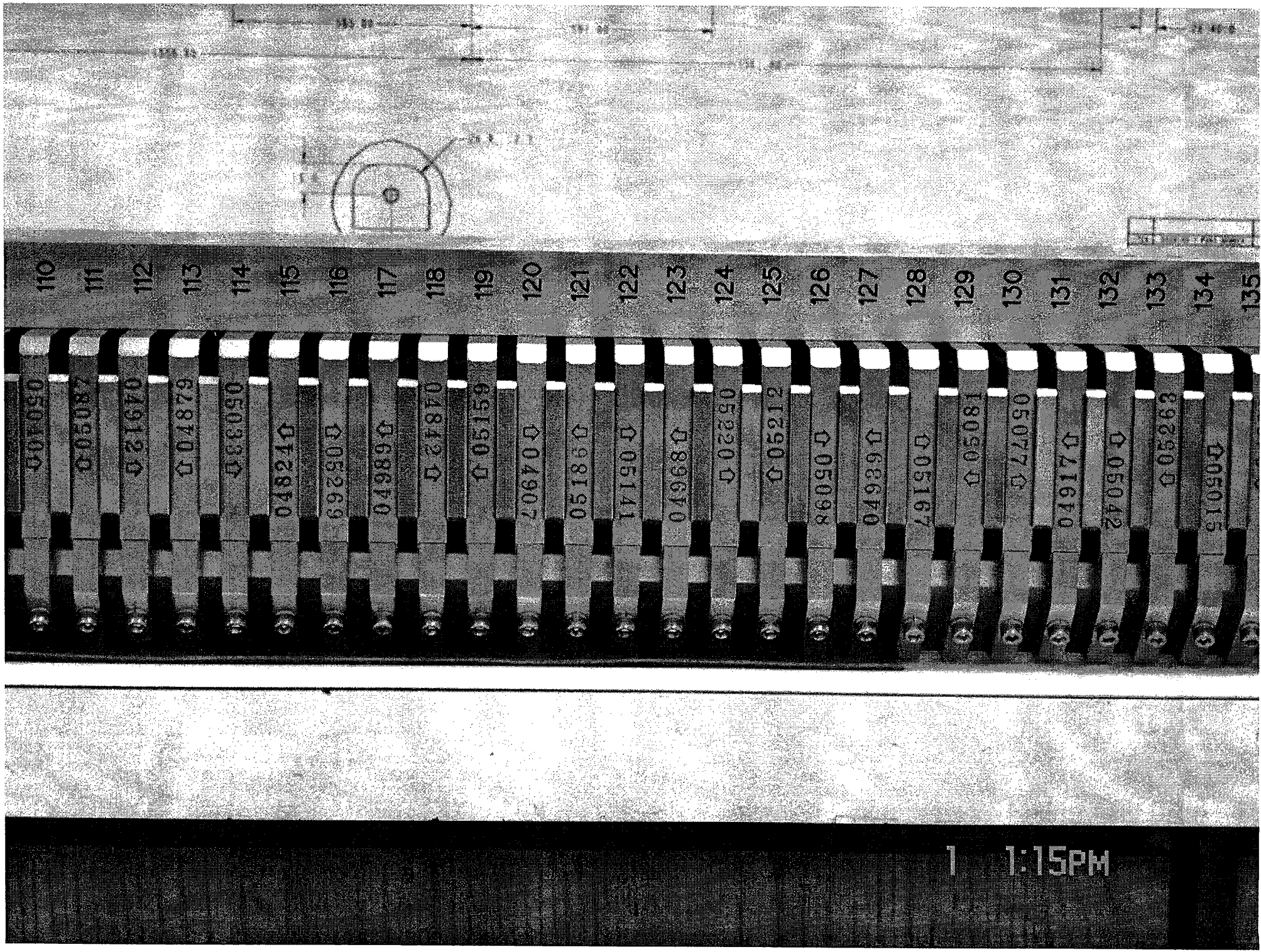
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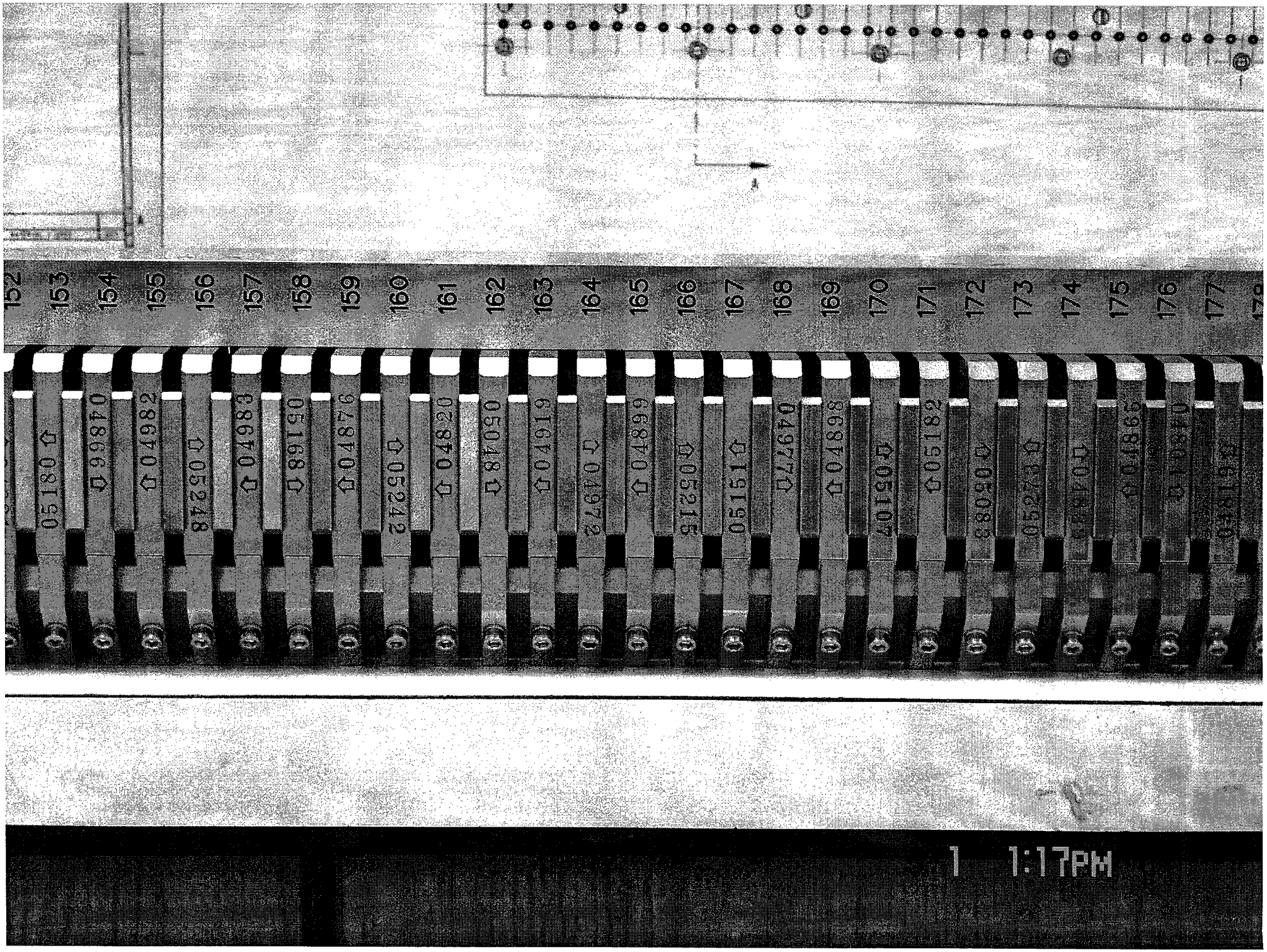
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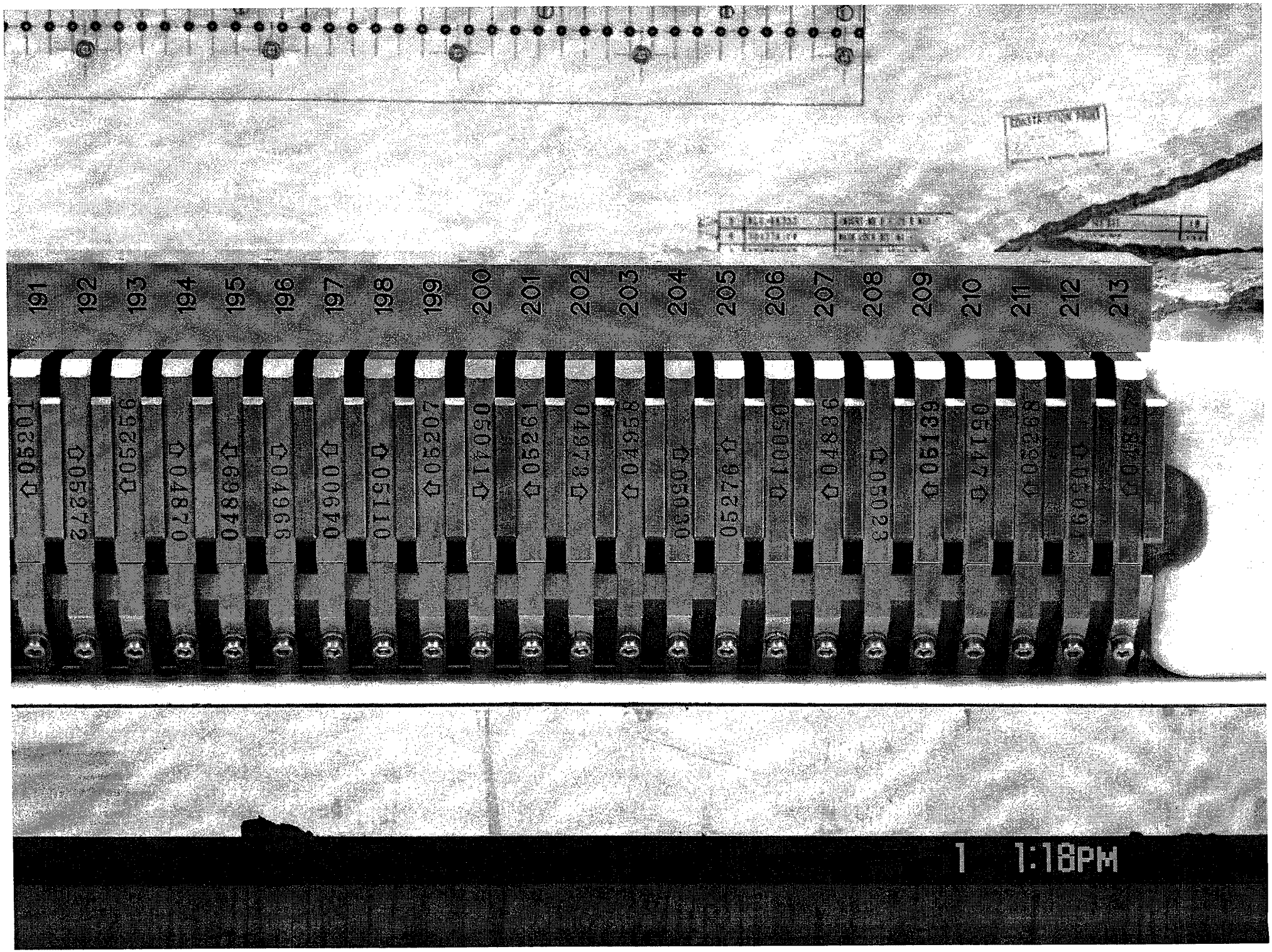
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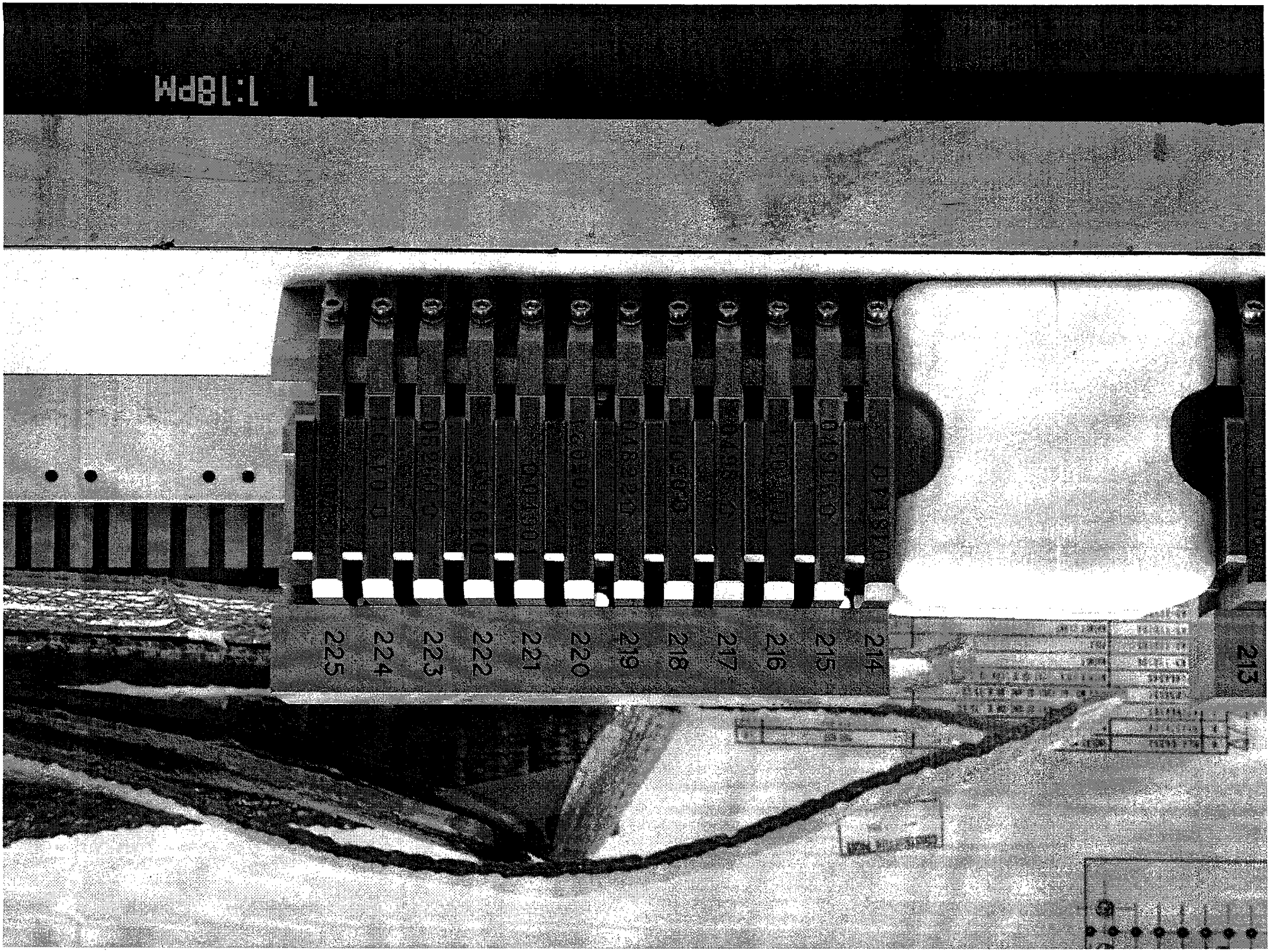
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INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Dial Machine, Inc.**

PART NAME: **LCLS Strongback**

DRAWING #: **L143-110700**

SERIAL #: 17

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

DATE: 07-28-06

#	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	07/28/06
2	Check Strongback is marked with serial number & part no.'s (ANL & SLAC) per SOW Section 4.1.3?	H.T.	SIMON	07/28/06
3	Check all accompanying Certifications have correct part serial number	H.T.	SIMON	7/28/06
4	Check Material Certification for compliance with ASTM B381-03, Grade F2	H.T.	SIMON	7/28/06
5	Check Forging Annealing Certification for annealing conformance to AMS-H-81200A, Table V, commercial Pure, Bars & Forgings, including Note 8	H.T.	SIMON	7/28/06
6	Check Rough Machining Anneal Certification for annealing conformance to AMS-2801B section 3.2.9	H.T.	SIMON	07/28/06
7	Check the Strongback contractor's reported dimensional measurements against the part drawing	H.T.	SIMON	7/28/06
8	Verify the Strongback critical dimensions as listed in the SOW section 4.5.2 are in compliance with the print	H.T.	SIMON	7/28/06

INSPECTOR: SIMON

QA Supervisor: Mullaze

TEST EQUIPMENT USED: VISUAL

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: Dial Machine, Inc.

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 17

P.O.#: 5A-13624

DATE: 07-28-06

FEATURE: Gap Flatness

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

INSPECTOR: SIMON

QA Supervisor: Mulaz

TEST EQUIPMENT USED: CUBIC PRECISION MODEL: 711010 S/N: 23/067

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR:

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 17

P.O. #: SA-13624

DATE: 07-28-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Overall length	3400.00	+0 / -.04	3399.91	Accept/Reject
Gap height	167.00	+0.05 / -.0	167.00	Accept/Reject
Gap flatness (top and bottom)	<= .05	N/A	<= .03	Accept/Reject
Gap depth	130.00	+/- .08	129.96	Accept/Reject
Flatness of front face	<= .05	N/A	<= .03	Accept/Reject
Perpendicularity of front face to A	<= .1	N/A	<= .03	Accept/Reject
End face perpendicularity to A and B	<= .05	N/A	<= .03 <= .03	Accept/Reject

INSPECTOR: SIMON.

QA Supervisor: Muelaza

TEST EQUIPMENT USED: SQUAR PRECISION DIAL CALIPER DROP INDICATOR

COMMENTS:

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. 23593

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	07/05/2006
Your Order	5A-04889
FOB	ROCKFORD
Ship Via	BEST WAY
Terms	NET 30
Our Order	21279

Order Qty	Ship Qty	Part ID/Description	Rev	U/M
1	1	SA-381-000-86 TITANIUM STRONGBACK SERIAL #17		EA

Argonne National Lab
Strongback -L143-110700
Inspection and Test Results

#17

Serial Number	[redacted]	[redacted]	Inspector	**Floyd**
Date				

CMM Critical Feature Results	*Req*	*Tolr*	*Actual*	
flatness - plane -A-		.050	.025	
side opposite -A- flatness		.050	.050	
surface finish -A-	1.6		.63	
surface finish side opposite -A-	1.6		.63	
-B- surface flatness		.050	.044	
-B- surface perp to -A-		.100	.020	
Pads				
RH Mounting Pad parallel to -A-		.050	.000	
LH Mounting Pad parallel to -A-		.050	.001	
Overall Length	3400.00	+.000/-.200	3399.907	
LH end to 1700mm holes right	1700.00	+.000/-.100	1699.941	
LH end to 1700mm holes left	1700.00	+.000/-.100	1699.981	
side opposite -A- 167.00 dim	167.00	+.050/-.000	167.016	plane to plane
Individual Gaps	167.00		167.00 - 167.028	direct gaps
side -A- to Centerline 83.5	83.50	+/- .080	83.508	
Other Dimensions		***Date***	***Reviewer***	
		6-6-06	SKL	SDR #5, SDR #6-16

Material and Certifications		***Date***	***Reviewer***	
Material Certs		2/17/06	SKL	
Heat Treat Certs		3/7/06, 3/14/06	SKL	
Visual inspection of Material		3/7/06	SKL	

Approvals	
.	
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Temps	
22.3	Start
21.8	Finish

SDR #5

Steve Lewis

To: stevel@dialmachine.com
Subject: FW: Strongback bars

I talked to Emil on 3/3/06 about this. Reviewed our measured actual sizes.

He said that he could, and would work around these size parts.

We do not need to take any action.

Steve

-----Original Message-----
From: Emil Trakhtenberg [mailto:emil@aps.anl.gov]
Sent: Friday, March 03, 2006 11:29 AM
To: SteveL@dialmachine.com
Subject: Re: Strongback bars

Steve,
I have add 5mm over nominal diameter of the titanium strong back for the earth field shield. Tell me if I have to add more.
Thank you.
Emil

Steve Lewis wrote:

> Emil, Glen,
>
> I know that Glen is gone for a few days.
>
> I had asked him if there was possibility for bars to be used if the outside
> diameter was oversized. He consulted Emil and gave me the answer.
>
> I took his call in the shop and do not remember whether he said that it was
> 4mm over nominal, or 4mm over high limit.
>
> Could you help refresh my memory.
>
> I did submit this as SDR #5.
>
> Thanks very much.
>
>
>
> Steve Lewis
> Dial Machine
>
> ph 815-397-6660
> fax 815-397-0562
> SteveL@dialmachine.com
>
> 2902 Eastrock Dr.
> Rockford, IL 61125
>
>

SUPPLIER DISPOSITION REQUEST (SDR)

(Form ANL-311 includes instructions and continuation sheet.)

Page ___ of ___

(CHECK ONE)

☐ 1A. **Deviation Request**

☐ 1B. **Nonconformance Action Request**

2. SDR No. 5

3. SDR Date 2/27/06

4. Supplier Name, Address, Telephone, Fax

DIAL MACHINE, INC.
2902 EASTROCK DRIVE
ROCKFORD, IL 61125

5. Purchase Order No. 51-0488

6. Related Documents

6.1 _____ Date _____

7. Qty.	8. Describe Nonconforming Condition	9. Identify Requirement	10. Cause & Corrective Action
3	OUTSIDE DIAMETER OF BAR IS OVERSIZE ACT 311.2 MM NOM 304.8 +2.-2.0/-.00 SER #19 - 309.6 MM SER #17 - 311.9 MM SER #3 - 308.4 MM		CAUSE - SUPPLIER DEVIATION

SUPPLIER'S COMMENTS
(IF YES, EXPLAIN):

11. Affects Form, Fit or Function

☐ Yes ☐ No _____

12. Affects Price

☐ Yes ☐ No _____

13. Affects Delivery

☐ Yes ☐ No _____

14. Recommended Disposition and Comments:

15. SUPPLIER REPRESENTATIVE – TITLE – DATE

16. ANL REPRESENTATIVE – DATE

17. ANL Disposition and Remarks:

18. Approved

TECHNICAL REPRESENTATIVE – DATE

QUALITY ASSURANCE REPRESENTATIVE – DATE

PROCUREMENT REPRESENTATIVE – DATE

ANL-311 (4-94)

SUPPLIER DISPOSITION REQUEST (SDR)

(Form ANL-311 includes instructions and continuation sheet.)

Page ___ of ___

(CHECK ONE)

☑ 1A. **Deviation Request**

☐ 1B. **Nonconformance Action Request**

2. **SDR No.** 7-10-2006

3. **SDR Date** 07/10/2006

4. **Supplier Name, Address, Telephone, Fax**

Dial Machine, Inc
2902 Eastrock Dr.
Rockford, IL 61125

5. **Purchase Order No.** 51-0488

6. **Related Documents**

6.1 _____ **Date** _____

7. Qty.	8. Describe Nonconforming Condition	9. Identify Requirement	10. Cause & Corrective Action
1	Strongback #17 15mm C'bores are dimensioned from the OD. Strongback #17 is oversized on OD (SDR #5). The 15mm C'bores therefore are up to 2.5mm further from the centerline.		Machine C'bores to the theoretical centerline rather than the OD.

SUPPLIER'S COMMENTS
(IF YES, EXPLAIN):

11. **Affects Form, Fit or Function**
☐ Yes ☑ No

12. **Affects Price**
☐ Yes ☑ No

13. **Affects Delivery**
☐ Yes ☑ No

14. **Recommended Disposition and Comments:**

Accept for this unit.

15. SUPPLIER REPRESENTATIVE – TITLE – DATE

Glen Lawrence 07-12-06
16. ANL REPRESENTATIVE – DATE

17. **ANL Disposition and Remarks:** Accept for this unit only. THd should have greater Than one P.D. engagement.

18. **Approved**

Glen Lawrence 7-12-06
TECHNICAL REPRESENTATIVE – DATE

7/12/06
QUALITY ASSURANCE REPRESENTATIVE – DATE

PROCUREMENT REPRESENTATIVE – DATE

ANL-311 (4-94)

SN 17

SUPPLIER DISPOSITION REQUEST (SDR)

(Form ANL-311 includes instructions and continuation sheet.)

Page ___ of ___

(CHECK ONE)

☑ 1A. **Deviation Request**

☐ 1B. **Nonconformance Action Request**

2. SDR No. 6-16

3. SDR Date 06/16/2006

4. Supplier Name, Address, Telephone, Fax

Dial Machine, Inc
2902 Eastrock Dr.
Rockford, IL 61125

5. Purchase Order No. 51-0488

6. Related Documents

6.1 _____ Date _____

7. Qty.	8. Describe Nonconforming Condition	9. Identify Requirement	10. Cause & Corrective Action
2	6.35+.01/-.00 Holes in end of part (2) of (6). (1) on each end are oversized. (1) is 6.400, (1) is 6.375		Cause is inherent in the process of small diameter work in large part. Correction is to plug and redrill if correction is functionally necessary

SUPPLIER'S COMMENTS (IF YES, EXPLAIN):

11. Affects Form, Fit or Function

☐ Yes ☑ No

12. Affects Price

☐ Yes ☑ No

13. Affects Delivery

☐ Yes ☑ No

14. Recommended Disposition and Comments:

Five holes plugged and re-drilled

6/16/06

15. SUPPLIER REPRESENTATIVE – TITLE – DATE

16. ANL REPRESENTATIVE – DATE

17. ANL Disposition and Remarks: Holes are critical, Plug & REDRILL

18. Approved

06/16/06

TECHNICAL REPRESENTATIVE – DATE

6/19/06

QUALITY ASSURANCE REPRESENTATIVE – DATE

PROCUREMENT REPRESENTATIVE – DATE

ANL-311 (4-94)

#18-19

CORROSION MATERIALS TEST REPORT

2262 Groom Rd.
Baker, LA 70714
(225) 775 - 3675 (Main Office)
(225) 778 - 6436 (Quality Control)
(225) 778 - 6439 (Fax)

Date: 2/17/2006

Customer: DIAL MACHINE

PO No: CMI No:

Alloy: TI GR2 Heat No: 064-1 Quantity:

Item Description: 12" DIA RND BAR X RL

Specifications: DIN 50049 3.1B ASTM B348, ASME SB348
EN 10204 3.1B

Chemical Components

C	CO	CR	CU	FE	MN	MO	NI	P	S
0.001	—	—	—	0.05	—	—	—	—	—
SI	TI	V	W	CB+TA	SN	AL	ZN	PB	N
—	—	—	—	—	—	—	—	—	0.018

Mechanical Properties

Tensile Strength:	50.70 KSI	Elongation in 2":	43.5 %
Yield Strength:	32.90 KSI	Reduction in Area:	77 %
Hardness:	56.00 HRB		

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

REFERENCE# PBA1063777 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.

#13-19

PBA/063777

Международная компания «ANTARES»

СЕРТИФИКАТ КАЧЕСТВА № 225

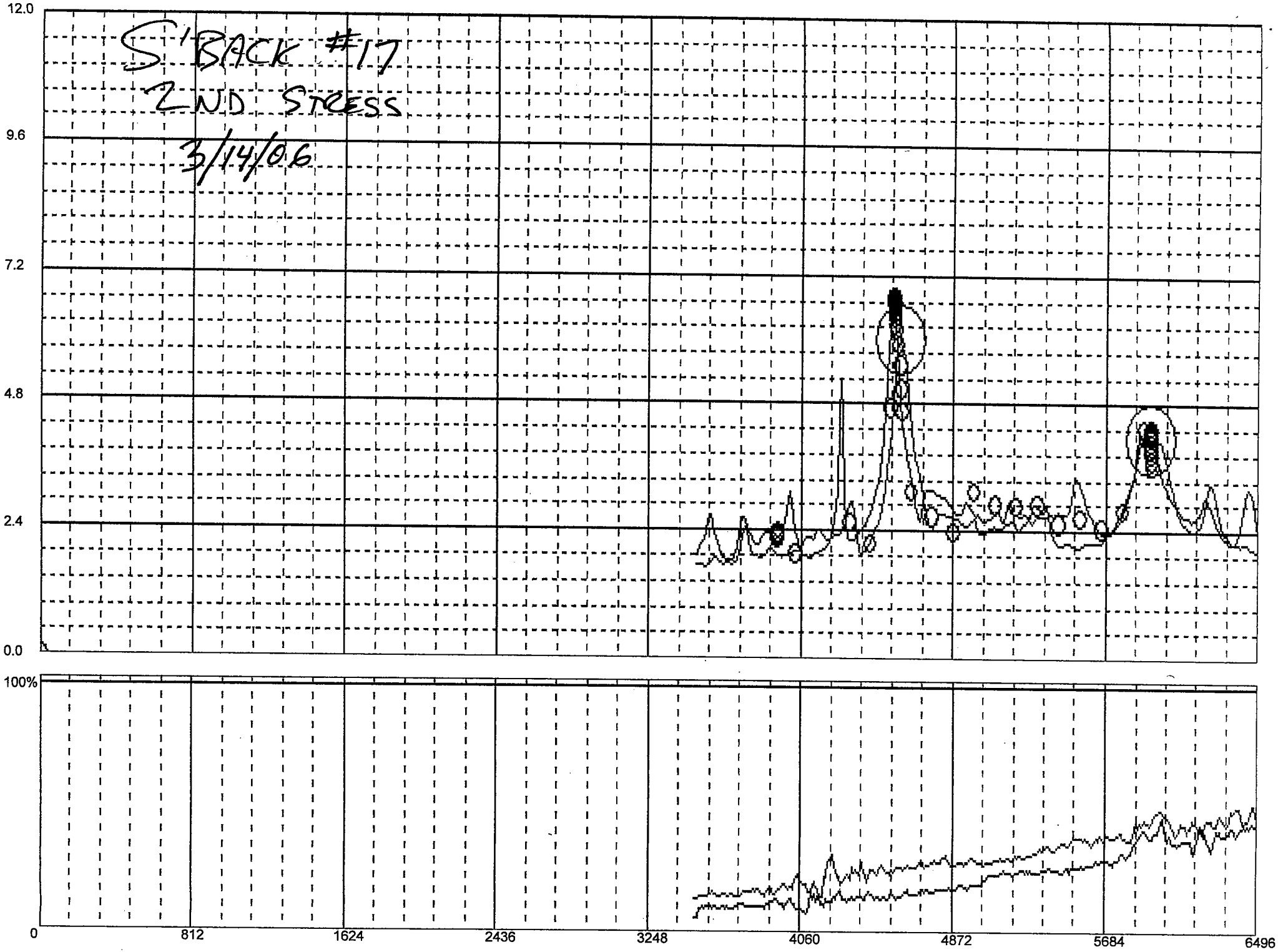
Вид продукции	заготовка литая цилиндрической формы	ТУ У 27.4-20056770-001
Заказчик "M-Solutions LLC"		КОНТРАКТ No. 28/12-04 от 28.12.200
Материал	титановый сплав Grade 2	ASTM B 348-00
		Дата выдачи: 14.

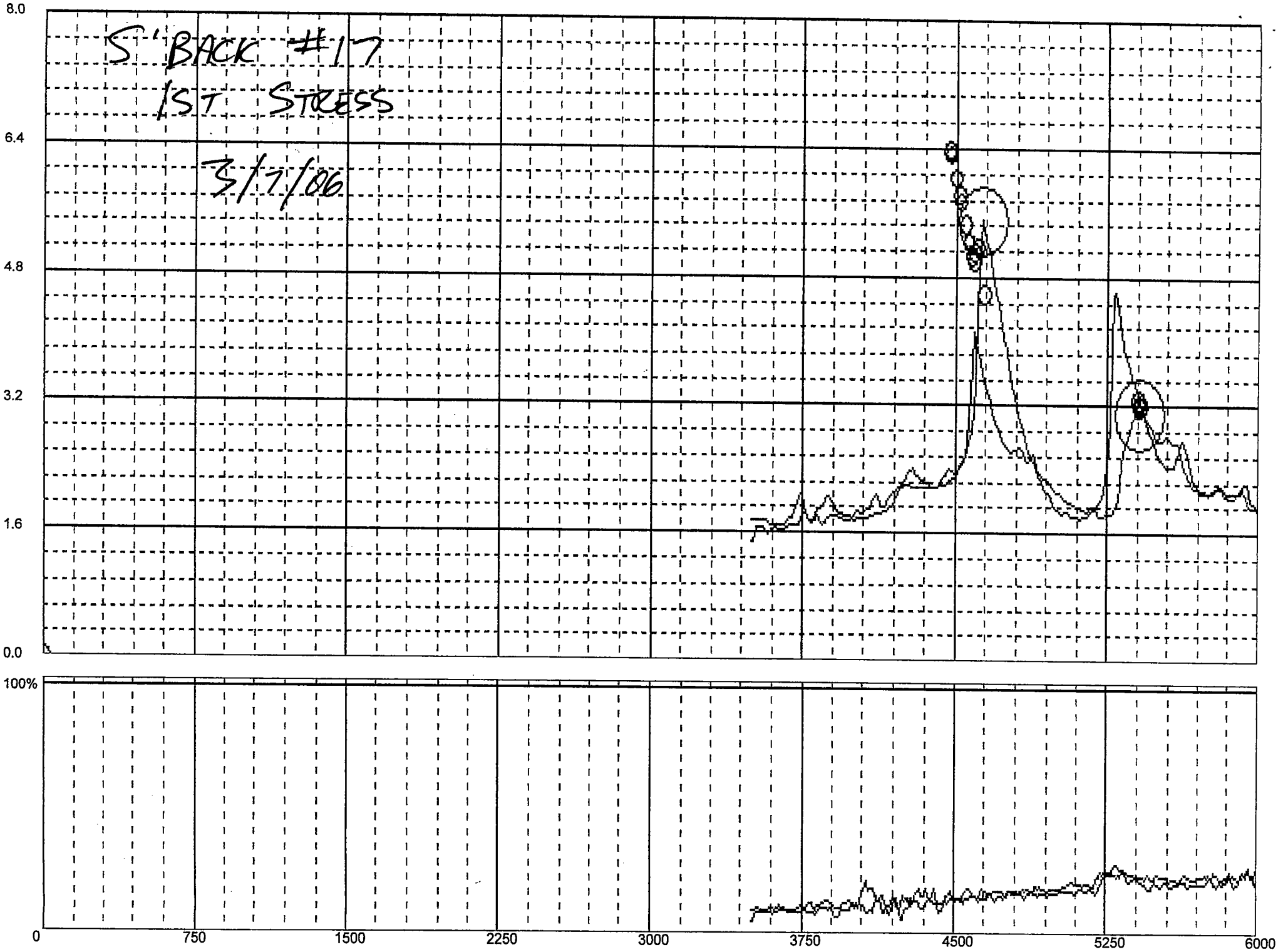
Размер, мм диаметр х длина	Масса, кг	№ плавки	Место отбора пробы	Химический состав, %								Ультразвуковой контроль
				Ti	Fe	O	N	H	C	Остаток (каждого) max	Остаток (всего) max	
810 X 3601	8386	064-1	голова	Осн.	0.05	0.04	0.018	0.002	0.01	≤ 0,1	≤ 0,4	Удовлетворительн.
			дно		0.05	0.04	0.020	0.002	0.01	≤ 0,1	≤ 0,4	

Главный технолог Дереча А.Я.

Начальник ОТК Кривошлыков Ю.М

УКРАЇНА * ЧИЖКА * ТОВАРИСТВО З ОБМЕЖЕНОЮ ВІДПОВІДАЛЬНІСТЮ * ЧИЖКА * "ANTARES" СВІДОЦТВО № 20056770


S'BACK #17
2ND STRESS
3/14/06
12.0
9.6
7.2
4.8
2.4
0.0
100%
0
812
1624
2436
3248
4060
4872
5684
6496


S'BACK #17
1ST STRESS
3/7/06
8.0
6.4
4.8
3.2
1.6
0.0
100%
0
750
1500
2250
3000
3750
4500
5250
6000

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 04903

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.96	(Accept)/Reject

INSPECTOR: SIMON

QA Supervisor: Muelaz

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 #: 04918

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.96	(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 #: 04892

P.O. #: **5A13624**

DATE: 07-08-02

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	8.96	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 #: 04906

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	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 #: 04845

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	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 #: 05240

P.O. #: **5A13624**

DATE: 07-08-02

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	66.02	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 #: 05232

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	(Accept) Reject
Magnet thickness	9.00	+0 / -.10	8.98	(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 #: 04981

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	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 #: 05038

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	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 #: 04896

P.O. #: **5A13624**

DATE: 07-08-06

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: Murlage

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 #: 05181

P.O. #: **5A13624**

DATE: 07-08-06

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	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muela

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 #: 05087

P.O. #: **5A13624**

DATE: 07-08-06

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: [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 #: 05186

P.O. #: **5A13624**

DATE: 07-08-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Alurlaze

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 #: 04917

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	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 #: 04854

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.95	(Accept)/Reject

INSPECTOR: SIMON

QA Supervisor: Murlage

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 #: 05104

P.O. #: **5A13624**

DATE: 07-08-06

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: 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 #: 04820

P.O. #: **5A13624**

DATE: 07-08-06

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	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murtaza

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 #: 05182

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlage

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 #: 05175

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	(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 #: 05201

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	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 #: 05261

P.O. #: **5A13624**

DATE: 07-08-06

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	65.99	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.96	(Accept)/Reject

INSPECTOR: Simon

QA Supervisor: Muñoz

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 #: 05268

P.O. #: **5A13624**

DATE: 07-08-06

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	66.01	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 #: 04901

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	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 #: **L143-110106-04**

SERIAL #: 05047

P.O. #: **5A13624**

DATE: 07-08-06

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	8.99	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 #: 05130

P.O. #: **5A13624**

DATE: 07/08/06

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	8.99	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 #: 04932

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.95	(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 #: 05114

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	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 #: 05032

P.O. #: **5A13624**

DATE: 07-08-06

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	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelate

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 #: 05185

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	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 #: 05113

P.O. #: **5A13624**

DATE: 07-08-06

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: 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 #: 05245

P.O. #: **5A13624**

DATE: 07-08-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

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 #: 04992

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mustaz

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 #: 04837

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mallaze

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 #: 05111

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	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 #: 04954

P.O. #: **5A13624**

DATE: 07-08-06

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	66.03	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 #: 05266

P.O. #: **5A13624**

DATE: 07-08-02

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.98	Accept/Reject
Magnet Width	66.00	+/- .25	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlage

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 #: 05165

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mueller

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 #: 05066

P.O. #: **5A13624**

DATE:

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	8.99	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 #: 05100

P.O. #: **5A13624**

DATE: 07-08-06

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	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

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 #: 05280

P.O. #: **5A13624**

DATE: 07-08-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	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 #: 05025

P.O. #: **5A13624**

DATE: 07-08-06

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	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	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 #: 05060

P.O. #: **5A13624**

DATE: 07-08-06

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	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

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 #: 04862

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	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 #: 05102

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlage

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 #: 05036

P.O. #: **5A13624**

DATE: 07-08-06

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	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.99	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 #: 05143

P.O. #: **5A13624**

DATE: 07-08-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.98	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: [illegible]

TEST EQUIPMENT USED: **Drop Indicators**

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 #: L143-110800-17

P.O. #: 5A13624

DATE: 07-28-06

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 30.00/29.98	Accept/Reject
Bottom surface flatness	<= .04	N/A	0.012	Accept/Reject
Overall length	195	+0 / -.1	194.97	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Murlaga

QA Supervisor: Murlaga

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 #: Ll43-111200-17

P.O. #: 5A13624

DATE: 07-28-06

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 29.995.00/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.03	Accept/Reject
Overall length	189	+0 / -.1	188.975	Accept/Reject
Overall width	128	+0 / -.1	127.965	Accept/Reject

INSPECTOR: Muñoz

QA Supervisor: Muñoz

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 #: L143-111000-1-17

P.O. #: 5A13624

DATE: 06-26-06

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 29.99/29.970	Accept/Reject
Bottom surface flatness	</= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.90	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Mueleza

QA Supervisor: Mueleza

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 #: L143-111000-2-17

P.O. #: 5A13624

DATE: 06-26-06

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 29.984/29.972	Accept/Reject
Bottom surface flatness	<= .04	N/A	.035	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.90	Accept/Reject
Overall width	128	+0 / -.1	127.94	Accept/Reject

INSPECTOR: Muelaze

QA Supervisor: Muelaze

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 #: L143-111000-3-17

P.O. #: 5A13624

DATE: 06-26-06

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 29.990/29.980	Accept/Reject
Bottom surface flatness	<= .04	N/A	.035	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.90	Accept/Reject
Overall width	128	+0 / -.1	127.93	Accept/Reject

INSPECTOR: Murlaza

QA Supervisor: Murlaza

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 #: L143-111100-1-17

P.O. #:5A13624

DATE: 06-26-06

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 29.980/29.970	Accept/Reject
Bottom surface flatness	</= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.90	Accept/Reject
Overall width	128	+0 / -.1	127.927	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 #: L143-111100-2-17

P.O. #:5A13624

DATE: 06-26-06

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 29.980/29.970	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	127.92	Accept/Reject

INSPECTOR: Murlaza

QA Supervisor: Murlaza

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 #: L143-111100-3-17

P.O. #:5A13624

DATE: 06-26-06

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 29.985/29.970	Accept/Reject
Bottom surface flatness	<= .04	N/A	.025	Accept/Reject
Overall length	1005	+0 / -.1	1004.95	Accept/Reject
Overall width	128	+0 / -.1	127.93	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

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 #: L143-111300-17

P.O. #: 5A13624

DATE: 07-28-06

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 30.00/29.990	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.02	Accept/Reject
Overall length	189	+0 / -.1	188.988	Accept/Reject
Overall width	128	+0 / -.1	127.99	Accept/Reject

INSPECTOR: Murtaza

QA Supervisor: Murtaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

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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 #: L143-110900-17

P.O. #: 5A13624

DATE: 07-28-06

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 30.990/29.980	Accept/Reject
Bottom surface flatness	</= .04	N/A	.015	Accept/Reject
Overall length	195	+0 / -.1	194.98	Accept/Reject
Overall width	128	+0 / -.1	127.98	Accept/Reject

INSPECTOR: Muelaza

QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer .

COMMENTS: .