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.** 21-11-13

3. **SDR Date** 11/13/2006

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
	(6) Tap Holes M6x1.0 in end opposite of side -C- out of position. True position of worst one is .218mm against a tolerance of .100mm.		This is a very tight tolerance for a drill and tap hole. The worst hole location is out of position .118mm(.0046 inch). A standard tight fit bolt hole clearance is 6.400mm, which would leave .200mm per side of bolt clearance.

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 11/14/06

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)

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

Serial Number	#	21	Inspector	Floyd
Date		11/13/06		

CMM Critical Feature Results	*Req*	*Tolr*	*Actual*	
flatness - plane -A-		.050	.020	
side opposite -A- flatness		.050	.019	
surface finish -A-	1.6		.5	
surface finish side opposite -A-	1.6		.6	
-B- surface flatness		.050	.009	
-B- surface perp to -A-		.100	.025	
Pads				
RH Mounting Pad parallel to -A-		.050	.039	
LH Mounting Pad parallel to -A-		.050	.024	
Overall Length	3400.00	+.000/-.200	-.120	
LH end to 1700mm holes right	1700.00	+.000/-.100	-.060	
LH end to 1700mm holes left	1700.00	+.000/-.100	-.060	
side opposite -A- 167.00 dim	167.00	+.050/-.000	+.015	plane to plane
Individual Gaps	167.00		167.00 -167.028	direct gaps
side -A- to Centerline 83.5	83.50	+/- .080	.008	
Other Dimensions		*Date*	*Reviewer*	
		11-13	skl	see notes

Material and Certifications		*Date*	*Reviewer*	
Material Certs		11-13	skl	
Heat Treat Certs		11-13	skl	
Visual inspection of Material		11-13	skl	

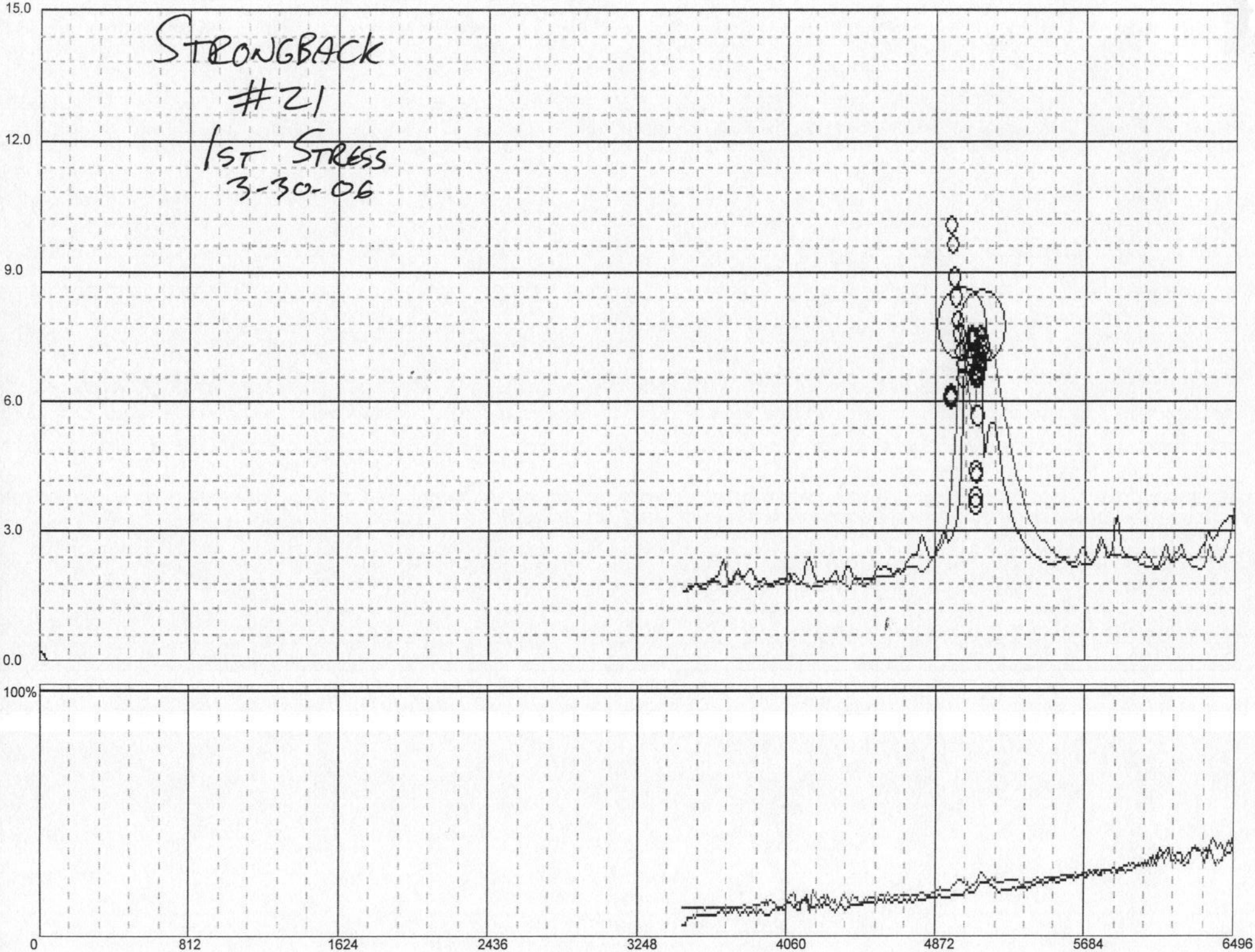
Approvals	
.	
.	

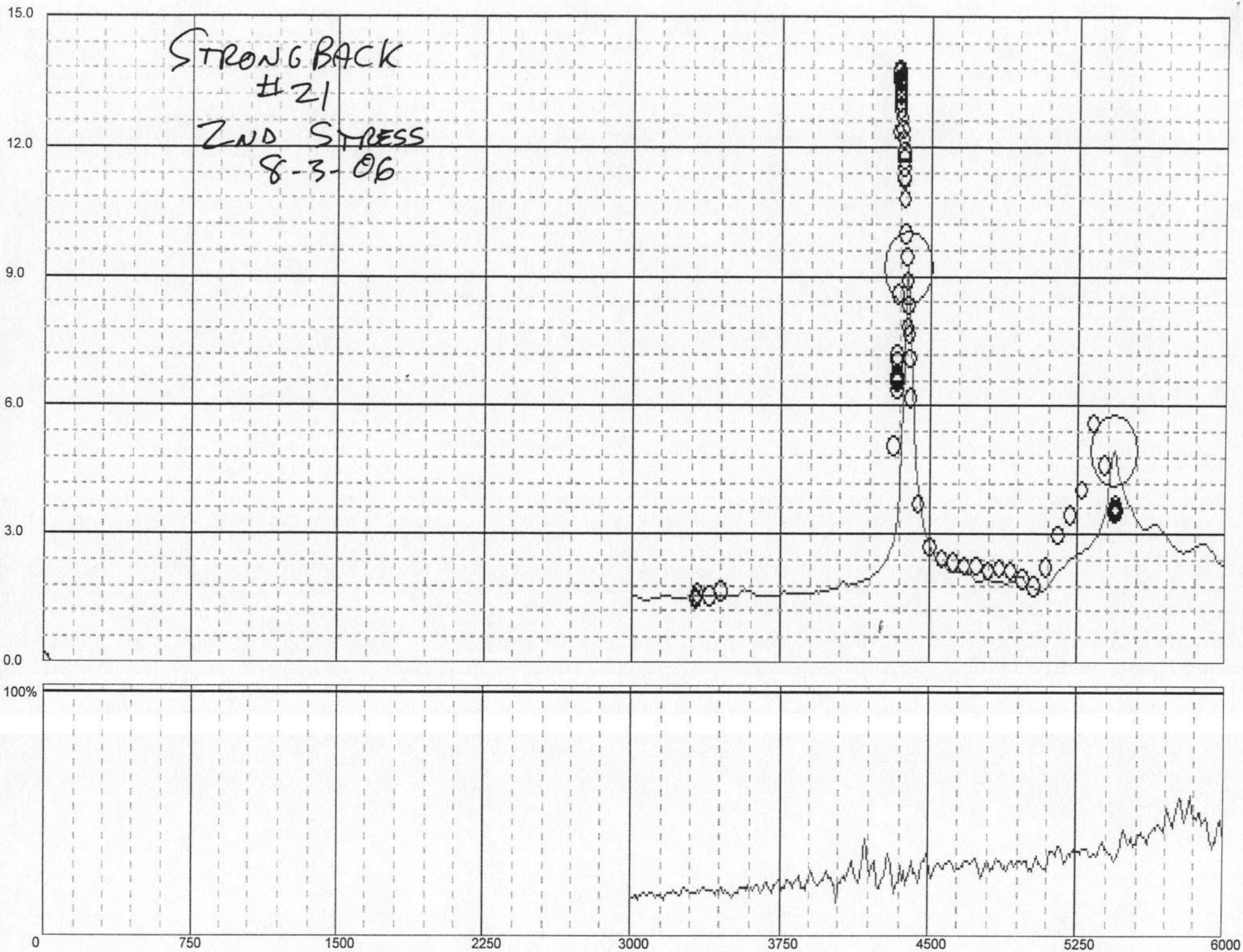
Temps	
20.9	Start
20.4	Finish

Serial # 1 **LCLS Strongback** **11/14/2006**

Deviations on Features not on Critical Feature List

Feature	Nominal	Tolr	Actual	Deviation	Comment
(6) M6 tap holes in End Opposite -C-					
	various	TP .100	worst one	.218	worst tap hole is .114mm(.0045") from nominal


STRONGBACK
#21
1ST STRESS
3-30-06
15.0
12.0
9.0
6.0
3.0
0.0
100%
0
812
1624
2436
3248
4060
4872
5684
6496


STRONGBACK
#21
2ND STRESS
8-3-06
15.0
12.0
9.0
6.0
3.0
0.0
100%
0
750
1500
2250
3000
3750
4500
5250
6000

21,23,25,27,29,31

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: 3/9/2006

Customer: Dial Machine

PO No: 102437 & 102669

CMI No: C89385 C83758

Alloy: TI GR2 Heat No: 089-1 Quantity: 6 PCS

Item Description: 12" DIA RND BAR X 137"

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
0.02	—	—	—	0.05	—	—	—	—	—
SI	TI	V	W	CB+TA	SN	AL	ZN	PB	N
—	—	—	—	—	—	—	—	—	0.010

Mechanical Properties

Tensile Strength: Elongation in 2":

Yield Strength: Reduction in Area:

Hardness:

Remarks: O=0.10, H=0.002, TI=BAL
CHEMISTRY ONLY
MATERIAL HAS BEEN ANNEALED PER AMS-H-81200 AND WAS ANNEALLED AT 1200 DEG FOR 4 HOURS.

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.

International Company «ANTARES»

CERTIFICATE OF QUALITY № 285

Kind of product						titanium cast cylindrical billet						Tu U 27.4-20056770-001-2003	
Customer	"Rovena" / "M-Solutions LLC"								CONTRACT № 26/05-05			dated 26.05.2005	
Material	Grade 2						ASTM B 348-00					Date of issue: 14.07.2005	
Size, mm Diam x length	Weight kg	№ of melting	Place of test	Chemical specification, %								Ultrasonic test	Condition of surface
				Ti	Fe	O	N	H	C	Residuals (each) max	Residuals (total) max		
807 X 3437	7906	089-1	Top	Base	0.06	0.07	0.010	0.002	0.02	≤ 0,1	≤ 0,4	acceptable	machined
			Bottom		0.05	0.10	0.010	0.002	0.02	≤ 0,1	≤ 0,4		

Chief of technological department — Derecha A.Y.

Chief of quality control department — Krivoshlykov U.M.

71,25,27,29,31

LOT25 magnets Serial # 11521-12000

Bottom Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	11669	Upstream	Right
2	11915	Downstream	Right
3	11681	Upstream	Left
4	11918	Downstream	Left
5	11884	Upstream	Left
6	11848	Downstream	Right
7	11740	Upstream	Right
8	11616	Downstream	Left
9	11539	Upstream	Right
10	11926	Downstream	Left
11	11719	Upstream	Left
12	11950	Downstream	Left
13	11623	Upstream	Right
14	11824	Downstream	Left
15	11905	Upstream	Right
16	11859	Downstream	Left
17	11847	Upstream	Right
18	11656	Downstream	Left
19	11878	Upstream	Right
20	11923	Downstream	Left
21	11691	Upstream	Right
22	11737	Downstream	Left
23	11817	Upstream	Left
24	11879	Downstream	Right
25	11548	Upstream	Left
26	11728	Downstream	Left
27	11893	Upstream	Left
28	11858	Downstream	Right
29	11640	Upstream	Right
30	11641	Downstream	Right
31	11747	Upstream	Right
32	11754	Downstream	Left
33	11768	Upstream	Left
34	11715	Downstream	Right
35	11631	Upstream	Left
36	11805	Downstream	Left
37	11666	Upstream	Right
38	11869	Downstream	Right
39	11600	Upstream	Left
40	11735	Downstream	Left
41	11722	Upstream	Left
42	11887	Downstream	Left
43	11530	Upstream	Right
44	11913	Downstream	Left
45	11776	Upstream	Left
46	11628	Downstream	Left
47	11670	Upstream	Left

Top Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	11958	Downstream	Left
2	11818	Upstream	Right
3	11912	Downstream	Left
4	11529	Upstream	Right
5	11717	Downstream	Right
6	11599	Upstream	Left
7	11949	Downstream	Right
8	11890	Upstream	Right
9	11904	Downstream	Left
10	11554	Upstream	Left
11	11928	Downstream	Right
12	11849	Upstream	Right
13	11779	Downstream	Right
14	11766	Upstream	Right
15	11720	Downstream	Right
16	11945	Upstream	Left
17	11664	Downstream	Left
18	11972	Upstream	Left
19	11649	Downstream	Left
20	11711	Upstream	Right
21	11593	Downstream	Right
22	11946	Upstream	Right
23	11763	Downstream	Left
24	11575	Upstream	Left
25	11558	Downstream	Right
26	11867	Upstream	Left
27	11716	Downstream	Left
28	11700	Upstream	Right
29	11665	Downstream	Right
30	11626	Upstream	Left
31	11635	Downstream	Left
32	11814	Upstream	Left
33	11589	Downstream	Right
34	11607	Upstream	Right
35	11606	Downstream	Left
36	11604	Upstream	Right
37	11620	Downstream	Right
38	11567	Upstream	Left
39	11661	Downstream	Left
40	11916	Upstream	Right
41	11752	Downstream	Right
42	11611	Upstream	Right
43	11971	Downstream	Left
44	11929	Upstream	Left
45	11901	Downstream	Right
46	11744	Upstream	Left
47	11721	Downstream	Left

48	11603	Downstream	Right
49	11762	Upstream	Right
50	11724	Downstream	Right
51	11648	Upstream	Left
52	11690	Downstream	Left
53	11686	Upstream	Left
54	11592	Downstream	Left
55	11910	Upstream	Left
56	11685	Downstream	Right
57	11934	Upstream	Left
58	11602	Downstream	Left
59	11540	Upstream	Left
60	11956	Downstream	Right
61	11687	Upstream	Right
62	11546	Downstream	Right
63	11624	Upstream	Right
64	11712	Downstream	Right
65	11937	Upstream	Left
66	11800	Downstream	Right
67	11697	Upstream	Left
68	11844	Downstream	Right
69	11834	Upstream	Right
70	11940	Downstream	Left
71	11973	Upstream	Right
72	11781	Downstream	Left
73	11702	Upstream	Left
74	11969	Downstream	Right
75	11703	Upstream	Right
76	11843	Downstream	Right
77	11544	Upstream	Right
78	11772	Downstream	Right
79	11713	Upstream	Left
80	11683	Downstream	Right
81	11581	Upstream	Left
82	11873	Downstream	Left
83	11829	Upstream	Left
84	11842	Downstream	Left
85	11550	Upstream	Right
86	11637	Downstream	Right
87	11797	Upstream	Right
88	11723	Downstream	Right
89	11572	Upstream	Left
90	11571	Downstream	Left
91	11799	Upstream	Right
92	11741	Downstream	Right
93	11757	Upstream	Left
94	11708	Downstream	Left
95	11980	Upstream	Left
96	11710	Downstream	Left
97	11579	Upstream	Right
98	11783	Downstream	Left
99	11748	Upstream	Left

48	11862	Upstream	Right
49	11653	Downstream	Left
50	11764	Upstream	Left
51	11876	Downstream	Right
52	11576	Upstream	Right
53	11696	Downstream	Left
54	11979	Upstream	Left
55	11563	Downstream	Right
56	11638	Upstream	Left
57	11985	Downstream	Right
58	11675	Upstream	Left
59	11705	Downstream	Right
60	11743	Upstream	Left
61	11573	Downstream	Left
62	11933	Upstream	Right
63	11718	Downstream	Right
64	11892	Upstream	Right
65	11882	Downstream	Left
66	11955	Upstream	Right
67	11774	Downstream	Right
68	11854	Upstream	Left
69	11684	Downstream	Left
70	11976	Upstream	Right
71	11662	Downstream	Right
72	11837	Upstream	Right
73	11632	Downstream	Left
74	11785	Upstream	Right
75	11922	Downstream	Left
76	11804	Upstream	Left
77	11645	Downstream	Left
78	11613	Upstream	Right
79	11528	Downstream	Left
80	11523	Upstream	Left
81	11549	Downstream	Right
82	11673	Upstream	Left
83	11872	Downstream	Left
84	11584	Upstream	Right
85	11745	Downstream	Left
86	11672	Upstream	Left
87	11525	Downstream	Right
88	11739	Upstream	Left
89	11917	Downstream	Left
90	11964	Upstream	Right
91	11794	Downstream	Right
92	11932	Upstream	Left
93	11967	Downstream	Left
94	11596	Upstream	Right
95	11733	Downstream	Right
96	11815	Upstream	Left
97	11984	Downstream	Right
98	11835	Upstream	Left
99	11591	Downstream	Left

100	11587	Downstream	Right
101	11526	Upstream	Right
102	11614	Downstream	Left
103	11622	Upstream	Left
104	11655	Downstream	Left
105	11639	Upstream	Left
106	11574	Downstream	Left
107	11981	Upstream	Right
108	11924	Downstream	Right
109	11568	Upstream	Left
110	11642	Downstream	Left
111	11810	Upstream	Left
112	11896	Downstream	Right
113	11707	Upstream	Right
114	11542	Downstream	Right
115	11609	Upstream	Right
116	11668	Downstream	Right
117	11991	Upstream	Left
118	11982	Downstream	Left
119	11699	Upstream	Left
120	11727	Downstream	Right
121	11986	Upstream	Left
122	12000	Downstream	Left
123	11532	Upstream	Left
124	11521	Downstream	Left
125	11801	Upstream	Left
126	11629	Downstream	Left
127	11784	Upstream	Left
128	11545	Downstream	Right
129	11527	Upstream	Left
130	11907	Downstream	Right
131	11883	Upstream	Left
132	11902	Downstream	Right
133	11533	Upstream	Right
134	11732	Downstream	Right
135	11617	Upstream	Right
136	11833	Downstream	Left
137	11619	Upstream	Right
138	11658	Downstream	Right
139	11674	Upstream	Left
140	11634	Downstream	Left
141	11680	Upstream	Right
142	11677	Downstream	Left
143	11970	Upstream	Right
144	11671	Downstream	Right
145	11993	Upstream	Left
146	11857	Downstream	Left
147	11938	Upstream	Left
148	11871	Downstream	Left
149	11957	Upstream	Right
150	11995	Downstream	Right
151	11881	Upstream	Left

100	11823	Upstream	Left
101	11935	Downstream	Left
102	11832	Upstream	Left
103	11566	Downstream	Left
104	11880	Upstream	Left
105	11731	Downstream	Right
106	11755	Upstream	Left
107	11959	Downstream	Left
108	11963	Upstream	Right
109	11654	Downstream	Left
110	11822	Upstream	Right
111	11570	Downstream	Left
112	11736	Upstream	Right
113	11536	Downstream	Right
114	11977	Upstream	Right
115	11803	Downstream	Right
116	11819	Upstream	Right
117	11827	Downstream	Right
118	11778	Upstream	Right
119	11562	Downstream	Left
120	11966	Upstream	Right
121	11551	Downstream	Right
122	11782	Upstream	Right
123	11667	Downstream	Right
124	11590	Upstream	Right
125	11942	Downstream	Left
126	11953	Upstream	Left
127	11845	Downstream	Left
128	11701	Upstream	Left
129	11936	Downstream	Left
130	11657	Upstream	Left
131	11861	Downstream	Left
132	11965	Upstream	Left
133	11659	Downstream	Right
134	11877	Upstream	Right
135	11838	Downstream	Right
136	11868	Upstream	Right
137	11714	Downstream	Left
138	11553	Upstream	Left
139	11875	Downstream	Left
140	11920	Upstream	Left
141	11864	Downstream	Left
142	11992	Upstream	Left
143	11694	Downstream	Left
144	11531	Upstream	Left
145	11709	Downstream	Left
146	11852	Upstream	Right
147	11543	Downstream	Right
148	11994	Upstream	Left
149	11911	Downstream	Left
150	11903	Upstream	Left
151	11538	Downstream	Left

152	11990	Downstream	Right
153	11997	Upstream	Left
154	11927	Downstream	Left
155	11692	Upstream	Left
156	11813	Downstream	Right
157	11954	Upstream	Right
158	11597	Downstream	Left
159	11951	Upstream	Left
160	11853	Downstream	Left
161	11831	Upstream	Right
162	11555	Downstream	Left
163	11809	Upstream	Left
164	11769	Downstream	Right
165	11663	Upstream	Left
166	11968	Downstream	Right
167	11615	Upstream	Left
168	11760	Downstream	Left
169	11792	Upstream	Left
170	11841	Downstream	Left
171	11836	Upstream	Left
172	11608	Downstream	Left
173	11906	Upstream	Left
174	11750	Downstream	Left
175	11534	Upstream	Right
176	11630	Downstream	Left
177	11761	Upstream	Left
178	11914	Downstream	Left
179	11660	Upstream	Right
180	11825	Downstream	Left
181	11808	Upstream	Left
182	11770	Downstream	Left
183	11759	Upstream	Right
184	11564	Downstream	Left
185	11952	Upstream	Right
186	11742	Downstream	Left
187	11944	Upstream	Left
188	11698	Downstream	Left
189	11897	Upstream	Right
190	11582	Downstream	Left
191	11780	Upstream	Left
192	11921	Downstream	Right
193	11786	Upstream	Left
194	11541	Downstream	Left
195	11682	Upstream	Right
196	11749	Downstream	Left
197	11650	Upstream	Right
198	11552	Downstream	Right
199	11820	Upstream	Left
200	11585	Downstream	Left
201	11688	Upstream	Left
202	11679	Downstream	Left
203	11734	Upstream	Right

152	11866	Upstream	Left
153	11894	Downstream	Left
154	11925	Upstream	Left
155	11729	Downstream	Left
156	11789	Upstream	Left
157	11524	Downstream	Left
158	11767	Upstream	Right
159	11598	Downstream	Right
160	11676	Upstream	Left
161	11791	Downstream	Left
162	11816	Upstream	Left
163	11636	Downstream	Right
164	11790	Upstream	Right
165	11795	Downstream	Right
166	11891	Upstream	Left
167	11601	Downstream	Left
168	11828	Upstream	Right
169	11787	Downstream	Left
170	11998	Upstream	Left
171	11919	Downstream	Left
172	11826	Upstream	Left
173	11580	Downstream	Left
174	11974	Upstream	Left
175	11939	Downstream	Right
176	11725	Upstream	Right
177	11889	Downstream	Right
178	11693	Upstream	Right
179	11975	Downstream	Left
180	11738	Upstream	Right
181	11895	Downstream	Left
182	11839	Upstream	Right
183	11704	Downstream	Left
184	11978	Upstream	Left
185	11850	Downstream	Right
186	11840	Upstream	Left
187	11522	Downstream	Right
188	11860	Upstream	Left
189	11846	Downstream	Left
190	11900	Upstream	Left
191	11989	Downstream	Left
192	11618	Upstream	Left
193	11874	Downstream	Right
194	11647	Upstream	Left
195	11983	Downstream	Left
196	11908	Upstream	Left
197	11730	Downstream	Left
198	11773	Upstream	Right
199	11547	Downstream	Right
200	11802	Upstream	Right
201	11830	Downstream	Left
202	11561	Upstream	Left
203	11583	Downstream	Right

204	11855	Downstream	Right
205	11569	Upstream	Right
206	11807	Downstream	Left
207	11798	Upstream	Right
208	11865	Downstream	Left
209	11633	Upstream	Right
210	11577	Downstream	Right
211	11595	Upstream	Left
212	11621	Downstream	Right
213	11652	Upstream	Right
214	11856	Downstream	Right
215	11941	Upstream	Right
216	11812	Downstream	Right
217	11758	Upstream	Right
218	11695	Downstream	Right
219	11788	Upstream	Left
220	11771	Downstream	Left
221	11625	Upstream	Right
222	11777	Downstream	Right
223	11930	Upstream	Right
224	11999	Downstream	Right
225	11605	Upstream	Left

204	11885	Upstream	Right
205	11961	Downstream	Right
206	11565	Upstream	Right
207	11811	Downstream	Left
208	11962	Upstream	Right
209	11888	Downstream	Left
210	11643	Upstream	Right
211	11775	Downstream	Right
212	11909	Upstream	Left
213	11578	Downstream	Right
214	11746	Upstream	Left
215	11948	Downstream	Right
216	11898	Upstream	Left
217	11560	Downstream	Right
218	11931	Upstream	Right
219	11588	Downstream	Right
220	11851	Upstream	Right
221	11996	Downstream	Left
222	11821	Upstream	Left
223	11706	Downstream	Right
224	11751	Upstream	Left
225	11793	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
11796	33%
11646	80%
11556	
11899	
11627	
11557	
11537	
11947	
11870	
11651	
11559	
11756	

Sample magnets

serial No.	
11535	
11644	
11765	
11886	
11943	

11612	
11594	
11610	
11960	
11689	
11726	
11859	went to BJ_slot#16
11987	
11586	
11753	
11806	
11988	
11863	

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 #: Ll43-111200-21

P.O. #: 5A13624 DATE: 08-19-06

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 29.985/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.025	Accept/Reject
Overall length	189	+0 / -.1	188.97	Accept/Reject
Overall width	128	+0 / -.1	127.96	Accept/Reject

INSPECTOR: Murlage QA Supervisor: Murlage

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 #: L143-111300-21

P.O. #: 5A13624 DATE: 08-19-06

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 29.985/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.03	Accept/Reject
Overall length	189	+0 / -.1	188.97	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Murlaze QA Supervisor: Murlaze

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 #: L143-110800-21

P.O. #: 5A13624 DATE: 08-19-06

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 29.993/29.982	Accept/Reject
Bottom surface flatness	</= .04	N/A	0.015	Accept/Reject
Overall length	195	+0 / -.1	194.96	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Murlage QA Supervisor: Murlage

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 #: L143-110900-21

P.O. #: 5A13624 DATE: 08-19-06

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 29.992/29.984	Accept/Reject
Bottom surface flatness	<= .04	N/A	.025	Accept/Reject
Overall length	195	+0 / -.1	194.985	Accept/Reject
Overall width	128	+0 / -.1	127.976	Accept/Reject

INSPECTOR: Mullaze QA Supervisor: Mullaze

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 #: L143-111000-1-21

P.O. #: 5A13624 DATE: 08-19-06

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 29.985/29.975	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: 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: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111000-2-21

P.O. #: 5A13624 DATE: 08-19-06

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	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.91	Accept/Reject
Overall width	128	+0 / -.1	127.95	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: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111000-3-21

P.O. #: 5A13624 DATE: 08-19-06

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	+0 / -.1	1004.92	Accept/Reject
Overall width	128	+0 / -.1	127.93	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

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 #: L143-111100-1-21

P.O. #:5A13624 DATE: 08-19-06

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 29.980/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	.03	Accept/Reject
Overall length	1005	+0 / -.1	1004.93	Accept/Reject
Overall width	128	+0 / -.1	127.95	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 #: L143-111100-2-21

P.O. #:5A13624 DATE: 08-19-06

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	.035	Accept/Reject
Overall length	1005	+0 / -.1	1004.93	Accept/Reject
Overall width	128	+0 / -.1	127.952	Accept/Reject

INSPECTOR: Muelaga QA Supervisor: Muelaga

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 #: L143-111100-3-21

P.O. #:5A13624 DATE: 08-19-06

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 29.990/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	.035	Accept/Reject
Overall length	1005	+0 / -.1	1004.92	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Murlaza QA Supervisor: Murlaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Dial Machine, Inc.**

PART NAME: **LCLS Strongback**

DRAWING #: **L143-110700**

SERIAL #: 21

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

DATE: 12-12-06

#	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	12/12/06
2	Check Strongback is marked with serial number & part no.'s (ANL & SLAC) per SOW Section 4.1.3?	H.T.	SIMON	12/12/06
3	Check all accompanying Certifications have correct part serial number	H.T.	SIMON	12/12/06
4	Check Material Certification for compliance with ASTM B381-03 or ASTM B348, Grade F2	H.T.	SIMON	12/12/06
5	Check Forging Annealing Certification for annealing conformance to AMS-H-81200A, Table V, commercial Pure, Bars & Forgings, including Note 8	H.T.	SIMON	12/12/06
6	Check Rough Machining Anneal Certification for annealing conformance to AMS-2801B section 3.2.9	H.T.	SIMON	12/12/06
7	Check the Strongback contractor's reported dimensional measurements against the part drawing	H.T.	SIMON	12/12/06
8	Verify the Strongback critical dimensions as listed in the SOW section 4.5.2 are in compliance with the print	H.T.	SIMON	12/12/06

INSPECTOR: SIMON

QA Supervisor: Muwage

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:

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 21

P.O. #: 5A-13624

DATE: 12-12-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Overall length	3400.00	+0 / -.04	3399.85	Accept/Reject
Gap height	167.00	+0.05 / -.0	167.01	Accept/Reject
Gap flatness (top and bottom)	</= .05	N/A	<=.03	Accept/Reject
Gap depth	130.00	+/- .08		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	Accept/Reject
Mounting Pads Area	60.00	+0.1/-.0	60.04	Accept/Reject
Holes Location	2 x 30.00	+0.1/-0.1	30.02	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

TEST EQUIPMENT USED: DIAL CALIPER
MICROMETER
ADJUSTEBLE PARALELS.
SQUAR PRECISION
DROP INDICATOR

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 #: 21

P.O.#: 5A-13624

DATE: 12-12-06

FEATURE: Gap Flatness

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

INSPECTOR: Simon

QA Supervisor: Muelaze

TEST EQUIPMENT USED: Jig TRANSIT MODEL: 711010 SERIAL# 231067

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

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

SERIAL #: 11669

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

DATE: 11-07-06

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: [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 #: 11719

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

DATE: 11-07-06

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: 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 #: 11691

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

DATE: 11-07-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	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 #: 11747

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

DATE: 11-07-06

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: Sima

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 #: 11722

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

DATE: 11-07-06

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	66.01	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 #: 11648

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

DATE: 11-07-06

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

INSPECTOR: Sunda

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 #: 11687

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

DATE: 11-07-06

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: Muelage

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 #: 11973

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

DATE: 11-07-06

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: Muelaz

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 #: 11581

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

DATE: 11-07-06

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	8.96	Accept/Reject

INSPECTOR: Simon

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 #: 11799

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

DATE: 11-07-06

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: Muelaza

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 #: 11526

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

DATE: 11-07-06

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: 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 #: 11810

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

DATE: 11-07-06

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: 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 #: 11986

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

DATE: 11-07-06

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: 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 #: 11883

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

DATE: 11-07-06

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: 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 #: 11680

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

DATE: 11-07-06

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: Smad

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 #: 11881

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

DATE: 11-07-06

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: Simad

QA Supervisor: Mulaze

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 #: 11831

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

DATE: 11-07-06

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	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelage

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 #: 11836

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

DATE: 11-07-06

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: Mullaly

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 #: 11808

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

DATE: 11-07-06

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	8.95	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: **Shin-Etsu**

PART NAME: **LCLS Magnet**

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

SERIAL #: 11780

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

DATE: 11-07-06

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: 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: **Shin-Etsu**

PART NAME: **LCLS Magnet**

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

SERIAL #: 11688

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

DATE: 11-07-06

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: Muller

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 #: 11595

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

DATE: 11-07-06

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	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Multer

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 #: 11625

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

DATE: 11-07-06

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	66.01	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 #: 11958

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

DATE: 11-07-06

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: Mustafa

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 #: 11928

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

DATE: 11-07-06

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: Muller

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 #: 11593

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

DATE: 11-07-06

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

INSPECTOR: Simon

QA Supervisor: Mulaga

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 #: 11635

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

DATE: 11-07-06

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: Muelage

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 #: 11752

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

DATE: 11-07-06

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

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 #: 11876

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

DATE: 11-07-06

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: 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 #: 11573

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

DATE: 11-07-06

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: Muelle

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 #: 11662

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

DATE: 11-07-06

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: Mallage

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 #: 11549

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

DATE: 11-07-06

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 #: 11794

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

DATE: 11-07-06

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

INSPECTOR: Simon

QA Supervisor: Muller

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 #: 11935

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

DATE: 11-07-06

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

INSPECTOR: Simon

QA Supervisor: Mulaza

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 #: 11570

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

DATE: 11-07-06

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	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	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 #: 11551

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

DATE: 11-07-06

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: Muller

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 #: 11861

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

DATE: 11-07-06

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: 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 #: 11864

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

DATE: 11-07-06

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: Murlaza

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 #: 11538

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

DATE: 11-07-06

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: 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 #: 11791

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

DATE: 11-07-06

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: 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 #: 11919

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

DATE: 11-07-06

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: Muliza

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 #: 11895

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

DATE: 11-07-06

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	8.96	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 #: 11989

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

DATE: 11-07-06

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: [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 #: 11830

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

DATE: 11-07-06

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: Simow

QA Supervisor: Mulaza

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 #: 11775

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

DATE: 11-07-06

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: 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 #: 11996

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

DATE: 11-07-06

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: Smod

QA Supervisor: Murlaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

800-521-9520
jlindustrial.com
11669
11915
11891
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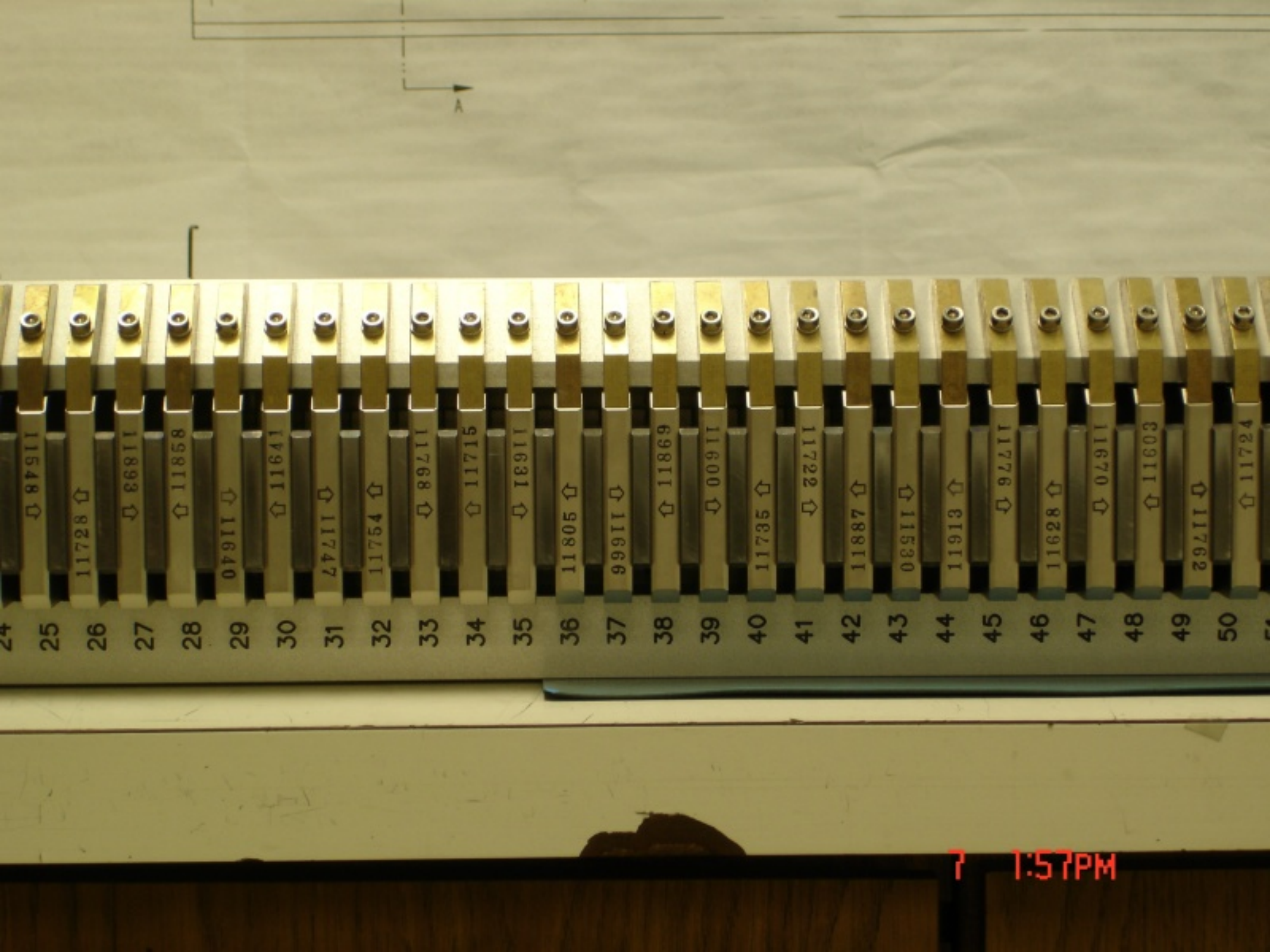
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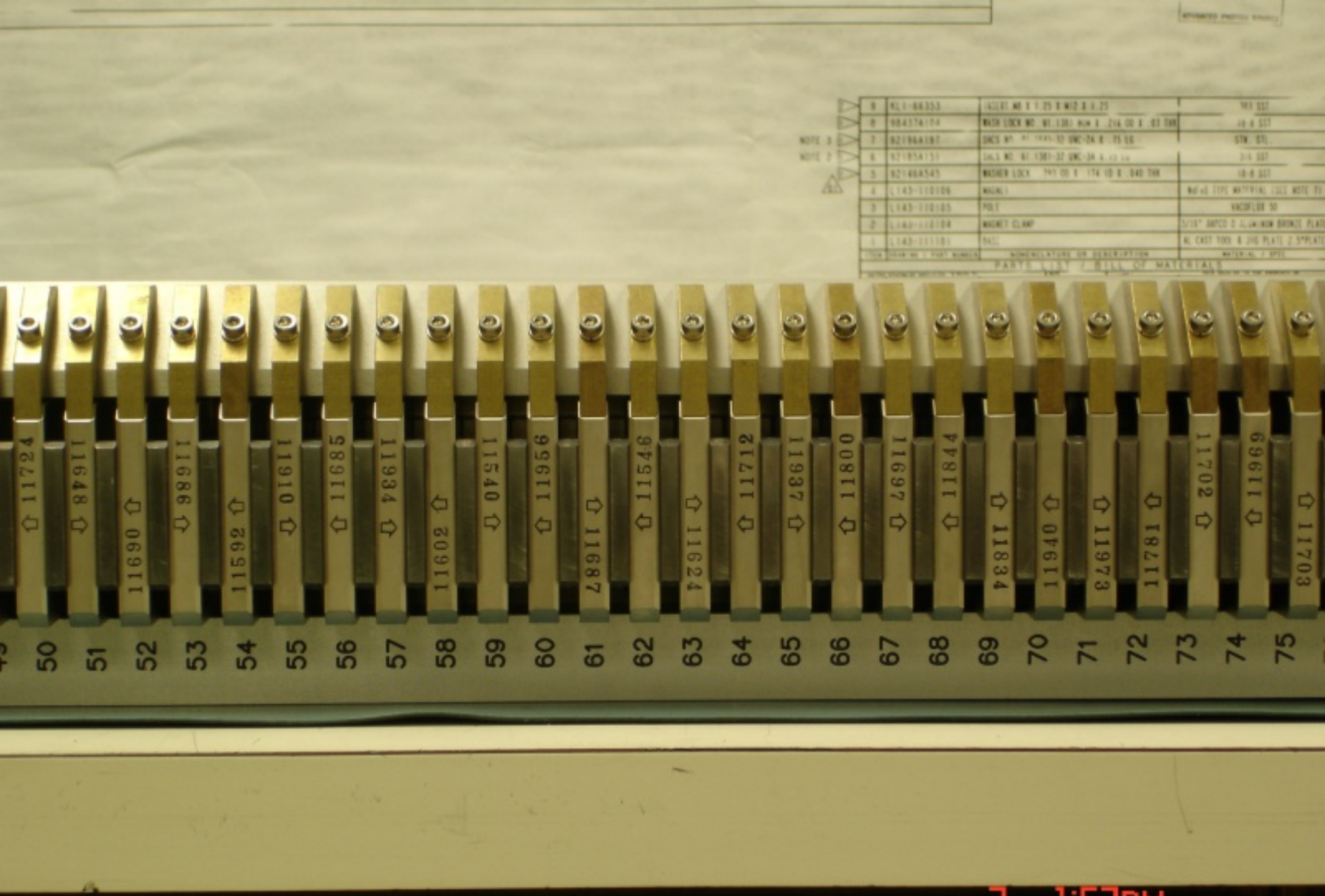
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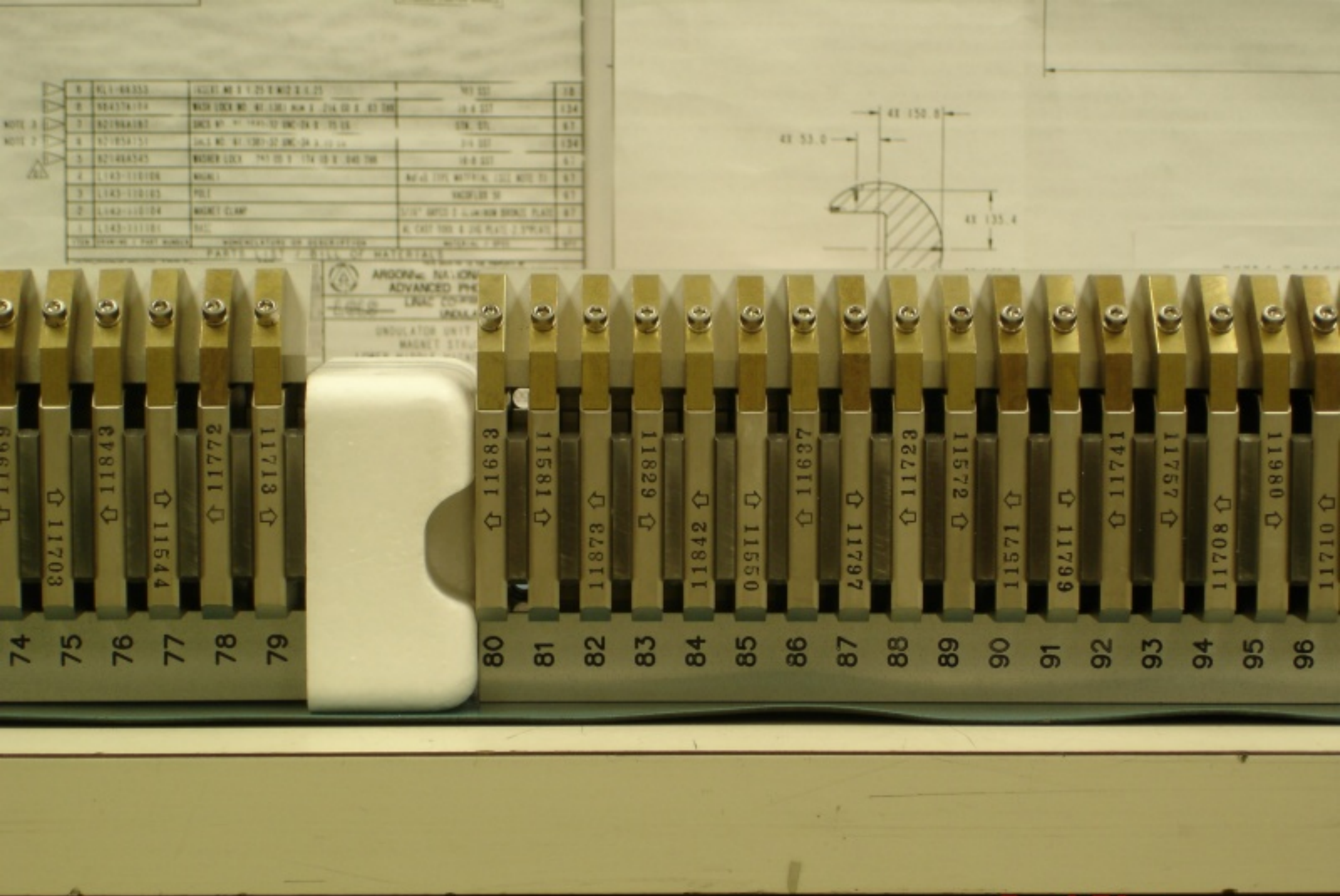
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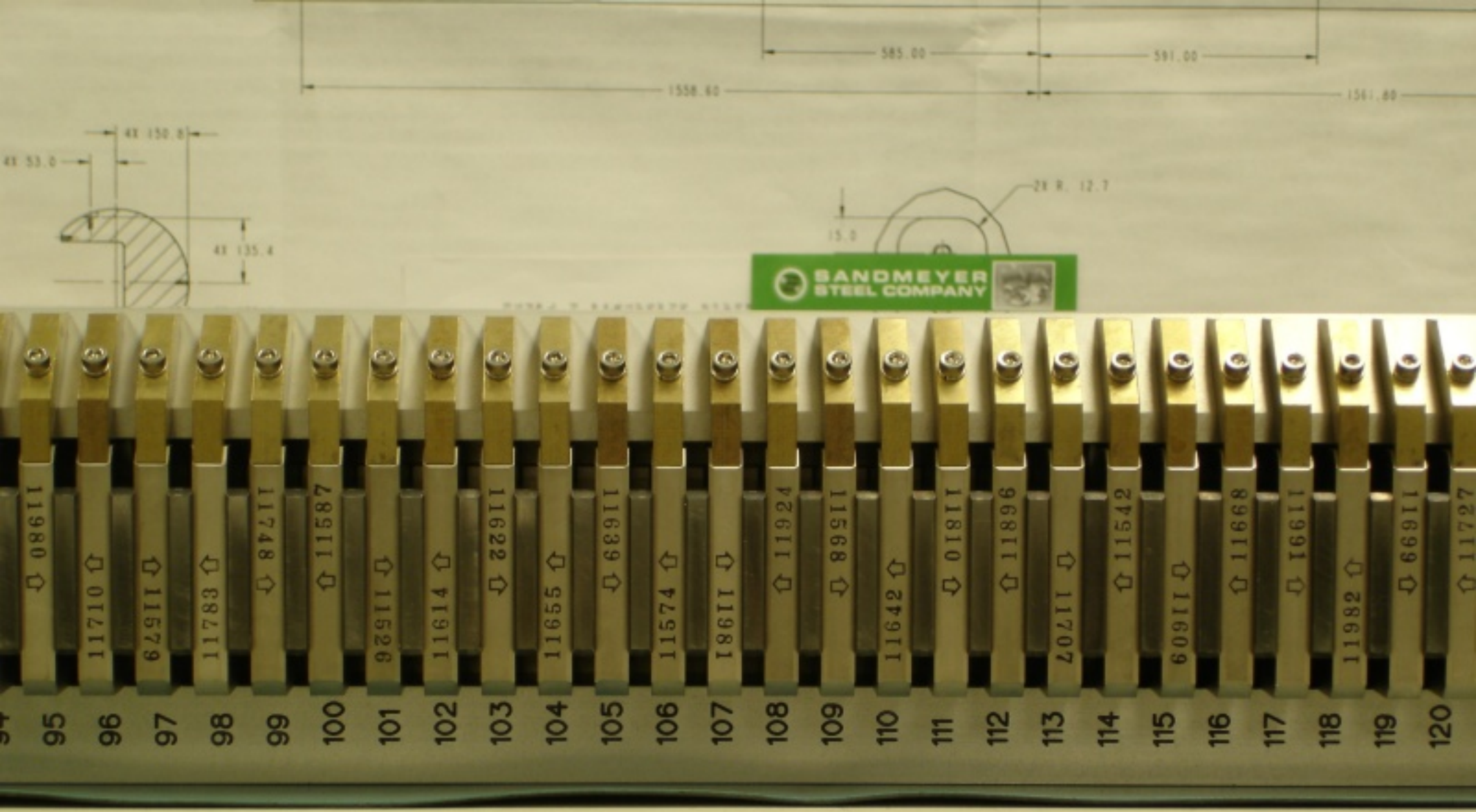
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STEEL COMPANY
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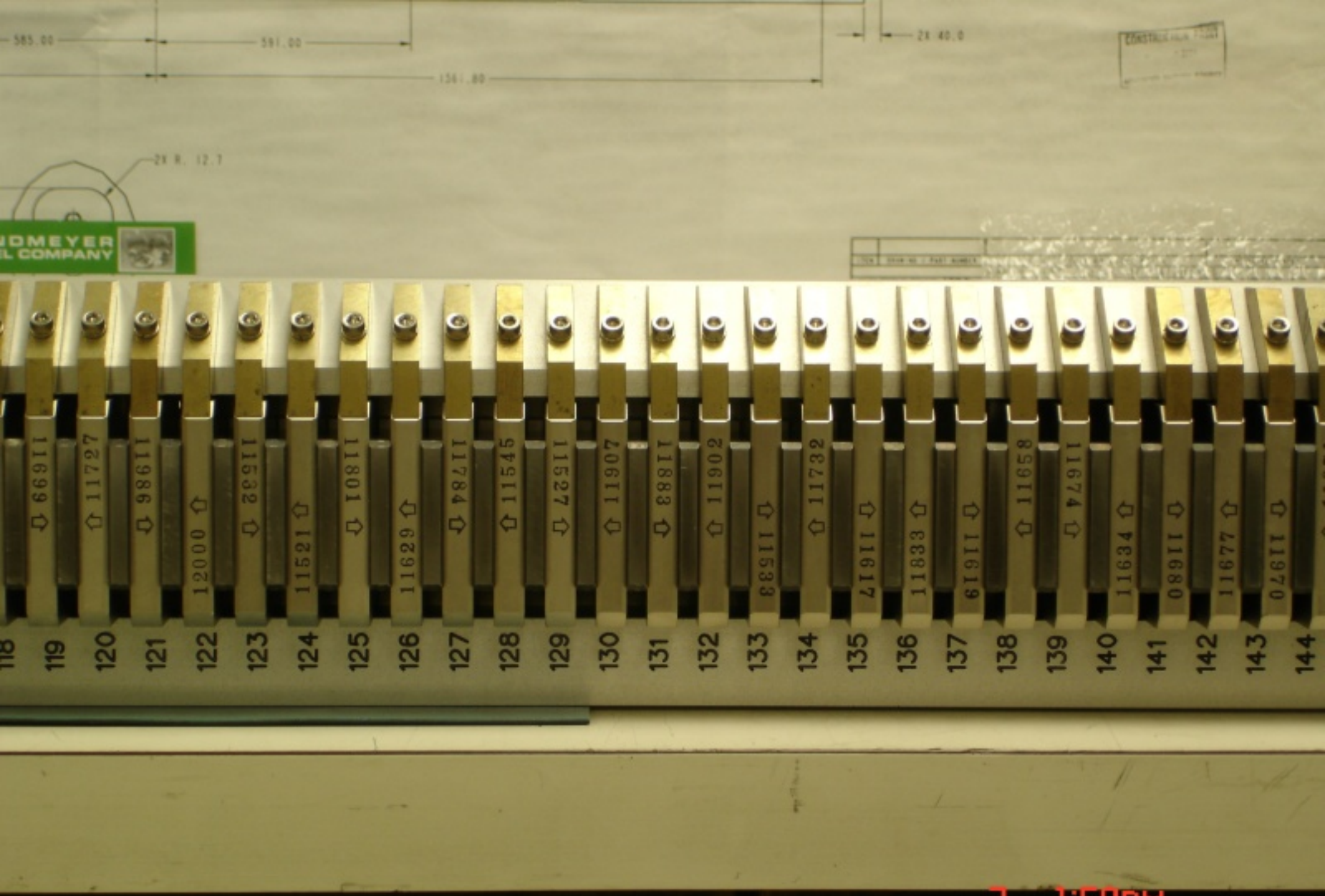
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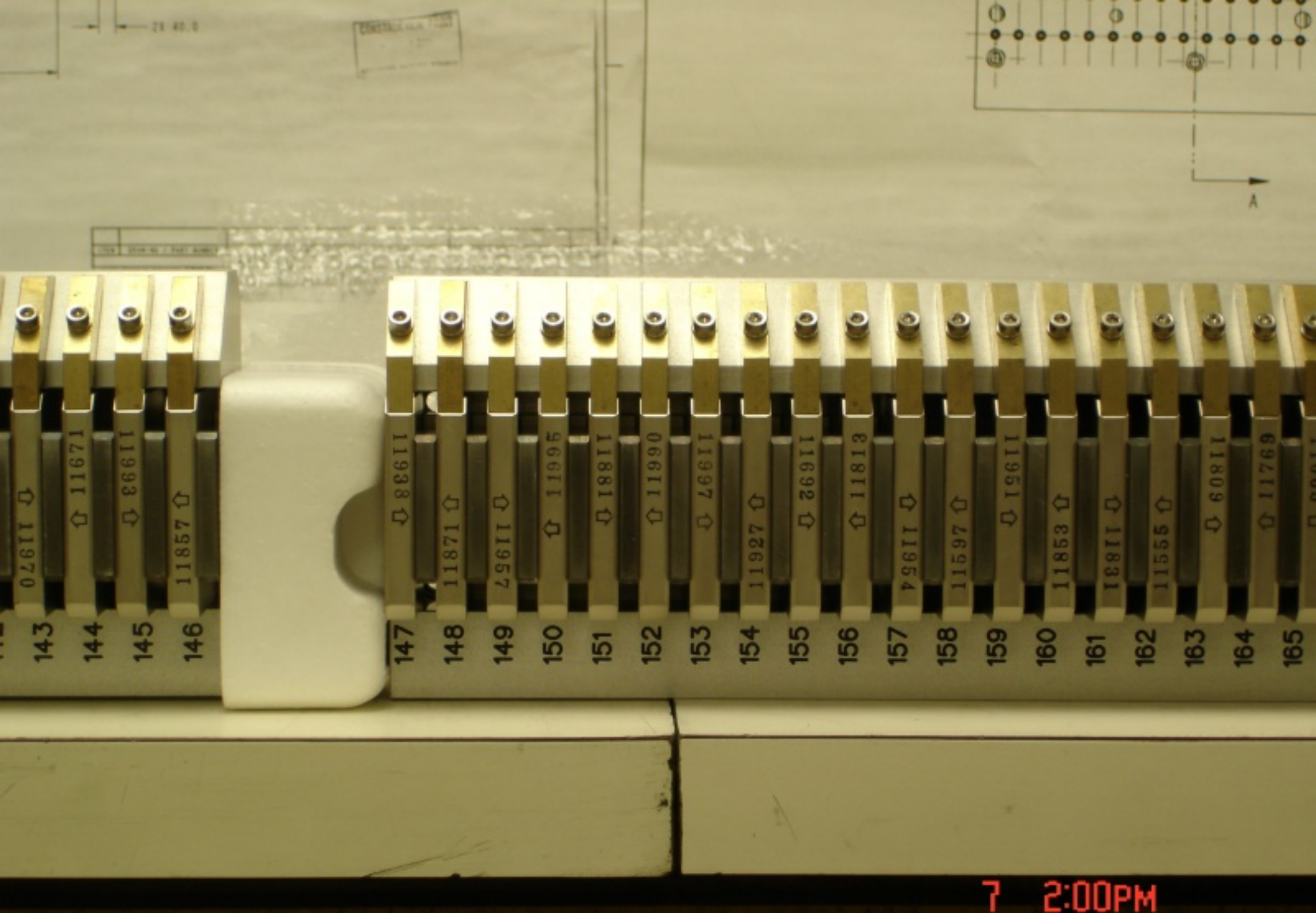
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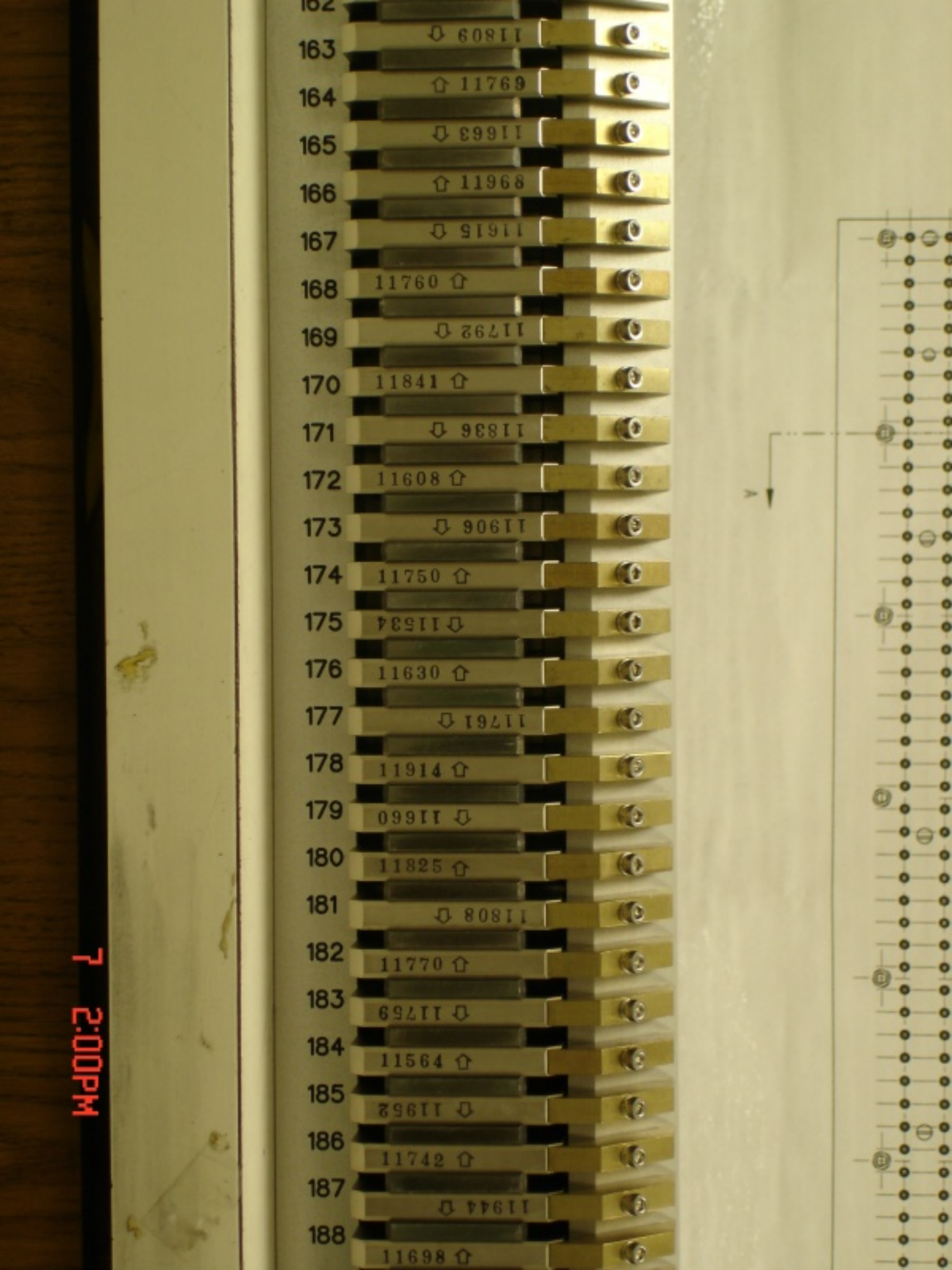
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800-521-9520
jlindustrial.com
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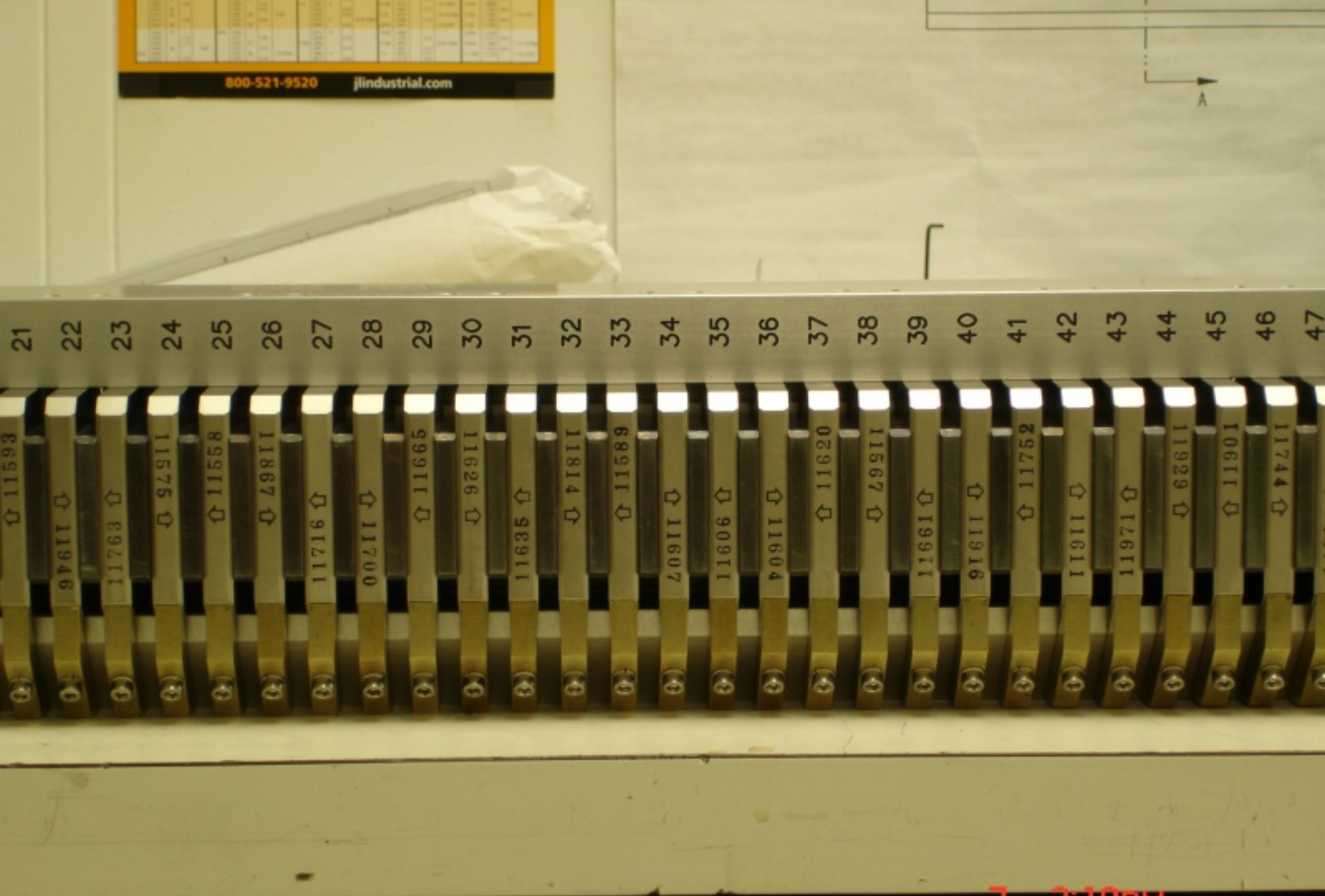
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jlindustrial.com
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7	92196A182	SCREW NO. [illegible]	STN. STL
6	92185A151	SCREW NO. 401-1301-32 UNC-2A [illegible]	[illegible]
5	92148A545	WASHER LOCK [illegible]	[illegible]
4	L143-110106	MAGNET	[illegible]
3	L143-110105	POLE	VACROLUX 50
2	L143-110104	MAGNET CLAMP	[illegible]
1	L143-111101	TOOL	[illegible]
ITEM	DRAWING / PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC

PARTS LIST / BILL OF MATERIALS

NOTE 3

NOTE 2

NOTE 1

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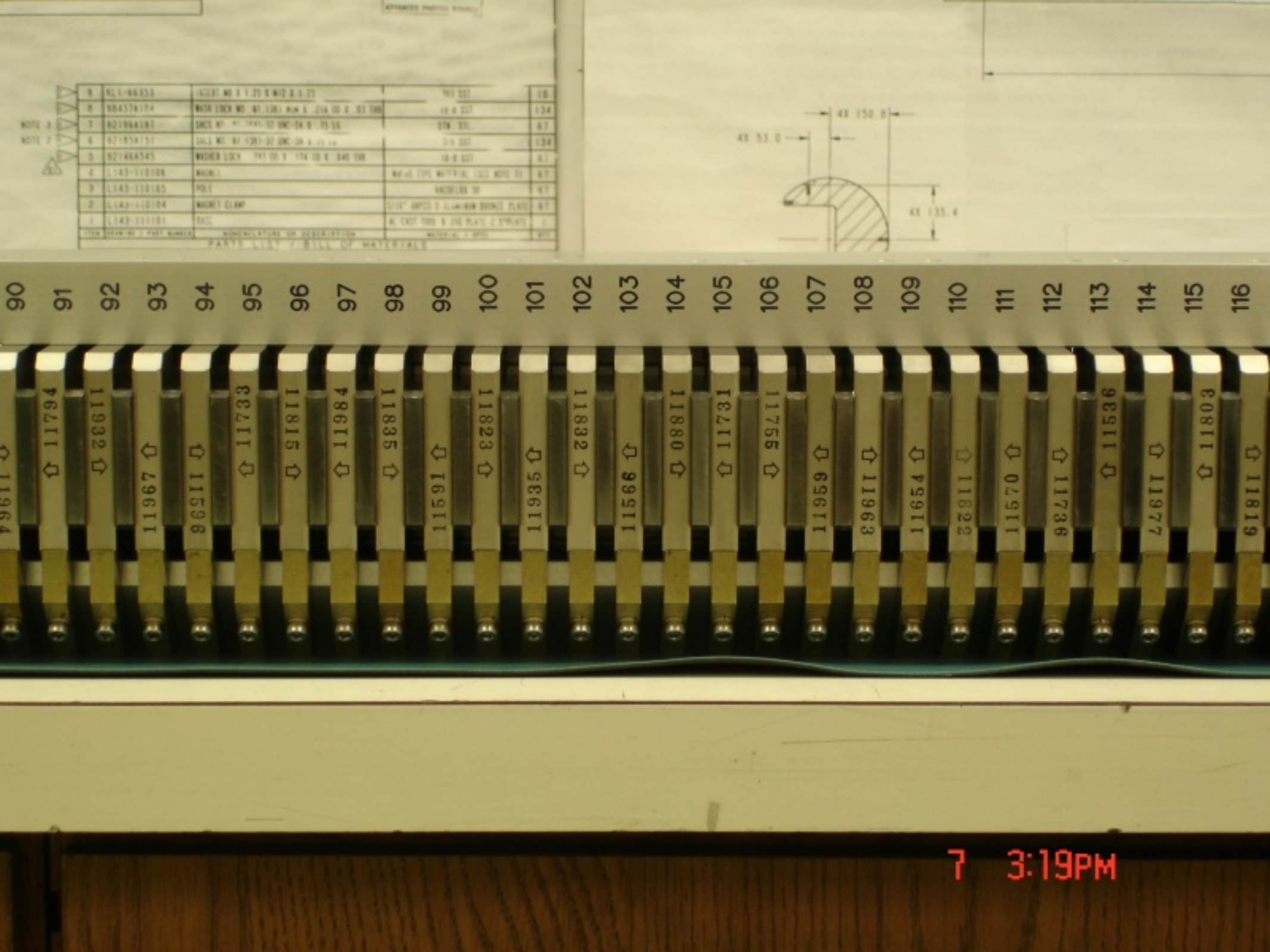
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SANDMEYER STEEL COMPANY
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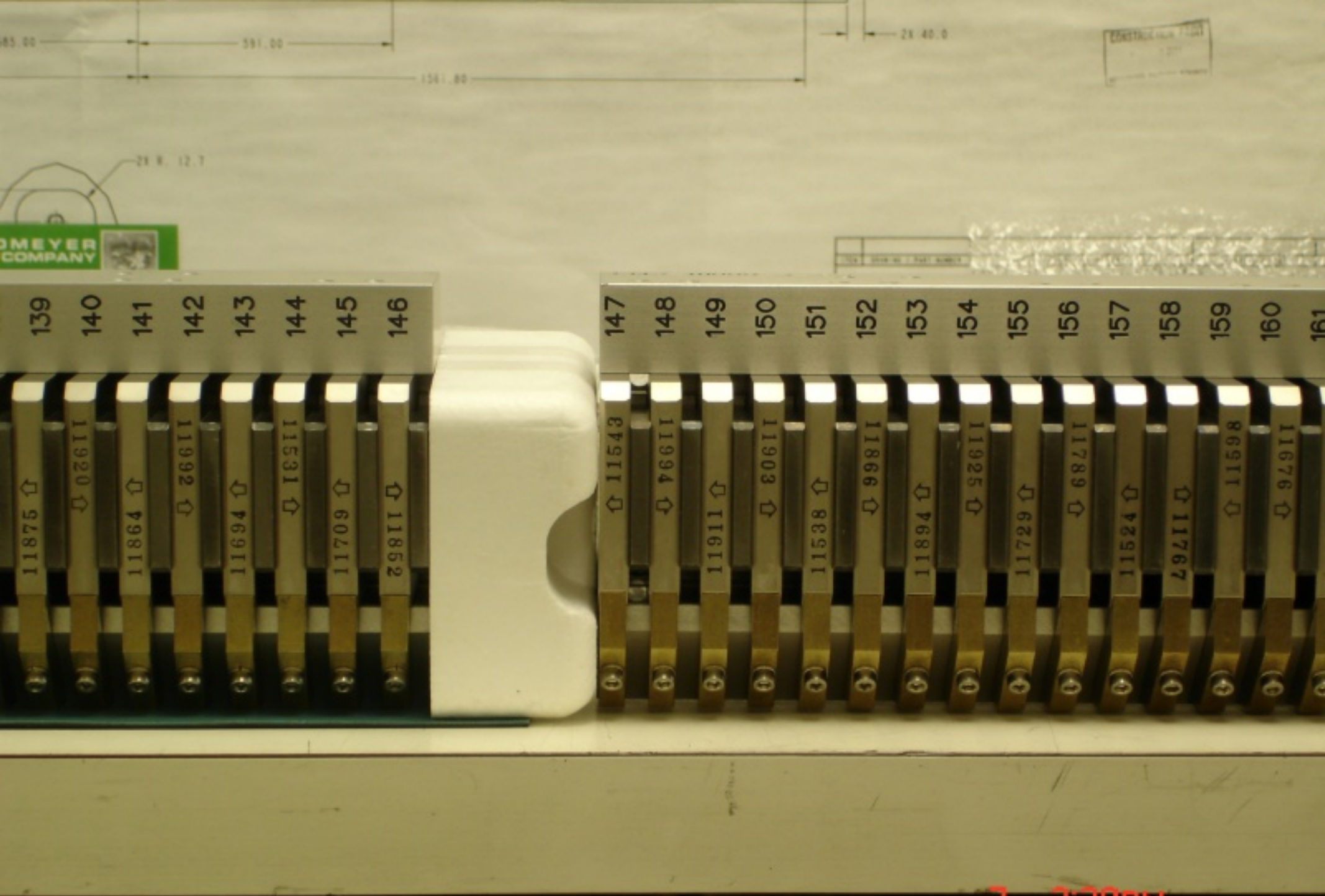
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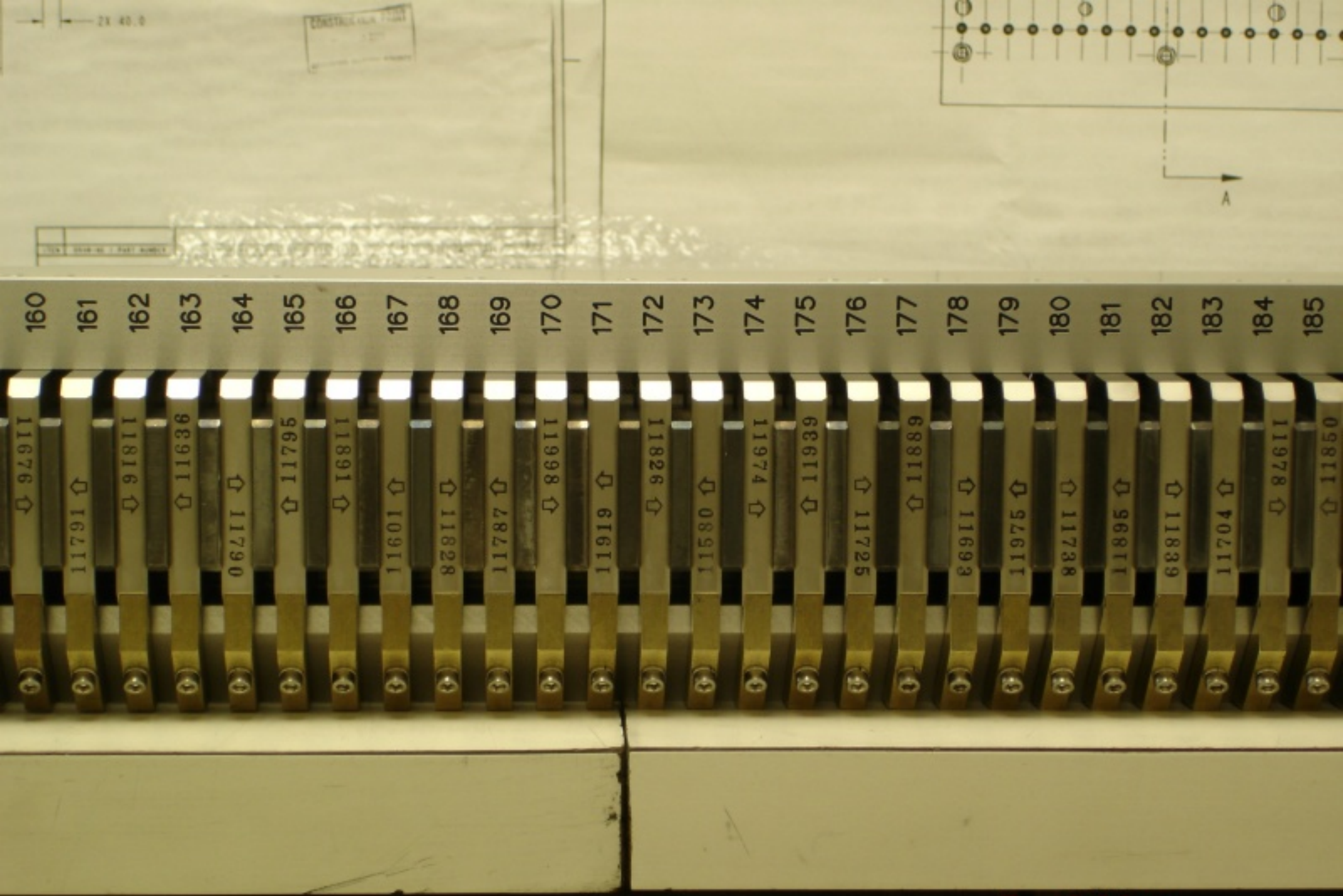
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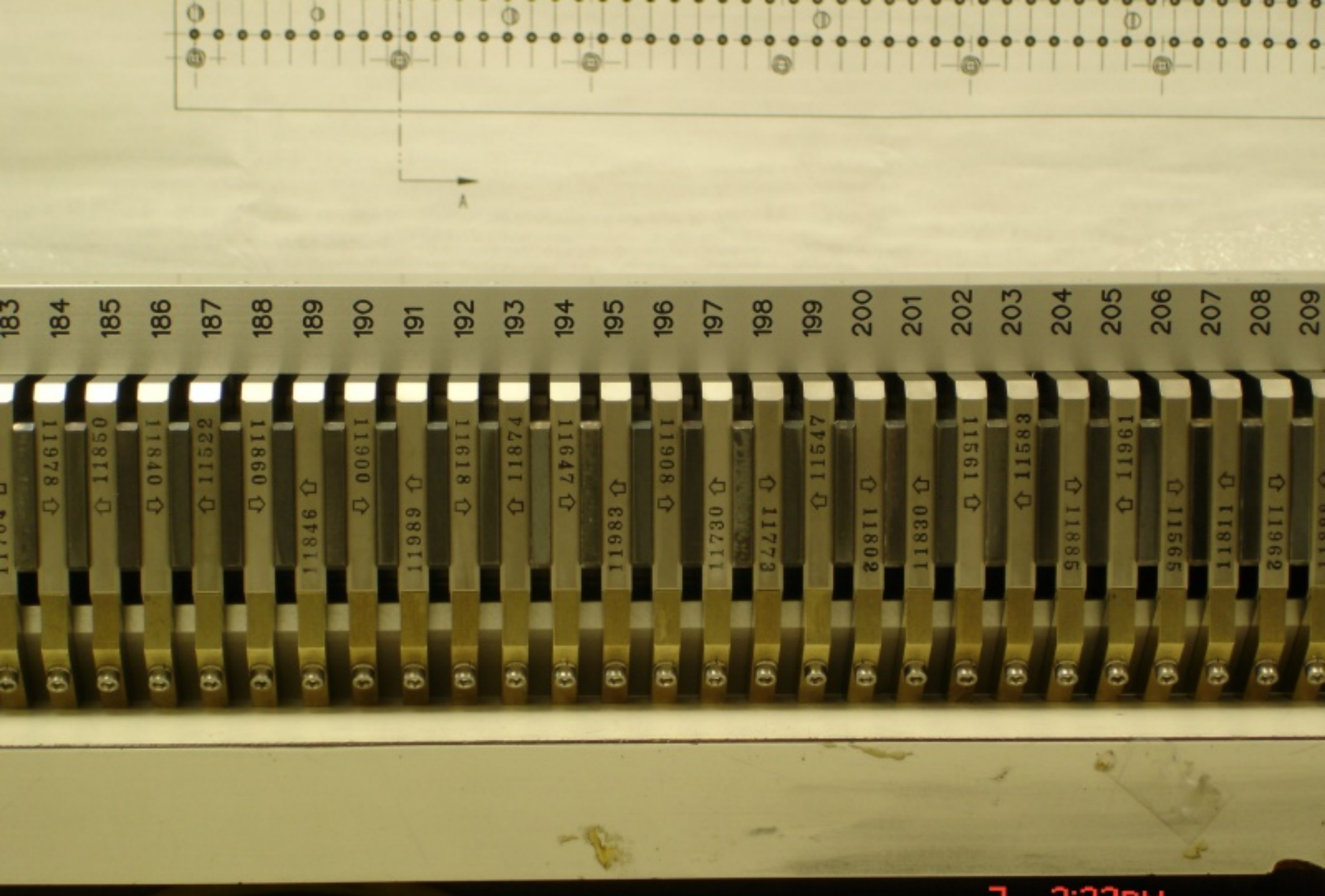
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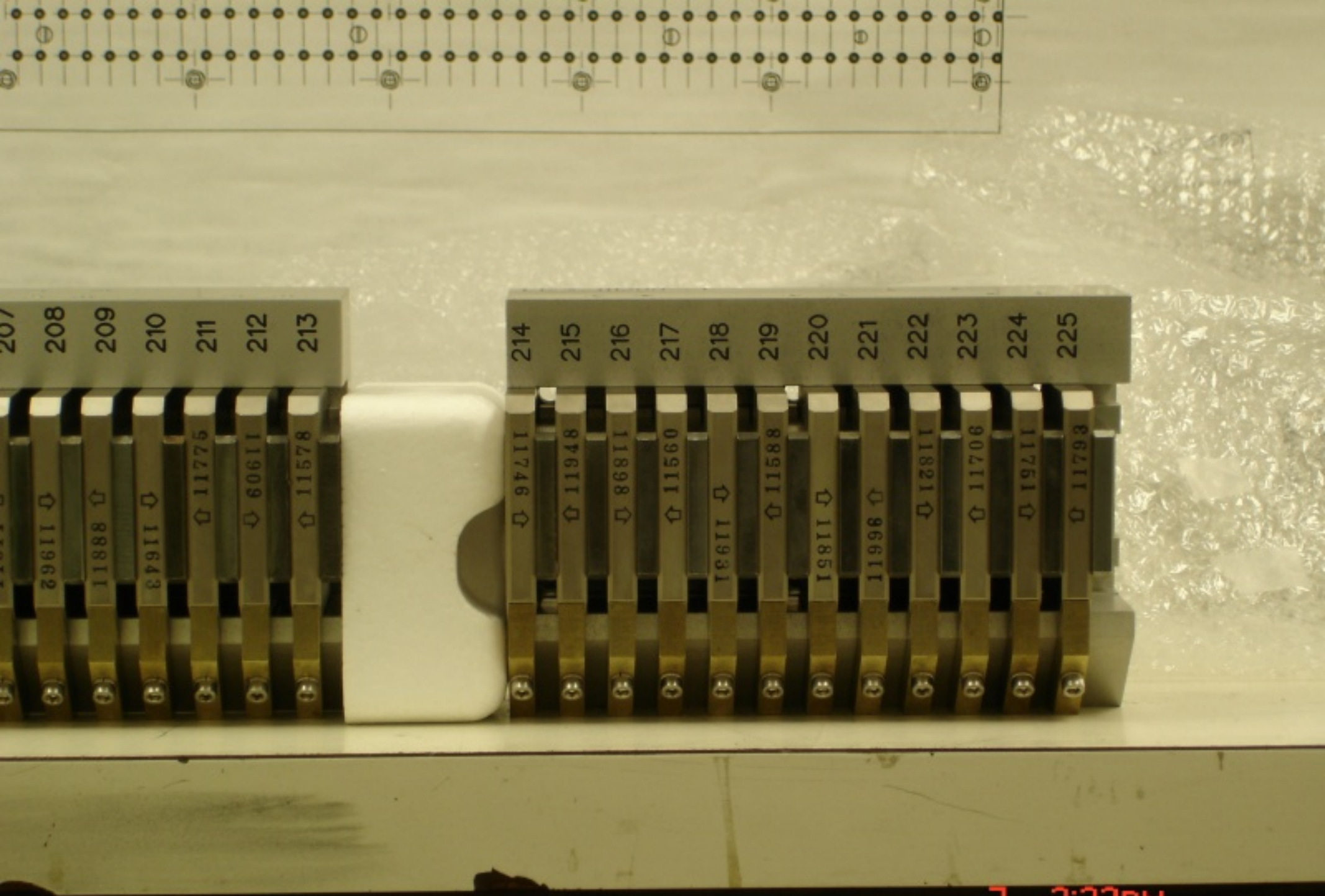
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